

06594497

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington®

MODEL 700™ M24

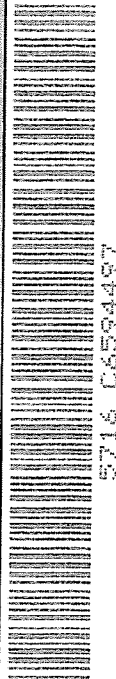
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

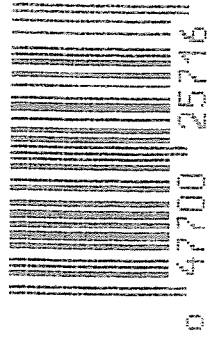
DU PONT
REGISTERED PAT. & TM. OFF.

SERIAL NO.
C6594497

ORDER NO.
5716



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594497

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-18-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			1/30/91	WLB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			1/30/91	WLB
	H) Trigger Pull Test & Retainability						1/30/91	SH
	I) Firing Pin Indent	.021	.0208	.021			1/30/91	WLB
	J) Assemble Stock						1/30/91	RW
	K) Assemble Swivel Studs						2-6-91	DH
	L) Attach Front and Rear Sight Assemblies						1/30/91	RW
	M) Iron Sight Alignment						1/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/30/91	RW
	O) Attach Scope to Rifle						1/30/91	RW
	P) Detach & Attach Scope 20 Times						1/30/91	RW
640	Gallery Target & Test						1-30-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-30-91	NF
655	Final Inspection							
	A) Headspace						2-5-91	DH
	B) Trigger Pull	2.25	2.26	2.32	2.33	2.30	2-4-91	SH
	C) Function						2-5-91	DH
660	Pack						3/13/91	WLB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594497

DATE 11/30/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.44	2.35	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.19	2.20	2.26	
PULL #3	2.32	2.33	2.28	2.32	
PULL #4	2.45	2.27	2.20	2.33	
PULL #5	2.39	2.23	2.24	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.30		
PULL #2	3.53	3.37		
PULL #3	3.31	3.33		
PULL #4	3.24	3.28		
PULL #5	3.29	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.29		4.35
PULL #2	4.23	4.27		4.30
PULL #3	4.33	4.13		4.27
PULL #4	4.34	4.41		4.39
PULL #5	4.11	4.35		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594497
31 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.344105
1 TO	2	.324031
1 TO	3	.361365
1 TO	4	.491351
1 TO	5	.142225

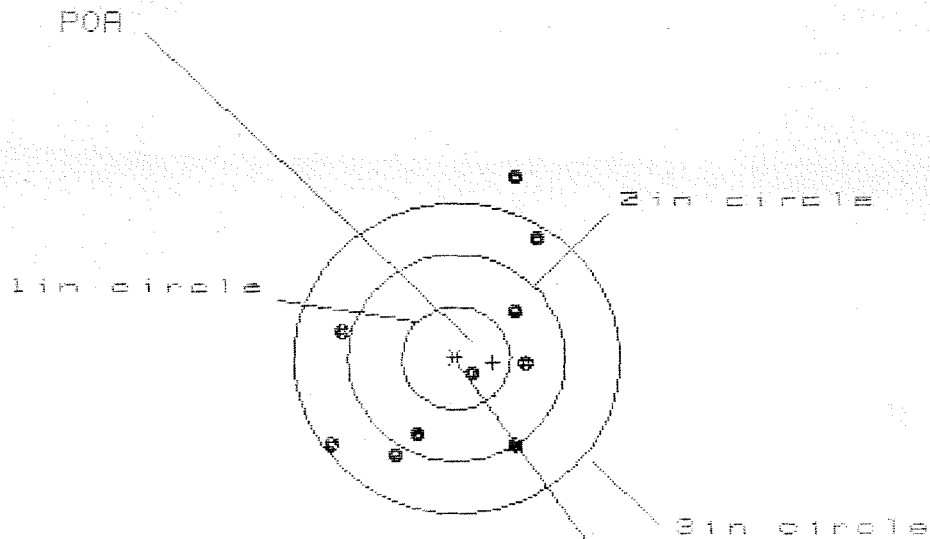
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0962
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11032
THE AMP FOR THIS RIFLE IS: 1.001

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594497

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

CENTROID #

HS= 1.853

VS= 2.687

GS= 3.116

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.703	.762	.625
MINIMUM X	:	-1.150	-1.091	-1.101
MAXIMUM Y	:	1.743	1.391	1.305
MINIMUM Y	:	-.944	-.751	-.837
CENTROID X	:	-.342	-.401	-.264
CENTROID Y	:	.038	-.155	-.069
POA TO CENTROID in.	:	.344	.430	.273
MIN RADIUS	:	.177	.169	.044
MEAN RADIUS	:	1.017	.902	.830
MAX RADIUS	:	1.820	1.586	1.447
HORIZONTAL SPREAD	:	1.853	1.853	1.726
VERTICAL SPREAD	:	2.687	2.142	2.142
EXTREME SPREAD	:	3.116	2.788	2.476
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jan 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.782

VS= 2.582

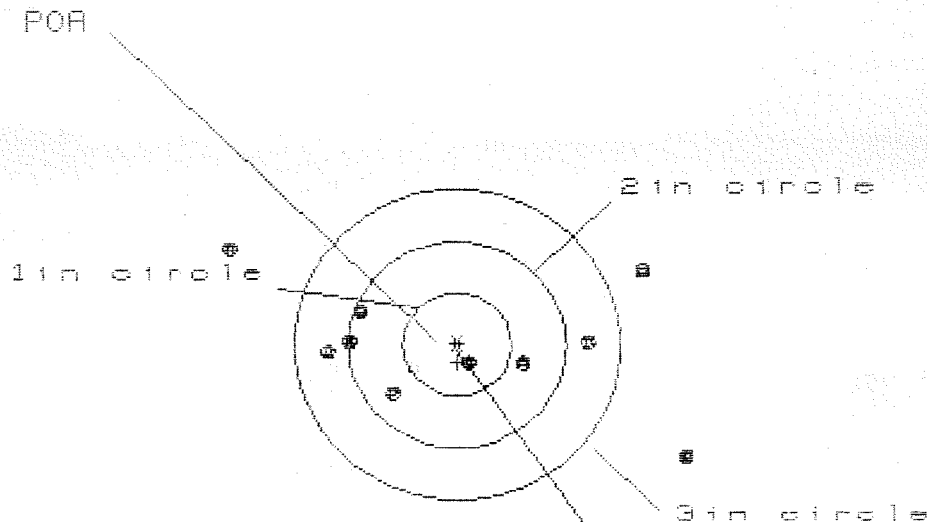
GS= 2.650

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.566	.431	.459
MINIMUM X	:	-1.216	-.536	-.508
MAXIMUM Y	:	1.291	1.189	1.014
MINIMUM Y	:	-1.291	-1.393	-.528
CENTROID X	:	-.028	.107	.079
CENTROID Y	:	.118	.220	.395
POA TO CENTROID in.	:	.122	.245	.402
MIN RADIUS	:	.340	.409	.374
MEAN RADIUS	:	.775	.679	.574
MAX RADIUS	:	1.524	1.411	1.024
HORIZONTAL SPREAD	:	1.782	.967	.967
VERTICAL SPREAD	:	2.582	2.582	1.542
EXTREME SPREAD	:	2.650	2.584	1.629
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 4.216

VS= 1.956

GS= 4.648

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.099	1.974	1.739
MINIMUM X	-2.117	-1.884	-1.268
MAXIMUM Y	.882	.762	.708
MINIMUM Y	-1.074	-.607	-.511
CENTROID X	-.006	-.239	-.004
CENTROID Y	.171	.291	.195
POA TO CENTROID in.	.172	.377	.196
MIN RADIUS	.187	.431	.287
MEAN RADIUS	1.251	1.116	.986
MAX RADIUS	2.358	2.067	1.877
HORIZONTAL SPREAD	4.216	3.858	2.947
VERTICAL SPREAD	1.956	1.369	1.219
EXTREME SPREAD	4.648	3.861	3.066
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

31 Jan 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.047

VS= 3.124

GS= 3.527

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.803	.665	.498
MINIMUM X	-1.244	-1.339	-.808
MAXIMUM Y	1.816	1.352	1.268
MINIMUM Y	-1.308	-1.106	-1.190
CENTROID X	.109	.247	.414
CENTROID Y	-.157	-.359	-.275
POA TO CENTROID in.	.191	.436	.497
MIN RADIUS	.503	.678	.689
MEAN RADIUS	1.195	1.052	.997
MAX RADIUS	2.201	1.507	1.362
HORIZONTAL SPREAD	2.047	2.004	1.306
VERTICAL SPREAD	3.124	2.458	2.458
EXTREME SPREAD	3.527	2.849	2.492
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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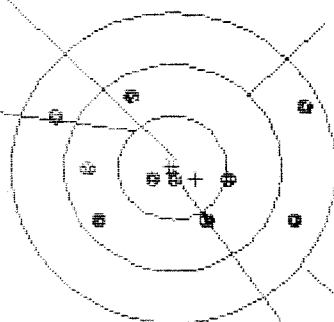
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.244

VS= 1.246

GS= 2.467

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	1.275	.848
MINIMUM X	:	-1.079	-.950	-.790
MAXIMUM Y	:	.699	.769	.709
MINIMUM Y	:	-.547	-.477	-.494
CENTROID X	:	-.214	-.343	-.503
CENTROID Y	:	.100	.030	.090
POA TO CENTROID in.	:	.236	.345	.511
MIN RADIUS	:	.131	.072	.116
MEAN RADIUS	:	.769	.679	.598
MAX RADIUS	:	1.321	1.362	.951
HORIZONTAL SPREAD	:	2.244	2.225	1.638
VERTICAL SPREAD	:	1.246	1.246	1.203
EXTREME SPREAD	:	2.467	2.467	1.758
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	