

C6611413

MODEL 700TM M24

Model SMSTM

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.
C6611413

ORDER NO.
5716

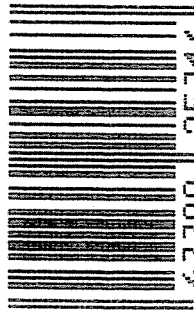
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off; Marca Registrada Marque Deposee.

46



5716 C6611413

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611413

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	KR
615	Rollmark Caliber		APR 2 1991	LS
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	LB
620	Apply Coatings (Barrel Action)		4-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	KS
	C) Inspect Ejector Hole for Chamfer		4/12/91	KS
	D) Oil Firing Pin Ass'y		4/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	KS

op. #	BARBER - M24 0076420 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/12/91	WB
	G) Safety Off Force	2	2	2			4/12/91	WB
	H) Trigger Pull Test & Retainability						4/12/91	JH
	I) Firing Pin Indent	.024	.0235	.0235			4/12/91	WB
	J) Assemble Stock						4/14/91	KS
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/14/91	KS
	M) Iron Sight Alignment						4/12/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	KS
	O) Attach Scope to Rifle						4/12/91	KS
	P) Detach & Attach Scope 20 Times						4/12/91	KS
640	Gallery Target & Test						4-15-91	DH
	A) Time						4-15-91	DH
	B) Malfunctions						4-15-91	DH
	C) Pierced Primers						4-15-91	DH
	D) Optical Clarity of Scope						4-15-91	DH
645	Inspect for Live Ammo						4-15-91	DH
655	Final Inspection A) Headspace						4-17-91	A
	B) Trigger Pull	2.54	2.55	2.60	2.62	2.60	4/16/91	JH
	C) Function						4-17-91	A
660	Pack						6-18-91	NF

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

SERIAL NO. 06611413

DATE 4/12/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.15	2.45	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.13	2.33	2.55	
PULL #3	2.52	2.18	2.46	2.60	
PULL #4	2.24	2.19	2.46	2.62	
PULL #5	2.20	2.16	2.43	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.41		
PULL #2	3.57	3.44		
PULL #3	3.33	3.45		
PULL #4	3.39	3.45		
PULL #5	3.47	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.30		4.32
PULL #2	4.35	4.44		4.28
PULL #3	4.37	4.43		4.32
PULL #4	4.40	4.45		4.33
PULL #5	4.41	4.44		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611413
15 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.126016
1 TO	2	.137437
1 TO	3	.113217
1 TO	4	.120507
1 TO	5	.362229

5# <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0079
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0117593
THE AMR FOR THIS RIFLE IS: .7662

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611413

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.954

VS= 1.960

GS= 2.225

CENTROID #

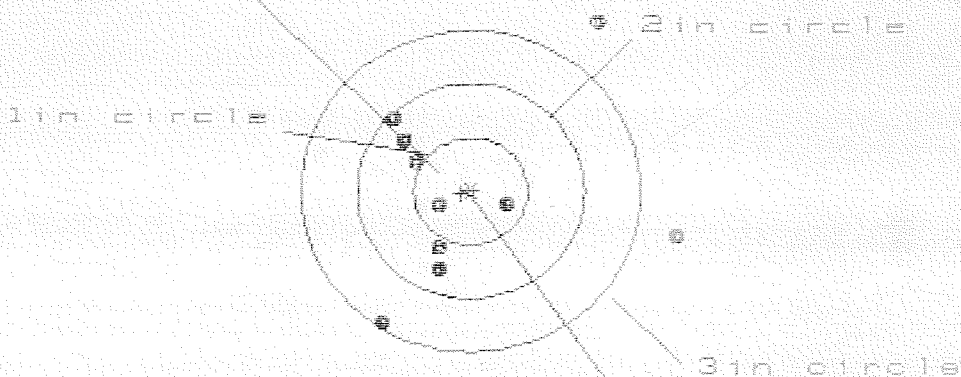
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.991	.884	.854
MINIMUM X	-.963	-.546	-.576
MAXIMUM Y	.865	.780	.632
MINIMUM Y	-1.095	-1.180	-1.074
CENTROID X	-.002	.105	.135
CENTROID Y	.126	.210	.358
POA TO CENTROID in.	.126	.235	.382
MIN RADIUS	.200	.250	.285
MEAN RADIUS	.823	.769	.689
MAX RADIUS	1.229	1.205	1.142
HORIZONTAL SPREAD	1.954	1.430	1.430
VERTICAL SPREAD	1.960	1.960	1.706
EXTREME SPREAD	2.225	1.970	1.790
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11413

CENTERFIRE PATTERNS # 2

POR



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.534

VS= 2.821

GS= 3.376

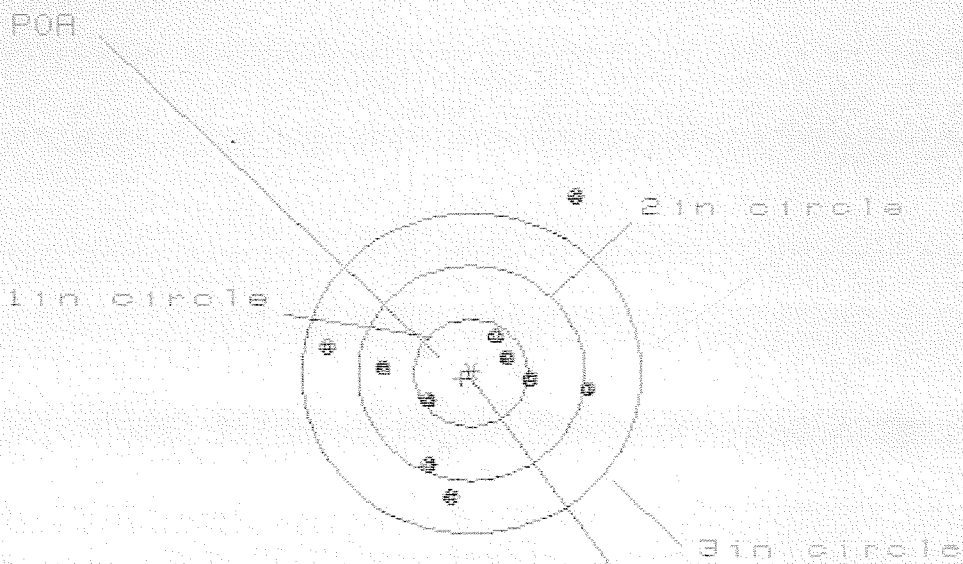
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.775	1.897	.720
MINIMUM X	-.759	-.637	-.400
MAXIMUM Y	1.581	.903	.869
MINIMUM Y	-1.240	-1.064	-1.098
CENTROID X	.083	-.039	-.276
CENTROID Y	.018	-.158	-.124
POR TO CENTROID in.	.084	.163	.303
MIN RADIUS	.325	.172	.068
MEAN RADIUS	.950	.796	.620
MAX RADIUS	1.924	1.917	1.169
HORIZONTAL SPREAD	2.534	2.534	1.120
VERTICAL SPREAD	2.821	1.967	1.967
EXTREME SPREAD	3.376	2.685	1.971
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611413

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.323

VS= 2.790

GS= 3.014

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	1.165	1.020
MINIMUM X	-1.260	-1.158	-.823
MAXIMUM Y	1.615	.561	.615
MINIMUM Y	-1.175	-.995	-.941
CENTROID X	.081	-.021	.123
CENTROID Y	.049	-.131	-.185
POA TO CENTROID in.	.094	.132	.223
MIN RADIUS	.347	.320	.452
MEAN RADIUS	.893	.776	.714
MAX RADIUS	1.858	1.237	1.023
HORIZONTAL SPREAD	2.323	2.323	1.843
VERTICAL SPREAD	2.790	1.556	1.556
EXTREME SPREAD	3.014	2.360	1.853
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611413

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

CENTROID *

HS= 1.494

VS= 1.980

GS= 2.120

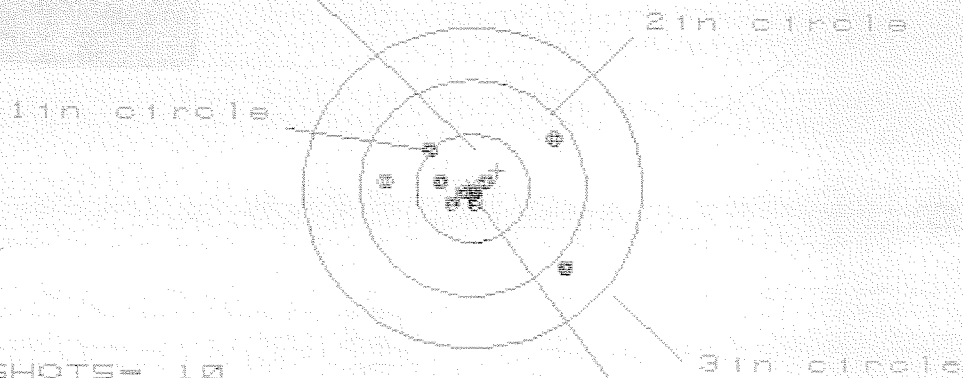
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.638	.574	.558
MINIMUM X	-.856	-.920	-.936
MAXIMUM Y	1.178	1.015	.585
MINIMUM Y	-.802	-.671	-.545
CENTROID X	.017	.081	.097
CENTROID Y	.007	-.124	-.250
POA TO CENTROID in.	.018	.148	.268
MIN RADIUS	.375	.256	.226
MEAN RADIUS	.721	.627	.560
MAX RADIUS	1.312	1.022	.937
HORIZONTAL SPREAD	1.494	1.494	1.494
VERTICAL SPREAD	1.980	1.686	1.130
EXTREME SPREAD	2.120	1.703	1.498
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611413

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 6

2in = 9

3in = 10

HS= 1.655

VS= 1.224

GS= 1.854

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.841	.856	.299
MINIMUM X	-.814	-.721	-.614
MAXIMUM Y	.461	.376	.321
MINIMUM Y	-.763	-.265	-.218
CENTROID X	-.223	-.316	-.423
CENTROID Y	-.161	-.076	-.123
POA TO CENTROID in.	.275	.325	.441
MIN RADIUS	.072	.095	.085
MEAN RADIUS	.444	.364	.282
MAX RADIUS	1.136	.935	.615
HORIZONTAL SPREAD	1.655	1.577	.913
VERTICAL SPREAD	1.224	.641	.539
EXTREME SPREAD	1.854	1.624	.914
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		