

C6611619

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
REMINGTON & CO. N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

MODEL 700™ N24

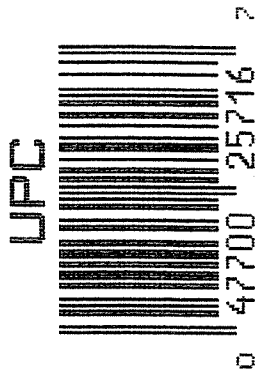
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6611619

ORDER NO.
5716

46



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611619

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		11
615	Rollmark Caliber	APR 2 1991		2/21
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	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	KS

op. #	BARBER - M24 0079697 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/11/91	KL
	G) Safety Off Force	2	2	2			4/11/91	KL
	H) Trigger Pull Test & Retainability						4/11/91	KL
	I) Firing Pin Indent	.022	.022	.022			4/11/91	KL
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/24/91	KS
	O) Attach Scope to Rifle						4/24/91	KS
	P) Detach & Attach Scope 20 Times						4/24/91	KS
640	Gallery Target & Test						4/25/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						4/25/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.55	2.53	2.54	2.60	2.60	4/24/91	KL
	C) Function						5-1-91	DH
660	Pack						6-17-91	VC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6611619

DATE 4/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.37	2.38	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.32	2.35	2.53	
PULL #3	2.19	2.32	2.31	2.54	
PULL #4	2.19	2.31	2.35	2.60	
PULL #5	2.18	2.34	2.36	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.53		
PULL #2	3.19	3.42		
PULL #3	3.43	3.50		
PULL #4	3.46	3.48		
PULL #5	3.46	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.26		4.40
PULL #2	4.26	4.37		4.36
PULL #3	4.35	4.48		4.19
PULL #4	4.33	4.37		4.40
PULL #5	4.41	4.45		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611619
25 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.318423
1 TO	2	.477504
1 TO	3	.240853
1 TO	4	.304311
1 TO	5	.119097

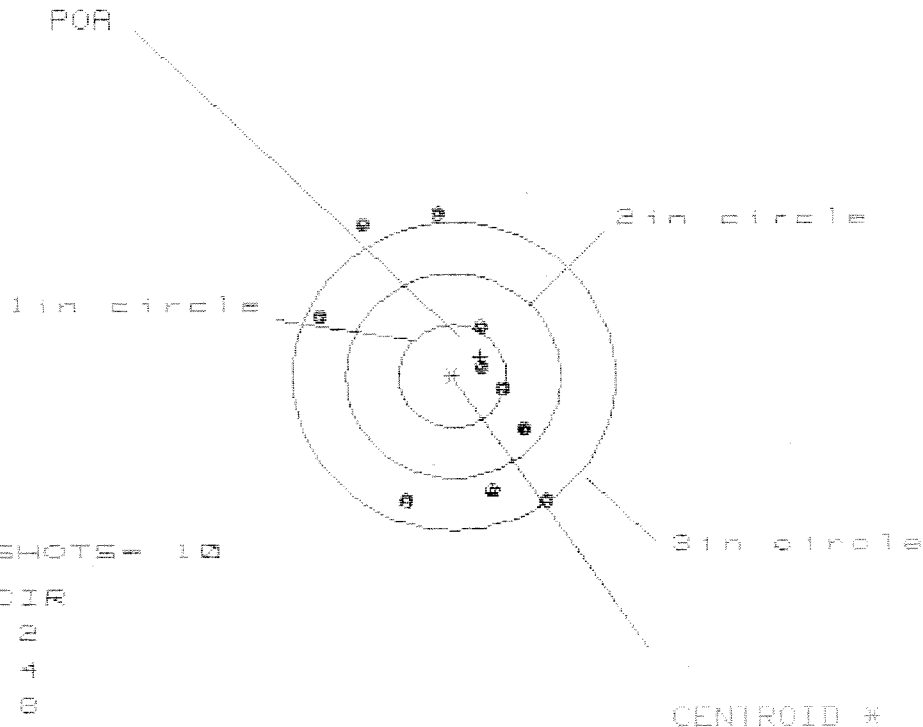
PR <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0404
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0986
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110018
THE AMR FOR THIS RIFLE IS: .8282

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611619

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.127

VS= 2.787

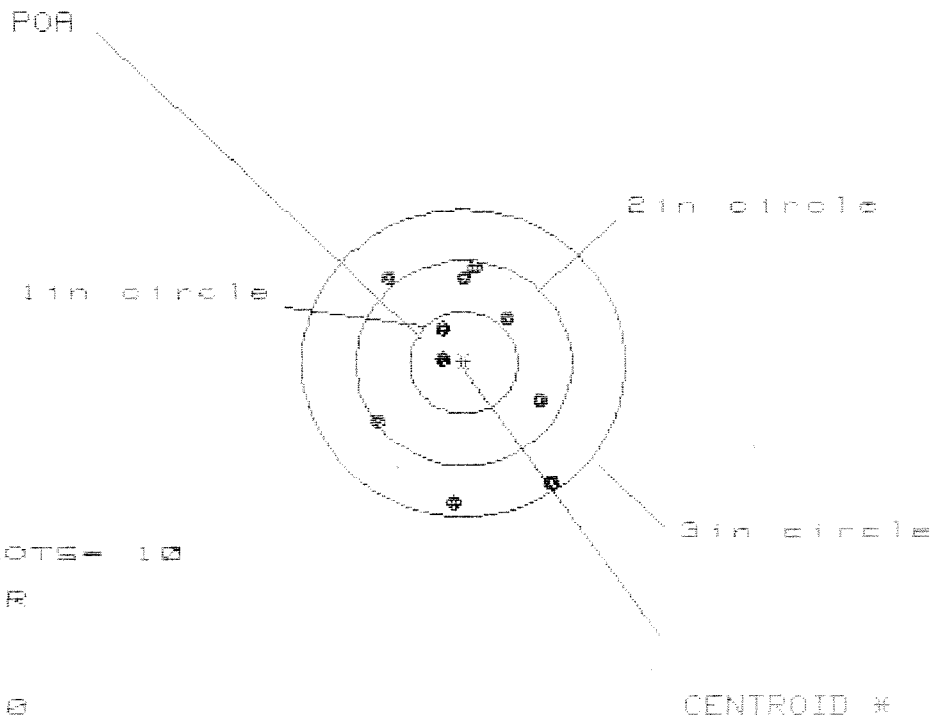
GS= 3.137

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.746	.715
MINIMUM X	-1.284	-1.381	-1.412
MAXIMUM Y	1.571	1.731	.955
MINIMUM Y	-1.216	-1.056	-.840
CENTROID X	-.257	-.160	-.129
CENTROID Y	-.188	-.348	-.564
POA TO CENTROID in.	.318	.383	.579
MIN RADIUS	.258	.269	.432
MEAN RADIUS	1.071	.971	.860
MAX RADIUS	1.685	1.748	1.704
HORIZONTAL SPREAD	2.127	2.127	2.127
VERTICAL SPREAD	2.787	2.787	1.795
EXTREME SPREAD	3.137	2.929	2.763
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11619

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.588

VS= 2.297

GS= 2.539

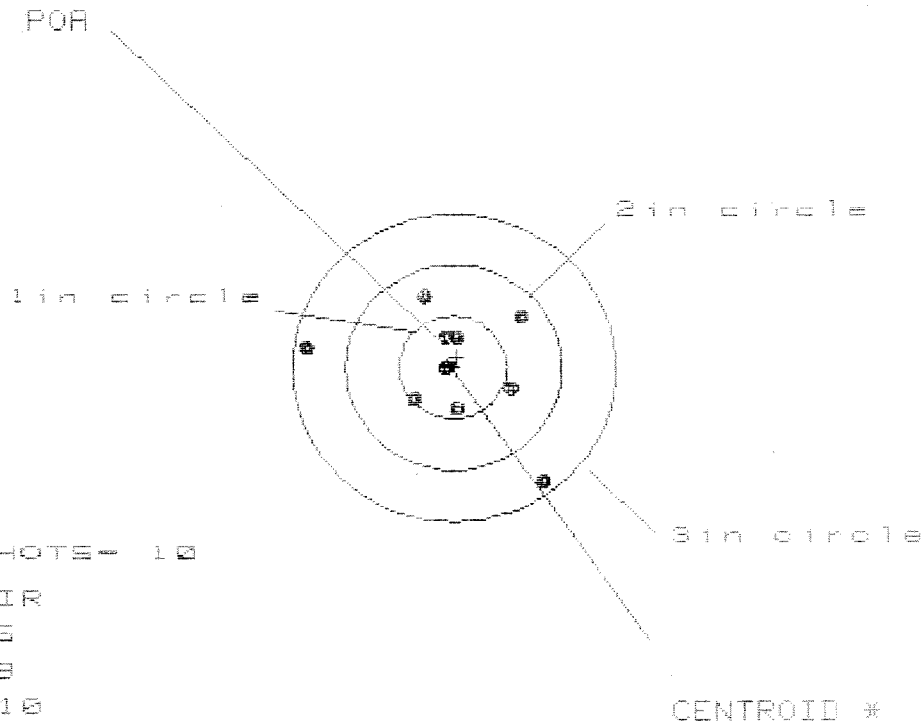
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.835	.788	.784
MINIMUM X	-.750	-.658	-.663
MAXIMUM Y	.925	.793	.695
MINIMUM Y	-1.372	-1.504	-.880
CENTROID X	.196	.104	.108
CENTROID Y	-.037	.095	.283
POA TO CENTROID in.	.200	.141	.393
MIN RADIUS	.241	.143	.169
MEAN RADIUS	.872	.767	.638
MAX RADIUS	1.449	1.504	1.085
HORIZONTAL SPREAD	1.585	1.446	1.446
VERTICAL SPREAD	2.297	2.297	1.465
EXTREME SPREAD	2.539	2.307	1.863
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811619

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.194

VS= 1.778

GS= 2.562

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.840	.690	.536
MINIMUM X	-1.354	-.509	-.423
MAXIMUM Y	.696	.722	.590
MINIMUM Y	-1.083	-1.056	-.527
CENTROID X	-.034	.116	.030
CENTROID Y	-.097	-.123	.009
POA TO CENTROID in.	.102	.169	.031
MIN RADIUS	.061	.209	.174
MEAN RADIUS	.645	.576	.457
MAX RADIUS	1.375	1.261	.665
HORIZONTAL SPREAD	2.194	1.199	.959
VERTICAL SPREAD	1.778	1.778	1.117
EXTREME SPREAD	2.562	2.082	1.264
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

25 Apr 1991

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CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.200

VS = 2.115

GS = 2.347

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.406

1.334

.676

MINIMUM X

-.794

-.866

-.699

MAXIMUM Y

1.365

.514

.560

MINIMUM Y

-.750

-.598

-.552

CENTROID X

.020

.092

-.075

CENTROID Y

-.062

-.214

-.260

POB TO CENTROID in.

.065

.233

.271

MIN RADIUS

.391

.445

.442

MEAN RADIUS

.801

.708

.610

MAX RADIUS

1.509

1.385

.760

HORIZONTAL SPREAD

2.200

2.200

1.375

VERTICAL SPREAD

2.115

1.112

1.112

EXTREME SPREAD

2.347

2.244

1.445

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

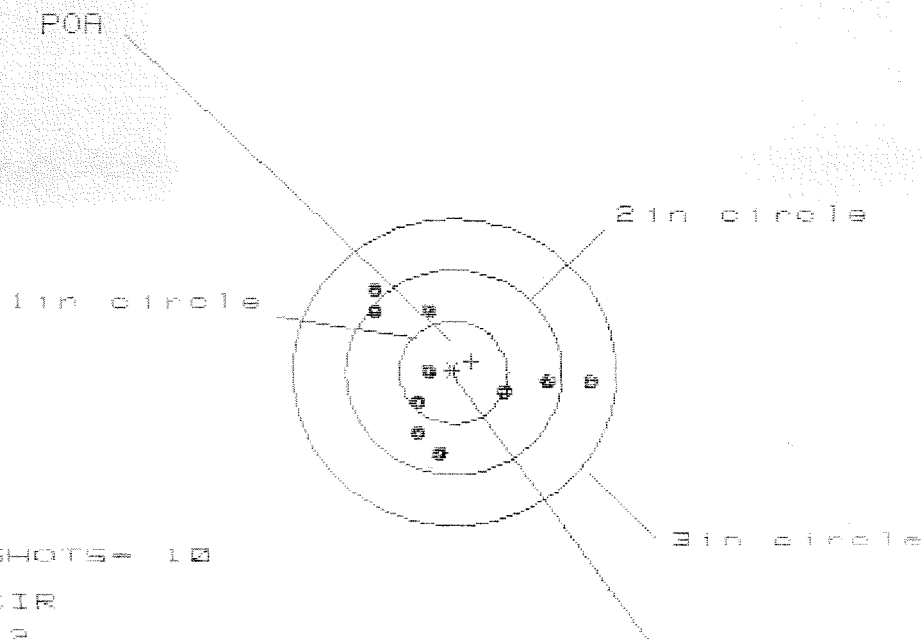
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25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811619

CENTERFIRE PATTERNS

5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.989

VS = 1.608

GS = 2.174

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.247
MINIMUM X	-.742
MAXIMUM Y	.789
MINIMUM Y	-.819
CENTROID X	-.167
CENTROID Y	-.110
POA TO CENTROID in.	.199
MIN RADIUS	.271
MEAN RADIUS	.752
MAX RADIUS	1.250
HORIZONTAL SPREAD	1.989
VERTICAL SPREAD	1.608
EXTREME SPREAD	2.174
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10