

C6611509

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700TM M24

SERIAL NO.
C6611509

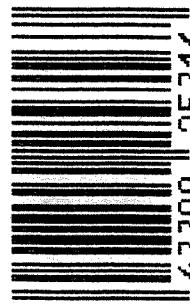
ORDER NO.
5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611509

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611509

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	"
615	Rollmark Caliber	3 28	91	GL
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-24-91	D/H
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5-24-91	D/H
	H) Trigger Pull Test & Retainability						5-20-91	D/H
	I) Firing Pin Indent	.020	.020	.020			5-21-91	D/H
	J) Assemble Stock						5/24/91	Rw
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/24/91	Rw
	M) Iron Sight Alignment						5/24/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	Rw
	O) Attach Scope to Rifle						5/24/91	Rw
	P) Detach & Attach Scope 20 Times						5/24/91	Rw
640	Gallery Target & Test						5-25-91	D/H
	A) Time						5-25-91	D/H
	B) Malfunctions						5-25-91	D/H
	C) Pierced Primers						5-25-91	D/H
	D) Optical Clarity of Scope						5-25-91	D/H
645	Inspect for Live Ammo						5-25-91	D/H
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.19	2.20	2.19	2.28	2.29	6/1/91	D/H
	C) Function						6-1-91	D/H
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. CCG11509
DATE 5-20-91
TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.18	2.33	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.13	2.17	2.47	2.20	
PULL #3	2.06	2.12	2.37	2.19	
PULL #4	2.04	2.09	2.34	2.28	
PULL #5	2.13	2.17	2.33	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.27		
PULL #2	3.10	3.12		
PULL #3	3.07	3.20		
PULL #4	3.13	3.17		
PULL #5	3.14	3.13		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.03		4.22
PULL #2	4.15	4.07		4.02
PULL #3	4.19	4.08		4.10
PULL #4	4.20	4.11		4.12
PULL #5	4.18	4.13		4.10
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611509
25 May 1991

CENTROIDAL DISTANCES

0 TO	1	.426058
1 TO	2	.269002
1 TO	3	.499362
1 TO	4	.737019
1 TO	5	.641137

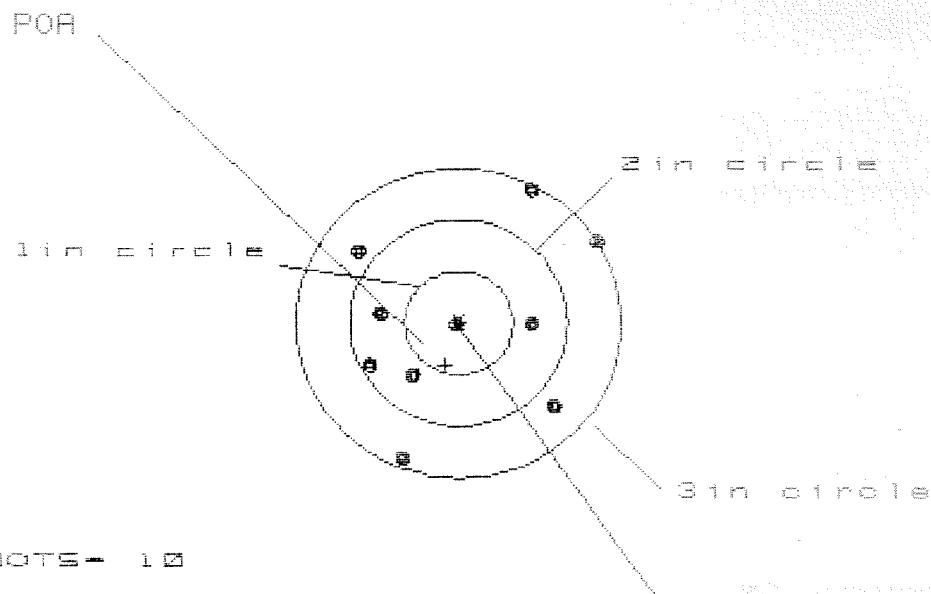
4 ³/₂ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0588
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0486
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .076285
THE AMR FOR THIS RIFLE IS: 1.022

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611503

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.124

VS= 2.535

GS= 2.792

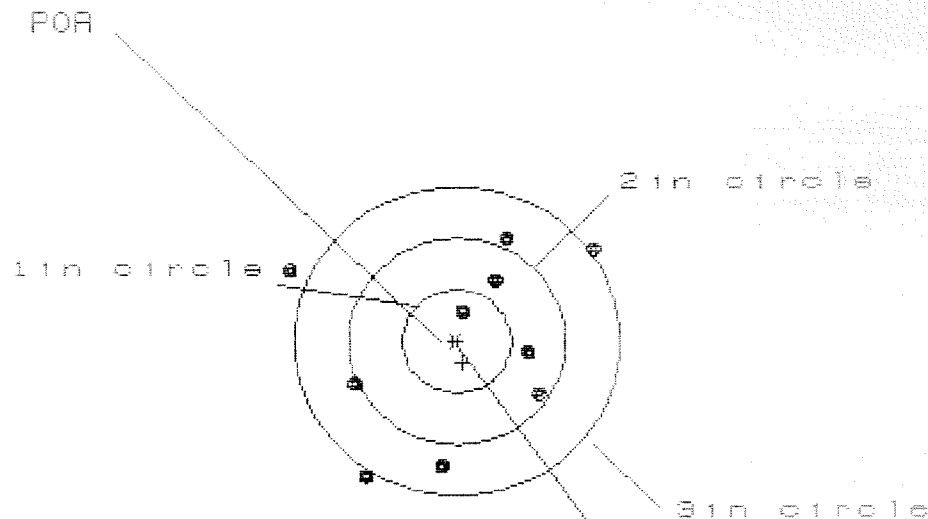
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.225	.988	1.084
MINIMUM X	-.899	-.763	-.667
MAXIMUM Y	1.262	1.351	.976
MINIMUM Y	-1.273	-1.184	-1.016
CENTROID X	.126	-.010	-.106
CENTROID Y	.407	.318	.150
POA TO CENTROID in.	.426	.319	.184
MIN RADIUS	.057	.143	.291
MEAN RADIUS	.962	.888	.788
MAX RADIUS	1.462	1.555	1.202
HORIZONTAL SPREAD	2.124	1.751	1.751
VERTICAL SPREAD	2.535	2.535	1.992
EXTREME SPREAD	2.792	2.792	2.302
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611509

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

IS= 2.838

VS= 2.214

GS= 3.010

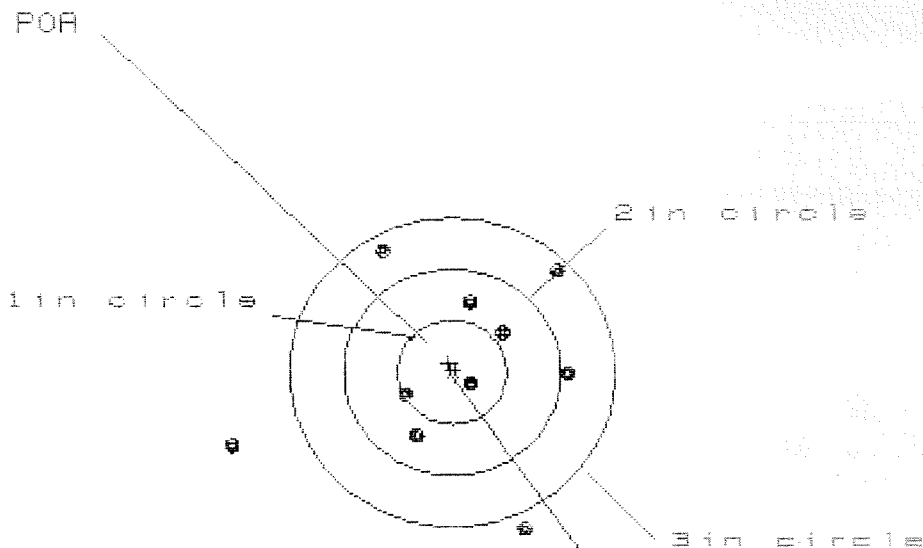
CENTROID *

PATTERN #	:	2	:	9	:	8
SHOTS (BEST OF)	:	10	:	9	:	8
MAXIMUM X	:	1.274	:	1.100	:	.730
MINIMUM X	:	-1.564	:	-1.146	:	-1.008
MAXIMUM Y	:	.947	:	1.026	:	1.146
MINIMUM Y	:	-1.267	:	-1.188	:	-1.068
CENTROID X	:	-.055	:	.119	:	-.019
CENTROID Y	:	.208	:	.129	:	.009
POA TO CENTROID in.	:	.215	:	.176	:	.021
MIN RADIUS	:	.275	:	.386	:	.474
MEAN RADIUS	:	1.064	:	.972	:	.925
MAX RADIUS	:	1.718	:	1.557	:	1.376
HORIZONTAL SPREAD	:	2.838	:	2.246	:	1.738
VERTICAL SPREAD	:	2.214	:	2.214	:	2.214
EXTREME SPREAD	:	3.010	:	3.010	:	2.551
NUMBER IN ONE INCH CIRCLE	=		=	1	=	
NUMBER IN TWO INCH CIRCLE	=		=	4	=	
NUMBER IN THREE INCH CIRCLE	=		=	7	=	

25 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 3.074

VS = 2.718

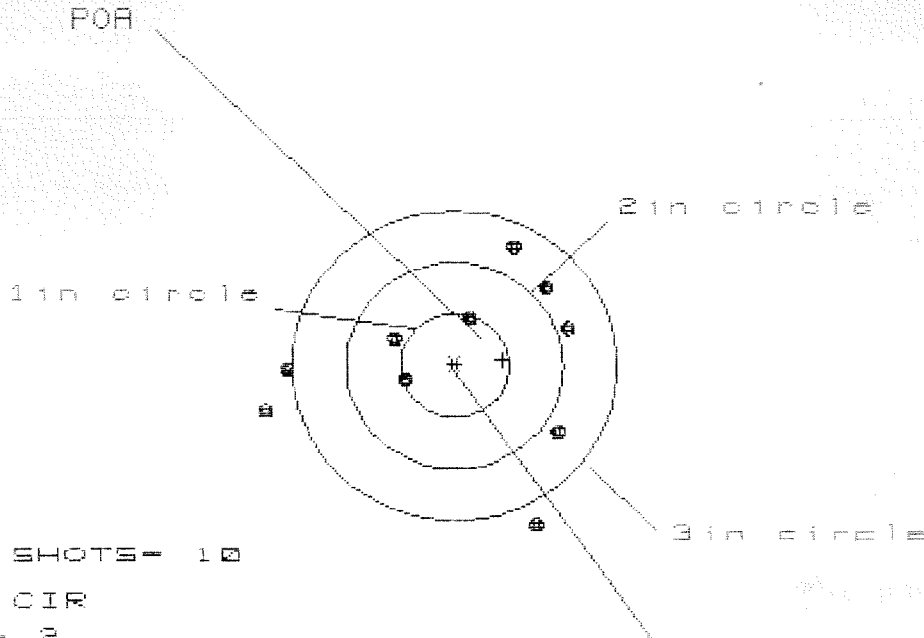
GS = 3.429

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.057
MINIMUM X	-2.017
MAXIMUM Y	1.169
MINIMUM Y	-1.549
CENTROID X	.035
CENTROID Y	-.084
POA TO CENTROID in.	.092
MIN RADIUS	.184
MEAN RADIUS	1.027
MAX RADIUS	2.148
HORIZONTAL SPREAD	3.074
VERTICAL SPREAD	2.718
EXTREME SPREAD	3.429
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 8

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611589

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.777

VS= 2.710

GS= 2.884

CENTROID # 4

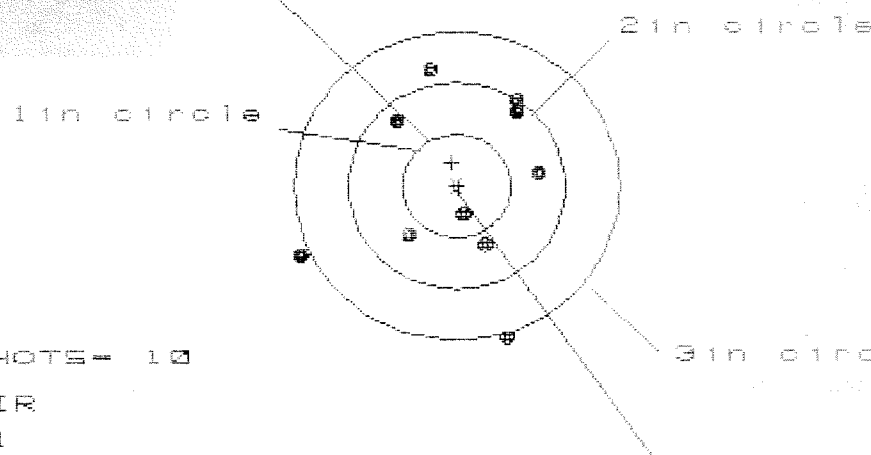
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.065	.874	.939
MINIMUM X	-1.712	-1.740	-1.675
MAXIMUM Y	1.122	1.071	.866
MINIMUM Y	-1.588	-1.639	-.873
CENTROID X	-.445	-.254	-.319
CENTROID Y	-.059	-.008	.196
POA TO CENTROID in.	.449	.255	.375
MIN RADIUS	.427	.372	.177
MEAN RADIUS	1.115	1.024	.895
MAX RADIUS	1.772	1.744	1.700
HORIZONTAL SPREAD	2.777	2.614	2.614
VERTICAL SPREAD	2.710	2.710	1.739
EXTREME SPREAD	2.884	2.717	2.645
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611509

CENTERFIRE PATTERNS # 5

POB



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.132

VS= 2.687

GS= 2.770

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.706	.548	.584
MINIMUM X	:	-1.426	-.692	-.656
MAXIMUM Y	:	1.170	1.093	.894
MINIMUM Y	:	-1.517	-1.594	-.804
CENTROID X	:	.045	.203	.167
CENTROID Y	:	-.229	-.152	.047
POB TO CENTROID in.	:	.234	.254	.174
MIN RADIUS	:	.276	.364	.552
MEAN RADIUS	:	.942	.856	.754
MAX RADIUS	:	1.587	1.620	.963
HORIZONTAL SPREAD	:	2.132	1.240	1.240
VERTICAL SPREAD	:	2.687	2.687	1.698
EXTREME SPREAD	:	2.770	2.770	1.757
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	