

C6649286

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
®
REG. U.S. PAT. & TM. OFF.
DUPONT
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

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

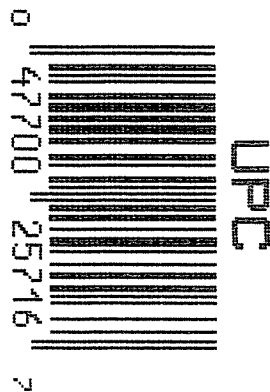
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SERIAL NO.
C6649286

ORDER NO.
5716



5716 C6649286



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649286

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	AW
600	Proof	6 27	9 1	AW
607	Check Headspace	6 27	9 1	AW
610	Dis-assemble Gun	6 27	9 1	AW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL	1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	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		8-8-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8-8-91	JK
	G) Safety Off Force	3	3	3			8-8-91	JK
	H) Trigger Pull Test & Retainability						8-8-91	JK
	I) Firing Pin Indent	.0215	.022	.022			8-8-91	JK
	J) Assemble Stock						8/10/91	RW
	K) Assemble Swivel Studs						8-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	AC
	A) Time						8-12-91	AC
	B) Malfunctions						8-12-91	AC
	C) Pierced Primers						8-12-91	AC
	D) Optical Clarity of Scope						8-12-91	AC
645	Inspect for Live Ammo						8-12-91	AC
655	Final Inspection A) Headspace						8-13-91	D/H
	B) Trigger Pull	2.19	2.15	2.20	2.22	2.15	8-13-91	JK
	C) Function						8-13-91	D/H
660	Pack						9-19-91	RF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>that OK</i> <i>test</i> <i>8-12-91</i>	<i>DA</i>
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

24

MOD. _____ GA. _____ GUN _____
CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaver Brass ejector sticks	RW
	2nd	Polish face of Bolt	RW
	8/ 12/ 91		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649286

DATE 8-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.38	2.23	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.31	2.28	2.15	
PULL #3	2.36	2.45	2.35	2.20	
PULL #4	2.32	2.20	2.30	2.22	
PULL #5	2.53	2.27	2.31	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.19		
PULL #2	3.39	3.38		
PULL #3	3.31	3.30		
PULL #4	3.36	3.43		
PULL #5	3.41	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.43		4.31
PULL #2	4.34	4.42		4.39
PULL #3	4.36	4.43		4.39
PULL #4	4.20	4.44		4.42
PULL #5	4.30	4.54		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649286
12 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.703119
1 TO 2	1.00138
1 TO 3	.809961
1 TO 4	.394446
1 TO 5	1.01116

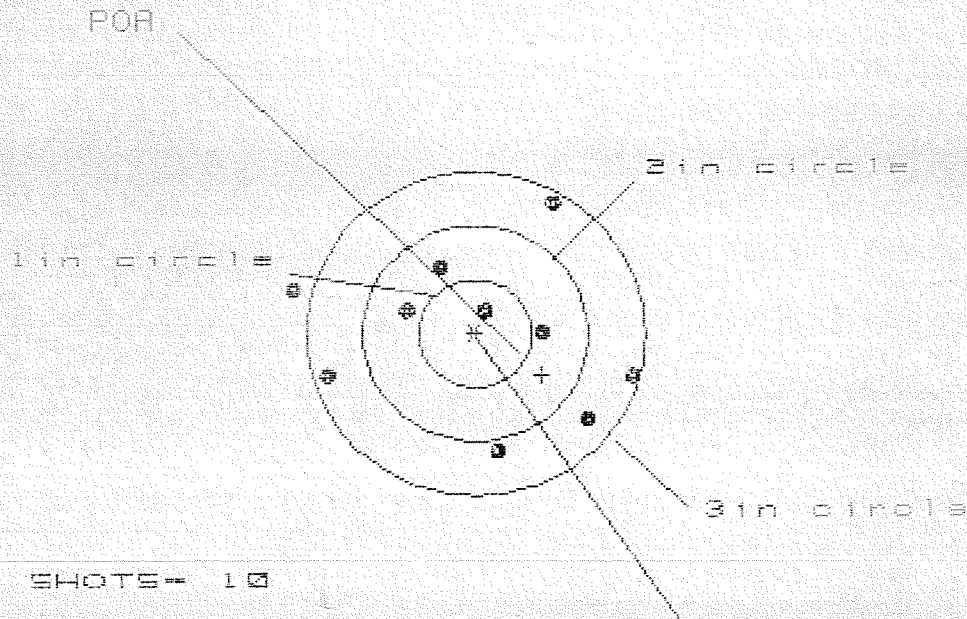
L₄ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0986
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .100729
THE AMR FOR THIS RIFLE IS: 1.008

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B6

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 3.053

VS = 2.266

GS = 3.148

CENTROID +

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.405	1.222	1.001
MINIMUM X	:	-1.648	-1.490	-1.337
MAXIMUM Y	:	1.182	1.227	1.187
MINIMUM Y	:	-1.084	-1.039	-1.079
CENTROID X	:	-.589	-.406	-.559
CENTROID Y	:	.384	.339	.379
POA TO CENTROID in.	:	.704	.529	.676
MIN RADIUS	:	.231	.290	.229
MEAN RADIUS	:	1.037	.955	.903
MAX RADIUS	:	1.696	1.529	1.391
HORIZONTAL SPREAD	:	3.053	2.712	2.338
VERTICAL SPREAD	:	2.266	2.266	2.266
EXTREME SPREAD	:	3.148	2.712	2.512
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	9		

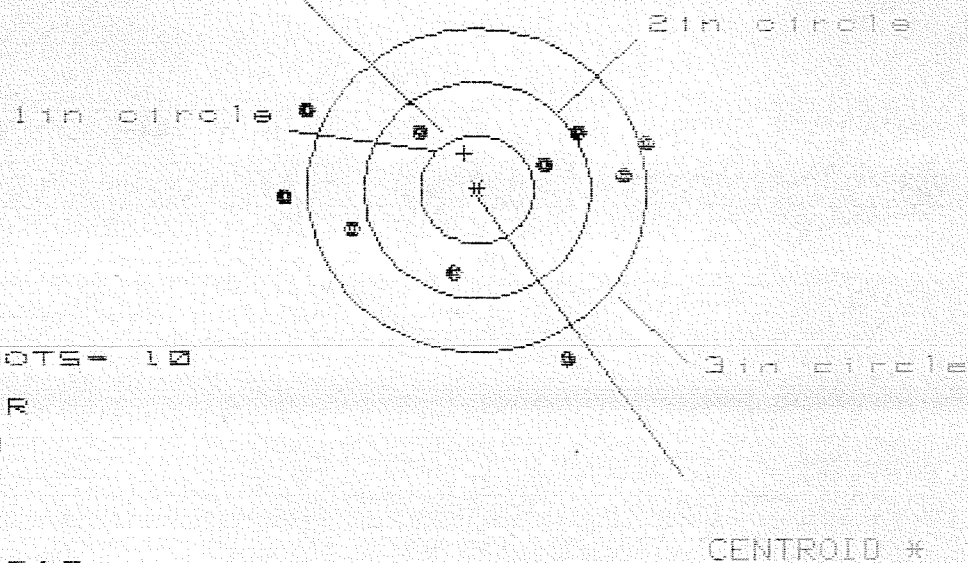
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CENTERFIRE PATTERNS

2

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 3.216

VS= 2.286

GS= 3.264

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.517

1.608

1.407

MINIMUM X

:

-1.699

-1.608

-1.603

MAXIMUM Y

:

.771

.603

.568

MINIMUM Y

:

-1.515

-.926

-.961

CENTROID X

:

.108

.017

.218

CENTROID Y

:

-.335

-.167

-.132

POA TO CENTROID in.:

:

.352

.168

.255

MIN RADIUS

:

.643

.578

.474

MEAN RADIUS

:

1.244

1.178

1.095

MAX RADIUS

:

1.724

1.633

1.701

HORIZONTAL SPREAD

:

3.216

3.216

3.010

VERTICAL SPREAD

:

2.286

1.529

1.529

EXTREME SPREAD

:

3.264

3.264

3.027

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

6

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B6

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.195

VS= 2.578

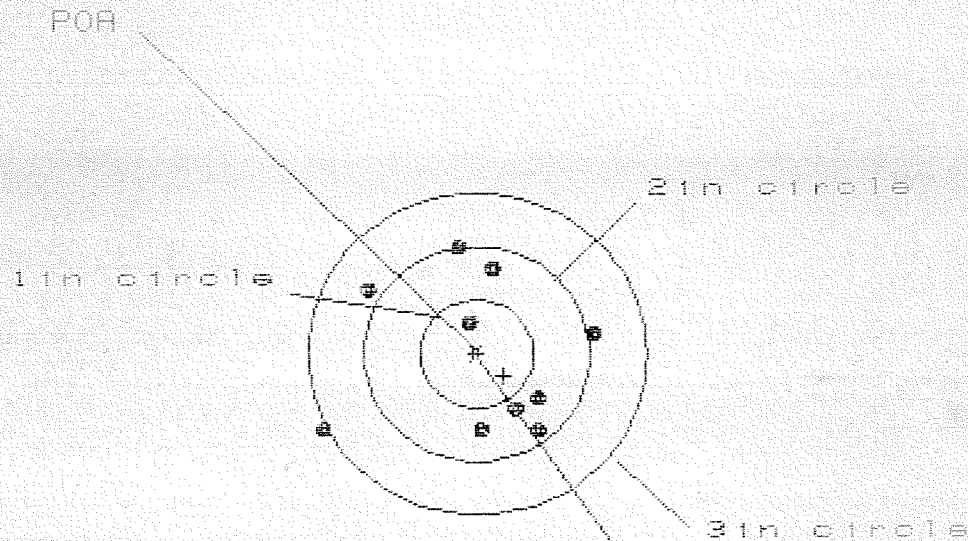
GS= 2.820

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.707	.542	.558
MINIMUM X	:	-1.488	-.686	-.670
MAXIMUM Y	:	1.329	1.234	.869
MINIMUM Y	:	-1.249	-1.344	-1.190
CENTROID X	:	-.055	.110	.094
CENTROID Y	:	-.225	-.130	-.284
POA TO CENTROID in.	:	.231	.171	.299
MIN RADIUS	:	.176	.079	.081
MEAN RADIUS	:	.868	.741	.671
MAX RADIUS	:	1.715	1.361	1.206
HORIZONTAL SPREAD	:	2.195	1.228	1.228
VERTICAL SPREAD	:	2.578	2.578	2.059
EXTREME SPREAD	:	2.820	2.602	2.112
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.444

VS= 1.745

ES= 2.620

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	.989	.743
MINIMUM X	:	-1.399	-1.167	-.460
MAXIMUM Y	:	1.024	.944	1.013
MINIMUM Y	:	-.721	-.770	-.701
CENTROID X	:	-.237	-.082	.064
CENTROID Y	:	.206	.286	.217
POA TO CENTROID in.	:	.315	.298	.226
MIN RADIUS	:	.333	.332	.485
MEAN RADIUS	:	.884	.787	.704
MAX RADIUS	:	1.574	1.293	1.113
HORIZONTAL SPREAD	:	2.444	2.056	1.203
VERTICAL SPREAD	:	1.745	1.714	1.714
EXTREME SPREAD	:	2.620	2.097	1.821
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649266

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.518

VS= 2.413

GS= 3.260

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.494	1.333	.792
MINIMUM X	:	-1.024	-.858	-.692
MAXIMUM Y	:	1.225	1.118	.956
MINIMUM Y	:	-1.188	-1.295	-.876
CENTROID X	:	.280	.114	-.052
CENTROID Y	:	-.133	-.026	.136
POB TO CENTROID in.	:	.310	.117	.146
MIN RADIUS	:	.241	.325	.358
MEAN RADIUS	:	1.009	.924	.802
MAX RADIUS	:	1.779	1.858	1.083
HORIZONTAL SPREAD	:	2.318	2.191	1.484
VERTICAL SPREAD	:	2.413	2.413	1.832
EXTREME SPREAD	:	3.260	3.170	2.089
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		