

C6636178

MODEL 700TM M24

Model **SMS** TM

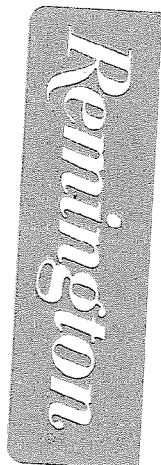
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

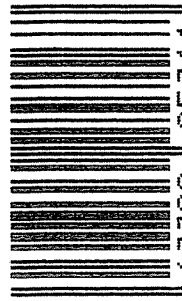


Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT! Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6636178	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off; Marca Registrada Marque Deposee.		20	



5716 C6636178

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636178

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5	2 9 1	Rw
600	Proof	5 2	9 1	Rw
607	Check Headspace	5 2	9 1	Rw
610	Dis-assemble Gun	5 2	9 1	Rw
612	Magnaflux Barrel Action	5 8	0 -	KCR
	Magnaflux Bolt	5 8	9 1	KCR
615	Rollmark Caliber	5 8	9 1	GB
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-29-91	TH
	Apply Coating (Bolt)			TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	GB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-4-91	QU
	G) Safety Off Force	3	3	3			6-4-91	QU
	H) Trigger Pull Test & Retainability						6-4-91	QU
	I) Firing Pin Indent	.0225	.022	.022			6-4-91	QU
	J) Assemble Stock						6-5-91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6-5-91	RW
	M) Iron Sight Alignment						6-5-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-5-91	RW
	O) Attach Scope to Rifle						6-5-91	RW
	P) Detach & Attach Scope 20 Times						6-5-91	RW
640	Gallery Target & Test						6-6-91	AC
	A) Time						6-6-91	AC
	B) Malfunctions						6-6-91	AC
	C) Pierced Primers						6-6-91	AC
	D) Optical Clarity of Scope						6-6-91	AC
645	Inspect for Live Ammo						6-6-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.39	2.39	2.50	2.51	2.57	6-8-91	QU
	C) Function						6-8-91	D/H
660	Pack						6-20-91	RF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636178
6 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.254751
1 TO 2	.387675
1 TO 3	.264121
1 TO 4	.0434166
1 TO 5	.0210238

2.4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .150877
THE AMR FOR THIS RIFLE IS: .9688

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8536178

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.199

VS= 1.992

GS= 2.201

CENTROID #

PATTERN #

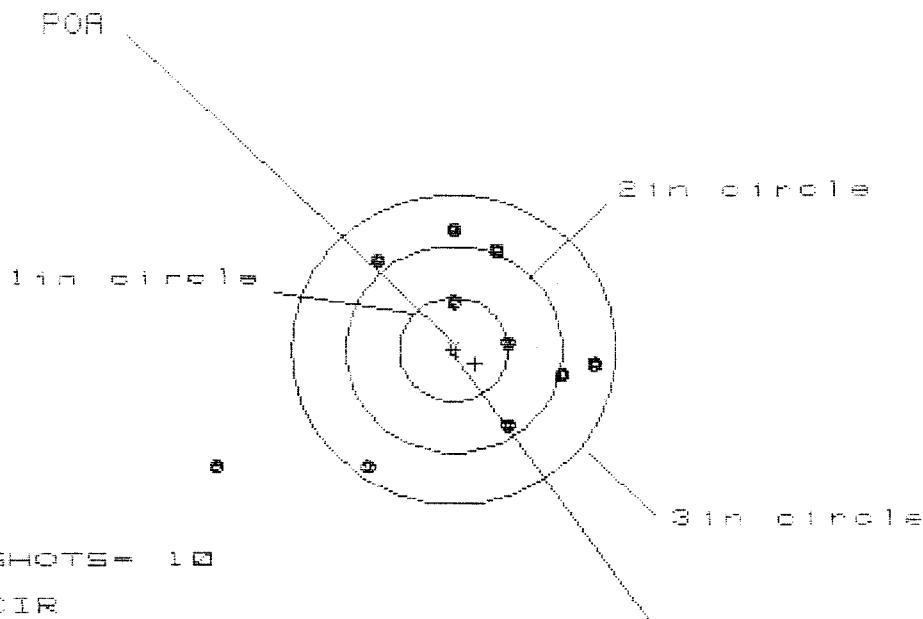
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.013	.865
MINIMUM X	:	-1.118	-1.186	-.890
MAXIMUM Y	:	1.187	.820	.879
MINIMUM Y	:	-.805	-.673	-.614
CENTROID X	:	.187	.255	.403
CENTROID Y	:	.173	.041	-.018
POB TO CENTROID in.	:	.254	.258	.404
MIN RADIUS	:	.485	.450	.353
MEAN RADIUS	:	.939	.871	.804
MAX RADIUS	:	1.337	1.275	1.122
HORIZONTAL SPREAD	:	2.199	2.199	1.755
VERTICAL SPREAD	:	1.992	1.493	1.493
EXTREME SPREAD	:	2.201	2.201	1.947
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 3.550

VS= 2.292

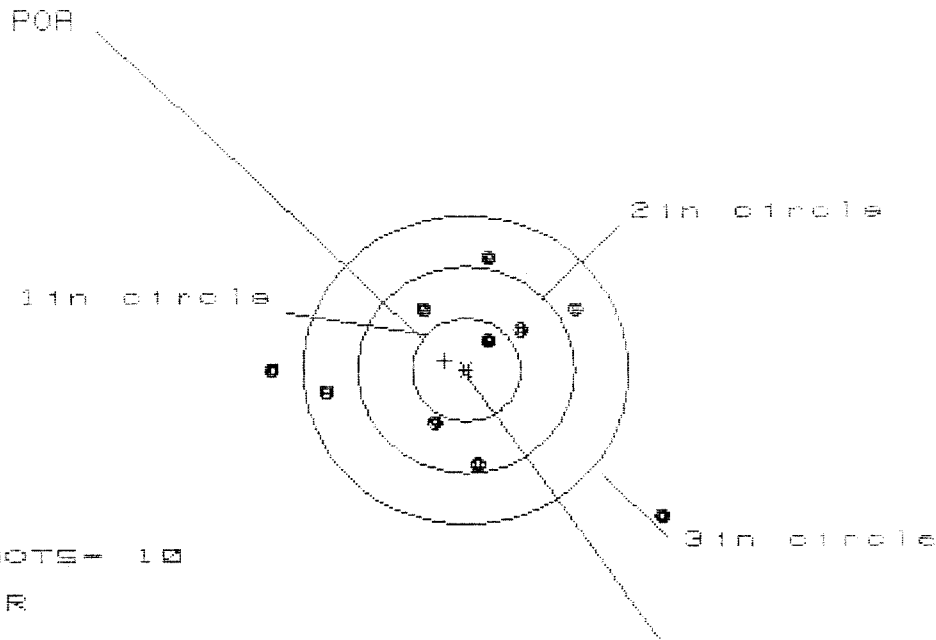
GS= 3.682

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.093	.958
MINIMUM X	:	-2.211	-1.083	-1.061
MAXIMUM Y	:	1.134	1.006	.848
MINIMUM Y	:	-1.158	-1.258	-1.029
CENTROID X	:	-.199	.047	.182
CENTROID Y	:	.137	.265	.423
POA TO CENTROID in.	:	.242	.269	.460
MIN RADIUS	:	.452	.262	.260
MEAN RADIUS	:	1.136	.914	.794
MAX RADIUS	:	2.496	1.660	1.223
HORIZONTAL SPREAD	:	3.550	2.176	2.019
VERTICAL SPREAD	:	2.292	2.264	1.877
EXTREME SPREAD	:	3.682	2.417	2.288
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= 3.643

VS= 2.475

GS= 3.895

CENTROID #

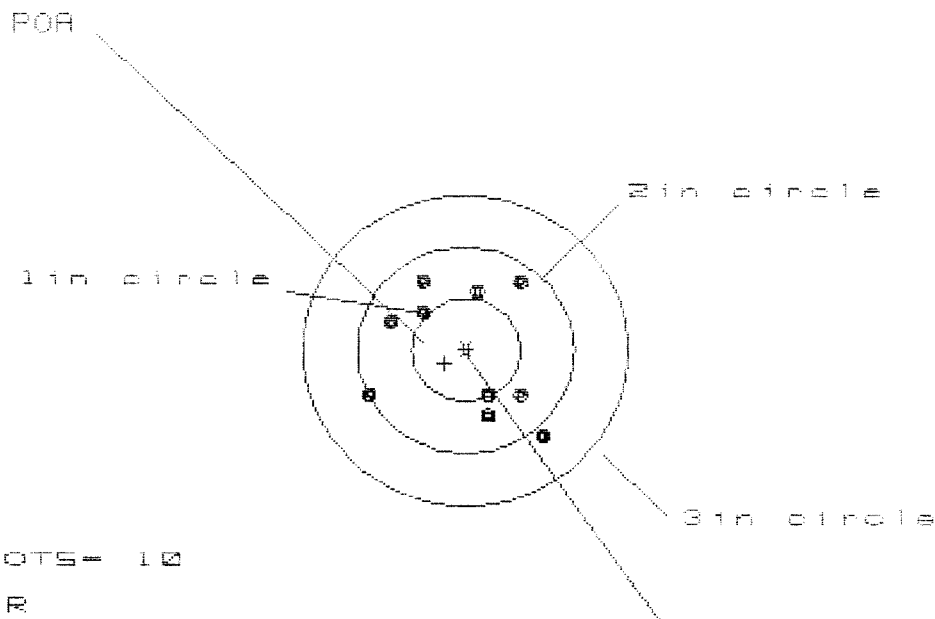
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.831	1.202	1.001
MINIMUM X	:	-1.812	-1.609	-1.304
MAXIMUM Y	:	1.093	.939	.919
MINIMUM Y	:	-1.382	-1.061	-1.081
CENTROID X	:	.195	-.008	.193
CENTROID Y	:	-.091	.063	.083
POR TO CENTROID in.	:	.215	.064	.210
MIN RADIUS	:	.346	.423	.235
MEAN RADIUS	:	1.084	.935	.812
MAX RADIUS	:	2.294	1.617	1.359
HORIZONTAL SPREAD	:	3.643	2.811	2.305
VERTICAL SPREAD	:	2.475	2.000	2.000
EXTREME SPREAD	:	3.895	2.881	2.451
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.616

VS= 1.490

GS= 1.867

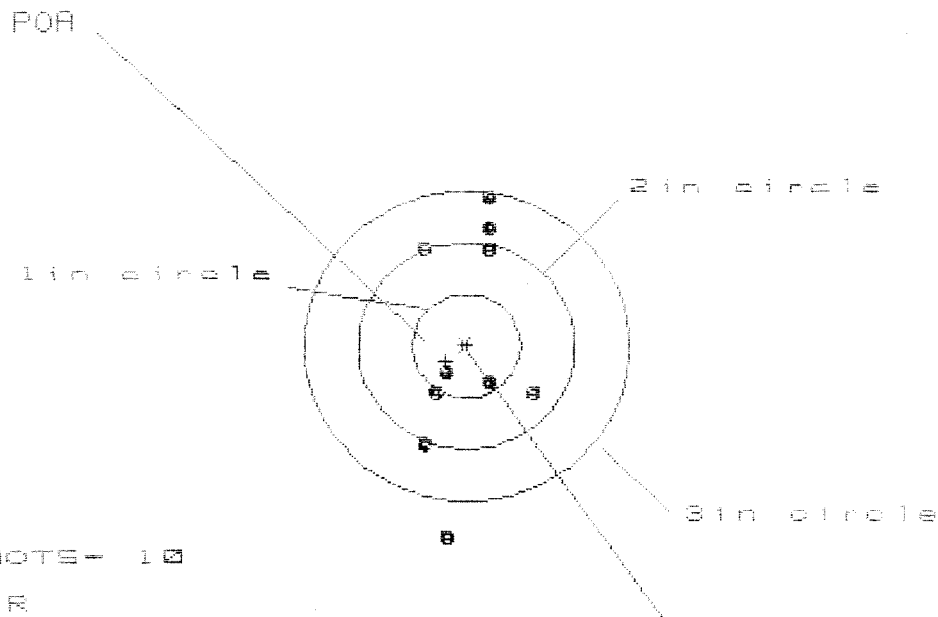
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.756	.639	.542
MINIMUM X	:	-.860	-.776	-.682
MAXIMUM Y	:	.683	.593	.533
MINIMUM Y	:	-.808	-.687	-.747
CENTROID X	:	.193	.109	.206
CENTROID Y	:	.130	.219	.279
POA TO CENTROID in.	:	.233	.245	.347
MIN RADIUS	:	.452	.439	.429
MEAN RADIUS	:	.727	.674	.637
MAX RADIUS	:	1.106	.912	.784
HORIZONTAL SPREAD	:	1.616	1.415	1.224
VERTICAL SPREAD	:	1.490	1.280	1.280
EXTREME SPREAD	:	1.867	1.775	1.413
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.094

VS= 3.248

CS= 3.275

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.657	.637	.663
MINIMUM X	:	-.437	-.457	-.431
MAXIMUM Y	:	1.429	1.227	1.111
MINIMUM Y	:	-1.819	-1.156	-.997
CENTROID X	:	.188	.268	.182
CENTROID Y	:	.152	.354	.201
POA TO CENTROID in.	:	.242	.411	.271
MIN RADIUS	:	.333	.527	.374
MEAN RADIUS	:	.958	.873	.796
MAX RADIUS	:	1.829	1.245	1.127
HORIZONTAL SPREAD	:	1.094	1.094	1.094
VERTICAL SPREAD	:	3.248	2.377	2.108
EXTREME SPREAD	:	3.275	2.463	2.191
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636178
DATE 6-4-91
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.65	2.48	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.65	2.50	2.39	
PULL #3	2.47	2.69	2.53	2.50	
PULL #4	2.50	2.22	2.55	2.51	
PULL #5	2.56	2.51	2.50	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.40		
PULL #2	3.65	3.46		
PULL #3	3.37	3.42		
PULL #4	3.48	3.52		
PULL #5	3.69	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.27		4.34
PULL #2	4.32	4.36		4.13
PULL #3	4.34	4.30		4.21
PULL #4	4.35	4.36		4.38
PULL #5	4.33	4.18		4.43
TOTAL				
AVG.				