

C6611535

MODEL 780TM M24

Model **SMS**TM

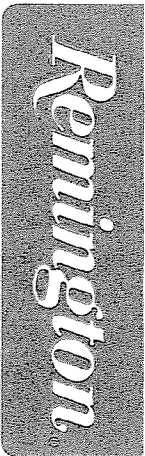
Action

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 700TM M24

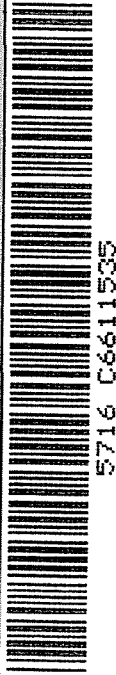
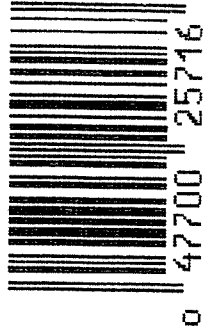
SERIAL NO. C6611535

ORDER NO. 5716

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

20

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611535

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	11
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4/10/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/1/91	RL
	G) Safety Off Force	3	3	3			5/1/91	RL
	H) Trigger Pull Test & Retainability						4/30/91	JD
	I) Firing Pin Indent	.0205	.021	.021			5/1/91	RL
	J) Assemble Stock						5/1/91	RW
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/1/91	RW
	M) Iron Sight Alignment						5/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	RW
	O) Attach Scope to Rifle						5/1/91	RW
	P) Detach & Attach Scope 20 Times						5/1/91	RW
640	Gallery Target & Test						5-1-91	AC
	A) Time						5-1-91	AC
	B) Malfunctions						5-1-91	AC
	C) Pierced Primers						5-1-91	AC
	D) Optical Clarity of Scope						5-1-91	AC
645	Inspect for Live Ammo						5-1-91	AC
655	Final Inspection						5-1-91	DH
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.17	2.22	2.19	2.26	2.23	5/1/91	JD
	C) Function						5-1-91	DH
660	Pack						6-18-91	N-

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611535

DATE 4/30/91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.56	2.40	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.39	2.43	2.22	
PULL #3	2.54	2.37	2.39	2.19	
PULL #4	2.59	2.18	2.22	2.26	
PULL #5	2.57	2.38	2.30	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.36		
PULL #2	3.15	3.33		
PULL #3	3.39	3.25		
PULL #4	3.38	3.32		
PULL #5	3.34	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.48		4.45
PULL #2	4.20	4.51		4.42
PULL #3	4.37	4.46		4.45
PULL #4	4.45	4.47		4.46
PULL #5	4.47	4.41		
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611535
1 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.173416
1 TO	2	.721472
1 TO	3	.424094
1 TO	4	.43915
1 TO	5	.163768

$\frac{5}{2}$ 4 <----POA

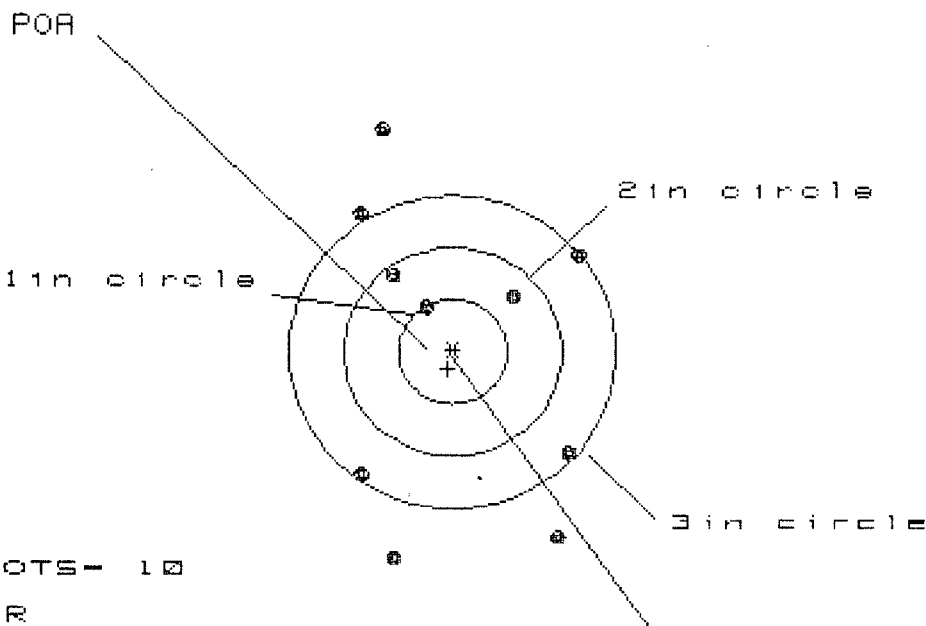
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .001
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1346
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134604
THE AMR FOR THIS RIFLE IS: 1.179

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611535

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 5

HS= 2.061

VS= 4.134

GS= 4.196

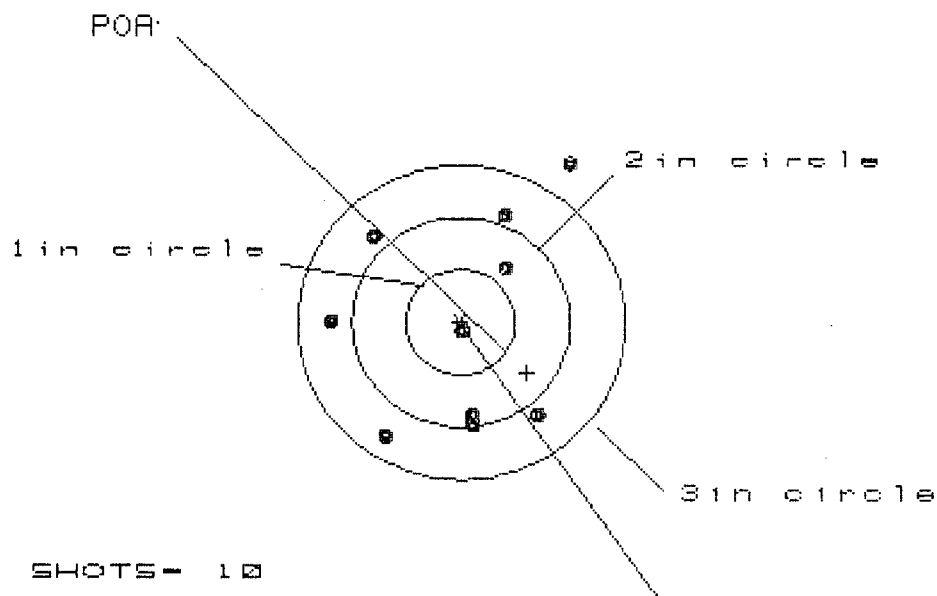
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.176	1.110	1.037
MINIMUM X	-.885	-.951	-1.024
MAXIMUM Y	2.137	1.525	1.305
MINIMUM Y	-1.997	-1.760	-1.754
CENTROID X	.043	.109	.182
CENTROID Y	.168	-.069	.151
POA TO CENTROID in.	.173	.129	.236
MIN RADIUS	.505	.744	.603
MEAN RADIUS	1.439	1.372	1.266
MAX RADIUS	2.219	1.854	1.924
HORIZONTAL SPREAD	2.061	2.061	2.061
VERTICAL SPREAD	4.134	3.285	3.059
EXTREME SPREAD	4.196	3.524	3.524
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611535

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

IS= 2.215

VS= 2.585

GS= 3.107

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.013	.775	.701
MINIMUM X	:	-1.202	-1.090	-1.164
MAXIMUM Y	:	1.530	1.158	1.047
MINIMUM Y	:	-1.055	-.885	-.953
CENTROID X	:	-.608	-.720	-.646
CENTROID Y	:	.479	.309	.420
POA TO CENTROID in.	:	.774	.784	.770
MIN RADIUS	:	.110	.152	.079
MEAN RADIUS	:	1.031	.928	.896
MAX RADIUS	:	1.835	1.251	1.189
HORIZONTAL SPREAD	:	2.215	1.865	1.865
VERTICAL SPREAD	:	2.585	2.043	2.000
EXTREME SPREAD	:	3.107	2.308	2.237
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		3	
NUMBER IN THREE INCH CIRCLE =	:		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611535

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.543

VS = 2.873

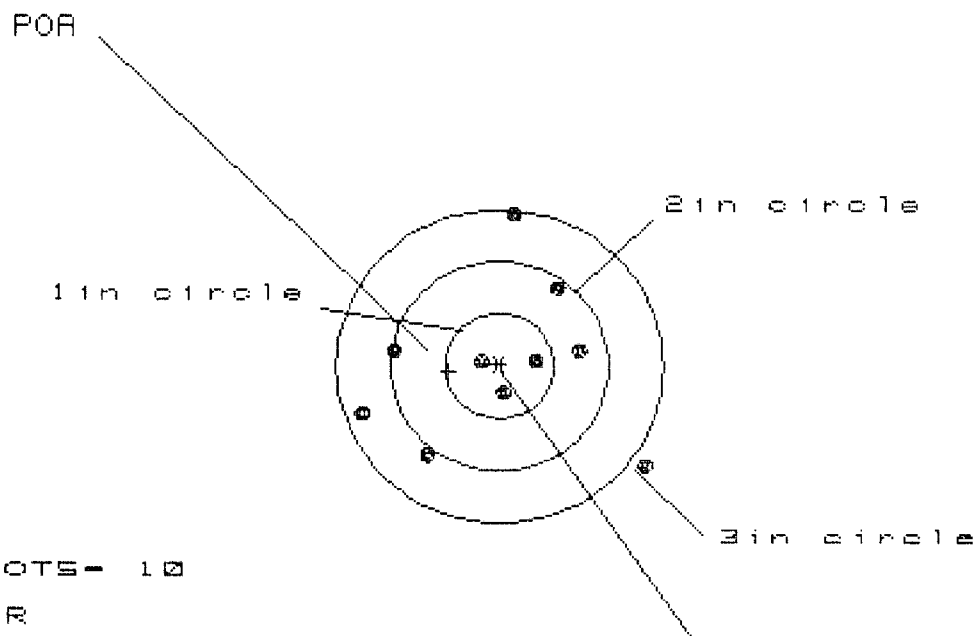
GS = 2.889

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.800	1.780	1.229
MINIMUM X	:	-.743	-.763	-.540
MAXIMUM Y	:	1.073	.874	.834
MINIMUM Y	:	-1.800	-1.490	-1.530
CENTROID X	:	.233	.253	.030
CENTROID Y	:	-.216	-.017	.023
POA TO CENTROID in.	:	.318	.253	.038
MIN RADIUS	:	.516	.509	.294
MEAN RADIUS	:	1.114	.992	.809
MAX RADIUS	:	1.808	1.809	1.569
HORIZONTAL SPREAD	:	2.543	2.543	1.769
VERTICAL SPREAD	:	2.873	2.364	2.364
EXTREME SPREAD	:	2.889	2.603	2.443
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811535

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.602

VS= 2.435

GS= 2.702

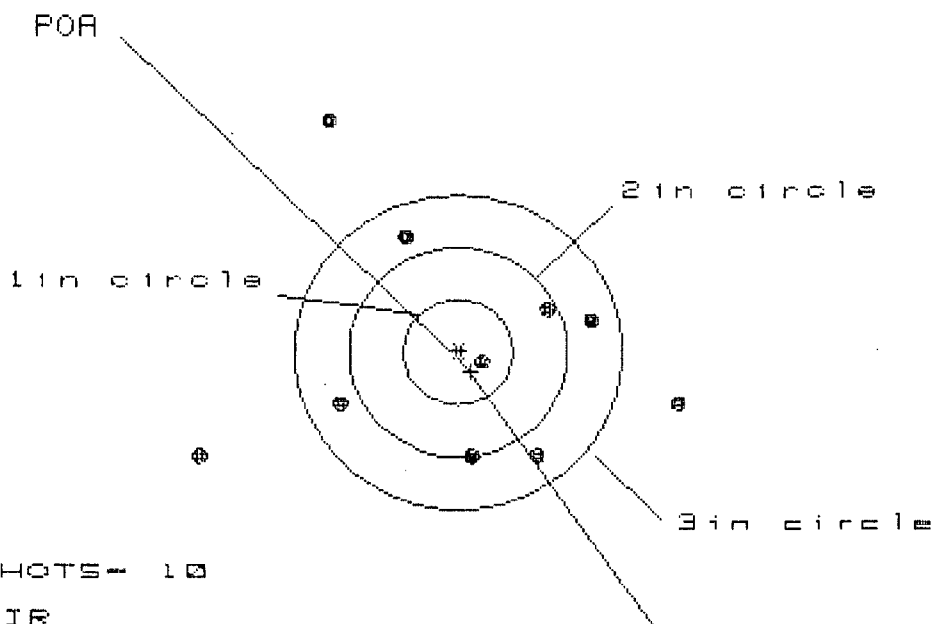
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.321	.864	.901
MINIMUM X	:	-1.281	-1.134	-1.097
MAXIMUM Y	:	1.462	1.354	.775
MINIMUM Y	:	-.973	-.936	-.767
CENTROID X	:	.466	.319	.282
CENTROID Y	:	.050	.158	-.011
POA TO CENTROID in.	:	.468	.356	.282
MIN RADIUS	:	.209	.071	.123
MEAN RADIUS	:	.885	.801	.714
MAX RADIUS	:	1.641	1.386	1.158
HORIZONTAL SPREAD	:	2.602	1.998	1.998
VERTICAL SPREAD	:	2.435	2.290	1.542
EXTREME SPREAD	:	2.702	2.436	2.176
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611535

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 4.448

VS = 3.200

GS = 4.475

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.030	1.761	1.583
MINIMUM X	:	-2.418	-1.420	-1.563
MAXIMUM Y	:	2.183	2.075	1.277
MINIMUM Y	:	-1.017	-1.125	-.865
CENTROID X	:	-.119	.150	.328
CENTROID Y	:	.192	.300	.040
POA TO CENTROID in.	:	.225	.335	.330
MIN RADIUS	:	.252	.202	.219
MEAN RADIUS	:	1.425	1.249	1.046
MAX RADIUS	:	2.607	2.515	1.618
HORIZONTAL SPREAD	:	4.448	3.181	3.146
VERTICAL SPREAD	:	3.200	3.200	2.142
EXTREME SPREAD	:	4.475	4.152	3.146
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	