

C6636051

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington

Remington®


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

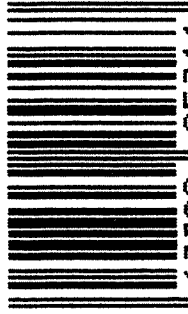
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24	SERIAL NO. C6636051
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.	ORDER NO. 5716



5716 C6636051

UPC



0 47200 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636051

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	Ru
600	Proof	4 8	91	Ru
607	Check Headspace	4 8	91	Ru
610	Dis-assemble Gun	4 8	91	Ru
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	U
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 9 1991	FB
618	Polish Barrel		APR 9 1991	WU
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	Ru
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	Ru
	C) Inspect Ejector Hole for Chamfer		5/14/91	Ru
	D) Oil Firing Pin Ass'y		5/14/91	Ru
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-28-91	D/H
	G) Safety Off Force	3	3	3			5-28-91	D/H
	H) Trigger Pull Test & Retainability						5/25/91	NU
	I) Firing Pin Indent	.022	.022	.022			5-28-91	D/H
	J) Assemble Stock						5/29/91	Rev
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/29/91	Rev
	M) Iron Sight Alignment						5/29/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	Rev
	O) Attach Scope to Rifle						5/29/91	Rev
	P) Detach & Attach Scope 20 Times						5/29/91	Rev
640	Gallery Target & Test						5-31-91	AC
	A) Time						5-31-91	AC
	B) Malfunctions						5-31-91	AC
	C) Pierced Primers						5-31-91	AC
	D) Optical Clarity of Scope						5-31-91	AC
645	Inspect for Live Ammo						5-31-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.29	2.33	2.30	2.31	2.30	6/1/91	NU
	C) Function						6-1-91	D/H
660	Pack						6-20-91	W

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6636051

DATE 5/25/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.68	2.39	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.69	2.44	2.33	
PULL #3	2.54	2.34	2.45	2.30	
PULL #4	2.62	2.25	2.48	2.31	
PULL #5	2.58	2.57	2.38	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.56		
PULL #2	3.52	3.40		
PULL #3	3.52	3.57		
PULL #4	3.54	3.57		
PULL #5	3.45	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	4.19	4.25		4.23
PULL #2	4.24	4.22		4.23
PULL #3	4.25	4.26		4.23
PULL #4	4.25	4.18		4.23
PULL #5	4.25	4.20		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636051
31 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0730068
1 TO	2	.153688
1 TO	3	.311117
1 TO	4	.0276586
1 TO	5	.385188

$\frac{5}{4}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .141
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .177609
THE AMR FOR THIS RIFLE IS: 1.025

FILE: /PATTERNING/CENTERFIRE PATT/08638851

Diagram illustrating a target with three concentric circles. The circles are labeled 1in circle, 2in circle, and 3in circle. A line labeled POB points to the center of the circles.

CONFIDENTIAL























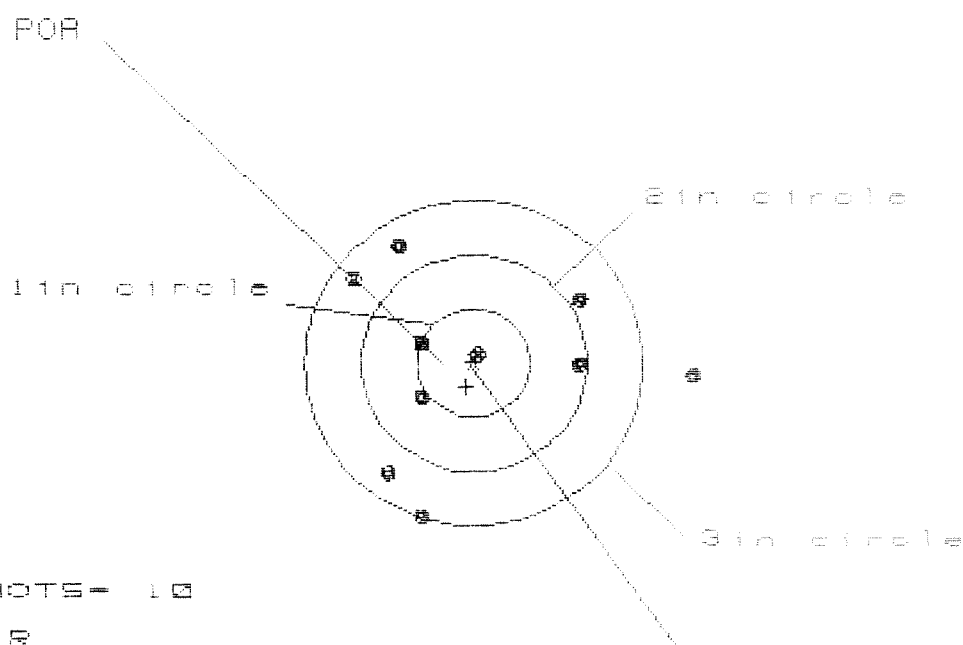


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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.018

VS= 2.491

GS= 3.142

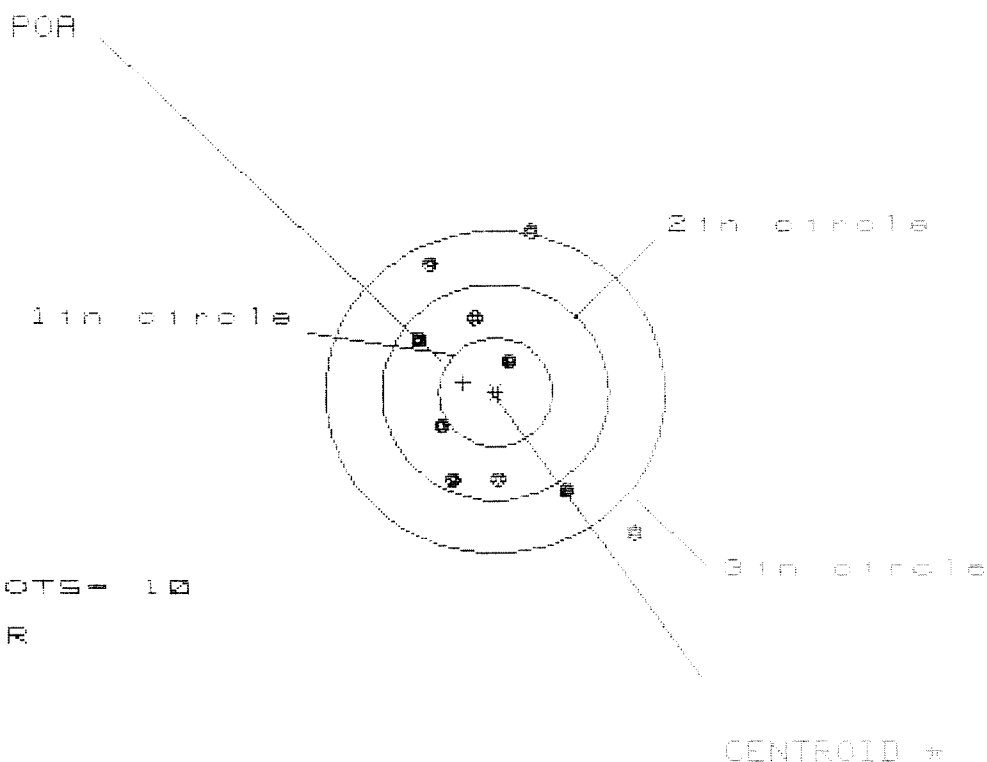
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.950	1.179	1.148
MINIMUM X	:	-1.068	-.852	-.883
MAXIMUM Y	:	1.090	1.079	.902
MINIMUM Y	:	-1.401	-1.412	-1.206
CENTROID X	:	.065	-.151	-.120
CENTROID Y	:	.217	.228	.405
POR TO CENTROID in.	:	.227	.274	.423
MIN RADIUS	:	.096	.261	.234
MEAN RADIUS	:	1.047	.921	.846
MAX RADIUS	:	1.952	1.434	1.318
HORIZONTAL SPREAD	:	3.018	2.031	2.031
VERTICAL SPREAD	:	2.491	2.491	2.108
EXTREME SPREAD	:	3.142	2.501	2.300
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1in = 1
 2in = 5
 3in = 8
 HS= 1.908
 VS= 2.770
 GS= 3.039

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	.784	.842
MINIMUM X	:	-.683	-.547	-.489
MAXIMUM Y	:	1.491	1.349	1.196
MINIMUM Y	:	-1.279	-1.081	-.912
CENTROID X	:	.282	.146	.088
CENTROID Y	:	-.092	.050	-.119
POA TO CENTROID in.	:	.296	.154	.148
MIN RADIUS	:	.291	.259	.346
MEAN RADIUS	:	.989	.875	.797
MAX RADIUS	:	1.771	1.427	1.255
HORIZONTAL SPREAD	:	1.908	1.331	1.331
VERTICAL SPREAD	:	2.770	2.430	2.108
EXTREME SPREAD	:	3.039	2.451	2.437
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.407

VS= 2.736

GS= 3.291

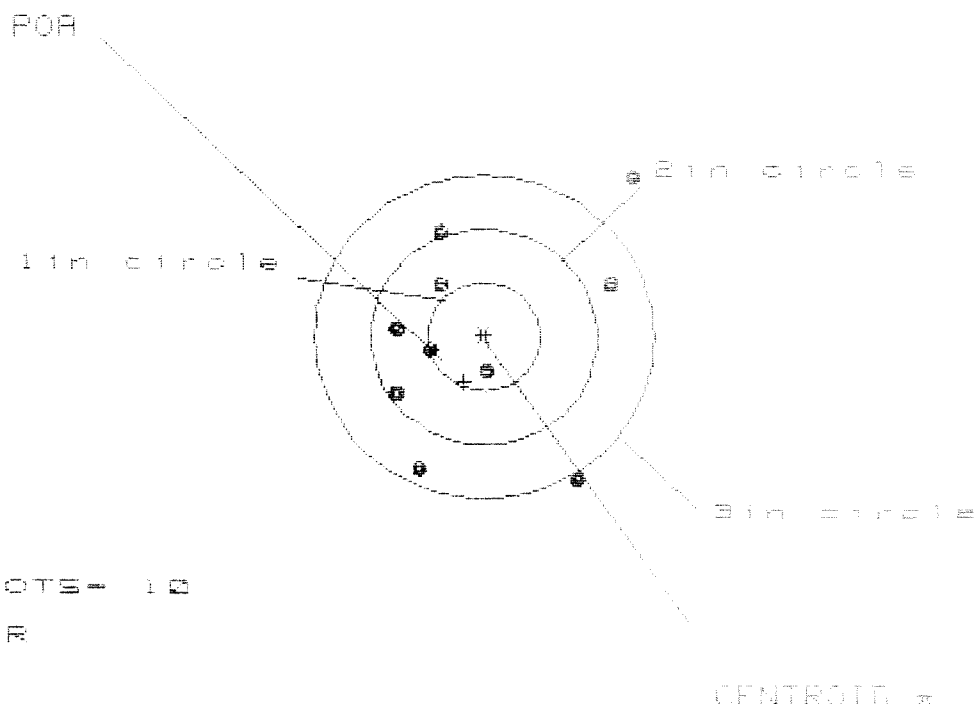
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.299	1.190	1.038
MINIMUM X	:	-1.108	-1.217	-1.991
MAXIMUM Y	:	.877	.670	.735
MINIMUM Y	:	-1.859	-.965	-.900
CENTROID X	:	-.004	.105	.257
CENTROID Y	:	.089	.296	.231
POA TO CENTROID in.	:	.089	.314	.345
MIN RADIUS	:	.379	.261	.328
MEAN RADIUS	:	.952	.793	.721
MAX RADIUS	:	2.102	1.322	1.040
HORIZONTAL SPREAD	:	2.407	2.407	2.029
VERTICAL SPREAD	:	2.736	1.635	1.635
EXTREME SPREAD	:	3.291	2.463	2.057
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.085

VS = 2.730

GS = 3.253

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.389	1.427
MINIMUM X	:	-1.795	-1.651	-1.533
MAXIMUM Y	:	1.431	1.165	1.022
MINIMUM Y	:	-1.299	-1.140	-1.244
CENTROID X	:	.100	.036	-.082
CENTROID Y	:	.420	.261	.404
POB TO CENTROID in.	:	.457	.264	.412
MIN RADIUS	:	.337	.232	.206
MEAN RADIUS	:	1.025	.878	.768
MAX RADIUS	:	1.927	1.483	1.527
HORIZONTAL SPREAD	:	2.085	1.960	1.960
VERTICAL SPREAD	:	2.730	2.305	2.266
EXTREME SPREAD	:	3.253	2.571	2.466
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	