

C6648932

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

crack
stock

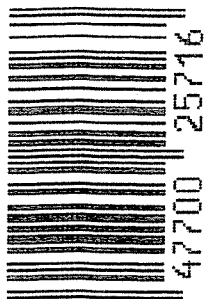
Repaired

9/16/91 RW

Remington® REG. U.S. PAT. & TM. OFF. 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6648932	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		06	



LPC



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648932

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-28-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	SH
	G) Safety Off Force	4	4	4			9/11/91	SH
	H) Trigger Pull Test & Retainability						9-11-91	SH
	I) Firing Pin Indent	.022	.022	.022			9/11/91	SH
	J) Assemble Stock						9/13/91	RW
	K) Assemble Swivel Studs						9-16-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/13/91	RW
	M) Iron Sight Alignment						9/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/13/91	RW
	O) Attach Scope to Rifle						9/13/91	RW
	P) Detach & Attach Scope 20 Times						9/13/91	RW
	640	Gallery Target & Test						9-14-91
	A) Time						9-14-91	D/H
	B) Malfunctions						9-14-91	D/H
	C) Pierced Primers						9-14-91	D/H
	D) Optical Clarity of Scope						9-14-91	D/H
645	Inspect for Live Ammo						9-14-91	D/H
655	Final Inspection						9-16-91	D/H
	A) Headspace							
	B) Trigger Pull	258	248	247	251	255	9-16-91	D/H
	C) Function						9-16-91	D/H
660	Pack						9-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06648932

DATE 9-11-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.49	2.55	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.39	2.63	2.48	
PULL #3	2.38	2.53	2.60	2.47	
PULL #4	2.45	2.64	2.50	2.51	
PULL #5	2.48	2.65	2.52	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.47		
PULL #2	3.66	3.54		
PULL #3	3.47	3.60		
PULL #4	3.67	3.62		
PULL #5	3.33	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.67		4.70
PULL #2	4.58	4.50		4.34
PULL #3	4.28	4.51		4.39
PULL #4	4.35	4.51		4.45
PULL #5	4.31	4.32		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648932
14 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0860233
1 TO	2	.19898
1 TO	3	.144997
1 TO	4	.0860233
1 TO	5	.269258

44 <----POA

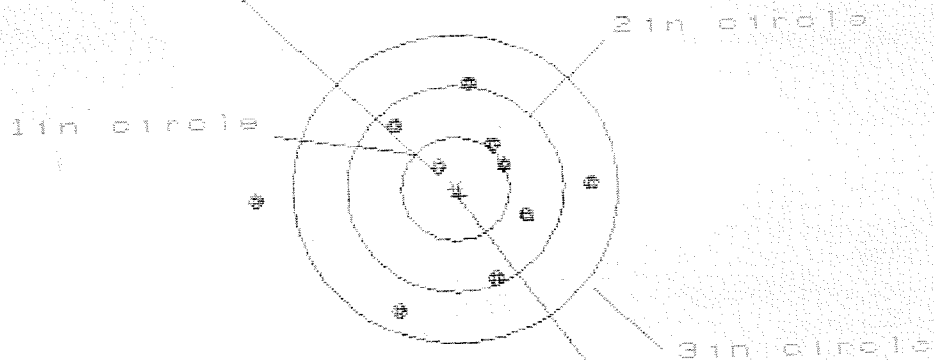
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.135
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .044
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141689
THE AMR FOR THIS RIFLE IS: 1.002

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B932

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.076

VS= 2.244

GS= 3.076

CENTROID *

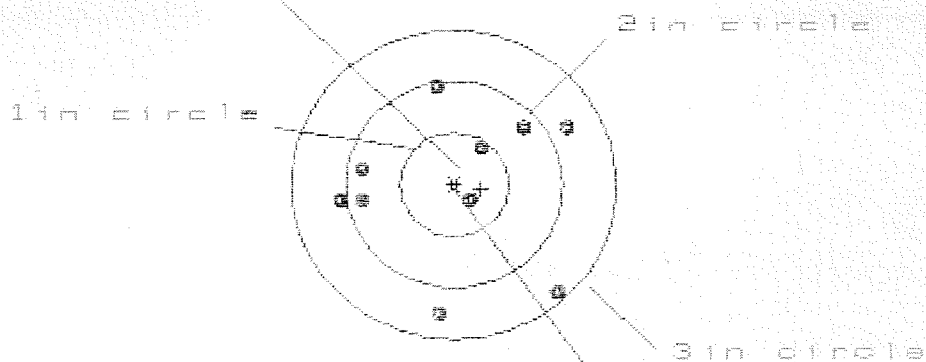
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.221	1.015	.924
MINIMUM X	-1.853	-.804	-.895
MAXIMUM Y	1.053	1.046	.896
MINIMUM Y	-1.191	-1.198	-1.041
CENTROID X	-.058	.156	.247
CENTROID Y	.070	.077	.227
POA TO CENTROID in.	.086	.174	.336
MIN RADIUS	.241	.296	.144
MEAN RADIUS	.917	.776	.659
MAX RADIUS	1.856	1.401	1.043
HORIZONTAL SPREAD	3.076	1.819	1.819
VERTICAL SPREAD	2.244	2.244	1.937
EXTREME SPREAD	3.076	2.338	1.949
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

14 Sep 1931

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CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.149

VS= 2.262

GS= 2.366

CENTROID *

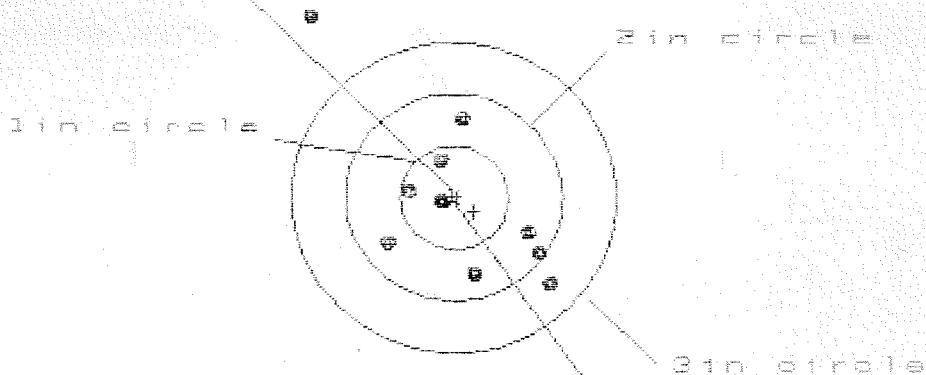
PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.091	1.197	1.194
MINIMUM X	-1.058	-.952	-.955
MAXIMUM Y	.993	.873	.699
MINIMUM Y	-1.269	-1.389	-.439
CENTROID X	-.247	-.353	-.350
CENTROID Y	.042	.162	.336
POA TO CENTROID in.	.250	.389	.485
MIN RADIUS	.196	.355	.329
MEAN RADIUS	.933	.864	.784
MAX RADIUS	1.445	1.389	1.232
HORIZONTAL SPREAD	2.149	2.149	2.149
VERTICAL SPREAD	2.262	2.262	1.138
EXTREME SPREAD	2.366	2.273	2.273
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.217

VS= 2.582

GS= 3.403

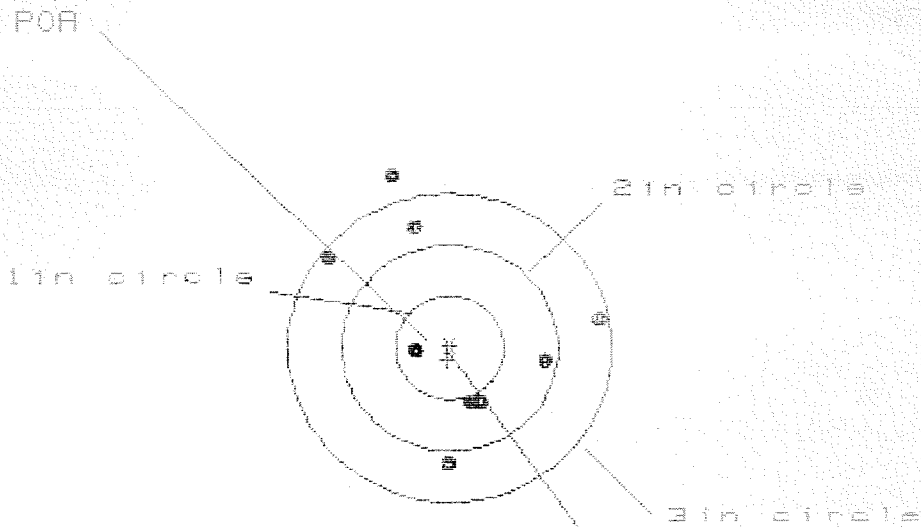
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.915	.770	.689
MINIMUM X	-1.302	-.771	-.674
MAXIMUM Y	1.787	.941	.867
MINIMUM Y	-.795	-.597	-.639
CENTROID X	-.182	-.037	-.134
CENTROID Y	.130	-.068	.006
POA TO CENTROID in.	.224	.078	.134
MIN RADIUS	.162	.309	.194
MEAN RADIUS	.837	.677	.620
MAX RADIUS	2.211	.974	.868
HORIZONTAL SPREAD	2.217	1.541	1.363
VERTICAL SPREAD	2.582	1.538	1.506
EXTREME SPREAD	3.403	1.743	1.507
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.473

VS = 3.594

GS = 3.594

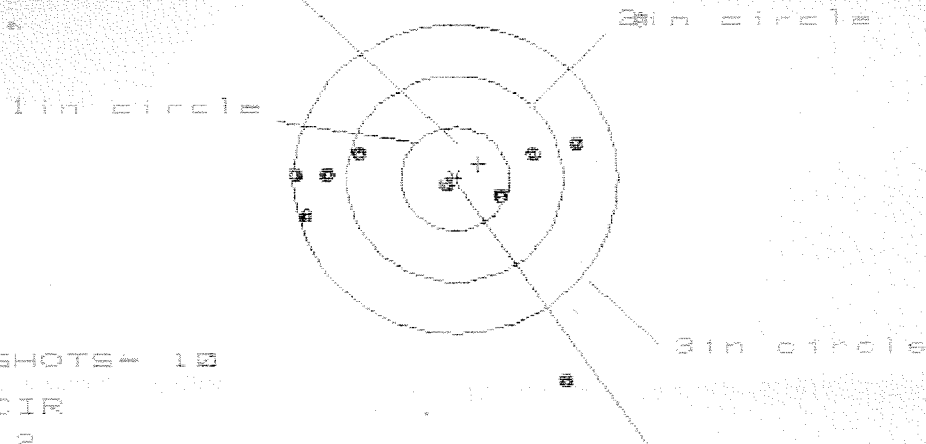
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.397	1.338	1.266
MINIMUM X	:	-1.076	-1.135	-1.207
MAXIMUM Y	:	1.724	1.516	1.204
MINIMUM Y	:	-1.870	-1.331	-1.141
CENTROID X	:	.020	.079	.151
CENTROID Y	:	.120	.328	.138
POA TO CENTROID in.	:	.122	.337	.205
MIN RADIUS	:	.319	.438	.450
MEAN RADIUS	:	1.132	1.058	.943
MAX RADIUS	:	1.944	1.621	1.501
HORIZONTAL SPREAD	:	2.473	2.473	2.473
VERTICAL SPREAD	:	3.594	2.847	2.345
EXTREME SPREAD	:	3.594	2.887	2.551
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6648332

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.194

VS= 3.439

GS= 3.628

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.737	1.264	1.418
MINIMUM X	-1.457	-1.264	-1.110
MAXIMUM Y	1.508	1.506	1.285
MINIMUM Y	-1.931	-1.763	-1.373
CENTROID X	-.216	-.409	-.563
CENTROID Y	-.142	-.310	-.089
POA TO CENTROID in.	.259	.513	.570
MIN RADIUS	.085	.176	.283
MEAN RADIUS	1.191	1.069	.906
MAX RADIUS	2.300	2.151	1.447
HORIZONTAL SPREAD	3.194	2.528	2.528
VERTICAL SPREAD	3.439	2.269	1.659
EXTREME SPREAD	3.628	3.211	2.554
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 8		