

C6611439

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

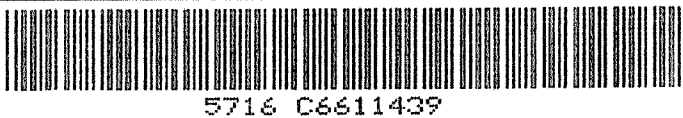
Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6611439
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611439

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		"
615	Rollmark Caliber	3 28 91		LS
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-14-91	TA

op. #	BARBER - M24 0076874	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-15-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5-15-91	DH
	H) Trigger Pull Test & Retainability						5/14/91	JH
	I) Firing Pin Indent	.021	.021	.021			5-15-91	DH
	J) Assemble Stock						5/15/91	RW
	K) Assemble Swivel Studs						5-20-91	AC
	L) Attach Front and Rear Sight Assemblies						5/15/91	RW
	M) Iron Sight Alignment						5/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/91	RW
	O) Attach Scope to Rifle						5/15/91	RW
	P) Detach & Attach Scope 20 Times						5/15/91	RW
640	Gallery Target & Test						5-15-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-15-91	NF
655	Final Inspection							
	A) Headspace						5-20-91	AC
	B) Trigger Pull	2.16	2.14	2.12	2.14	2.12	5/20/91	JH
	C) Function						5-20-91	AC
660	Pack						6-19-91	NF

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

SERIAL NO. _____

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.26	2.18	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.21	2.22	2.14	
PULL #3	2.24	2.23	2.20	2.12	
PULL #4	2.14	2.15	2.20	2.14	
PULL #5	2.20	2.19	2.19	2.12	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.46		
PULL #2	3.44	3.42		
PULL #3	3.36	3.42		
PULL #4	3.36	3.44		
PULL #5	3.48	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.40		4.58
PULL #2	4.41	4.40		4.45
PULL #3	4.41	4.56		4.48
PULL #4	4.41	4.60		4.38
PULL #5	4.49	4.50		4.42
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611439
24 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0926607
1 TO	2	.13448
1 TO	3	.202872
1 TO	4	.492311
1 TO	5	.445917

4 5 (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.079
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.227
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240354
THE AMR FOR THIS RIFLE IS: .8432

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611439.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.026

VS = 1.988

GS = 2.507

PATTERN #

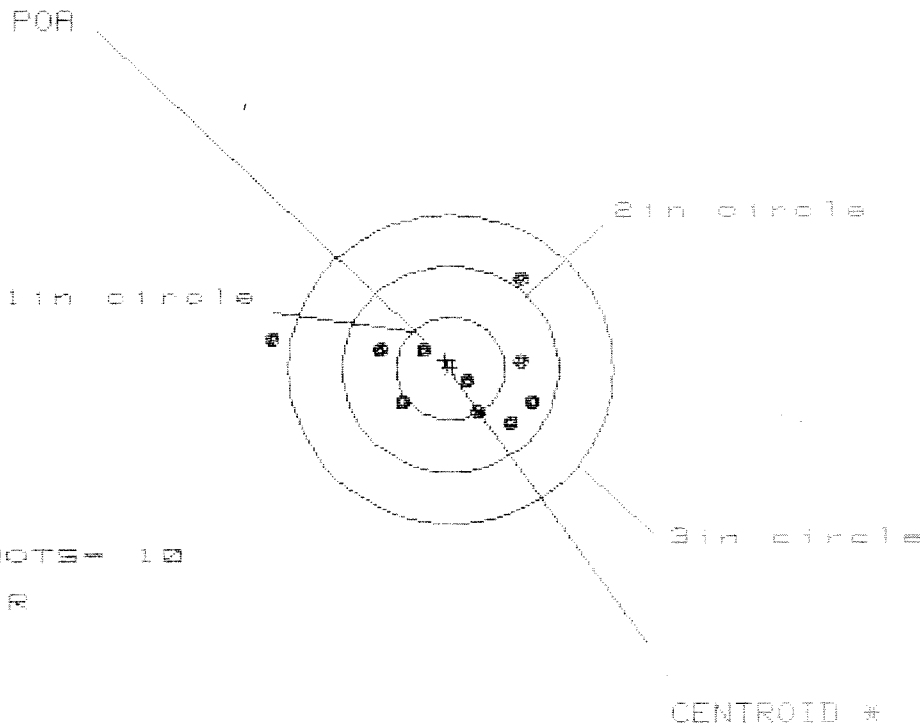
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.150	1.265	.763
MINIMUM X	:	-.875	-.761	-.603
MAXIMUM Y	:	1.000	.895	.830
MINIMUM Y	:	-.987	-1.093	-1.158
CENTROID X	:	-.081	-.196	-.354
CENTROID Y	:	-.045	.060	.125
POA TO CENTROID in.	:	.093	.205	.375
MIN RADIUS	:	.342	.329	.295
MEAN RADIUS	:	.865	.779	.679
MAX RADIUS	:	1.402	1.365	1.164
HORIZONTAL SPREAD	:	2.026	2.026	1.366
VERTICAL SPREAD	:	1.988	1.988	1.988
EXTREME SPREAD	:	2.507	2.219	1.992
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611439.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 2.405

VS= 1.376

CS= 2.499

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.755	.572	.629
MINIMUM X	-1.650	-.781	-.724
MAXIMUM Y	.901	.936	.360
MINIMUM Y	-.475	-.440	-.323
CENTROID X	.048	.231	.174
CENTROID Y	-.093	-.118	-.235
POA TO CENTROID in.	.096	.259	.292
MIN RADIUS	.168	.070	.063
MEAN RADIUS	.715	.579	.505
MAX RADIUS	1.679	1.042	.808
HORIZONTAL SPREAD	2.405	1.353	1.353
VERTICAL SPREAD	1.376	1.376	.683
EXTREME SPREAD	2.499	1.611	1.459
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611439.1

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.241

VS = 2.293

GS = 3.055

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.003	1.090	.946
MINIMUM X	-1.238	-1.151	-.756
MAXIMUM Y	1.371	1.256	1.159
MINIMUM Y	-.922	-.769	-.747
CENTROID X	-.162	-.249	-.105
CENTROID Y	-.231	-.384	-.287
POA TO CENTROID in.	.282	.457	.306
MIN RADIUS	.301	.307	.301
MEAN RADIUS	.958	.883	.812
MAX RADIUS	1.578	1.385	1.215
HORIZONTAL SPREAD	2.241	2.241	1.702
VERTICAL SPREAD	2.293	2.025	1.906
EXTREME SPREAD	3.055	2.253	2.218
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C08B11439.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.992

VS = 1.298

GS = 2.375

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.952	.837	.691
MINIMUM X	-1.040	-.989	-.885
MAXIMUM Y	.364	.260	.292
MINIMUM Y	-.934	-.695	-.663
CENTROID X	-.420	-.305	-.410
CENTROID Y	-.402	-.298	-.330
POA TO CENTROID in.	.582	.426	.526
MIN RADIUS	.187	.110	.149
MEAN RADIUS	.628	.514	.470
MAX RADIUS	1.398	1.023	.931
HORIZONTAL SPREAD	1.992	1.026	1.575
VERTICAL SPREAD	1.298	.955	.955
EXTREME SPREAD	2.375	1.826	1.584
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611439.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.744

VS= 2.822

GS= 3.187

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.163	1.254	1.068
MINIMUM X	-1.581	-1.490	-.949
MAXIMUM Y	1.125	.936	.962
MINIMUM Y	-1.697	-.868	-.842
CENTROID X	.220	.129	.315
CENTROID Y	-.374	-.185	-.211
POA TO CENTROID in.	.434	.226	.379
MIN RADIUS	.490	.615	.427
MEAN RADIUS	1.050	.949	.855
MAX RADIUS	1.886	1.504	1.288
HORIZONTAL SPREAD	2.744	2.744	2.017
VERTICAL SPREAD	2.822	1.804	1.804
EXTREME SPREAD	3.187	2.905	2.463
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611439
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.178639
1 TO	2	.160851
1 TO	3	.273386
1 TO	4	.333098
1 TO	5	.186625

4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1182
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0678
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136265
THE AMR FOR THIS RIFLE IS: 1.047

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811438

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 1.947

VS = 3.811

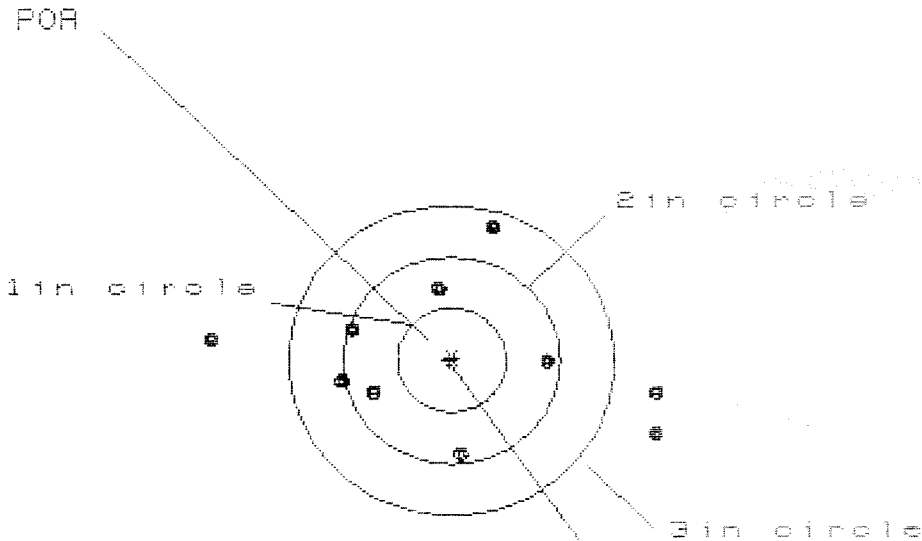
GS = 3.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.935	1.020	.989
MINIMUM X	-1.012	-.927	-.958
MAXIMUM Y	1.728	1.497	1.165
MINIMUM Y	-2.083	-1.316	-1.129
CENTROID X	.166	.081	.112
CENTROID Y	.066	.297	.110
POA TO CENTROID in.	.179	.308	.157
MIN RADIUS	.438	.220	.369
MEAN RADIUS	1.198	1.067	1.000
MAX RADIUS	2.221	1.518	1.508
HORIZONTAL SPREAD	1.947	1.947	1.947
VERTICAL SPREAD	3.811	2.813	2.294
EXTREME SPREAD	3.968	2.859	2.579
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611439

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 7

HS = 4.066

VS = 2.263

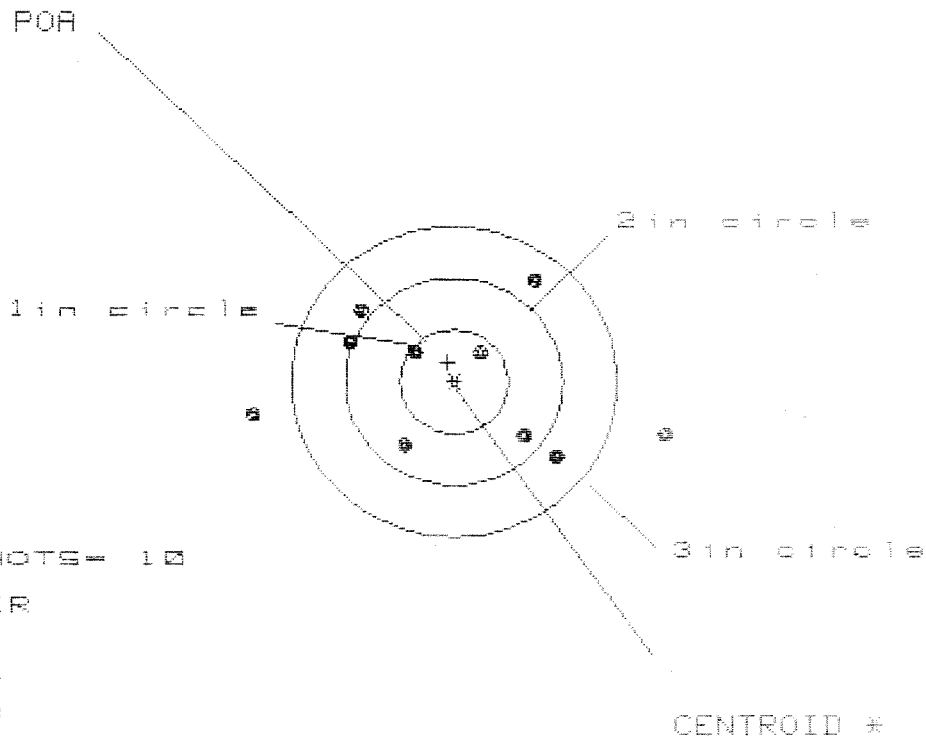
GS = 4.128

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.875	1.631	1.831
MINIMUM X	-2.191	-1.287	-1.087
MAXIMUM Y	1.319	1.339	1.256
MINIMUM Y	-0.944	-0.924	-1.007
CENTROID X	.018	.262	.062
CENTROID Y	.003	-.017	.067
POA TO CENTROID in.	.019	.262	.091
MIN RADIUS	.715	.596	.661
MEAN RADIUS	1.276	1.178	1.076
MAX RADIUS	2.199	1.734	1.870
HORIZONTAL SPREAD	4.066	2.918	2.918
VERTICAL SPREAD	2.263	2.263	2.263
EXTREME SPREAD	4.128	2.944	2.922
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	7	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611439

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 3.784

VS = 1.731

GS = 3.789

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.911	1.200	.992
MINIMUM X	-1.873	-1.660	-.965
MAXIMUM Y	1.024	.965	.915
MINIMUM Y	-.707	-.766	-.816
CENTROID X	.060	-.153	.055
CENTROID Y	-.186	-.127	-.077
POA TO CENTROID in.	.196	.199	.095
MIN RADIUS	.364	.318	.298
MEAN RADIUS	1.098	.978	.873
MAX RADIUS	1.984	1.700	1.284
HORIZONTAL SPREAD	3.784	2.860	1.957
VERTICAL SPREAD	1.731	1.731	1.731
EXTREME SPREAD	3.789	2.912	2.303
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611439

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.740

VS= 3.071

GS= 3.420

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.849	.608	.629
MINIMUM X	-.891	-.685	-.653
MAXIMUM Y	1.088	.982	.720
MINIMUM Y	-1.983	-2.089	-.619
CENTROID X	.351	.145	.123
CENTROID Y	-.211	-.105	.157
POA TO CENTROID in.	.409	.179	.199
MIN RADIUS	.036	.136	.131
MEAN RADIUS	.891	.735	.534
MAX RADIUS	2.083	2.096	.979
HORIZONTAL SPREAD	2.740	1.293	1.293
VERTICAL SPREAD	3.071	3.071	1.339
EXTREME SPREAD	3.420	3.189	1.668
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611439

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.857

VS= 2.116

GS= 2.931

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.182

.996

.264

MINIMUM X

-1.675

-.509

-.384

MAXIMUM Y

1.305

1.302

1.217

MINIMUM Y

-.811

-.814

-.899

CENTROID X

-.004

.182

.057

CENTROID Y

-.011

-.008

.077

POA TO CENTROID in.

.012

.182

.096

MIN RADIUS

.267

.140

.275

MEAN RADIUS

.771

.648

.585

MAX RADIUS

1.675

1.305

1.217

HORIZONTAL SPREAD

2.857

1.505

.648

VERTICAL SPREAD

2.116

2.116

2.116

EXTREME SPREAD

2.931

2.261

2.117

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9