

C6587515

MODEL 780TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M2400023872

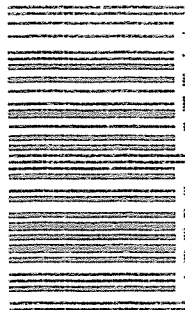
CONFIDENTIAL SUBJECT TO PROTECTIVE ORDER

Remington® REG. U.S. PAT. & TM. OFF. 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. 06587616
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 06587616

LPC



0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587616

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		71	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes		11/1/90	LOB
618	Polish Barrel RB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-4-91	DH

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.50	4.50	1/3/91	KT		
	G) Safety Off Force	3.25	3.25	3.25	1/3/91	KT		
	H) Trigger Pull Test & Retainability				1-4-91	DH		
	I) Firing Pin Indent	.020	.020	.020	1/3/91	KT		
	J) Assemble Stock				1/7/91	Rw		
	K) Assemble Swivel Studs				1-14-91	JV		
	L) Attach Front and Rear Sight Assemblies				1/7/91	Rw		
	M) Iron Sight Alignment				1/7/91	Rw		
	N) Detach Front & Rear Sights & place in numbered container				1/7/91	Rw		
	O) Attach Scope to Rifle				1/7/91	Rw		
	P) Detach & Attach Scope 20 Times				1/7/91	Rw		
640	Gallery Target & Test				1-11-91	AC		
	A) Time				1-11-91	AC		
	B) Malfunctions				1-11-91	AC		
	C) Pierced Primers				1-11-91	AC		
	D) Optical Clarity of Scope				1-11-91	AC		
645	Inspect for Live Ammo				1-11-91	AC		
655	Final Inspection							
	A) Headspace				1-14-91	JV		
	B) Trigger Pull	2.14	2.10	2.36	2.19	2.21	1-14-91	JV
	C) Function						1-14-91	JV
660	Pack						3-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587616
DATE 1-4-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.43	2.57	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.41	2.57	2.10	
PULL #3	2.33	2.39	2.52	2.36	
PULL #4	2.32	2.37	2.60	2.19	
PULL #5	2.35	2.37	2.58	2.21	
TOTAL	11.70	11.97	12.84		
AVG.	2.34	2.39	2.56		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.29		
PULL #2	3.25	3.27		
PULL #3	3.33	3.34		
PULL #4	3.24	3.34		
PULL #5	3.31	3.31		
TOTAL	16.34	16.55		
AVG.	3.26	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.40		4.13
PULL #2	4.38	4.40		4.19
PULL #3	4.42	4.38		4.26
PULL #4	4.43	4.40		4.23
PULL #5	4.07	4.35		4.23
TOTAL	21.68	21.93		21.04
AVG.	4.33	4.38		4.20

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587616
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.182631
1 TO	2	.375353
1 TO	3	.0206155
1 TO	4	.207171
1 TO	5	.541479

$\bar{x}^S$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1904
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .035
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .19359
THE AMR FOR THIS RIFLE IS: .9336

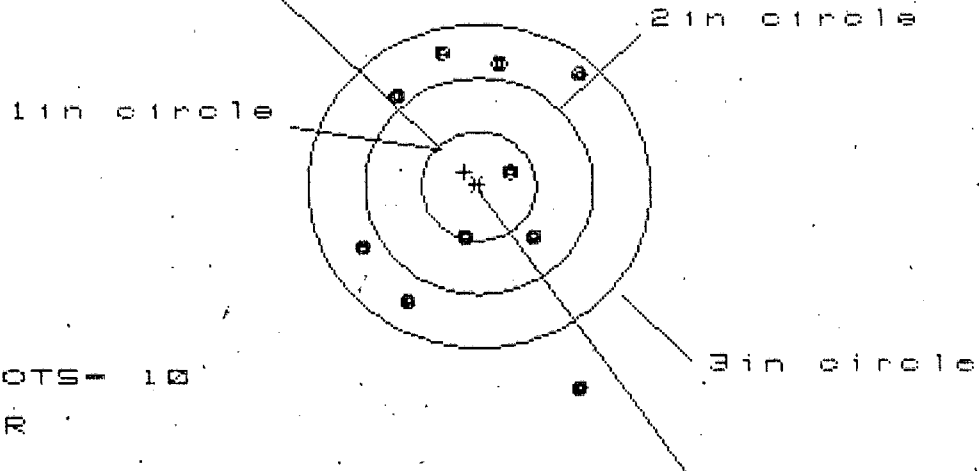
11 Jan 1991

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CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in - 2

2in - 3

3in = 5

HS- 1.911

VS= 3.087

GS= 3.326

CENTROID *

PATTERN #

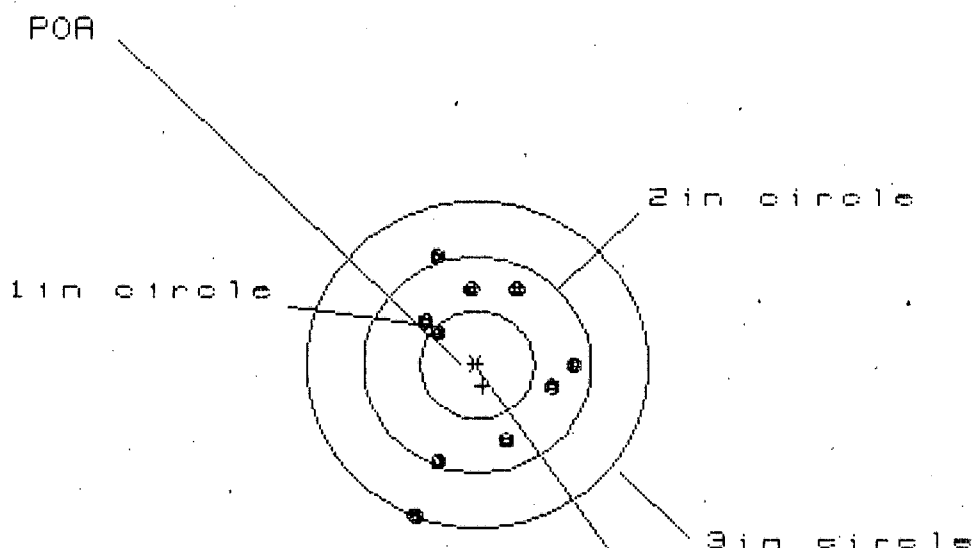
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.964	.684
MINIMUM X	-.989	-.887	-.766
MAXIMUM Y	1.266	1.064	1.167
MINIMUM Y	-1.821	-1.231	-1.128
CENTROID X	.123	.021	-.100
CENTROID Y	-.135	.068	-.035
POA TO CENTROID in.	.182	.071	.106
MIN RADIUS	.358	.423	.546
MEAN RADIUS	1.079	.968	.926
MAX RADIUS	2.041	1.340	1.199
HORIZONTAL SPREAD	1.911	1.851	1.450
VERTICAL SPREAD	3.087	2.295	2.295
EXTREME SPREAD	3.326	2.540	2.316
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

11 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 1.447

VS= 2.447

GS= 2.457

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.862	.797	.743
MINIMUM X	-.585	-.531	-.585
MAXIMUM Y	1.033	.876	.698
MINIMUM Y	-1.414	-1.035	-.925
CENTROID X	-.054	.011	.065
CENTROID Y	.196	.353	.243
POA TO CENTROID in.	.203	.353	.252
MIN RADIUS	.408	.389	.480
MEAN RADIUS	.833	.729	.703
MAX RADIUS	1.530	1.105	1.026
HORIZONTAL SPREAD	1.447	1.328	1.328
VERTICAL SPREAD	2.447	1.911	1.623
EXTREME SPREAD	2.457	1.912	1.744
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

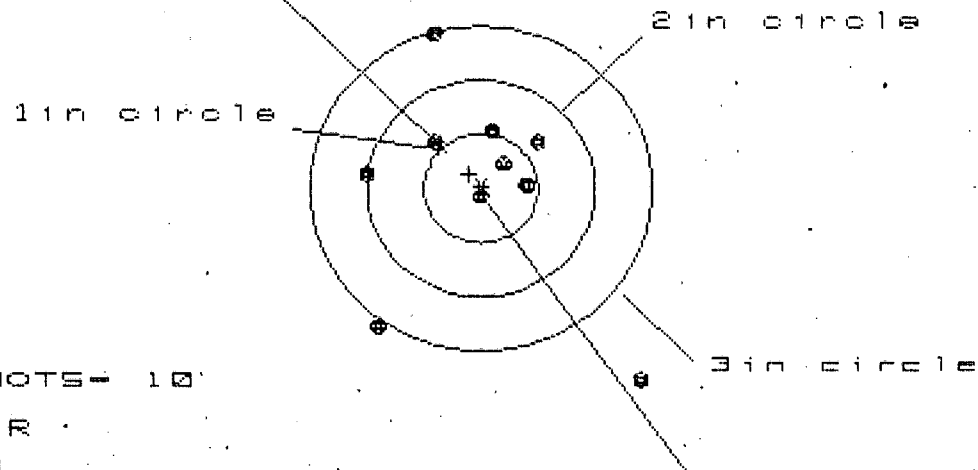
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CENTERFIRE PATTERNS

3

POR



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.398

VS= 3.155

GS= 3.641

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.435	.656	.563
MINIMUM X	-.963	-.804	-.897
MAXIMUM Y	1.392	1.196	1.008
MINIMUM Y	-1.763	-1.501	-.498
CENTROID X	.103	-.056	.037
CENTROID Y	-.130	.066	.254
POR TO CENTROID in.	.166	.087	.256
MIN RADIUS	.117	.287	.220
MEAN RADIUS	.890	.715	.563
MAX RADIUS	2.273	1.676	1.057
HORIZONTAL SPREAD	2.398	1.460	1.460
VERTICAL SPREAD	3.155	2.697	1.506
EXTREME SPREAD	3.641	2.747	1.551
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

11 Jan 1991

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CENTERFIRE PATTERNS

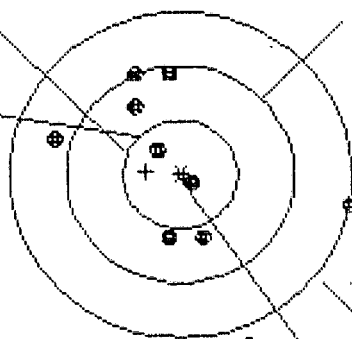
4

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.674

VS= 2.552

GS= 2.731

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.537	1.607	.445
MINIMUM X	:	-1.137	-1.067	-.866
MAXIMUM Y	:	.967	.791	.741
MINIMUM Y	:	-1.585	-.788	-.838
CENTROID X	:	.301	.231	.030
CENTROID Y	:	-.029	.147	.197
POA TO CENTROID in.	:	.302	.273	.199
MIN RADIUS	:	.123	.113	.104
MEAN RADIUS	:	.888	.776	.646
MAX RADIUS	:	1.705	1.657	.933
HORIZONTAL SPREAD	:	2.674	2.674	1.311
VERTICAL SPREAD	:	2.552	1.579	1.579
EXTREME SPREAD	:	2.731	2.731	1.621
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

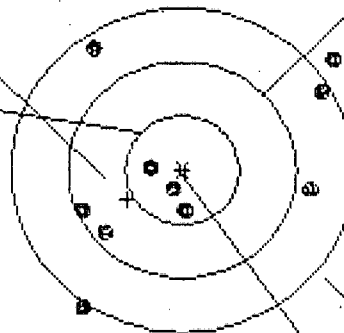
5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 2

HS= 2.222

VS= 2.431

GS= 3.142

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.317	1.322	1.235
MINIMUM X	-.905	-.758	-.845
MAXIMUM Y	1.159	1.271	1.126
MINIMUM Y	-1.272	-1.160	-.617
CENTROID X	.479	.332	.419
CENTROID Y	.273	.161	.306
POA TO CENTROID in.	.551	.369	.519
MIN RADIUS	.215	.097	.190
MEAN RADIUS	.978	.851	.819
MAX RADIUS	1.661	1.567	1.418
HORIZONTAL SPREAD	2.222	2.080	2.080
VERTICAL SPREAD	2.431	2.431	1.743
EXTREME SPREAD	3.142	2.840	2.347
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		