

C6636227

MODEL 700™ M24

Model **SMS**™

Action

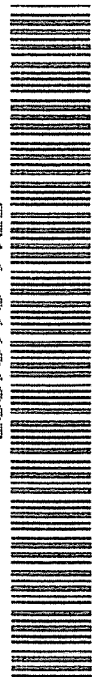
Barrel Length

Capacity

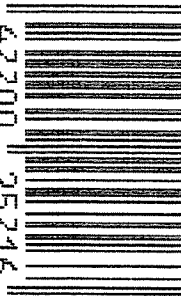
Order No. **5715**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT! Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6636227
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20
		ORDER NO. 5715
5716 C6636227		

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

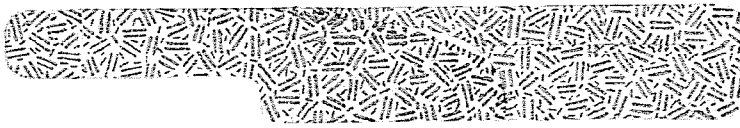
C6636227

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KL
600	Proof		6/27/91	KL
607	Check Headspace		6/27/91	KL
610	Dis-assemble Gun		6/27/91	KL
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	EB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8/16/91	KL
	Apply Coating (Bolt)		8/16/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KL
	C) Inspect Ejector Hole for Chamfer		8/15/91	KL
	D) Oil Firing Pin Ass'y		8/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	BARBER - M24 0031953	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/16/91	WB
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.0225	.0225	.0225			8/16/91	WB
	J) Assemble Stock						8/19/91	KA
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/19/91	KA
	M) Iron Sight Alignment						8/19/91	KA
	N) Detach Front & Rear Sights & place in numbered container						8/19/91	KA
	O) Attach Scope to Rifle						8/19/91	KA
	P) Detach & Attach Scope 20 Times						8/19/91	KA
640	Gallery Target & Test						8/20/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						8/20/91	F7
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	2.35	2.35	2.38	2.40	2.39	8/29/91	DL
	C) Function						8-31-91	DH
660	Pack						9-18-91	N

MOD. _____		GA. CAL. _____	GUN # <u>6227</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>4</i>	<i>8/20/91</i>	<i>Trigger Creeps</i>	<i>155</i>
	2nd		
	<i>8/27/91</i>	<i>1/E20 F/control</i>	<i>155</i>
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		



BOLT RELEASE
STICKS

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

SERIAL NO. C-6636227DATE 8-27-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.60	2.53	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.69	2.59	2.56	2.35	
PULL #3	2.63	2.64	2.58	2.38	
PULL #4	2.65	2.59	2.50	2.40	
PULL #5	2.66	2.63	2.58	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.45		
PULL #2	3.42	3.48		
PULL #3	3.44	3.45		
PULL #4	3.46	3.48		
PULL #5	3.46	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.18		4.43
PULL #2	4.21	4.20		4.45
PULL #3	4.23	4.25		4.45
PULL #4	4.22	4.21		4.48
PULL #5	4.26	4.45		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636227
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.329219
1 TO	2	.305098
1 TO	3	.384596
1 TO	4	.286245
1 TO	5	.286225

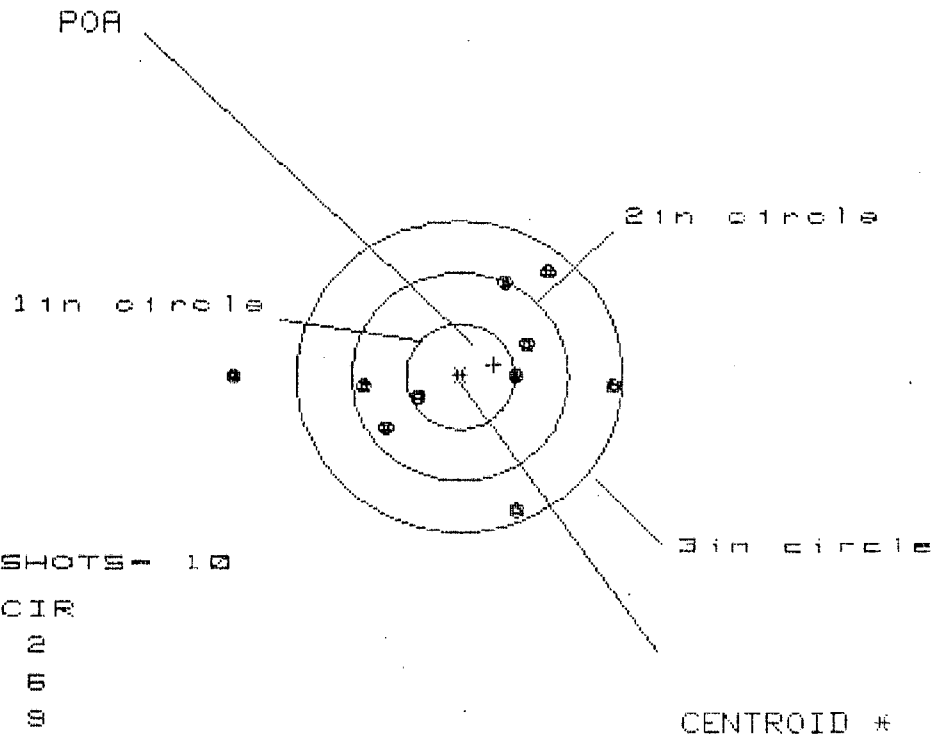
10 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0816
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0514
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0964392
THE AMR FOR THIS RIFLE IS: .9776

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636227

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 3.523

VS = 2.366

GS = 3.525

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.398	1.162	1.196
MINIMUM X	-2.125	-1.145	-1.111
MAXIMUM Y	1.046	1.049	.884
MINIMUM Y	-1.319	-1.317	-.685
CENTROID X	-.311	-.075	-.109
CENTROID Y	-.108	-.111	.054
POA TO CENTROID in.	.330	.134	.121
MIN RADIUS	.473	.237	.318
MEAN RADIUS	1.068	.920	.855
MAX RADIUS	2.125	1.344	1.223
HORIZONTAL SPREAD	3.523	2.307	2.307
VERTICAL SPREAD	2.366	2.366	1.569
EXTREME SPREAD	3.525	2.386	2.307
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536227

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.182

VS= 1.923

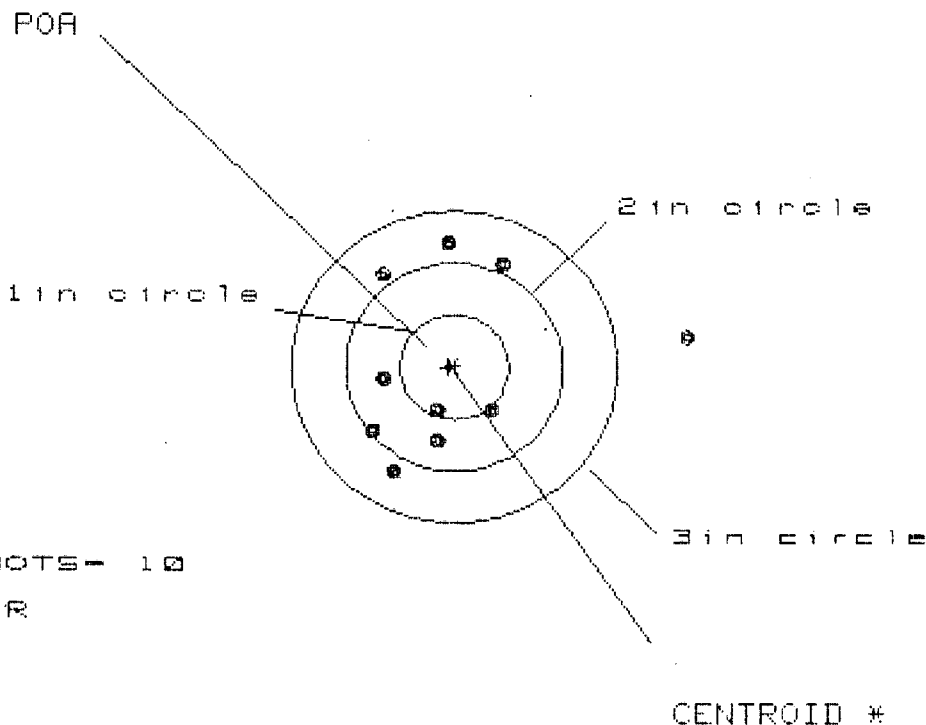
GS= 2.193

PATTERN #	:	2	3	4
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.885	.466
MINIMUM X	:	-1.167	-.704	-.593
MAXIMUM Y	:	1.090	1.047	.965
MINIMUM Y	:	-.833	-.876	-.958
CENTROID X	:	-.028	.102	-.009
CENTROID Y	:	-.222	-.179	-.097
POA TO CENTROID in.	:	.224	.206	.097
MIN RADIUS	:	.276	.212	.303
MEAN RADIUS	:	.721	.660	.588
MAX RADIUS	:	1.230	1.101	1.065
HORIZONTAL SPREAD	:	2.182	1.589	1.059
VERTICAL SPREAD	:	1.923	1.923	1.923
EXTREME SPREAD	:	2.193	1.924	1.924
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.916

VS= 2.247

GS= 3.046

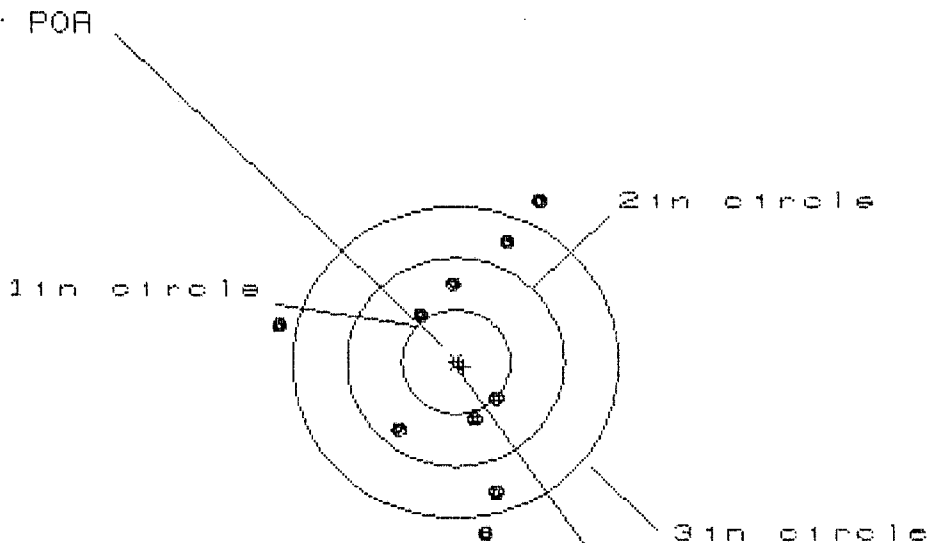
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.179	.730	.748
MINIMUM X	-.737	-.495	-.477
MAXIMUM Y	1.219	1.247	1.219
MINIMUM Y	-1.028	-1.000	-.844
CENTROID X	.056	-.186	-.204
CENTROID Y	.007	-.021	-.177
POA TO CENTROID in.	.056	.188	.270
MIN RADIUS	.473	.420	.301
MEAN RADIUS	1.013	.837	.737
MAX RADIUS	2.194	1.290	1.430
HORIZONTAL SPREAD	2.916	1.225	1.225
VERTICAL SPREAD	2.247	2.247	2.063
EXTREME SPREAD	3.046	2.313	2.313
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 2.312

VS= 3.191

GS= 3.224

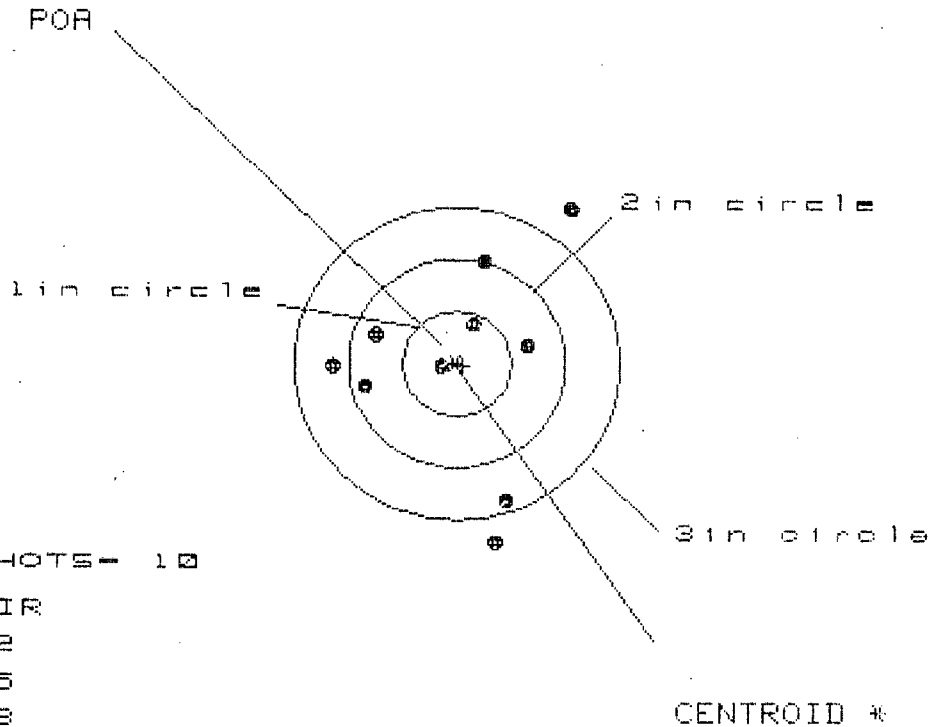
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.728	.539	.583
MINIMUM X	-1.585	-1.504	-1.460
MAXIMUM Y	1.569	1.298	1.117
MINIMUM Y	-1.623	-1.448	-1.218
CENTROID X	-.071	-.152	-.196
CENTROID Y	.048	-.127	.054
POA TO CENTROID in.	.086	.198	.204
MIN RADIUS	.503	.433	.520
MEAN RADIUS	1.069	.977	.914
MAX RADIUS	1.729	1.596	1.502
HORIZONTAL SPREAD	2.312	2.043	2.043
VERTICAL SPREAD	3.191	2.746	2.335
EXTREME SPREAD	3.224	2.752	2.542
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

23 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.168

VS= 3.148

GS= 3.228

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.013	.805	.861
MINIMUM X	-1.155	-1.043	-.987
MAXIMUM Y	1.442	1.175	.982
MINIMUM Y	-1.706	-1.546	-1.344
CENTROID X	-.054	-.166	-.222
CENTROID Y	.018	-.142	.051
POA TO CENTROID in.	.057	.219	.228
MIN RADIUS	.166	.138	.065
MEAN RADIUS	1.017	.934	.803
MAX RADIUS	1.762	1.609	1.501
HORIZONTAL SPREAD	2.168	1.848	1.848
VERTICAL SPREAD	3.148	2.721	2.326
EXTREME SPREAD	3.228	2.723	2.340
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		