

C6648981

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM H24

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

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

SERIAL NO.
C6648981

ORDER NO.
5716

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

Ø6



5716 C6648981

UPC



0 47700 25716 7

GFM

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648981

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KH
600	Proof		7/24/91	KH
607	Check Headspace		7/24/91	KH
610	Dis-assemble Gun		7/24/91	KH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		7-27-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KH
	C) Inspect Ejector Hole for Chamfer		8/29/91	KH
	D) Oil Firing Pin Ass'y		8/29/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5	3	4	8-31-91	DH
	G) Safety Off Force	23	23	23	23	23	8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	JH
	I) Firing Pin Indent	.024	.023	.023			8-31-91	DH
	J) Assemble Stock						8/31/91	KH
	K) Assemble Swivel Studs						8/31/91	JH
	L) Attach Front and Rear Sight Assemblies						8/31/91	KH
	M) Iron Sight Alignment						8/31/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/31/91	KH
	O) Attach Scope to Rifle						8/31/91	KH
	P) Detach & Attach Scope 20 Times						8/31/91	KH
640	Gallery Target & Test						9/3/91	KH
	A) Time						"	KH
	B) Malfunctions						"	KH
	C) Pierced Primers						"	147
	D) Optical Clarity of Scope						"	147
645	Inspect for Live Ammo						9/3/91	KH
655	Final Inspection							
	A) Headspace						9/12/91	JH
	B) Trigger Pull	2.44	2.41	2.41	2.40	2.40	9/16/91	JH
	C) Function						9/14/91	JH
660	Pack						9-18-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648981

DATE 8/31/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.47	2.38	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.37	2.40	2.41	
PULL #3	2.49	2.40	2.44	2.41	
PULL #4	2.33	2.36	2.35	2.40	
PULL #5	2.20	2.34	2.32	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.43		
PULL #2	3.62	3.32		
PULL #3	3.66	3.35		
PULL #4	3.19	3.39		
PULL #5	3.61	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	4.22	4.49		4.42
PULL #2	4.50	4.50		4.43
PULL #3	4.51	4.48		4.54
PULL #4	4.27	4.31		4.56
PULL #5	4.32	4.49		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648981
3 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.345254
1 TO	2	.348738
1 TO	3	.507304
1 TO	4	.111212
1 TO	5	.166355

~~724~~ <----POA

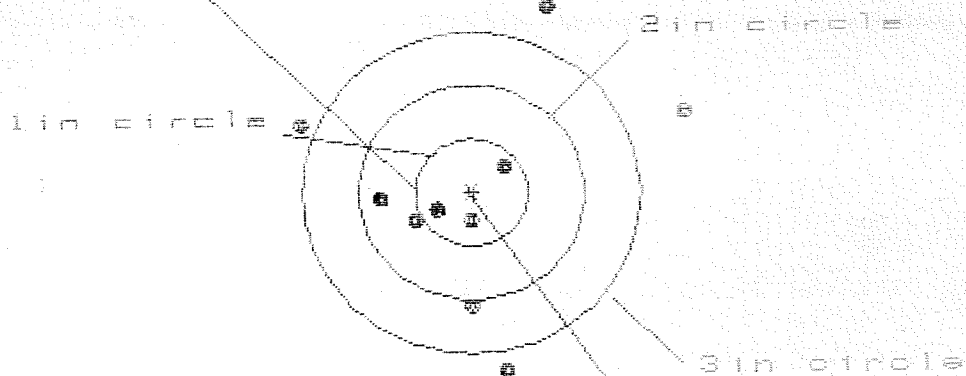
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0516
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14977
SAP FOR THIS RIFLE IS: 1.083

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B381

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 6

HS= 3.408

VS= 3.427

GS= 3.451

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.918	.896	.605
MINIMUM X	:	-1.490	-1.277	-1.165
MAXIMUM Y	:	1.740	1.825	.974
MINIMUM Y	:	-1.687	-1.602	-1.374
CENTROID X	:	.308	.095	-.017
CENTROID Y	:	.156	.071	-.157
POA TO CENTROID in.	:	.346	.119	.158
MIN RADIUS	:	.296	.107	.163
MEAN RADIUS	:	1.070	.899	.737
CA. RADIUS	:	2.065	2.033	1.519
HORIZONTAL SPREAD	:	3.408	2.173	1.770
VERTICAL SPREAD	:	3.427	3.427	2.348
EXTREME SPREAD	:	3.451	3.451	2.940
NO. OF SHOTS IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C884B981

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 8

3 in - 8

HS= 2.610

VS= 3.015

GS= 3.614

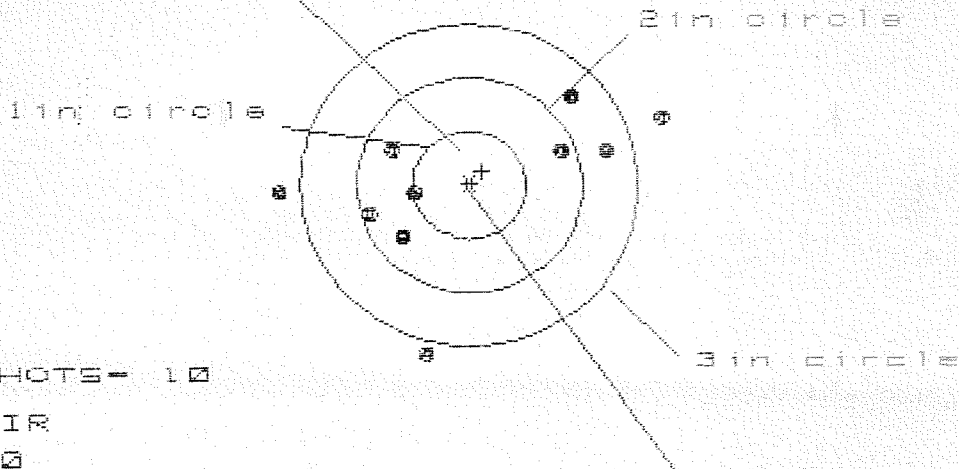
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	.878	.685
MINIMUM X	-1.650	-1.543	-1.620
MAXIMUM Y	2.058	.909	.882
MINIMUM Y	-.957	-.729	-.756
CENTROID X	-.035	-.142	.051
CENTROID Y	.093	-.135	-.108
POA TO CENTROID in.	.100	.196	.120
MIN RADIUS	.413	.478	.283
MEAN RADIUS	.934	.776	.627
MAX RADIUS	2.271	1.558	.960
HORIZONTAL SPREAD	2.610	2.421	1.305
VERTICAL SPREAD	3.015	1.638	1.638
EXTREME SPREAD	3.614	2.422	1.658
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C684B981

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.390

VS= 2.420

GS= 3.467

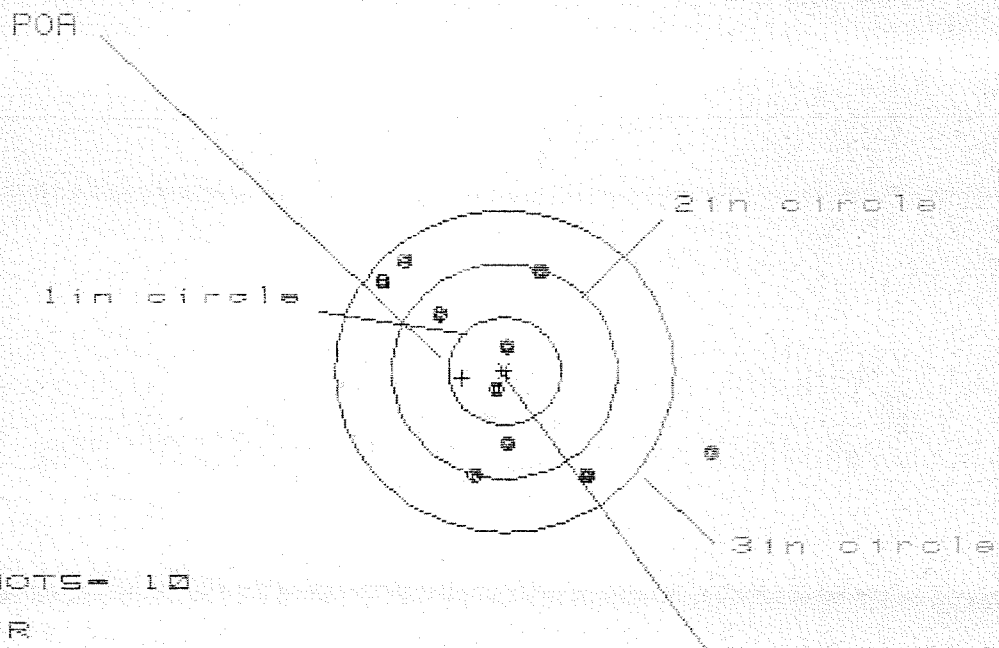
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.713	1.443	1.257
MINIMUM X	:	-1.677	-1.487	-.913
MAXIMUM Y	:	.848	.921	.921
MINIMUM Y	:	-1.572	-1.499	-1.499
CENTROID X	:	-.111	-.301	-.115
CENTROID Y	:	-.130	-.203	-.203
POA TO CENTROID in.	:	.171	.363	.234
MIN RADIUS	:	.507	.317	.502
MEAN RADIUS	:	1.148	1.027	.995
MAX RADIUS	:	1.835	1.508	1.539
HORIZONTAL SPREAD	:	3.390	2.930	2.170
VERTICAL SPREAD	:	2.420	2.420	2.420
EXTREME SPREAD	:	3.467	2.956	2.740
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648981

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.839

VS= 2.040

GS= 3.266

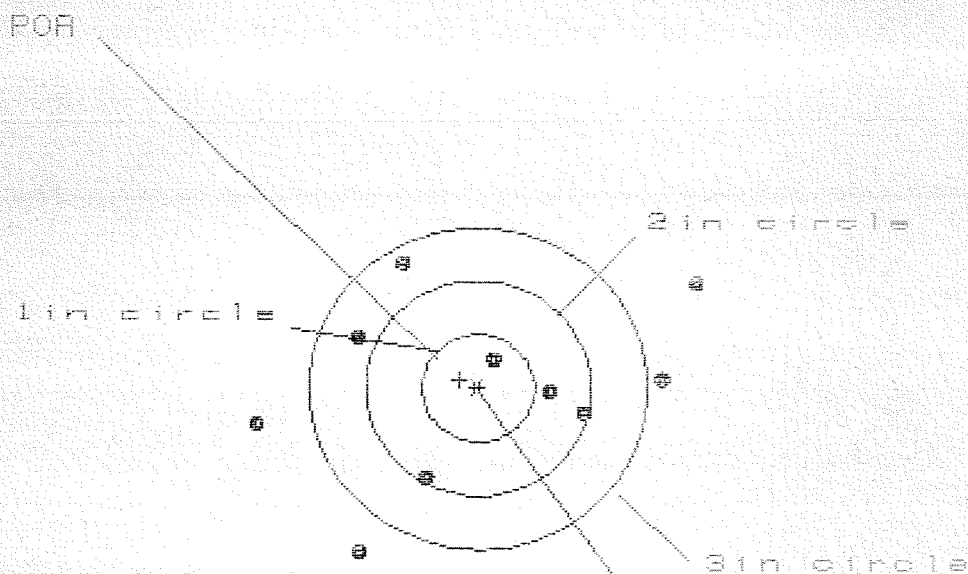
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.787	.919	.834
MINIMUM X	-1.052	-.853	-.938
MAXIMUM Y	1.063	.977	.937
MINIMUM Y	-.977	-1.063	-.940
CENTROID X	.376	.177	.262
CENTROID Y	.068	.154	.031
POA TO CENTROID in.	.382	.234	.264
MIN RADIUS	.143	.223	.092
MEAN RADIUS	.955	.834	.769
MAX RADIUS	1.947	1.405	1.286
HORIZONTAL SPREAD	2.839	1.772	1.772
VERTICAL SPREAD	2.040	2.040	1.877
EXTREME SPREAD	3.266	2.594	2.540
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648381

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.895

VS= 2.689

GS= 4.093

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.909	1.894	1.672
MINIMUM X	:	-1.986	-1.774	-1.081
MAXIMUM Y	:	1.133	1.240	1.217
MINIMUM Y	:	-1.556	-1.449	-1.472
CENTROID X	:	.165	-.047	.175
CENTROID Y	:	-.071	-.178	-.155
POA TO CENTROID in.	:	.180	.185	.234
MIN RADIUS	:	.337	.543	.411
MEAN RADIUS	:	1.306	1.224	1.119
MAX RADIUS	:	2.138	1.900	1.826
HORIZONTAL SPREAD	:	3.895	3.668	2.753
VERTICAL SPREAD	:	2.689	2.689	2.689
EXTREME SPREAD	:	4.093	3.684	3.185
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	