

C6649146

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

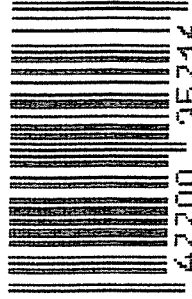
Remington

Remington REQUEST PATENT OFF		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6649146	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		Ø18	



5716 C6649146

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649146

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		6-27-91	KL
	Apply Coating (Bolt)		6-27-91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KL
	C) Inspect Ejector Hole for Chamfer		8/22/91	KL
	D) Oil Firing Pin Ass'y		8/22/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5	5			8-23-91	DH
	G) Safety Off Force	3 1/2	3	3			8-23-91	DH
	H) Trigger Pull Test & Retainability						8/23/91	JH
	I) Firing Pin Indent	.022	.023	.022			8-23-91	DH
	J) Assemble Stock						8/27/91	JK
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						8/27/91	JK
	M) Iron Sight Alignment						8/27/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/27/91	JK
	O) Attach Scope to Rifle						8/27/91	JK
	P) Detach & Attach Scope 20 Times						8/27/91	JK
640	Gallery Target & Test						8-28-91	AC
	A) Time						8-28-91	AC
	B) Malfunctions						8-28-91	AC
	C) Pierced Primers						8-28-91	AC
	D) Optical Clarity of Scope						8-28-91	AC
645	Inspect for Live Ammo						8-28-91	AC
655	Final Inspection							
	A) Headspace						9/13/91	JH
	B) Trigger Pull	2.50	2.45	2.45	2.45	2.42	8-28-91	DH
	C) Function						9/13/91	JH
660	Pack						9-18-91	AF

MOD. _____ GA. CAL. _____ GUN # 26648146

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
		8-28-91	ejector sticks	K5
		2nd		
		8/28/91	Repaired	K4
		3rd		
		4th		
			FUNCTION	

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rd Test OK	
TEST		
TGT		
PROOF	91391	
TEST		
TGT		Ac
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649146

DATE 8/23/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.30	2.38	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.42	2.30	2.45	
PULL #3	2.30	2.51	2.43	2.45	
PULL #4	2.44	2.45	2.30	2.45	
PULL #5	2.45	2.54	2.45	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.57		
PULL #2	3.26	3.55		
PULL #3	3.19	3.47		
PULL #4	3.16	3.38		
PULL #5	3.54	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.37		4.18
PULL #2	4.15	4.20		4.31
PULL #3	4.36	4.29		4.34
PULL #4	4.35	4.49		4.34
PULL #5	4.35	4.34		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649146
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.255327
1 TO	2	.626288
1 TO	3	.433748
1 TO	4	.596662
1 TO	5	.497122

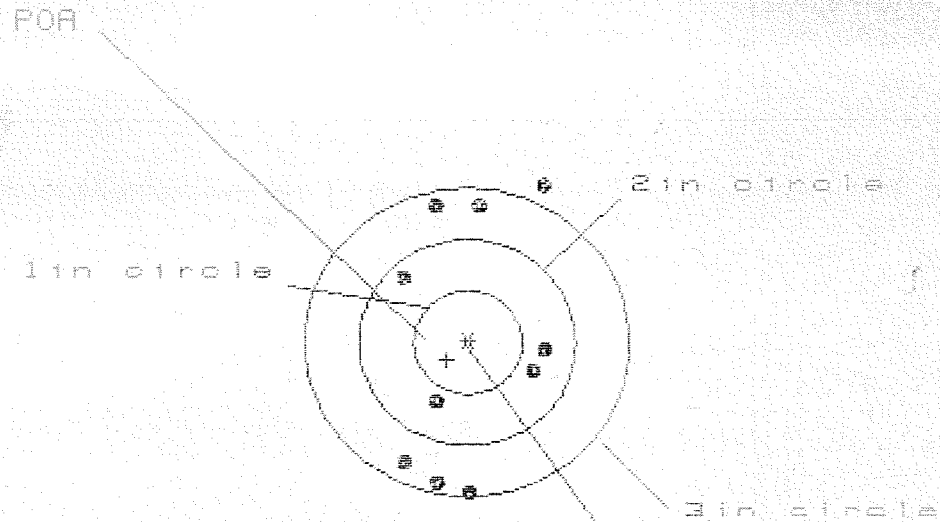
$\frac{2.1}{4}$ $\times$ ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.169
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169047
THE AMR FOR THIS RIFLE IS: .0838

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06049146

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 0

2in - 4

3in - 9

HS = 1.269

VS = 3.009

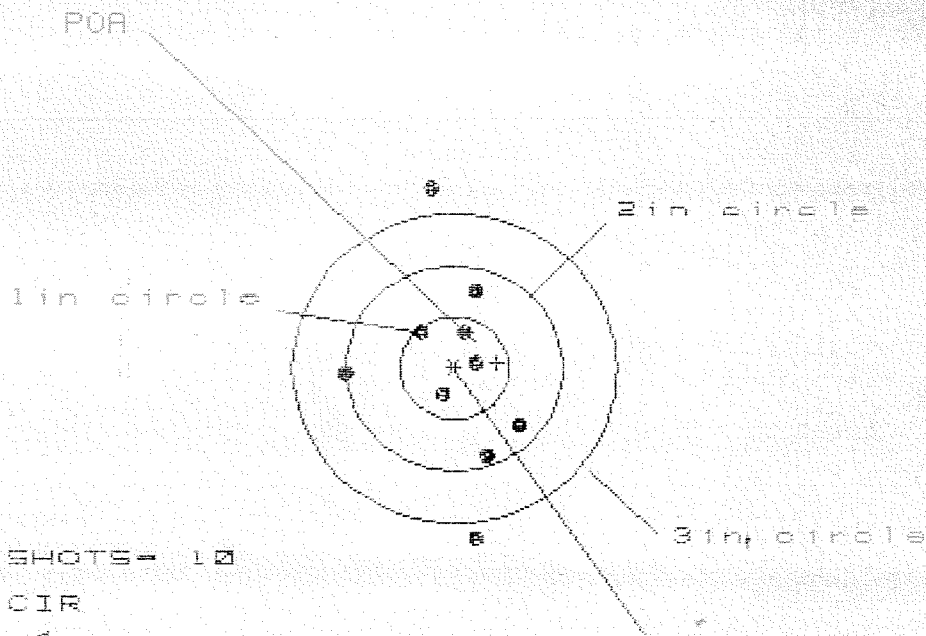
GS = 3.093

PATTERN #	1		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.700	.755	.763
MINIMUM X	-.569	-.491	-.483
MAXIMUM Y	1.545	1.535	1.373
MINIMUM Y	-1.464	-1.292	-1.338
CENTROID X	.194	.116	.108
CENTROID Y	.166	-.006	.156
FOR TO CENTROID in.	.255	.116	.109
MIN RADIUS	.621	.432	.579
MEAN RADIUS	1.136	1.051	1.027
MAX RADIUS	1.696	1.544	1.385
HORIZONTAL SPREAD	1.269	1.246	1.246
VERTICAL SPREAD	3.009	2.827	2.711
EXTREME SPREAD	3.093	2.829	2.738
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

28 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS = 1.589

VS = 3.395

GS = 3.422

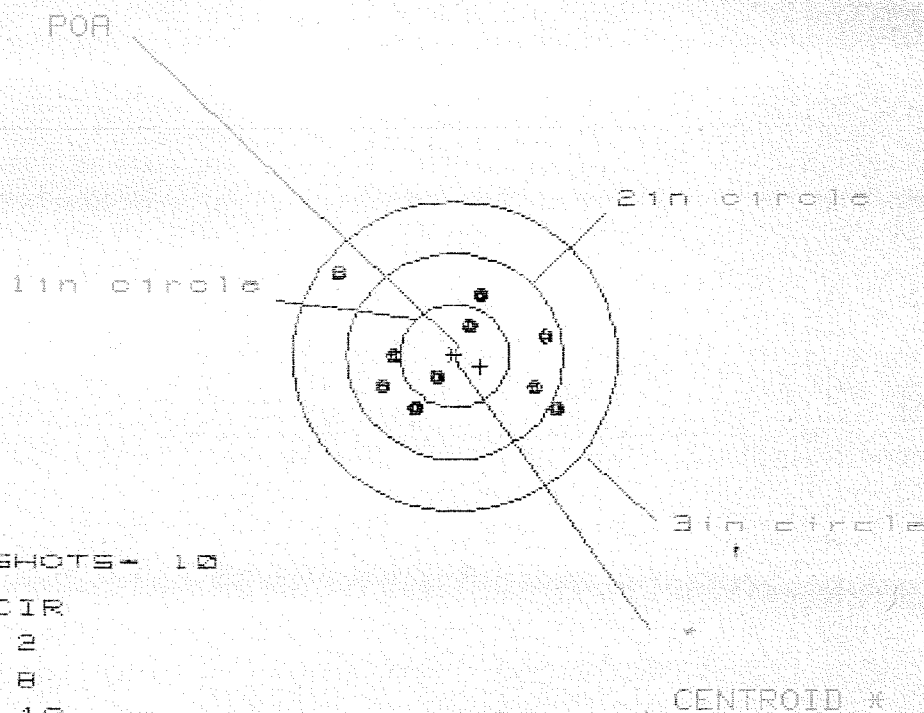
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.603	.578	.601
MINIMUM X	-.986	-1.011	-.988
MAXIMUM Y	1.714	.990	.804
MINIMUM Y	-1.681	-1.491	-.805
CENTROID X	-.392	-.367	-.390
CENTROID Y	-.055	-.245	-.059
POA TO CENTROID in.	.396	.442	.394
MIN RADIUS	.239	.116	.236
MEAN RADIUS	.823	.727	.601
MAX RADIUS	1.728	1.501	.990
HORIZONTAL SPREAD	1.589	1.589	1.589
VERTICAL SPREAD	3.395	2.481	1.609
EXTREME SPREAD	3.422	2.481	1.659
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.955

VS= 1.348

GS= 2.378

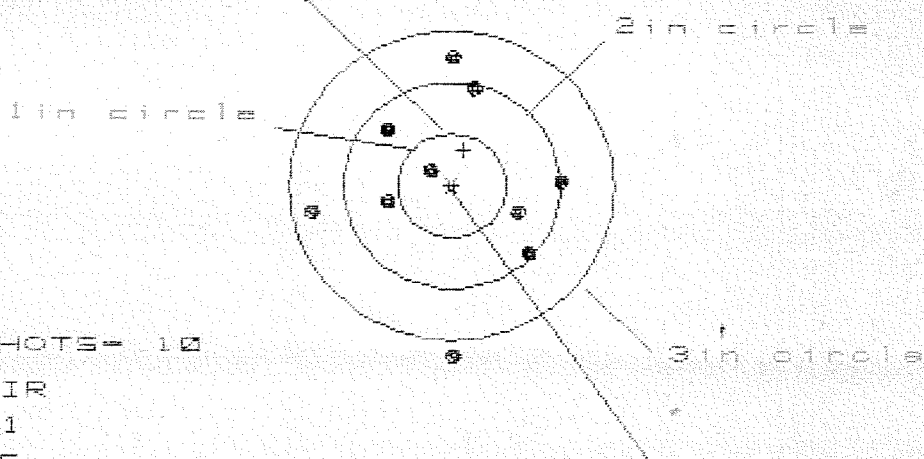
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.771	.791
MINIMUM X	-1.066	-.771	-.675
MAXIMUM Y	.806	.650	.594
MINIMUM Y	-.534	-.444	-.465
CENTROID X	-.235	-.117	-.213
CENTROID Y	.102	.012	.068
POA TO CENTROID in.	.256	.117	.223
MIN RADIUS	.240	.208	.231
MEAN RADIUS	.703	.632	.583
MAX RADIUS	1.337	.889	.817
HORIZONTAL SPREAD	1.955	1.542	1.466
VERTICAL SPREAD	1.348	1.094	1.059
EXTREME SPREAD	2.378	1.554	1.554
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.306

VS= 2.935

GS= 2.935

CENTROID *

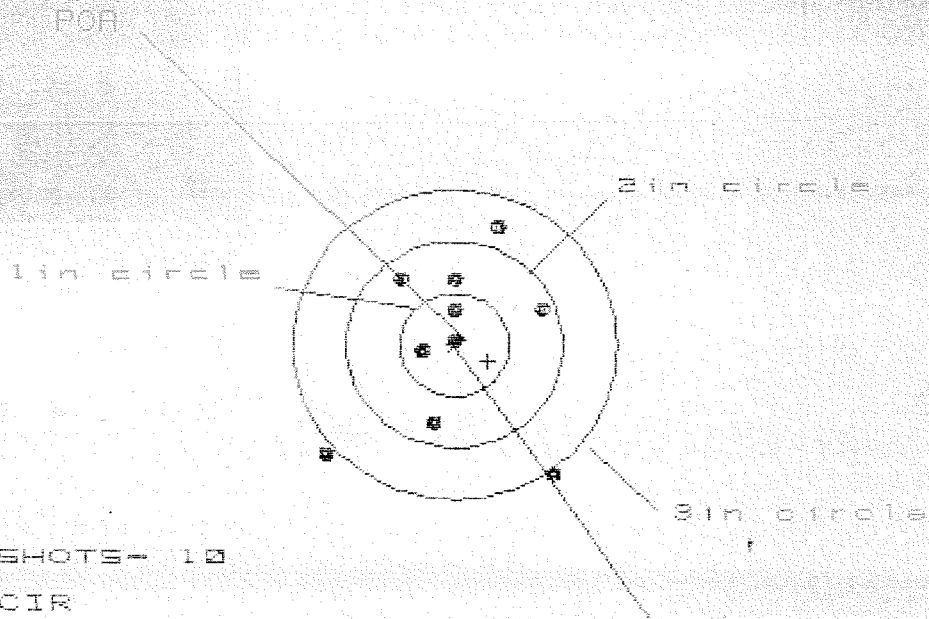
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	1.044	.886
MINIMUM X	:	-1.262	-1.262	-.731
MAXIMUM Y	:	1.248	1.060	1.010
MINIMUM Y	:	-1.687	-.843	-.893
CENTROID X	:	-.109	-.109	.049
CENTROID Y	:	-.348	-.160	-.110
POA TO CENTROID in.	:	.365	.194	.121
MIN RADIUS	:	.221	.158	.323 *
MEAN RADIUS	:	.943	.837	.782
MAX RADIUS	:	1.687	1.324	1.054
HORIZONTAL SPREAD	:	2.306	2.306	1.617
VERTICAL SPREAD	:	2.935	1.903	1.903
EXTREME SPREAD	:	2.935	2.317	2.040
NUMBER IN ONE INCH CIRCLE	=		1	
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 = 3

2 in = 7

3 in = 8

HS= 2.106

VS= 2.433

GS= 2.712

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.813	.800
MINIMUM X	:	-1.164	-.579	-.477
MAXIMUM Y	:	1.182	1.064	.893
MINIMUM Y	:	-1.251	-1.369	-1.048
CENTROID X	:	-.303	-.174	-.276
CENTROID Y	:	.155	.273	.444
POA TO CENTROID in.	:	.340	.323	.522
MIN RADIUS	:	.047	.142	.016
MEAN RADIUS	:	.814	.723	.566
MAX RADIUS	:	1.576	1.592	1.077
HORIZONTAL SPREAD	:	2.106	1.392	1.285
VERTICAL SPREAD	:	2.433	2.433	1.941
EXTREME SPREAD	:	2.712	2.502	2.026
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	