

C6636251

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

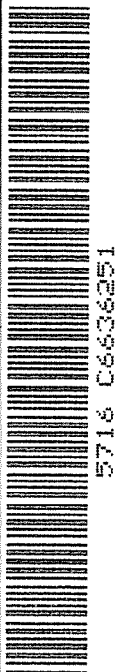
Capacity

Order No. **5715**

*Includes 1 in chamber.

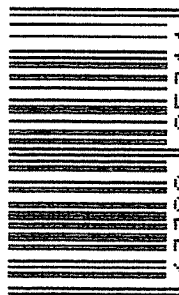


Remington  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24	SERIAL NO. C6636251	ORDER NO. 5716
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		



5716 C6636251

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636251

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25 91		RW
600	Proof	6 25 91		RW
607	Check Headspace	6 25 91		RW
610	Dis-assemble Gun	6 25 91		RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	EB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	JS
	Apply Coating (Bolt)			JS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/27/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	RW
	C) Inspect Ejector Hole for Chamfer		8/27/91	RW
	D) Oil Firing Pin Ass'y		8/27/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/28/91	SH
	G) Safety Off Force	4	4	4			8/28/91	SH
	H) Trigger Pull Test & Retainability						8/27/91	SH
	I) Firing Pin Indent	0235	0225	0225			8/28/91	SH
	J) Assemble Stock						8/28/91	RW
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	RW
	M) Iron Sight Alignment						8/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	RW
	O) Attach Scope to Rifle						8/28/91	RW
	P) Detach & Attach Scope 20 Times						8/28/91	RW
640	Gallery Target & Test						8/28/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/28/91	KT
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	259	267	267	258	258	8/29/91	SH
	C) Function						8-31-91	DH
660	Pack						8-31-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6636251

DATE 8/27/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.39	2.30	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.35	2.38	2.67	
PULL #3	2.35	2.41	2.36	2.67	
PULL #4	2.36	2.38	2.48	2.58	
PULL #5	2.30	2.35	2.43	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.56		
PULL #2	3.54	3.54		
PULL #3	3.60	3.41		
PULL #4	3.59	3.49		
PULL #5	3.55	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.60		4.65
PULL #2	4.53	4.63		4.64
PULL #3	4.48	4.57		4.62
PULL #4	4.54	4.48		4.66
PULL #5	4.59	4.51		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636251
29 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.19542
1 TO 2	.118069
1 TO 3	.160655
1 TO 4	.434716
1 TO 5	.412866

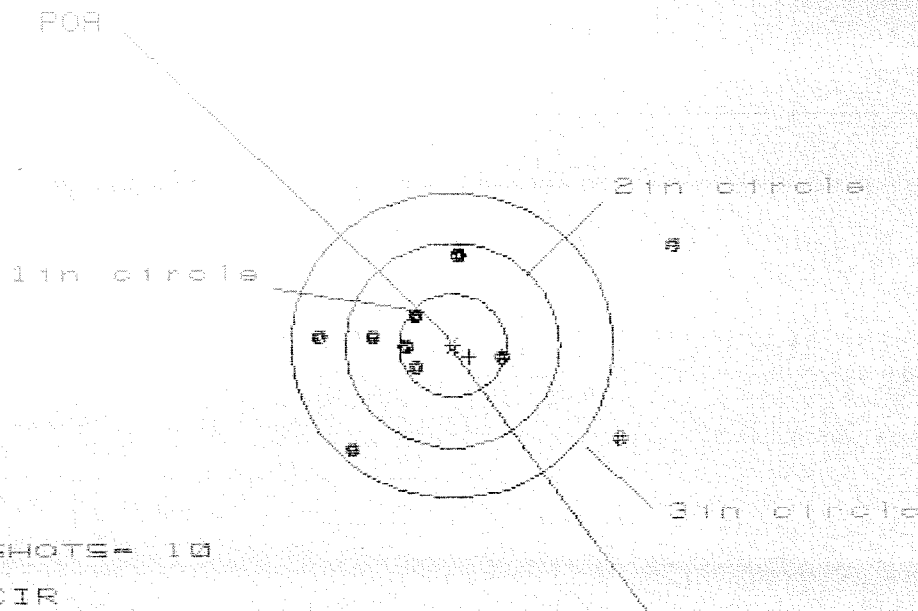
5.314 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 7.143
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0072
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .143181
THE AOR FOR THIS RIFLE IS: 1.027

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636251

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 3.244

VS= 2.030

GS= 3.566

CENTROID *

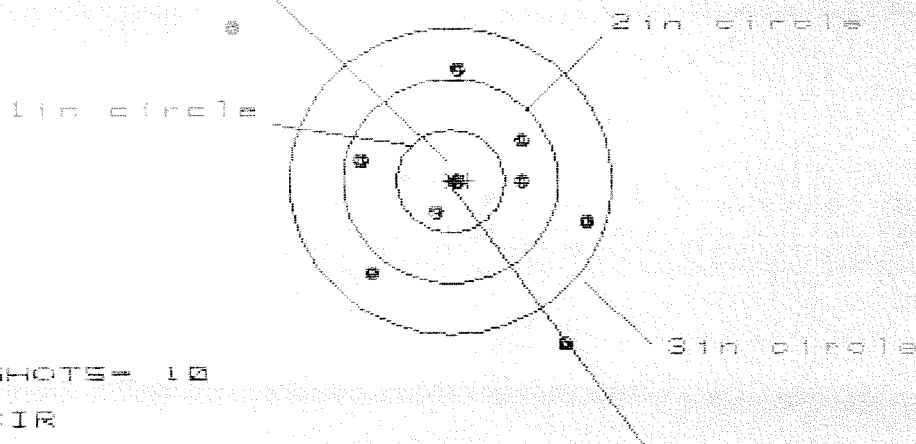
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.011	1.752	.930
MINIMUM X	-1.233	-1.010	-.791
MAXIMUM Y	1.032	.950	.854
MINIMUM Y	-.998	-.883	-.979
CENTROID X	-.158	-.381	-.600
CENTROID Y	.115	-.000	.096
POA TO CENTROID in.	.195	.381	.600
MIN RADIUS	.409	.166	.055
MEAN RADIUS	1.002	.791	.583
MAX RADIUS	2.260	1.913	1.091
HORIZONTAL SPREAD	3.244	2.762	1.721
VERTICAL SPREAD	2.030	1.833	1.833
EXTREME SPREAD	3.566	2.922	2.067
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

20 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636251

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.262

VS= 3.070

GS= 4.335

CENTROID *

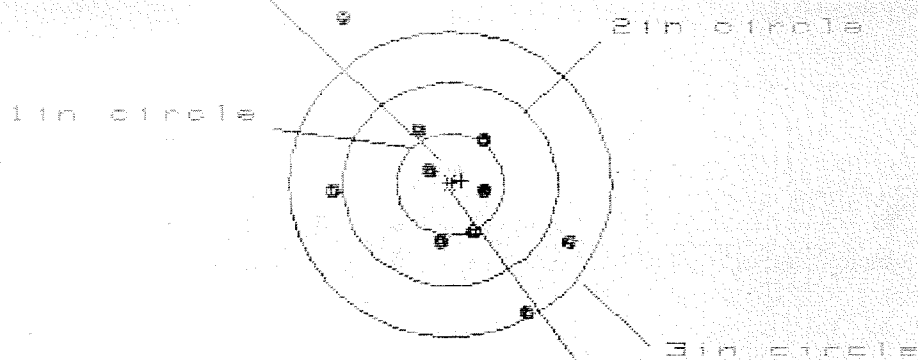
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.274	1.053	1.160
MINIMUM X	-1.988	-1.055	-1.948
MAXIMUM Y	1.502	1.236	1.061
MINIMUM Y	-1.568	-1.401	-0.866
CENTROID X	-0.162	.059	-0.048
CENTROID Y	-0.003	-0.170	.005
POA TO CENTROID in.	.162	.180	.048
MIN RADIUS	.059	.233	.056
MEAN RADIUS	1.054	.888	.760
MAX RADIUS	2.492	1.639	1.222
HORIZONTAL SPREAD	3.262	2.108	2.108
VERTICAL SPREAD	3.070	2.637	1.927
EXTREME SPREAD	4.335	2.822	2.186
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

28 Aug 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.188

VS = 2.887

GS = 3.356

CENTROID *

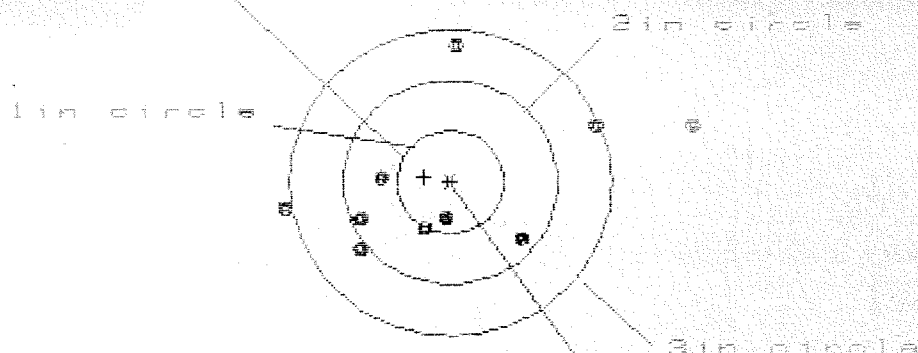
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.078
MINIMUM X	-1.110
MAXIMUM Y	1.645
MINIMUM Y	-1.242
CENTROID X	-.109
CENTROID Y	-.038
POA TO CENTROID in.	.116
MIN RADIUS	.251
MEAN RADIUS	.842
MAX RADIUS	1.903
HORIZONTAL SPREAD	2.188
VERTICAL SPREAD	2.887
EXTREME SPREAD	3.356
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636251

CENTERFIRE PATTERNS # 4

POA



* OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.798

VS= 2.001

GS= 3.000

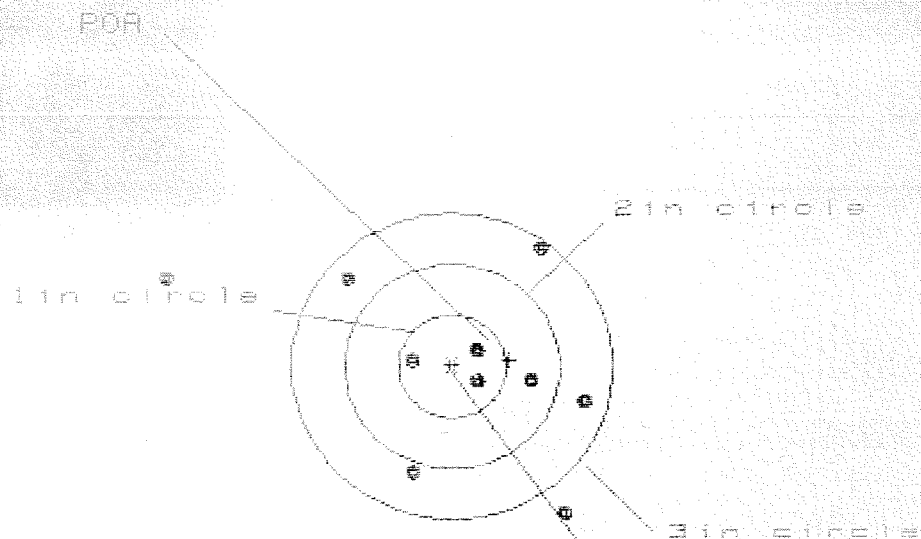
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.214	1.591	1.424
MINIMUM X	-1.584	-1.338	-1.758
MAXIMUM Y	1.390	1.451	1.428
MINIMUM Y	-1.611	-1.550	-1.573
CENTROID X	.245	-.001	.166
CENTROID Y	-.048	-.109	-.086
POA TO CENTROID in.	.249	.109	.187
MIN RADIUS	.342	.367	.315
MEAN RADIUS	1.185	.910	.873
MAX RADIUS	2.281	1.703	1.539
HORIZONTAL SPREAD	3.798	2.929	2.182
VERTICAL SPREAD	2.001	2.001	2.001
EXTREME SPREAD	3.000	3.034	2.459
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

28 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 3

HS = 3.825

VS = 2.596

GS = 4.342

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.188	.895	.988
MINIMUM X	-2.638	-1.249	-1.156
MAXIMUM Y	1.148	1.244	1.075
MINIMUM Y	-1.448	-1.352	-1.157
CENTROID X	-.531	-.238	-.331
CENTROID Y	-.062	-.158	.011
POA TO CENTROID in.	.535	.285	.332
MIN RADIUS	.295	.021	.097
MEAN RADIUS	1.134	.884	.802
MAX RADIUS	2.774	1.596	1.419
HORIZONTAL SPREAD	3.826	2.144	2.144
VERTICAL SPREAD	2.596	2.596	2.232
EXTREME SPREAD	4.342	3.080	2.534
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	3		