

C6611563

MODEL 700TM M24

Model **SMS**

Action TM

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

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

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

MODEL 700TM M24

SERIAL NO.
C6611563

ORDER NO.
5716

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

20



5716 C6611563

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611563

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KS
600	Proof		2/1/91	KS
607	Check Headspace		2/1/91	KS
610	Dis-assemble Gun		2/1/91	KS
612	Magnaflux Barrel Action	2 11 91		KCR
	Magnaflux Bolt	2 11 91		KCR
615	Rollmark Caliber	2 11 91		GS
617	Drill and Tap Sight Holes	2 13 91		WB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2/2/91	KS
	Apply Coating (Bolt)			KS
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/2/91	KS

op. #	BARBER - M24 0078901 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{1}{2}$	4 $\frac{1}{2}$			4-2-91	DH
	G) Safety Off Force	2 $\frac{1}{4}$	2	2			4-2-91	DH
	H) Trigger Pull Test & Retainability						4/2/91	JH
	I) Firing Pin Indent	.020	.020	.020			4-2-91	DH
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						4-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-5-91	NF
655	Final Inspection							
	A) Headspace						4-10-91	DH
	B) Trigger Pull	2.55	2.60	2.65	2.66	2.64	4/10/91	JH
	C) Function						4-10-91	DH
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611563

DATE 4/2/81

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.44	2.40	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.46	2.38	2.60	
PULL #3	2.41	2.46	2.35	2.65	
PULL #4	2.41	2.41	2.44	2.66	
PULL #5	2.33	2.41	2.42	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.28	3.33		
PULL #3	3.13	3.35		
PULL #4	3.39	3.44		
PULL #5	3.25	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.50		4.29
PULL #2	4.28	4.22		4.27
PULL #3	4.26	4.40		4.37
PULL #4	4.26	4.25		4.25
PULL #5	4.27	4.27		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611563
5 Apr 1991

CENTROIDAL DISTANCES

0	TO	1	.180953
1	TO	2	.302539
1	TO	3	.172073
1	TO	4	.155206
1	TO	5	.0518845

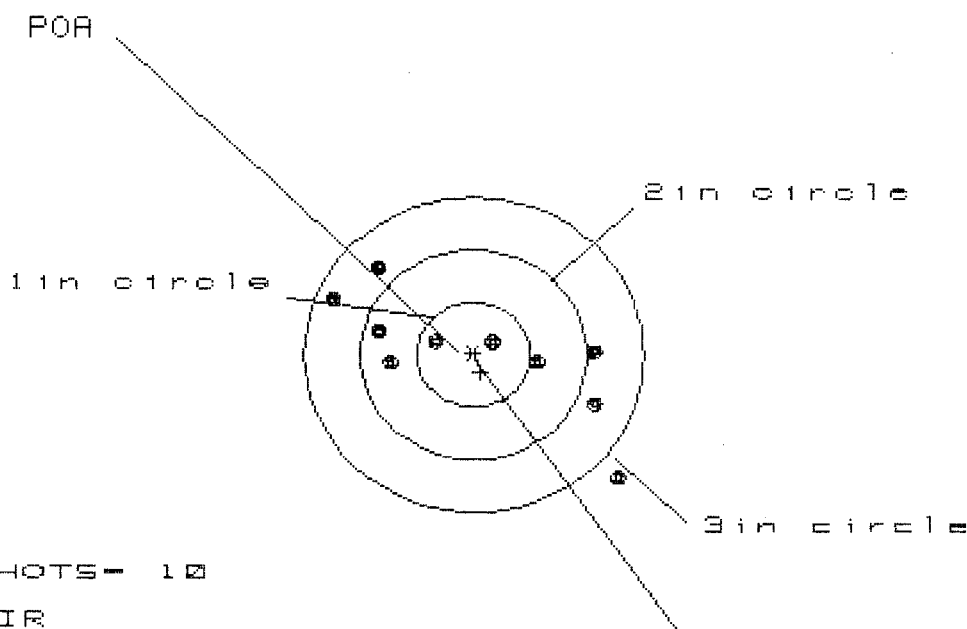
45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0866
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142685
THE AMR FOR THIS RIFLE IS: .7858

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611563

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.567

VS= 2.041

GS= 3.115

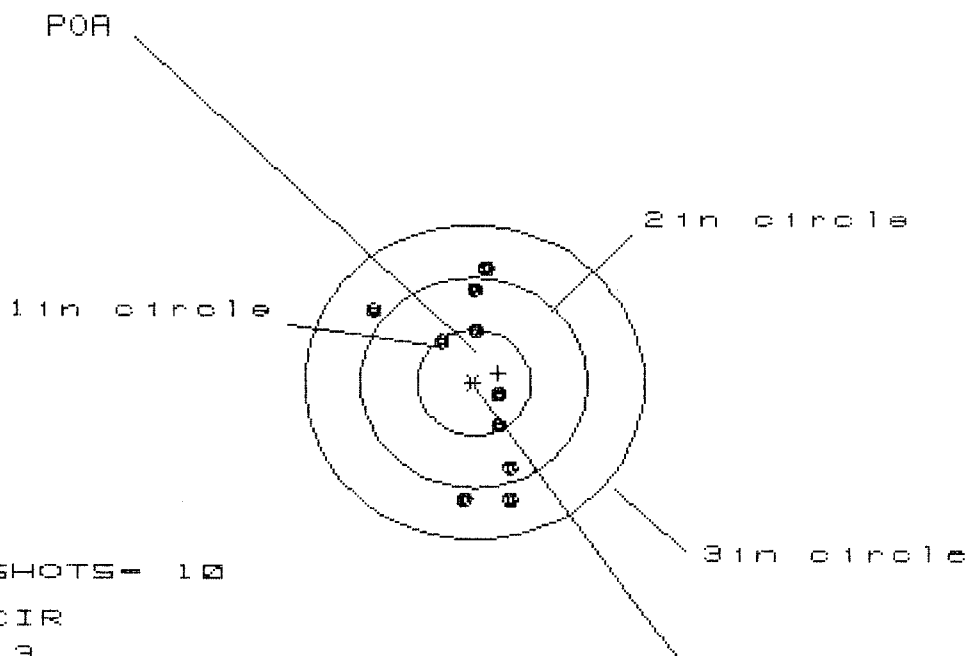
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.301	1.205	1.065
MINIMUM X	-1.266	-1.122	-.860
MAXIMUM Y	.841	.707	.761
MINIMUM Y	-1.200	-.614	-.560
CENTROID X	-.062	-.206	-.066
CENTROID Y	.170	.303	.249
POA TO CENTROID in.	.180	.366	.258
MIN RADIUS	.173	.220	.133
MEAN RADIUS	.927	.810	.757
MAX RADIUS	1.770	1.353	1.203
HORIZONTAL SPREAD	2.567	2.327	1.925
VERTICAL SPREAD	2.041	1.321	1.321
EXTREME SPREAD	3.115	2.551	2.335
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.205

VS = 2.156

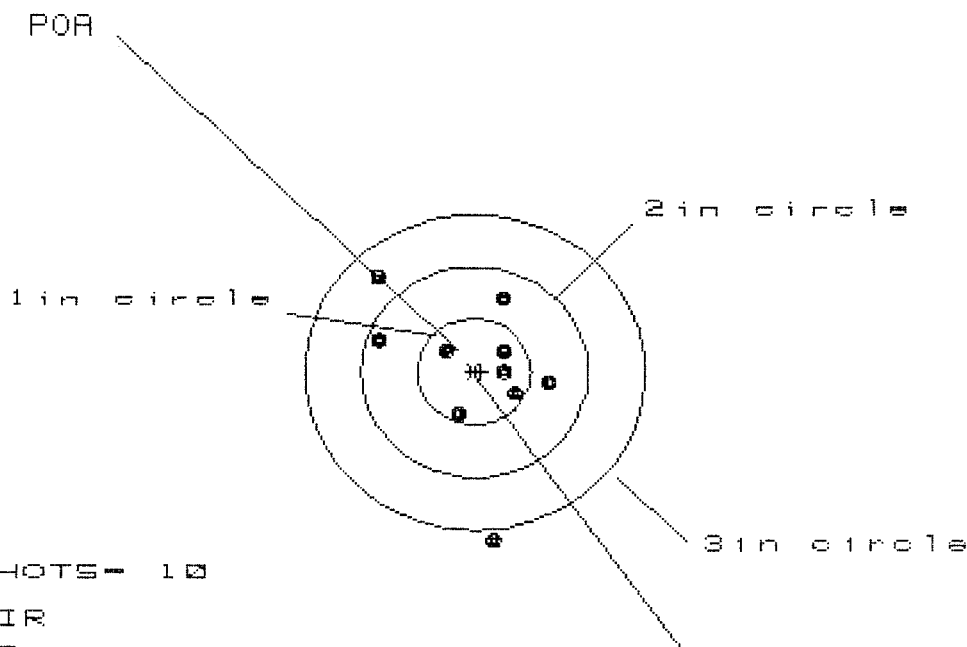
GS = 2.198

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.362	.322	.221
MINIMUM X	:	-.844	-.804	-.368
MAXIMUM Y	:	1.049	.926	1.002
MINIMUM Y	:	-1.107	-1.198	-1.122
CENTROID X	:	-.215	-.255	-.154
CENTROID Y	:	-.091	.032	-.044
POA TO CENTROID in.	:	.233	.257	.160
MIN RADIUS	:	.301	.355	.281
MEAN RADIUS	:	.789	.736	.694
MAX RADIUS	:	1.164	1.201	1.137
HORIZONTAL SPREAD	:	1.206	1.126	.589
VERTICAL SPREAD	:	2.156	2.124	2.124
EXTREME SPREAD	:	2.198	2.138	2.138
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 9

HS= 1.548

VS= 2.462

GS= 2.647

CENTROID #

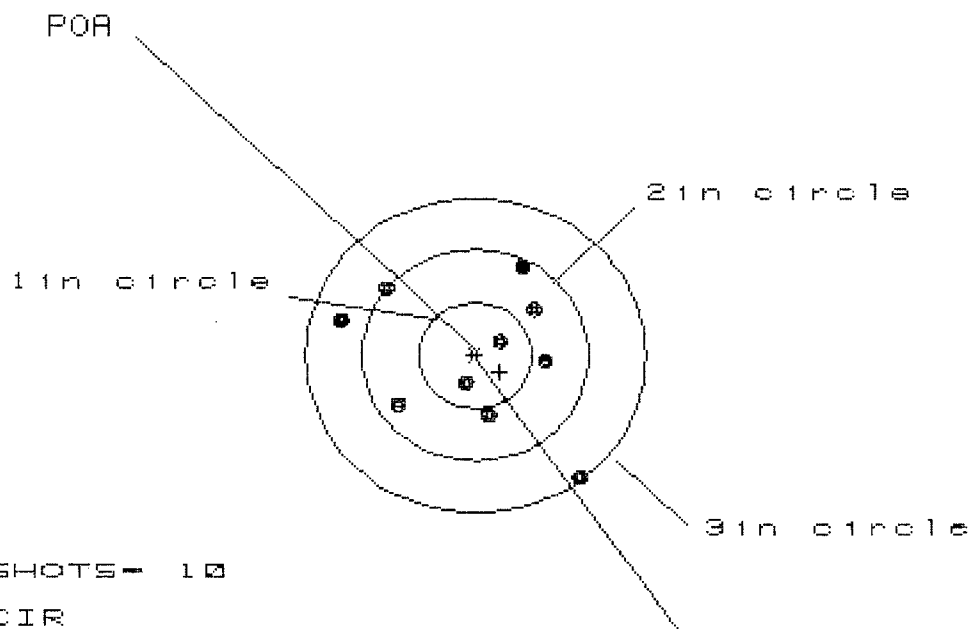
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.706	.721	.619
MINIMUM X	-.842	-.827	-.929
MAXIMUM Y	.856	.678	.570
MINIMUM Y	-1.606	-.533	-.449
CENTROID X	-.057	-.072	.030
CENTROID Y	-.002	.176	.092
POA TO CENTROID in.	.057	.191	.096
MIN RADIUS	.282	.227	.197
MEAN RADIUS	.689	.576	.487
MAX RADIUS	1.612	1.061	.957
HORIZONTAL SPREAD	1.548	1.548	1.548
VERTICAL SPREAD	2.462	1.211	1.019
EXTREME SPREAD	2.647	1.826	1.613
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in = 10

HS- 2.160

VS= 1.998

GS= 2.626

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.717	.576
MINIMUM X	:	-1.227	-1.123	-.803
MAXIMUM Y	:	.859	.733	.761
MINIMUM Y	:	-1.139	-.701	-.673
CENTROID X	:	-.217	-.321	-.180
CENTROID Y	:	.162	.288	.260
POA TO CENTROID in.	:	.270	.431	.316
MIN RADIUS	:	.262	.295	.172
MEAN RADIUS	:	.793	.727	.641
MAX RADIUS	:	1.472	1.146	.967
HORIZONTAL SPREAD	:	2.160	1.840	1.379
VERTICAL SPREAD	:	1.998	1.434	1.434
EXTREME SPREAD	:	2.626	1.880	1.674
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 2.104

VS= 1.623

GS= 2.151

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.979	.854	.791
MINIMUM X	:	-1.125	-.509	-.400
MAXIMUM Y	:	.714	.664	.658
MINIMUM Y	:	-.909	-.959	-.965
CENTROID X	:	-.016	.109	.003
CENTROID Y	:	.194	.244	.250
POA TO CENTROID in.	:	.194	.267	.250
MIN RADIUS	:	.233	.311	.212
MEAN RADIUS	:	.731	.672	.635
MAX RADIUS	:	1.213	1.068	1.072
HORIZONTAL SPREAD	:	2.104	1.363	1.194
VERTICAL SPREAD	:	1.623	1.623	1.623
EXTREME SPREAD	:	2.151	1.789	1.789
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	