

06636253

MODEL 700TH M24

Model **SMS** TH

Action

Barrel Length

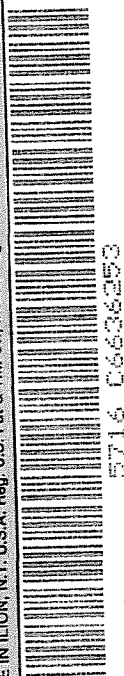
Capacity

Order No. **5716**

*Includes 1 in chamber.

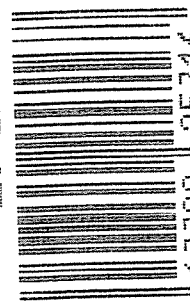
Remington

Remington MODEL 700™ M24 MADE IN ILLION, 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.
		SERIAL NO. C6636253
20		ORDER NO. 5716



5716 C6636253

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636253**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KE
600	Proof		6/24/91	KE
607	Check Headspace		6/24/91	KE
610	Dis-assemble Gun		6/24/91	KE
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS
617	Drill and Tap Sight Holes	JUL	1 1991	KB
618	Polish Barrel	JUL	2 1991	KB
620	Apply Coatings (Barrel Action)		7-23-91	KS
	Apply Coating (Bolt)			KS
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-31-91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 $\frac{1}{2}$	7	7			7-31-91	DH
	G) Safety Off Force	4	4	4			7-31-91	DH
	H) Trigger Pull Test & Retainability						7/31/91	X
	I) Firing Pin Indent	.022	.021	.027			7-31-91	DH
	J) Assemble Stock						7/31/91	K8
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/31/91	KL
	M) Iron Sight Alignment						7/31/91	KL
	N) Detach Front & Rear Sights & place in numbered container						7/31/91	KL
	O) Attach Scope to Rifle						7/31/91	KL
	P) Detach & Attach Scope 20 Times						7/31/91	KL
640	Gallery Target & Test						8-1-91	DH
	A) Time						8-1-91	DH
	B) Malfunctions						8-1-91	DH
	C) Pierced Primers						8-1-91	DH
	D) Optical Clarity of Scope						8-1-91	DH
645	Inspect for Live Ammo						8-1-91	DH
655	Final Inspection							
	A) Headspace						8-5-91	A
	B) Trigger Pull	2.45	2.20	2.55	2.48	2.50	8-5-91	X
	C) Function						8-5-91	A
660	Pack						9-11-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6636253

DATE 7-31-91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.56	2.52	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.36	2.55	2.20	
PULL #3	2.43	2.56	2.49	2.55	
PULL #4	2.56	2.51	2.55	2.48	
PULL #5	2.41	2.56	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.54		
PULL #2	3.49	3.60		
PULL #3	3.49	3.56		
PULL #4	3.49	3.62		
PULL #5	3.48	3.56		
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	4.27		4.37
PULL #2	4.19	4.34		4.41
PULL #3	4.29	4.34		4.37
PULL #4	4.35	4.35		4.31
PULL #5	4.23	4.32		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636253
1 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.123329
1 TO 2	.370871
1 TO 3	.663871
1 TO 4	.528573
1 TO 5	.0349857

3
2 <----POB
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0924
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155122

THE AMR FOR THIS RIFLE IS: .9108

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB836253

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.930

VS= 1.942

GS= 2.932

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.240	1.052	.733
MINIMUM X	-1.690	-1.314	-1.182
MAXIMUM Y	.866	.866	.880
MINIMUM Y	-1.076	-1.076	-1.062
CENTROID X	-.039	.149	.017
CENTROID Y	.117	.117	.103
POA TO CENTROID in.	.123	.189	.104
MIN RADIUS	.227	.152	.200
MEAN RADIUS	.953	.846	.822
MAX RADIUS	1.690	1.314	1.182
HORIZONTAL SPREAD	2.930	2.366	1.915
VERTICAL SPREAD	1.942	1.942	1.942
EXTREME SPREAD	2.932	2.371	2.242
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6836253

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.588

VS= 2.760

GS= 2.760

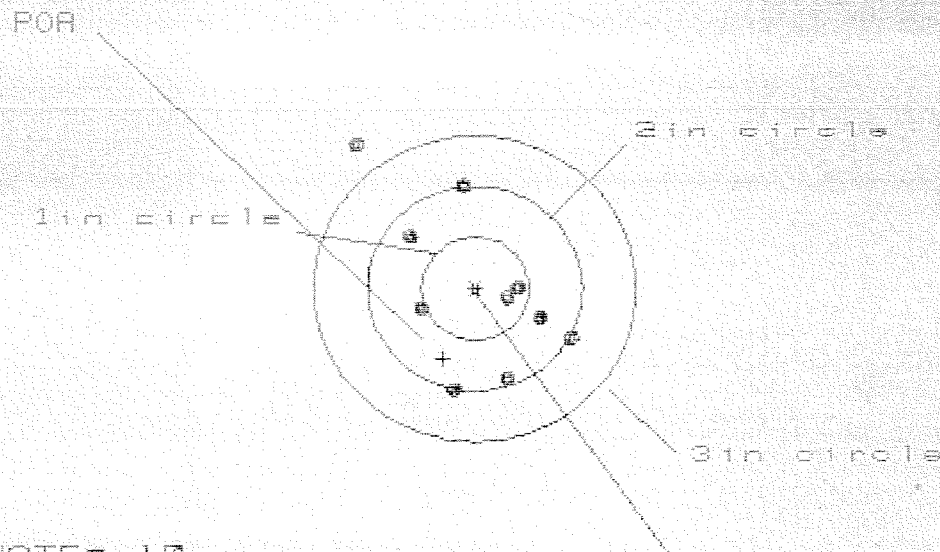
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.101	.936	.916
MINIMUM X	-1.487	-.582	-.602
MAXIMUM Y	1.384	1.342	1.156
MINIMUM Y	-1.376	-1.418	-1.250
CENTROID X	.297	.462	.482
CENTROID Y	-.040	.002	-.166
POA TO CENTROID in.	.300	.462	.510
MIN RADIUS	.510	.404	.375
MEAN RADIUS	.974	.891	.818
MAX RADIUS	1.534	1.423	1.303
HORIZONTAL SPREAD	2.588	1.518	1.510
VERTICAL SPREAD	2.760	2.760	2.406
EXTREME SPREAD	2.760	2.760	2.449
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6636253

CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.079

VS = 2.398

GS = 2.868

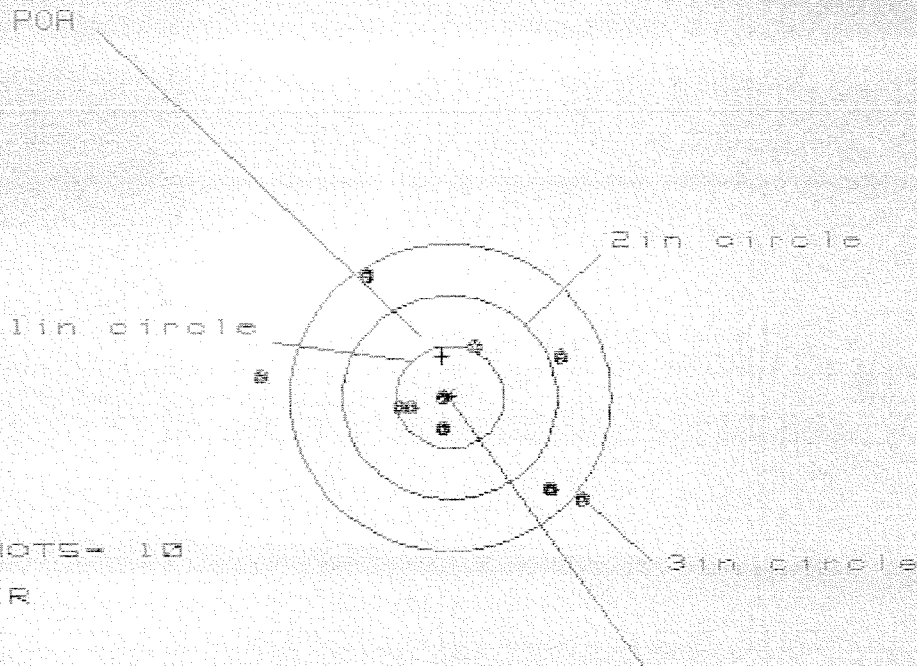
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.818	.622
MINIMUM X	:	-1.135	-.691	-.589
MAXIMUM Y	:	1.451	1.135	1.090
MINIMUM Y	:	-.947	-.786	-.831
CENTROID X	:	.303	.429	.327
CENTROID Y	:	.686	.525	.570
POA TO CENTROID in.	:	.750	.678	.657
MIN RADIUS	:	.278	.135	.229
MEAN RADIUS	:	.854	.699	.686
MAX RADIUS	:	1.842	1.164	1.101
HORIZONTAL SPREAD	:	2.079	1.509	1.211
VERTICAL SPREAD	:	2.398	1.921	1.921
EXTREME SPREAD	:	2.868	1.923	1.923
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB636253

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 3.021

VS= 2.166

GS= 3.231

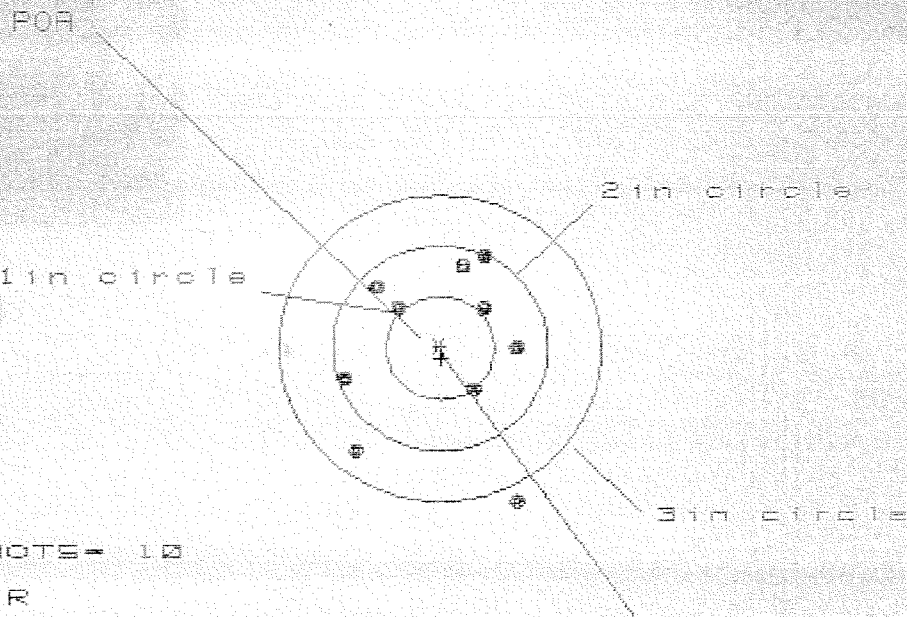
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	5	8
MAXIMUM X	:	1.267	1.072	.921
MINIMUM X	:	-1.754	-.984	-.050
MAXIMUM Y	:	1.215	1.237	1.121
MINIMUM Y	:	-.951	-.929	-.971
CENTROID X	:	.071	.266	.132
CENTROID Y	:	-.400	-.422	-.306
POA TO CENTROID in.	:	.407	.499	.333
MIN RADIUS	:	.068	.254	.122
MEAN RADIUS	:	.883	.813	.700
MAX RADIUS	:	1.765	1.581	1.407
HORIZONTAL SPREAD	:	3.021	2.056	1.771
VERTICAL SPREAD	:	2.166	2.166	2.092
EXTREME SPREAD	:	3.231	2.986	2.711
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Aug 1991

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CENTERFIRE PATTERNS

5



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 9

HS= 1.557

VS= 2.476

GS= 2.521

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.685	.744	.654
MINIMUM X	:	-.872	-.796	-.886
MAXIMUM Y	:	.949	.779	.636
MINIMUM Y	:	-1.527	-1.147	-.714
CENTROID X	:	-.009	-.085	.005
CENTROID Y	:	.099	.269	.412
POA TO CENTROID in.	:	.099	.282	.412
MIN RADIUS	:	.514	.389	.365
MEAN RADIUS	:	.890	.773	.669
MAX RADIUS	:	1.674	1.353	1.089
HORIZONTAL SPREAD	:	1.557	1.540	1.540
VERTICAL SPREAD	:	2.476	1.926	1.350
EXTREME SPREAD	:	2.521	2.275	1.809
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	