

C6522198

MODEL 700™ M24

Model SMS™

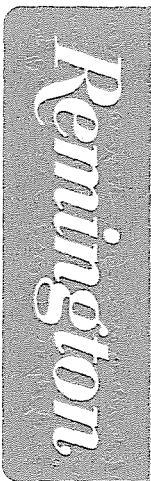
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

MODEL 700™ M24

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

Ø1

SERIAL NO.
C6522198

ORDER NO.
5716


5716 C6522198

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

UPC


0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6527198

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/21/90	DB
600	Proof		8/21/90	DB
607	Check Headspace		8/21/90	DB
610	Dis-assemble Gun		8/21/90	DB
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel AB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/20/90	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/3/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/3/90	RW
	C) Inspect Ejector Hole for Chamfer		10/3/90	RW
	D) Oil Firing Pin Ass'y		10/3/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/3/90	RW

BARBER - M24 0003142

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4	4			10/4/90	RW
	G) Safety Off Force	2.5	2.5	2.5			10/4/90	RW
	H) Trigger Pull Test & Retainability						10/3/90	RW
	I) Firing Pin Indent	.023	.023	.0225			10/4/90	RW
	J) Assemble Stock						10/5/90	RW
	K) Assemble Swivel Studs						10-20-90	JS
	L) Attach Front and Rear Sight Assemblies						10/5/90	RW
	M) Iron Sight Alignment						10/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/5/90	RW
	O) Attach Scope to Rifle						10/5/90	RW
	P) Detach & Attach Scope 20 Times						10/5/90	RW
640	Gallery Target & Test						10-9-90	AC
	A) Time						10-9-90	AC
	B) Malfunctions						10-9-90	AC
	C) Pierced Primers						10-9-90	AC
	D) Optical Clarity of Scope						10-9-90	AC
645	Inspect for Live Ammo						10-9-90	AC
655	Final Inspection							
	A) Headspace						10-20-90	JS
	B) Trigger Pull	217	219	219	216	219	10-20-90	JS
	C) Function						10-20-90	JS
660	Pack						12-8-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522198

DATE 10/3/90

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.31	2.33	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.20	2.24	2.19	
PULL #3	2.45	2.25	2.32	2.19	
PULL #4	2.34	2.24	2.23	2.16	
PULL #5	2.41	2.21	2.29	2.19	
TOTAL	11.71	11.21	11.41		
AVG.	2.34	2.24	2.28		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.02		
PULL #2	3.14	3.31		
PULL #3	3.19	3.10		
PULL #4	3.17	3.08		
PULL #5	3.18	3.12		
TOTAL	15.85	15.63		
AVG.	3.17	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.18		4.26
PULL #2	4.29	4.18		4.27
PULL #3	4.06	4.24		4.23
PULL #4	4.38	4.30		4.26
PULL #5	4.19	4.26		4.25
TOTAL	21.19	21.16		21.27
AVG.	4.24	4.23		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522198
9 Oct 1998

CENTROIDAL DISTANCES

0 TO	1	.486385
1 TO	2	.314269
1 TO	3	.337617
1 TO	4	.319678
1 TO	5	.599708

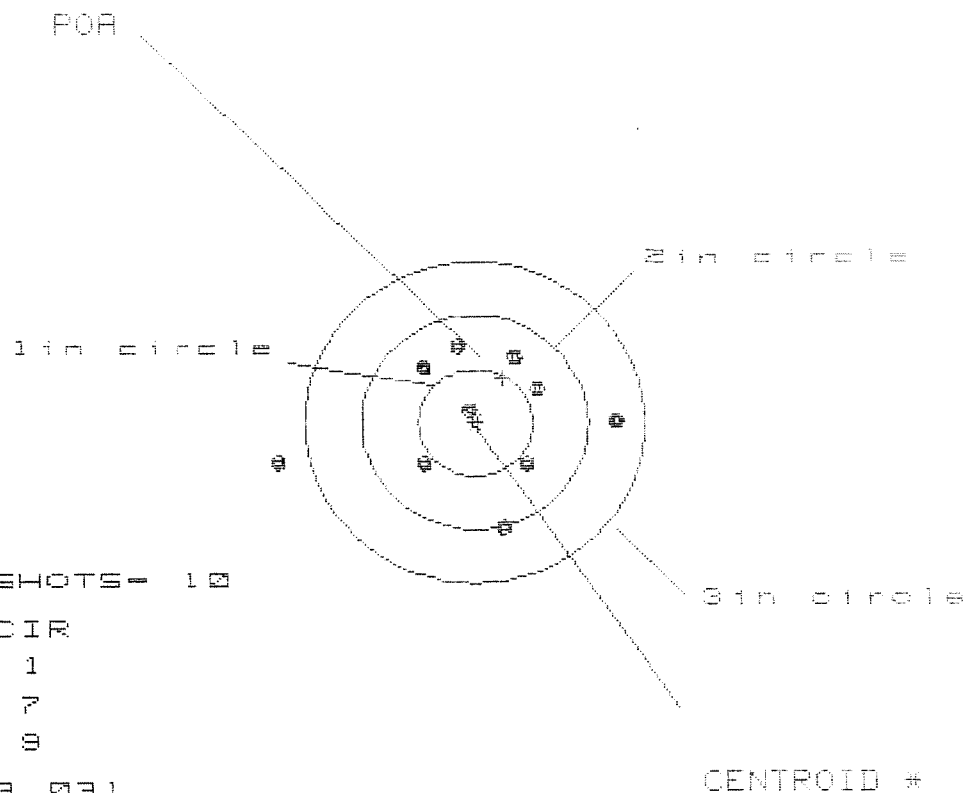
ats <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0908
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .198398
THE AMR FOR THIS RIFLE IS: .9798

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FILE:/PATTERNING/CENTERFIRE_PATT/00522198

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 3.031

VS= 1.697

GS= 3.052

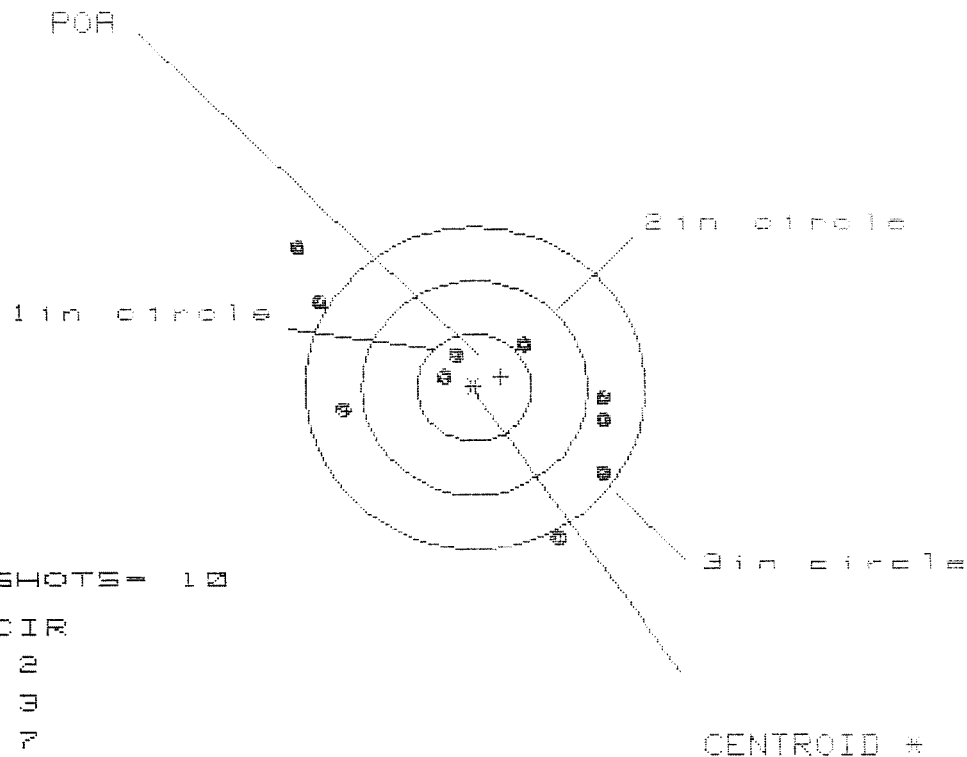
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.271	1.076	.458
MINIMUM X	:	-1.768	-.666	-.532
MAXIMUM Y	:	.675	.631	.622
MINIMUM Y	:	-1.022	-1.066	-1.075
CENTROID X	:	-.247	-.052	-.186
CENTROID Y	:	-.419	-.375	-.366
POA TO CENTROID in.	:	.486	.379	.411
MIN RADIUS	:	.104	.231	.101
MEAN RADIUS	:	.812	.688	.622
MAX RADIUS	:	1.802	1.078	1.088
HORIZONTAL SPREAD	:	3.031	1.742	.990
VERTICAL SPREAD	:	1.697	1.697	1.697
EXTREME SPREAD	:	3.052	1.824	1.733
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS= 2.732

VS= 2.672

GS= 3.526

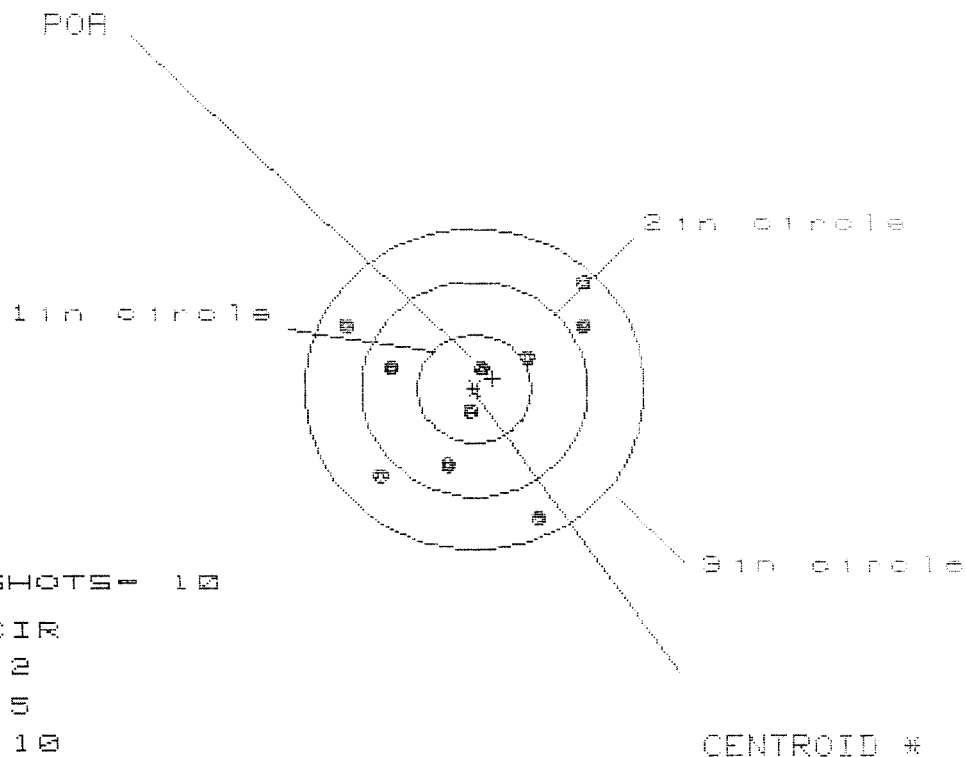
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.166	.992	.794
MINIMUM X	:	-1.566	-1.584	-1.551
MAXIMUM Y	:	1.262	.921	.625
MINIMUM Y	:	-1.410	-1.270	-1.155
CENTROID X	:	-.234	-.060	.138
CENTROID Y	:	-.105	-.245	-.360
POR TO CENTROID in.	:	.256	.253	.386
MIN RADIUS	:	.299	.517	.632
MEAN RADIUS	:	1.128	1.029	.915
MAX RADIUS	:	2.011	1.833	1.552
HORIZONTAL SPREAD	:	2.732	2.576	2.345
VERTICAL SPREAD	:	2.672	2.191	1.780
EXTREME SPREAD	:	3.526	3.065	2.413
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.121

VS= 2.141

GS= 2.500

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.943	1.029	.894
MINIMUM X	-1.178	-1.073	-.848
MAXIMUM Y	.962	.730	.774
MINIMUM Y	-1.179	-1.072	-.981
CENTROID X	-.163	-.258	-.133
CENTROID Y	-.092	-.199	-.290
POA TO CENTROID in.	.187	.333	.319
MIN RADIUS	.205	.164	.030
MEAN RADIUS	.865	.807	.726
MAX RADIUS	1.347	1.298	1.183
HORIZONTAL SPREAD	2.121	2.102	1.742
VERTICAL SPREAD	2.141	1.802	1.755
EXTREME SPREAD	2.500	2.495	2.227
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 3.390

VS= 2.320

GS= 3.490

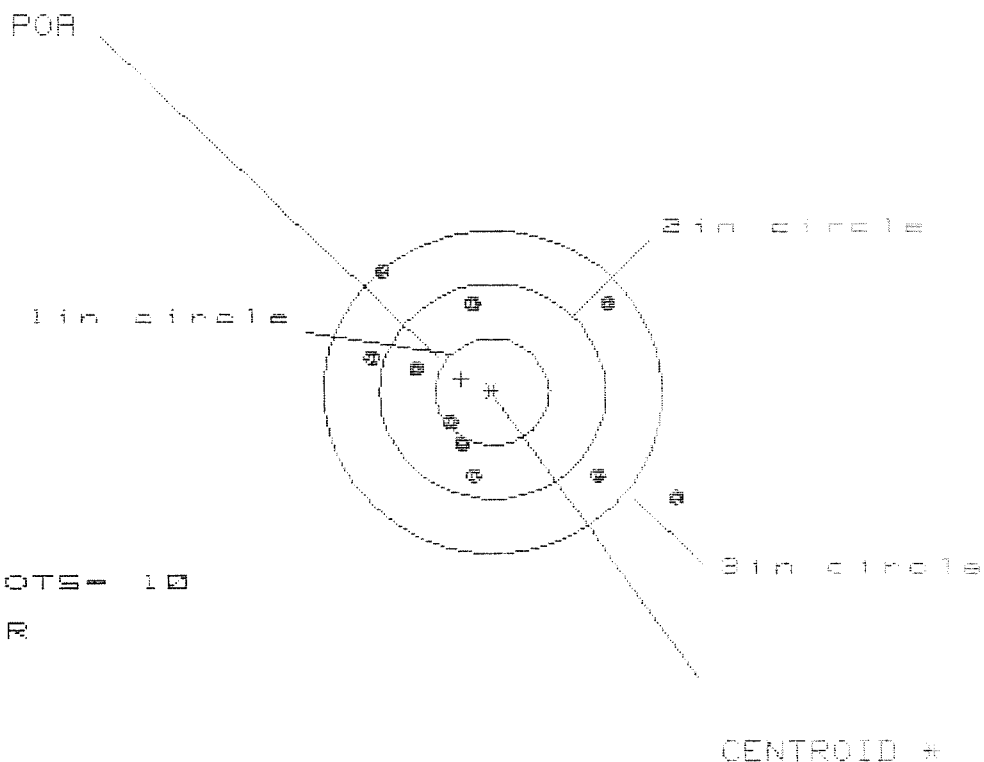
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.434	1.217	.712
MINIMUM X	:	-1.956	-.962	-.810
MAXIMUM Y	:	.983	.999	.914
MINIMUM Y	:	-1.337	-1.321	-1.406
CENTROID X	:	-.084	.133	-.019
CENTROID Y	:	-.144	-.160	-.075
POA TO CENTROID in.	:	.167	.268	.078
MIN RADIUS	:	.528	.478	.558
MEAN RADIUS	:	1.067	.948	.881
MAX RADIUS	:	1.961	1.635	1.623
HORIZONTAL SPREAD	:	3.390	2.179	1.522
VERTICAL SPREAD	:	2.320	2.320	2.320
EXTREME SPREAD	:	3.490	2.775	2.775
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.700

VS= 2.121

GS= 3.385

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.657	1.168	1.069
MINIMUM X	:	-1.043	-0.859	-0.958
MAXIMUM Y	:	1.157	1.050	.827
MINIMUM Y	:	-0.964	-0.898	-0.767
CENTROID X	:	.274	.090	.189
CENTROID Y	:	-.122	-.015	-.146
POA TO CENTROID in.	:	.380	.091	.239
MIN RADIUS	:	.434	.408	.354
MEAN RADIUS	:	1.027	.891	.833
MAX RADIUS	:	1.917	1.463	1.352
HORIZONTAL SPREAD	:	2.700	2.027	2.027
VERTICAL SPREAD	:	2.121	1.948	1.594
EXTREME SPREAD	:	3.385	2.757	2.293
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	