

C6649257

MODEL 700TH M24

Model **SMS** TH

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

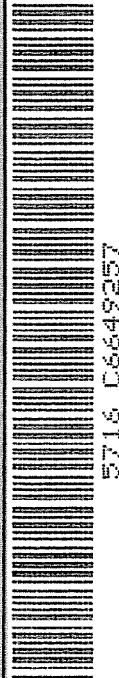
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO. C6649257

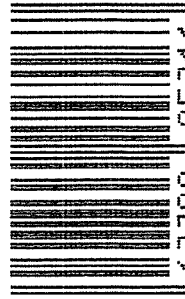
ORDER NO. 5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649257

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649257

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9	1	RW
600	Proof	6 27 9	1	RW
607	Check Headspace	6 27 9	1	RW
610	Dis-assemble Gun	6 27 9	1	RW
612	Magnaflux Barrel Action	1 JUL	2 1991	KR
	Magnaflux Bolt	1 JUL	2 1991	KR
615	Rollmark Caliber	1 JUL	2 1991	LS
617	Drill and Tap Sight Holes	1 JUL	2 1991	LB
618	Polish Barrel	1 JUL	17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	DH

BARBER - M24 0067016

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8-6-91	DH
	G) Safety Off Force	2 1/2	2	2			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-5-91	DH
	I) Firing Pin Indent	.020	.020	.020			8-6-91	DH
	J) Assemble Stock						8/2/91	RW
	K) Assemble Swivel Studs						8-8-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	RW
	M) Iron Sight Alignment						8/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	RW
	O) Attach Scope to Rifle						8/7/91	RW
	P) Detach & Attach Scope 20 Times						8/7/91	RW
640	Gallery Target & Test						8/7/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/7/91	KT
655	Final Inspection							
	A) Headspace						8-8-91	DH
	B) Trigger Pull	2.22	2.26	2.27	2.23	2.27	8-8-91	DL
	C) Function						8-8-91	DH
660	Pack						8-7-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+ 1.00#

SERIAL NO. C6649257

DATE 8-5-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.42	2.43	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.36	2.48	2.26	
PULL #3	2.38	2.40	2.35	2.27	
PULL #4	2.50	2.18	2.56	2.23	
PULL #5	2.52	2.31	2.46	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.31		
PULL #2	3.39	3.45		
PULL #3	3.40	3.44		
PULL #4	3.38	3.15		
PULL #5	3.37	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.56	4.53		4.47
PULL #2	4.58	4.50		4.45
PULL #3	4.53	4.47		4.46
PULL #4	4.46	4.51		4.43
PULL #5	4.49	4.50		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649257
7 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.161227
1 TO	2	.424401
1 TO	3	.0643817
1 TO	4	.154564
1 TO	5	.199444

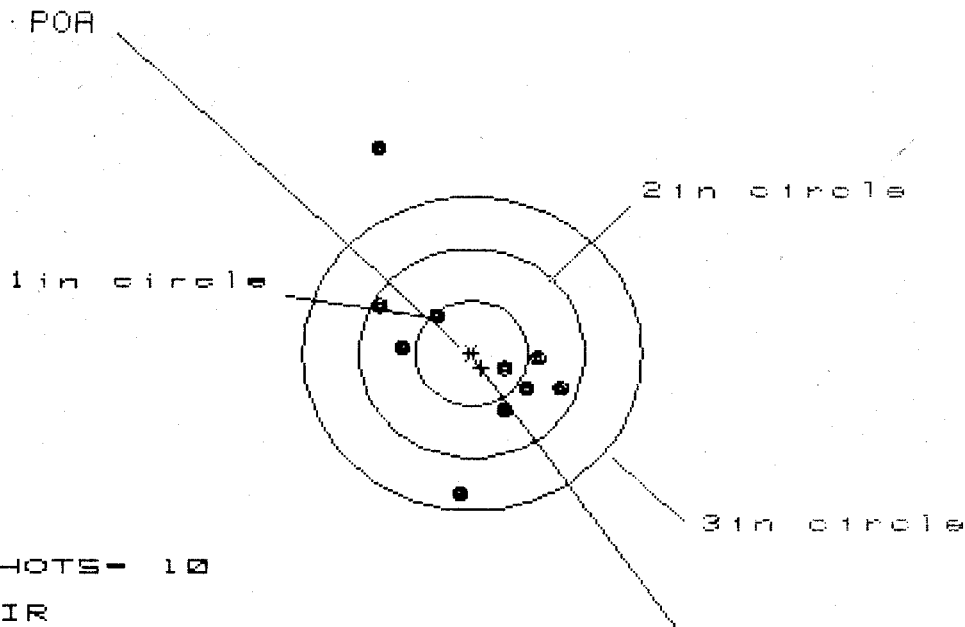
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1378
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .804
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137853
THE AMR FOR THIS RIFLE IS: 1.119

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649257

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.647

VS= 3.301

GS= 3.389

CENTROID *

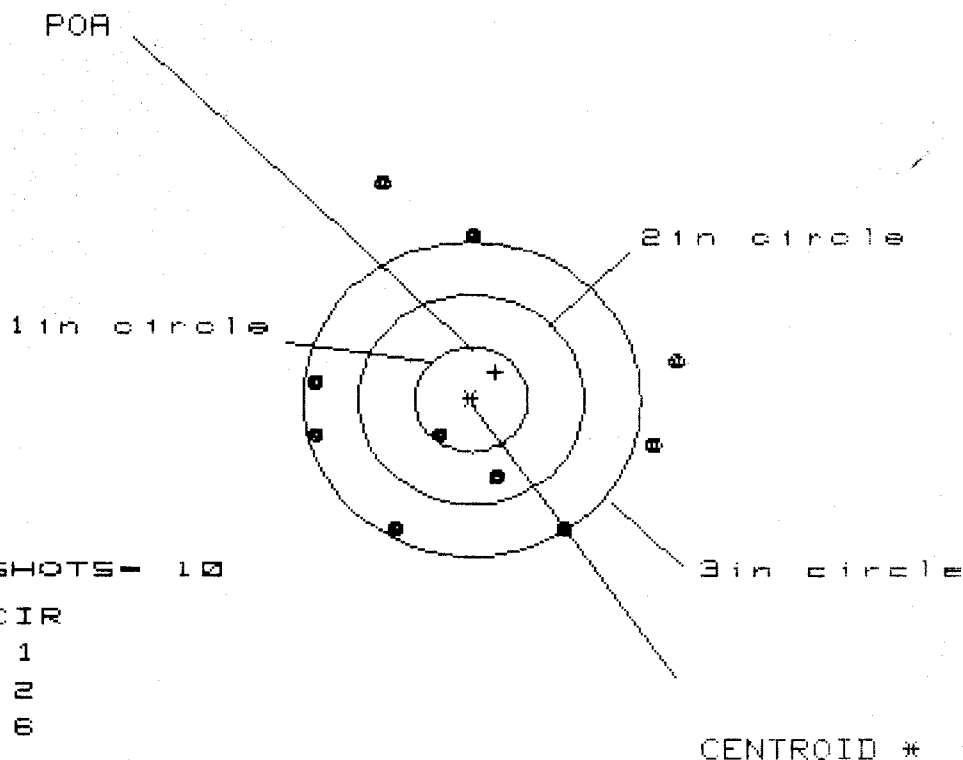
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.718	.698
MINIMUM X	:	-.836	-.921	-.941
MAXIMUM Y	:	1.971	.653	.514
MINIMUM Y	:	-1.330	-1.111	-.500
CENTROID X	:	-.085	.008	.028
CENTROID Y	:	.137	-.082	.056
POA TO CENTROID in.	:	.161	.083	.063
MIN RADIUS	:	.360	.233	.224
MEAN RADIUS	:	.856	.669	.604
MAX RADIUS	:	2.141	1.129	1.073
HORIZONTAL SPREAD	:	1.647	1.639	1.639
VERTICAL SPREAD	:	3.301	1.764	1.015
EXTREME SPREAD	:	3.389	1.921	1.823
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

7 Aug 1991

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CENTERFIRE PATTERNS

2



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 2

3 in - 6

HS = 3.198

VS = 3.304

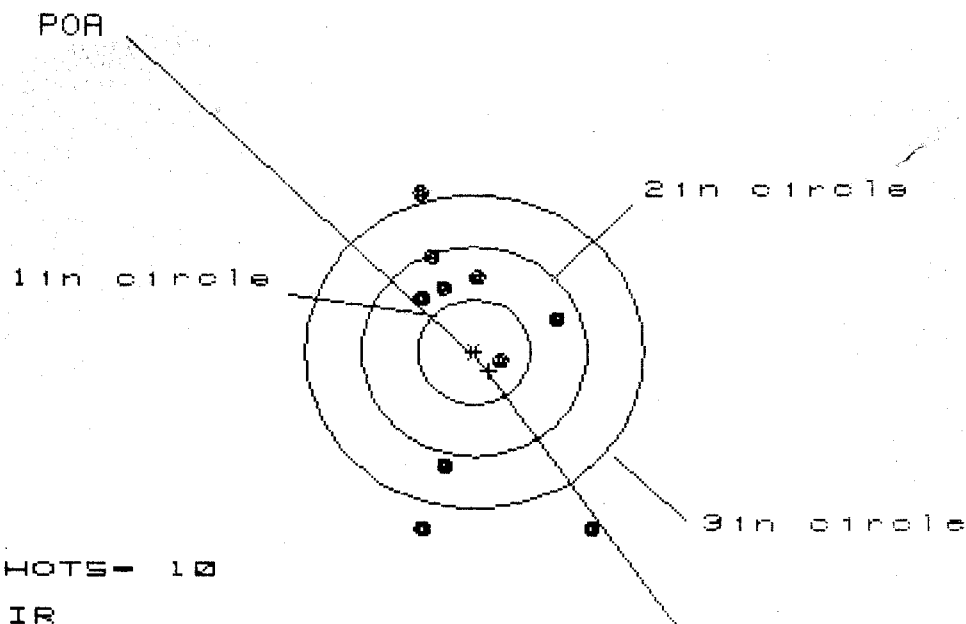
GS = 3.687

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.773	1.684	1.742
MINIMUM X	:	-1.425	-1.514	-1.303
MAXIMUM Y	:	2.086	1.783	1.863
MINIMUM Y	:	-1.218	-0.986	-0.906
CENTROID X	:	-0.215	-0.126	-0.337
CENTROID Y	:	-0.267	-0.499	-0.579
POA TO CENTROID in.	:	.343	.515	.670
MIN RADIUS	:	.475	.406	.180
MEAN RADIUS	:	1.418	1.280	1.167
MAX RADIUS	:	2.234	1.803	1.871
HORIZONTAL SPREAD	:	3.198	3.198	3.045
VERTICAL SPREAD	:	3.304	2.769	2.769
EXTREME SPREAD	:	3.687	3.275	3.059
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	6		

7 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 1.474

VS= 3.180

GS= 3.430

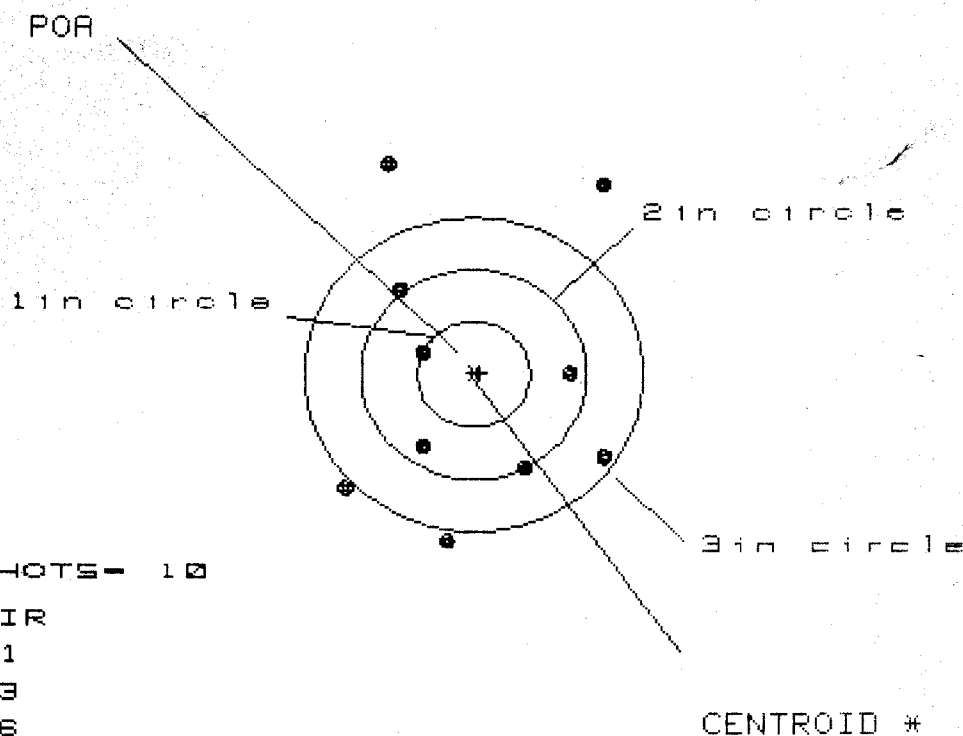
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.893	.854
MINIMUM X	:	-.432	-.316	-.355
MAXIMUM Y	:	1.466	1.284	1.047
MINIMUM Y	:	-1.714	-1.896	-1.550
CENTROID X	:	-.129	-.245	-.206
CENTROID Y	:	.184	.366	.603
POA TO CENTROID in.	:	.225	.440	.637
MIN RADIUS	:	.249	.445	.293
MEAN RADIUS	:	1.053	.907	.706
MAX RADIUS	:	1.939	1.921	1.557
HORIZONTAL SPREAD	:	1.474	1.209	1.209
VERTICAL SPREAD	:	3.180	3.180	2.597
EXTREME SPREAD	:	3.430	3.180	2.604
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

7 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.256

VS= 3.644

GS= 3.708

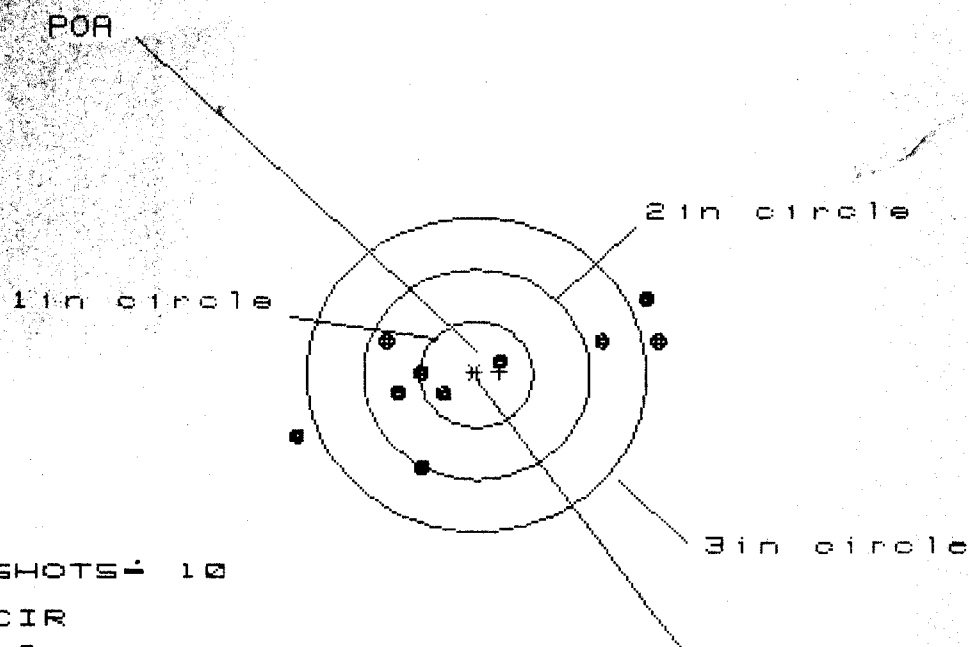
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.154	1.067	1.199
MINIMUM X	:	-1.102	-1.189	-1.057
MAXIMUM Y	:	2.049	2.051	1.330
MINIMUM Y	:	-1.595	-1.368	-1.111
CENTROID X	:	-.052	.035	-.097
CENTROID Y	:	-.014	-.241	-.498
POA TO CENTROID in.	:	.054	.244	.507
MIN RADIUS	:	.466	.671	.421
MEAN RADIUS	:	1.314	1.185	1.003
MAX RADIUS	:	2.194	2.305	1.468
HORIZONTAL SPREAD	:	2.256	2.256	2.256
VERTICAL SPREAD	:	3.644	3.419	2.441
EXTREME SPREAD	:	3.708	3.708	2.469
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	6		

7 Aug 1981

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CENTERFIRE PATTERNS

5



OF SHOTS: 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 3.103

VS = 1.525

GS = 3.292

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.560	1.389	1.552
MINIMUM X	-1.543	-.929	-.766
MAXIMUM Y	.686	.617	.365
MINIMUM Y	-.839	-.908	-.831
CENTROID X	-.208	-.037	-.200
CENTROID Y	-.020	.049	-.028
POA TO CENTROID in.	.209	.062	.202
MIN RADIUS	.189	.009	.185
MEAN RADIUS	.954	.886	.782
MAX RADIUS	1.663	1.445	1.593
HORIZONTAL SPREAD	3.103	2.318	2.318
VERTICAL SPREAD	1.525	1.525	1.196
EXTREME SPREAD	3.292	2.520	2.404
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		