

C6649292

MODEL 700TH M24

Model **SMS**TH

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

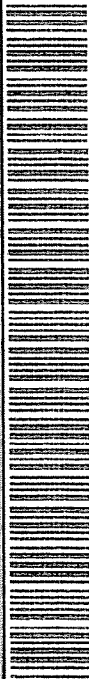
DUPONT
 REG. U.S. PAT. & TM. OFF.

SERIAL NO.
 C6649292

ORDER NO.
 5716

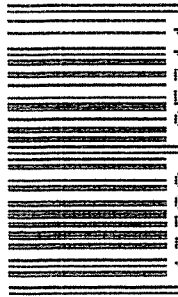
20

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



5716 C6649292

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649292

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7 2 9 1	RW
600	Proof		7 2 9 1	RW
607	Check Headspace		7 2 9 1	RW
610	Dis-assemble Gun		7 2 9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-13-91	HL

op. #	NAME M24 0067405	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-13-91	JL
	G) Safety Off Force	3	3	3			8-13-91	JL
	H) Trigger Pull Test & Retainability						8-13-91	JL
	I) Firing Pin Indent	1022	1022	1022			8-13-91	JL
	J) Assemble Stock						8-15-91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-15-91	RW
	M) Iron Sight Alignment						8-15-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-15-91	RW
	O) Attach Scope to Rifle						8-15-91	RW
	P) Detach & Attach Scope 20 Times						8-15-91	RW
640	Gallery Target & Test						8-15-91	AC
	A) Time						8-15-91	AC
	B) Malfunctions						8-15-91	AC
	C) Pierced Primers						8-15-91	AC
	D) Optical Clarity of Scope						8-15-91	AC
645	Inspect for Live Ammo						8-15-91	AC
655	Final Inspection						8-17-91	D/H
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	230	234	240	248	244	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						8-17-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO C-6649292
DATE 8-13-91
TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.47	2.50	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.49	2.53	2.34	
PULL #3	2.29	2.59	2.50	2.40	
PULL #4	2.32	2.53	2.56	2.48	
PULL #5	2.48	2.55	2.58	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.30		
PULL #2	3.40	3.32		
PULL #3	3.38	3.41		
PULL #4	3.58	3.18		
PULL #5	3.58	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.64	4.37		4.28
PULL #2	4.50	4.28		4.28
PULL #3	4.29	4.26		4.27
PULL #4	4.27	4.28		4.35
PULL #5	4.27	4.27		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649292
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0226716
1 TO	2	.352439
1 TO	3	.103097
1 TO	4	.229787
1 TO	5	.077801

2.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1334
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137566
THE AMR FOR THIS RIFLE IS: .974

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B2

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.177

VS = 1.698

GS = 3.178

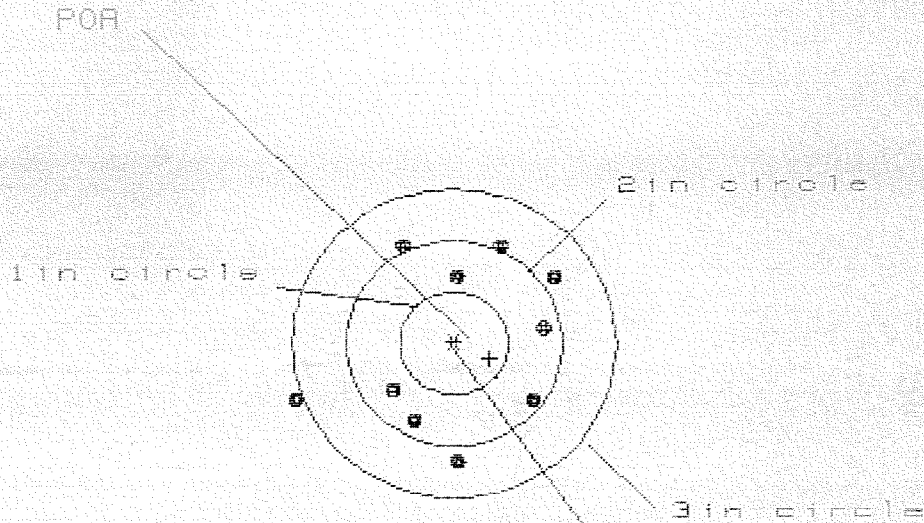
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.518	1.333	.713
MINIMUM X	-1.659	-.944	-.777
MAXIMUM Y	1.144	1.090	1.033
MINIMUM Y	-.554	-.608	-.665
CENTROID X	-.017	.168	.001
CENTROID Y	-.015	.039	.096
POA TO CENTROID in.	.022	.172	.096
MIN RADIUS	.413	.417	.499
MEAN RADIUS	.969	.894	.816
MAX RADIUS	1.729	1.408	1.228
HORIZONTAL SPREAD	3.177	2.277	1.490
VERTICAL SPREAD	1.698	1.698	1.698
EXTREME SPREAD	3.178	2.278	2.066
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649292

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.328

VS= 2.117

GS= 2.605

CENTROID #

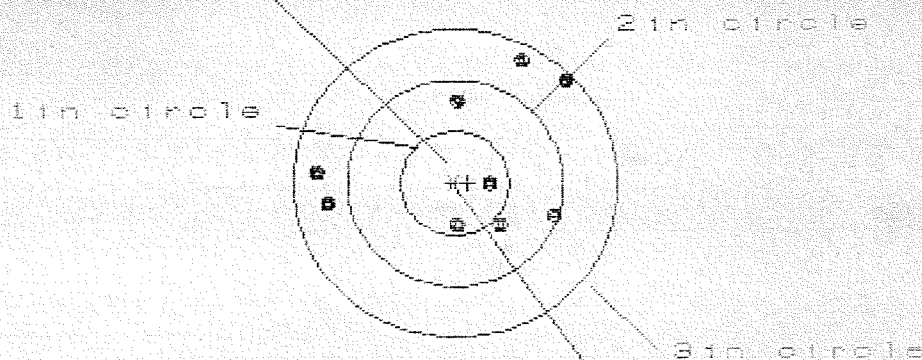
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.880	.723	.781
MINIMUM X	:	-1.445	-.753	-.776
MAXIMUM Y	:	.973	.917	.767
MINIMUM Y	:	-1.144	-1.200	-.929
CENTROID X	:	-.330	-.170	-.147
CENTROID Y	:	.147	.203	.353
POA TO CENTROID in.	:	.361	.265	.383
MIN RADIUS	:	.613	.571	.434
MEAN RADIUS	:	.985	.906	.845
MAX RADIUS	:	1.532	1.213	1.104
HORIZONTAL SPREAD	:	2.328	1.476	1.476
VERTICAL SPREAD	:	2.117	2.117	1.696
EXTREME SPREAD	:	2.605	2.159	1.909
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

FILE: \PATTERNING\CENTERFIRE_PATT\086498292

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.241

VS = 2.995

GS = 3.325

CENTROID *

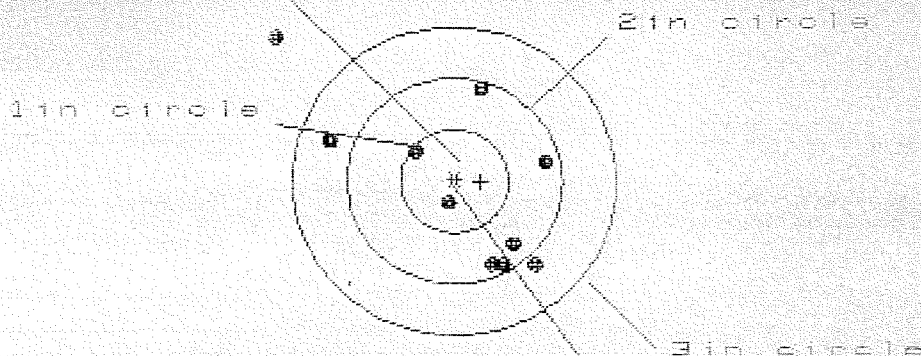
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.969	.985	.938
MINIMUM X	:	-1.272	-1.356	-1.246
MAXIMUM Y	:	1.171	.969	1.070
MINIMUM Y	:	-1.824	-1.626	-1.525
CENTROID X	:	-.119	-.035	-.145
CENTROID Y	:	-.000	.202	.101
POA TO CENTROID in.	:	.119	.205	.177
MIN RADIUS	:	.285	.262	.317
MEAN RADIUS	:	1.020	.904	.862
MAX RADIUS	:	1.976	1.358	1.246
HORIZONTAL SPREAD	:	2.241	2.241	2.184
VERTICAL SPREAD	:	2.995	1.595	1.595
EXTREME SPREAD	:	3.325	2.436	2.233
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849292

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.486

VS= 2.217

GS= 3.188

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.873	.693	.522
MINIMUM X	-1.613	-1.371	-.753
MAXIMUM Y	1.364	1.071	1.145
MINIMUM Y	-.853	-.702	-.628
CENTROID X	-.246	-.066	.105
CENTROID Y	.004	-.147	-.221
POA TO CENTROID in.	.246	.162	.244
MIN RADIUS	.187	.212	.383
MEAN RADIUS	.968	.797	.683
MAX RADIUS	2.113	1.490	1.149
HORIZONTAL SPREAD	2.486	2.064	1.275
VERTICAL SPREAD	2.217	1.773	1.773
EXTREME SPREAD	3.188	2.290	1.782
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649292

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.352

VS = 2.096

GS = 2.423

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.029	.949	.798
MINIMUM X	-1.323	-1.209	-.861
MAXIMUM Y	1.045	.946	.894
MINIMUM Y	-1.051	-1.150	-1.202
CENTROID X	.045	-.069	.082
CENTROID Y	.032	.131	.183
POB TO CENTROID in.	.055	.143	.200
MIN RADIUS	.339	.329	.188
MEAN RADIUS	.928	.872	.777
MAX RADIUS	1.363	1.324	1.448
HORIZONTAL SPREAD	2.352	2.158	1.659
VERTICAL SPREAD	2.096	2.096	2.096
EXTREME SPREAD	2.423	2.321	2.261
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		