

C6611452

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

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

46

SERIAL NO.
C6611452

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611452**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	LL
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/29/91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/29/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/29/91	KS
	C) Inspect Ejector Hole for Chamfer		4/29/91	KS
	D) Oil Firing Pin Ass'y		4/29/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/91	981

op. #	BARBER - M24 0077106	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/7/91	SH
	G) Safety Off Force	3	3	3			5/7/91	SH
	H) Trigger Pull Test & Retainability						5/7/91	SH
	I) Firing Pin Indent	.0205	.0215	.0215			5/7/91	SH
	J) Assemble Stock						5/7/91	ICS
	K) Assemble Swivel Studs						5-9-91	K
	L) Attach Front and Rear Sight Assemblies						5/7/91	ICS
	M) Iron Sight Alignment						5/7/91	ICS
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	ICS
	O) Attach Scope to Rifle						5/7/91	ICS
	P) Detach & Attach Scope 20 Times						5/7/91	ICS
640	Gallery Target & Test						5/8/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/8/91	KT
655	Final Inspection							
	A) Headspace						5-9-91	K
	B) Trigger Pull	2.18	2.15	2.14	2.15	2.15	5/9/91	SH
	C) Function						5-9-91	K
660	Pack						6-17-91	N

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

SERIAL NO.

C-6611452

DATE

5/7/91

TESTER

J. B. Smith (H)

VILLAGE

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET		COMMENTS
PULL #1	2.57	2.40	2.38	2.48	MIN. SETTING,
PULL #2	2.43	2.41	2.45	2.75	NO AVG. OF 5
PULL #3	2.41	2.29	2.49	2.14	READINGS ACCEPT-
PULL #4	2.35	2.38	2.36	2.15	ABLE LESS THAN 2#
PULL #5	2.28	2.46	2.42	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.48	3.31			
PULL #2	3.52	3.33			
PULL #3	3.49	3.33			
PULL #4	3.50	3.32			
PULL #5	3.48	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	4.40	4.31		4.42
PULL #2	4.46	4.34		4.39
PULL #3	4.30	4.36		4.46
PULL #4	4.40	4.41		4.46
PULL #5	4.37	5.50		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611452
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.204443
1 TO	2	.42043
1 TO	3	.484266
1 TO	4	.438292
1 TO	5	.0584123

4
3
2
1
0

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0202
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0230
THE AMR FOR THIS RIFLE IS: 1.025

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611452

CENTERFIRE PATTERNS

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.386

VS = 3.184

GS = 3.162

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	.806	.819	.630
MINIMUM X	-1.520	-1.507	-.689
MAXIMUM Y	1.181	.968	.921
MINIMUM Y	-1.923	-1.085	-1.132
CENTROID X	.126	.113	.302
CENTROID Y	.161	.374	.421
POA TO CENTROID in.	.204	.391	.518
MIN RADIUS	.496	.296	.235
MEAN RADIUS	1.021	.883	.769
MAX RADIUS	1.926	1.553	1.146
HORIZONTAL SPREAD	2.326	2.326	1.319
VERTICAL SPREAD	3.184	2.053	2.053
EXTREME SPREAD	3.162	2.616	2.121
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611452

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.652

VS = 2.944

GS = 3.544

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.122	.963
MINIMUM X	:	-1.408	-1.269	-.817
MAXIMUM Y	:	1.042	.831	.655
MINIMUM Y	:	-1.962	-1.410	-1.321
CENTROID X	:	-.018	-.157	.002
CENTROID Y	:	-.234	-.023	.153
POA TO CENTROID in.	:	.235	.158	.153
MIN RADIUS	:	.573	.417	.399
MEAN RADIUS	:	1.155	.980	.825
MAX RADIUS	:	2.272	1.897	1.353
HORIZONTAL SPREAD	:	2.652	2.391	1.780
VERTICAL SPREAD	:	2.944	2.241	1.976
EXTREME SPREAD	:	3.544	3.110	2.175
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611432

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

ME = 2.052

VS = 1.796

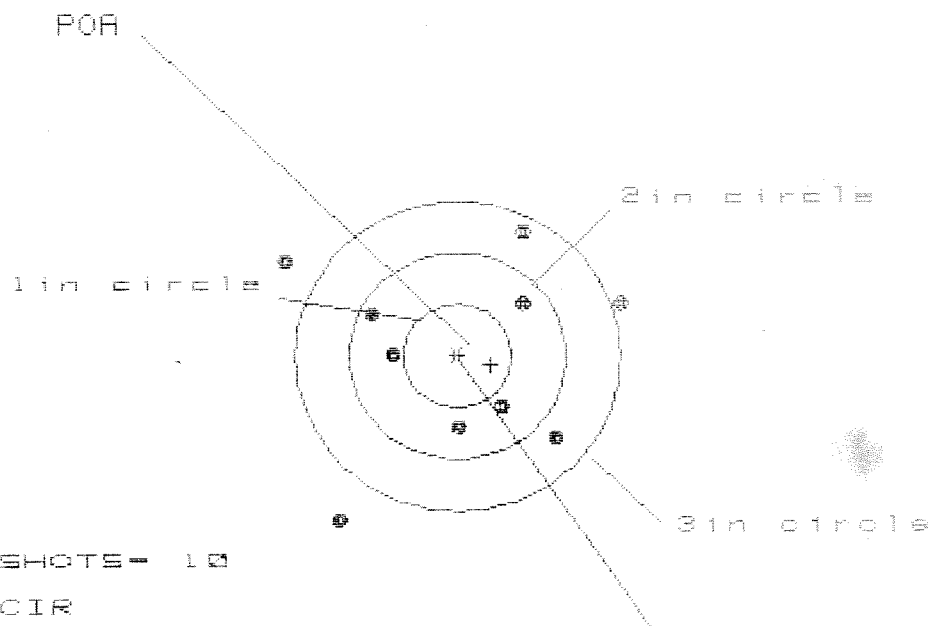
GS = 2.466

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.922	.797	.737
MINIMUM X	:	-1.129	-1.067	-.967
MAXIMUM Y	:	.827	.895	.728
MINIMUM Y	:	-.969	-.901	-.789
CENTROID X	:	.091	.217	.117
CENTROID Y	:	-.322	-.390	-.502
POA TO CENTROID in.	:	.335	.446	.515
MIN RADIUS	:	.229	.093	.144
MEAN RADIUS	:	.712	.626	.547
MAX RADIUS	:	1.285	1.198	1.088
HORIZONTAL SPREAD	:	2.052	1.864	1.704
VERTICAL SPREAD	:	1.796	1.796	1.517
EXTREME SPREAD	:	2.466	2.229	1.863
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS = 3.093

VS = 2.860

GS = 3.354

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.456
MINIMUM X	-1.637
MAXIMUM Y	1.241
MINIMUM Y	-1.619
CENTROID X	-0.386
CENTROID Y	.087
POA TO CENTROID in.	.318
MIN RADIUS	.569
MEAN RADIUS	1.158
MAX RADIUS	1.967
HORIZONTAL SPREAD	3.093
VERTICAL SPREAD	2.860
EXTREME SPREAD	3.354
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	7

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611452

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.400

VS= 3.091

GS= 3.101

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.617	.581	.576
MINIMUM X	-.783	-.603	-.608
MAXIMUM Y	1.466	1.533	1.338
MINIMUM Y	-1.625	-1.558	-1.557
CENTROID X	.162	-.018	-.013
CENTROID Y	.207	.140	.335
POA TO CENTROID in.	.262	.141	.335
MIN RADIUS	.397	.331	.402
MEAN RADIUS	1.078	.983	.897
MAX RADIUS	1.726	1.560	1.660
HORIZONTAL SPREAD	2.400	1.184	1.184
VERTICAL SPREAD	3.091	3.091	2.895
EXTREME SPREAD	3.101	3.101	3.023
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		