

C6611582

MODEL 700TM M24

Model SMS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



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. C6611582	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		46	



5716 C6611582

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611582

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	KR
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4/10/91	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	TA

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5 $\frac{1}{4}$			4-15-91	DH
	G) Safety Off Force	2	2	2			4-15-91	DH
	H) Trigger Pull Test & Retainability						4/12/91	JH
	I) Firing Pin Indent	.020	.021	.020			4-15-91	DH
	J) Assemble Stock						4/15/91	RW
	K) Assemble Swivel Studs						4-17-91	L
	L) Attach Front and Rear Sight Assemblies						4/15/91	RW
	M) Iron Sight Alignment						4/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/15/91	RW
	O) Attach Scope to Rifle						4/15/91	RW
640	P) Detach & Attach Scope 20 Times						4/15/91	RW
	Gallery Target & Test						4-15-91	AC
	A) Time						4-15-91	AC
	B) Malfunctions						4-15-91	AC
	C) Pierced Primers						4-15-91	AC
645	D) Optical Clarity of Scope						4-15-91	AC
	Inspect for Live Ammo						4-15-91	AC
655	Final Inspection							
	A) Headspace						4-17-91	L
	B) Trigger Pull	2.46	2.29	2.35	2.46	2.30	4/16/91	JH
660	C) Function						4-17-91	L
	Pack						6-14-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611582DATE 4/12/91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.20	2.30	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.26	2.46	2.29	
PULL #3	2.41	2.45	2.32	2.35	
PULL #4	2.44	2.32	2.45	2.46	
PULL #5	2.13	2.46	2.45	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.43		
PULL #2	3.56	3.42		
PULL #3	3.40	3.40		
PULL #4	3.39	3.38		
PULL #5	3.42	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.36		4.28
PULL #2	4.33	4.33		4.37
PULL #3	4.30	4.16		4.23
PULL #4	4.10	4.37		4.32
PULL #5	4.26	4.24		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611582
15 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.295237
1 TO	2	.275588
1 TO	3	.494977
1 TO	4	.360756
1 TO	5	.540408

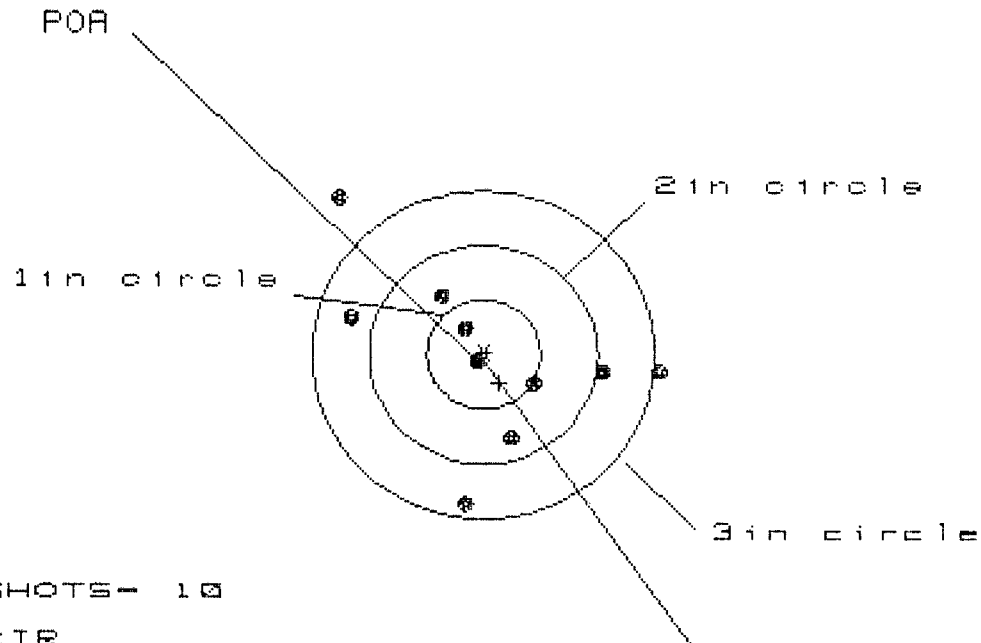
$\frac{1}{5} \frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0902
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120698
THE AMR FOR THIS RIFLE IS: 1.061

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611582

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.752

VS= 2.783

GS= 3.187

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	1.356	1.076
MINIMUM X	:	-1.256	-1.340	-1.170
MAXIMUM Y	:	1.471	.730	.733
MINIMUM Y	:	-1.312	-1.149	-1.145
CENTROID X	:	-.138	.002	-.168
CENTROID Y	:	.261	.098	.094
POA TO CENTROID in.	:	.295	.098	.193
MIN RADIUS	:	.113	.282	.158
MEAN RADIUS	:	.942	.826	.750
MAX RADIUS	:	1.934	1.447	1.293
HORIZONTAL SPREAD	:	2.752	2.696	2.246
VERTICAL SPREAD	:	2.783	1.879	1.879
EXTREME SPREAD	:	3.187	2.746	2.311
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.321

VS= 3.163

GS= 3.176

CENTROID #

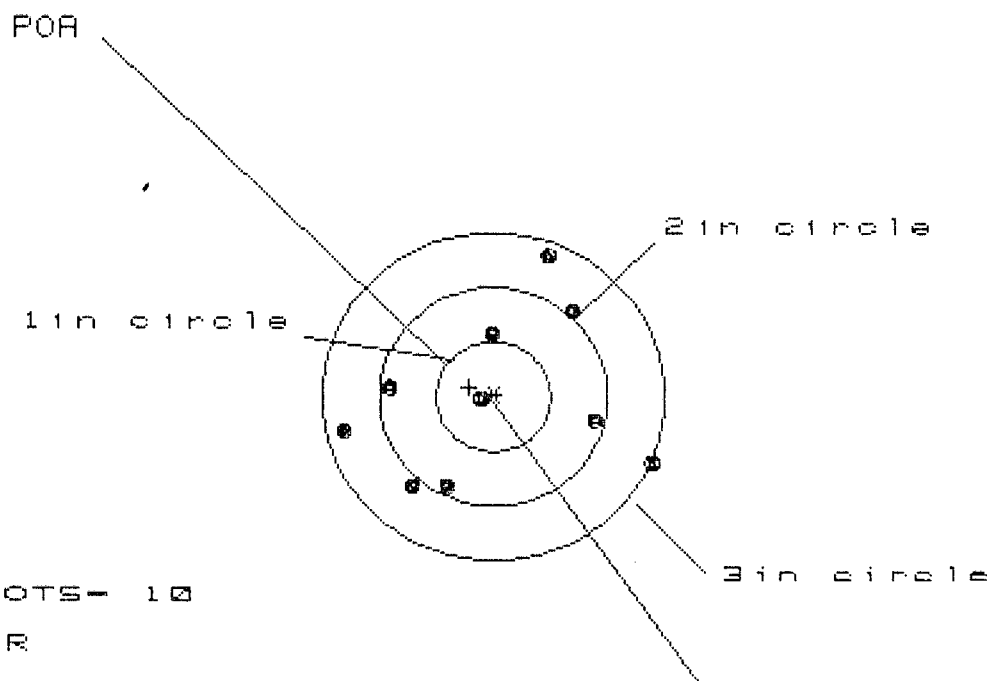
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.127	1.077	1.049
MINIMUM X	-1.194	-1.244	-1.272
MAXIMUM Y	1.603	.970	.797
MINIMUM Y	-1.560	-1.382	-.574
CENTROID X	.105	.155	.183
CENTROID Y	.131	-.047	.126
POA TO CENTROID in.	.168	.162	.222
MIN RADIUS	.788	.759	.804
MEAN RADIUS	1.151	1.084	1.033
MAX RADIUS	1.665	1.399	1.343
HORIZONTAL SPREAD	2.321	2.321	2.321
VERTICAL SPREAD	3.163	2.352	1.371
EXTREME SPREAD	3.176	2.552	2.552
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.722

VS= 2.107

GS= 2.738

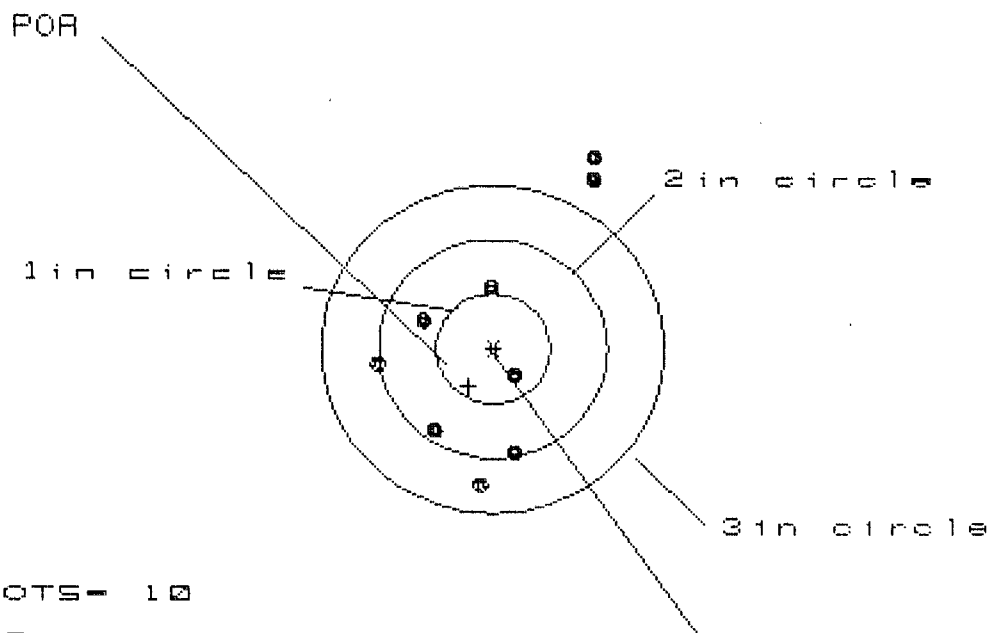
CENTROID *

PATTERN #	:	3	8	9	10
SHOTS (BEST OF)	:	10	9	8	
MAXIMUM X	:	1.432	1.061	1.139	
MINIMUM X	:	-1.290	-1.131	-1.053	
MAXIMUM Y	:	1.283	1.218	.829	
MINIMUM Y	:	-.824	-.889	-.737	
CENTROID X	:	.213	.054	-.024	
CENTROID Y	:	-.088	-.023	-.175	
POA TO CENTROID in.	:	.230	.058	.177	
MIN RADIUS	:	.119	.124	.134	
MEAN RADIUS	:	.977	.898	.826	
MAX RADIUS	:	1.546	1.366	1.224	
HORIZONTAL SPREAD	:	2.722	2.192	2.192	
VERTICAL SPREAD	:	2.107	2.107	1.566	
EXTREME SPREAD	:	2.738	2.414	2.206	
NUMBER IN ONE INCH CIRCLE	=		1		
NUMBER IN TWO INCH CIRCLE	=		6		
NUMBER IN THREE INCH CIRCLE	=		9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 1.971

VS= 3.020

GS= 3.160

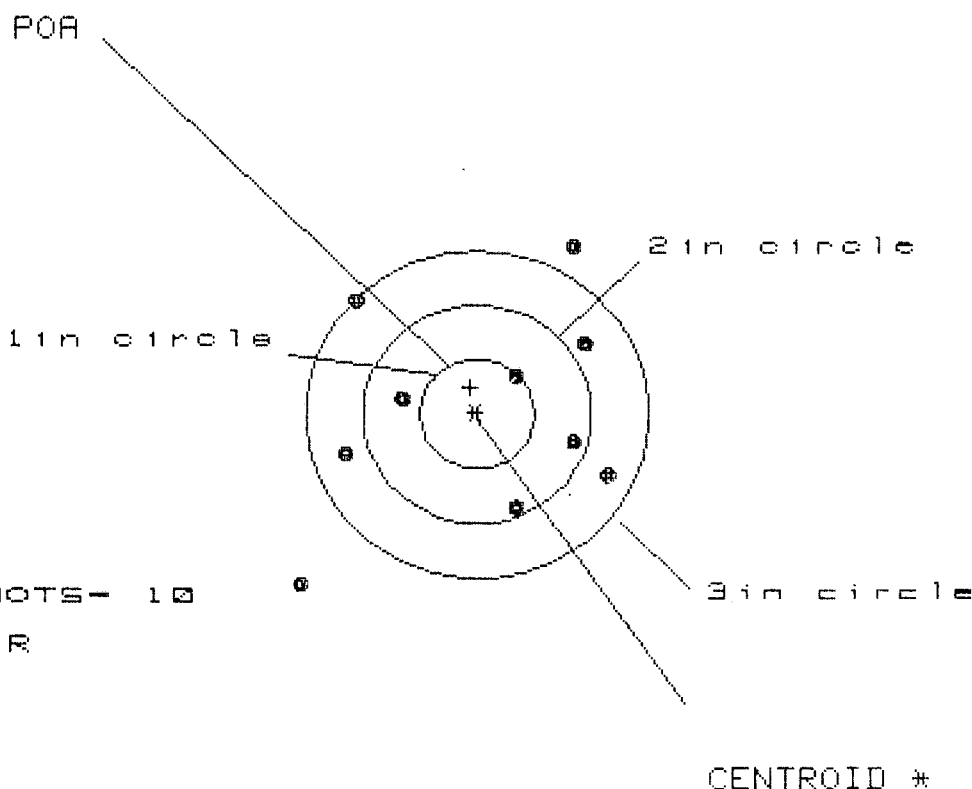
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	1.025	.416
MINIMUM X	:	-1.040	-.946	-.818
MAXIMUM Y	:	1.785	1.778	.944
MINIMUM Y	:	-1.235	-1.037	-.815
CENTROID X	:	.214	.120	-.008
CENTROID Y	:	.340	.142	-.080
POA TO CENTROID in.	:	.402	.186	.081
MIN RADIUS	:	.323	.294	.407
MEAN RADIUS	:	1.037	.884	.696
MAX RADIUS	:	1.975	2.052	.966
HORIZONTAL SPREAD	:	1.971	1.971	1.234
VERTICAL SPREAD	:	3.020	2.815	1.759
EXTREME SPREAD	:	3.160	2.993	1.760
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.649

VS= 3.101

GS= 3.926

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	.939	1.026
MINIMUM X	:	-1.539	-1.299	-1.212
MAXIMUM Y	:	1.499	1.321	1.066
MINIMUM Y	:	-1.602	-1.033	-.868
CENTROID X	:	.057	.228	.141
CENTROID Y	:	-.243	-.065	-.230
POA TO CENTROID in.	:	.250	.237	.270
MIN RADIUS	:	.437	.190	.375
MEAN RADIUS	:	1.198	1.047	.993
MAX RADIUS	:	2.221	1.510	1.550
HORIZONTAL SPREAD	:	2.649	2.238	2.238
VERTICAL SPREAD	:	3.101	2.354	1.934
EXTREME SPREAD	:	3.926	2.754	2.695
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	