

C6611411

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

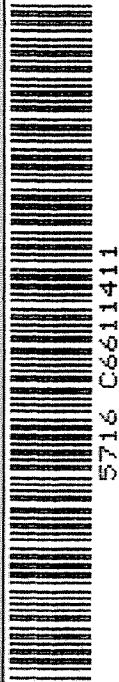
Capacity

Order No. **5715**

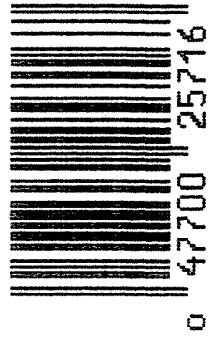
*Includes 1 in chamber.

Remington

Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM M24		SERIAL NO. C6611411	ORDER NO. 5716
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	



UPC



GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611411

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1		KR
	Magnaflux Bolt	1 25		KR
615	Rollmark Caliber	1 25	91	LS
617	Drill and Tap Sight Holes	1 30	91	LS
618	Polish Barrel <i>Rob.B</i>	1 30	91	LS
620	Apply Coatings (Barrel Action)		2-10-91	JK
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	JK

op. #	BARBER M24 0076398	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/18/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/18/91	WB
	H) Trigger Pull Test & Retainability						2/18/91	WB
	I) Firing Pin Indent	.0235	.023	.023			2/18/91	WB
	J) Assemble Stock						2/18/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	RW
	M) Iron Sight Alignment						2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	RW
	O) Attach Scope to Rifle						2/18/91	RW
	P) Detach & Attach Scope 20 Times						2/18/91	RW
640	Gallery Target & Test						2-19-91	AC
	A) Time						2-19-91	AC
	B) Malfunctions						2-19-91	AC
	C) Pierced Primers						2-19-91	AC
	D) Optical Clarity of Scope						2-19-91	AC
645	Inspect for Live Ammo						2-19-91	AC
655	Final Inspection							
	A) Headspace						2-25-91	R
	B) Trigger Pull	2.50	2.13	2.37	2.19	2.20	2/21/91	JP
	C) Function						2-25-91	R
660	Pack						3-19-91	VF

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

SERIAL NO. C 6611411DATE 2/18/91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.44	2.38	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.46	2.21	2.13	
PULL #3	2.37	2.43	2.33	2.37	
PULL #4	2.40	2.40	2.32	2.19	
PULL #5	2.40	2.40	2.40	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.39		
PULL #2	3.51	3.16		
PULL #3	3.26	3.20		
PULL #4	3.24	3.24		
PULL #5	3.28	3.16		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.41		4.47
PULL #2	4.14	4.41		4.24
PULL #3	4.25	4.29		4.22
PULL #4	4.45	4.45		4.23
PULL #5	4.51	4.29		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611411
13 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.463728
1 TO 2	.281503
1 TO 3	.163518
1 TO 4	.235733
1 TO 5	.920568

121 (---) POA
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .201
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .23744

THE AMR FOR THIS RIFLE IS: .979

19 Feb 1993

FILE: PATTERNING/CENTERFIRE_PATT/C8511411

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.592

VS= 3.259

GS= 3.275

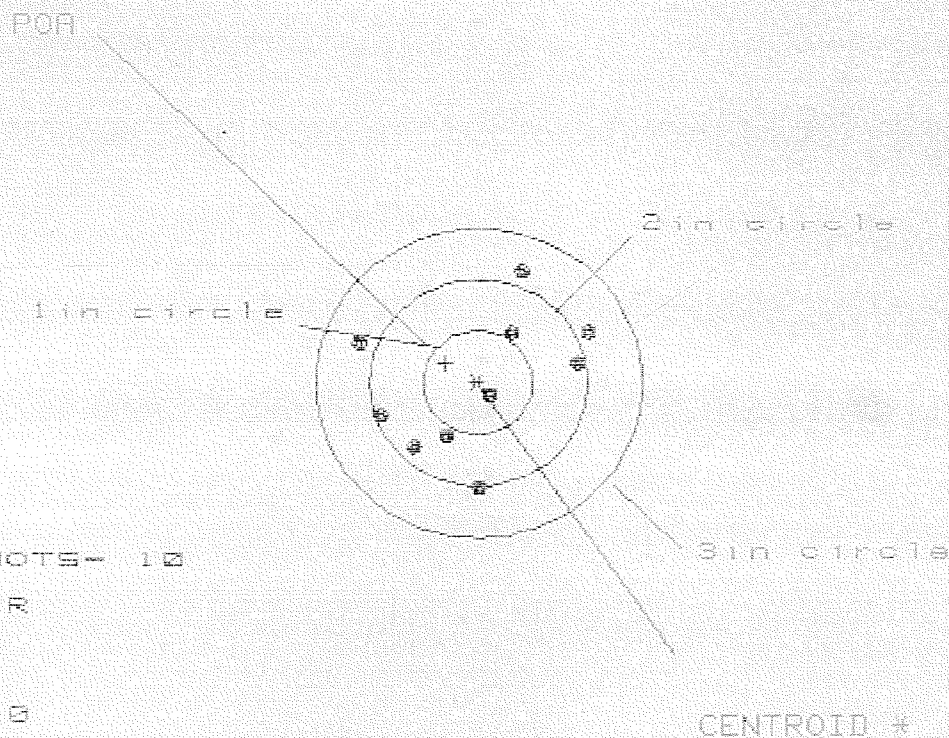
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.929	.618	.589
MINIMUM X	-.663	-.448	-.477
MAXIMUM Y	1.541	1.579	1.369
MINIMUM Y	-1.718	-1.680	-1.426
CENTROID X	.462	.247	.276
CENTROID Y	.040	.002	.212
POA TO CENTROID in.	.463	.247	.348
MIN RADIUS	.329	.282	.110
MEAN RADIUS	1.033	.915	.799
MAX RADIUS	1.959	1.696	1.504
HORIZONTAL SPREAD	2.592	1.066	1.066
VERTICAL SPREAD	3.259	3.259	2.798
EXTREME SPREAD	3.275	3.275	2.846
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511411

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.118

VS= 2.072

GS= 2.121

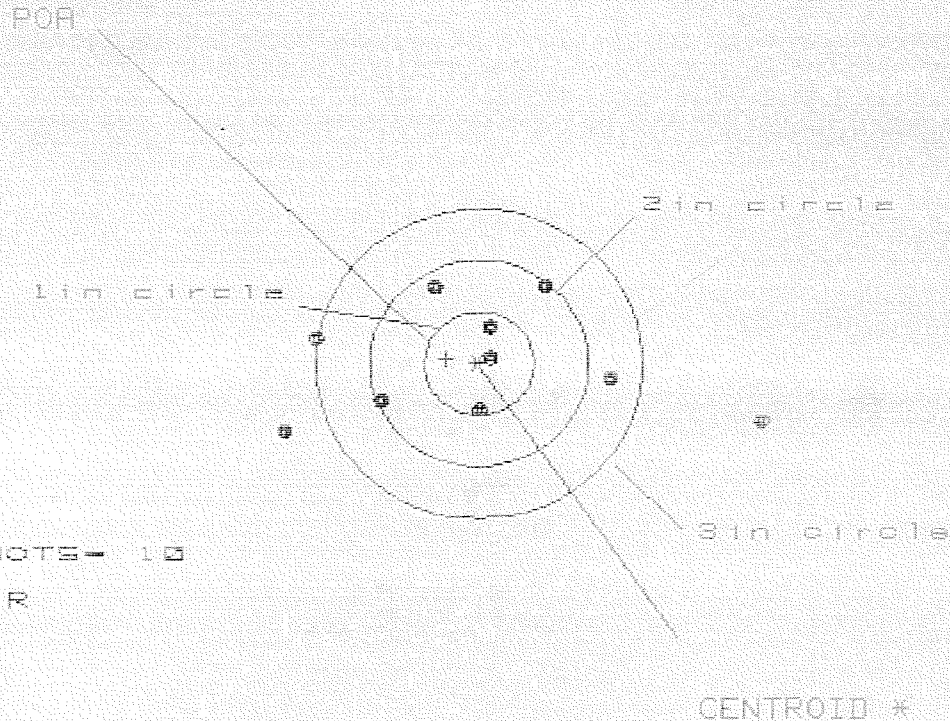
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.032	.912	.943
MINIMUM X	-1.036	-.986	-.955
MAXIMUM Y	1.082	1.124	.672
MINIMUM Y	-.990	-.948	-.807
CENTROID X	.294	.414	.383
CENTROID Y	-.186	-.228	-.369
POB TO CENTROID in.	.340	.473	.532
MIN RADIUS	.181	.064	.107
MEAN RADIUS	.844	.791	.737
MAX RADIUS	1.149	1.152	1.158
HORIZONTAL SPREAD	2.118	1.898	1.898
VERTICAL SPREAD	2.072	2.072	1.479
EXTREME SPREAD	2.121	2.096	2.050
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C661141

CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 4.426

VS = 1.437

GS = 4.426

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.623	1.537	1.348
MINIMUM X	-1.803	-1.512	-1.386
MAXIMUM Y	.793	.738	.650
MINIMUM Y	-.643	-.699	-.636
CENTROID X	.299	.008	.197
CENTROID Y	-.053	.003	.091
POA TO CENTROID in.	.304	.008	.217
MIN RADIUS	.128	.392	.212
MEAN RADIUS	1.109	.937	.803
MAX RADIUS	2.670	1.666	1.387
HORIZONTAL SPREAD	4.426	3.049	2.734
VERTICAL SPREAD	1.437	1.437	1.286
EXTREME SPREAD	4.426	3.085	2.760
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

13 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11411

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 2.551

VS= 2.242

GS= 3.396

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.724	.977	.898
MINIMUM X	-.827	-.636	-.636
MAXIMUM Y	.843	.872	.708
MINIMUM Y	-1.399	-1.305	-.836
CENTROID X	.249	.058	.137
CENTROID Y	-.061	-.155	.009
POA TO CENTROID in.	.256	.165	.137
MIN RADIUS	.329	.416	.309
MEAN RADIUS	.914	.785	.692
MAX RADIUS	1.919	1.452	.996
HORIZONTAL SPREAD	2.551	1.613	1.536
VERTICAL SPREAD	2.242	2.177	1.544
EXTREME SPREAD	3.396	2.492	1.614
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

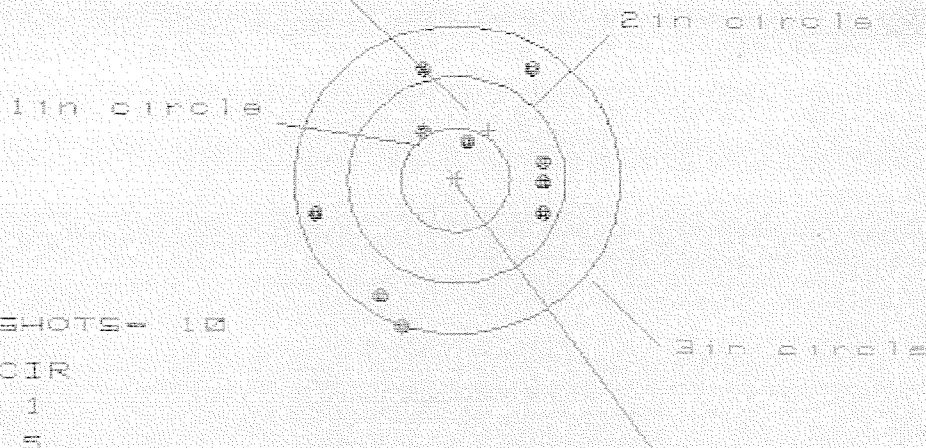
8 Feb 1993

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11411

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.137

VS= 2.506

GS= 2.724

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.799	.749	.574
MINIMUM X	-1.338	-1.389	-.884
MAXIMUM Y	1.103	.947	.884
MINIMUM Y	-1.403	-1.275	-1.338
CENTROID X	-.299	-.248	-.874
CENTROID Y	-.478	-.322	-.259
POA TO CENTROID in.	.564	.406	.270
MIN RADIUS	.373	.211	.207
MEAN RADIUS	.995	.901	.794
MAX RADIUS	1.478	1.477	1.603
HORIZONTAL SPREAD	2.137	2.137	1.458
VERTICAL SPREAD	2.506	2.222	2.222
EXTREME SPREAD	2.724	2.563	2.563
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		