

C6636308

MODEL 700™ M24

Model **SMS**™

Action

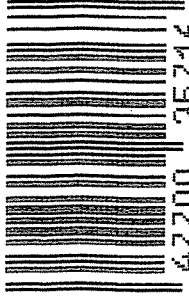
Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington REG. U.S. PAT. & TM. OFF.		DUPONT REG. U.S. PAT. & TM. OFF.	
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.			
MODEL 700™ M24		SERIAL NO. C6636308	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			
			
5716 C6636308		0 47700 25716 7	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636308

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	9 1	Rw
600	Proof	4 30	9 1	Rw
607	Check Headspace	4 30	9 1	Rw
610	Dis-assemble Gun	4 30	9 1	Rw
612	Magnaflux Barrel Action	5 6 9	1	KCR
	Magnaflux Bolt	5 6 9	1	KCR
615	Rollmark Caliber	5 6 9	1	68
617	Drill and Tap Sight Holes	5 10 9	1	B
618	Polish Barrel	5 10 9	1	W.B.
620	Apply Coatings (Barrel Action)		5/30/91	TH
	Apply Coating (Bolt)		5/30/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	DH

op. #	BARBER - M24 0032869	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			6-13-91	DH
	G) Safety Off Force	3	3	3			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.021	.020	.020			6-13-91	DH
	J) Assemble Stock						6-14-91	RW
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-14-91	RW
	M) Iron Sight Alignment						6-14-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-14-91	RW
	O) Attach Scope to Rifle						6-14-91	RW
	P) Detach & Attach Scope 20 Times						6-14-91	RW
640	Gallery Target & Test						6-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-14-91	NF
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.36	2.36	2.40	2.46	2.50	6-15-91	DH
	C) Function						6-15-91	DH
660	Pack						6-19-91	NF

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636308DATE 6-13-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.14	2.26	2.53	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.13	2.19	2.55	2.36	
PULL #3	2.15	2.20	2.42	2.40	
PULL #4	2.18	2.21	2.40	2.46	
PULL #5	2.12	2.17	2.53	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.11		
PULL #2	3.11	3.00		
PULL #3	3.11	3.08		
PULL #4	3.04	2.96		
PULL #5	3.04	3.09		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.39		4.28
PULL #2	4.24	4.00		4.13
PULL #3	4.26	4.31		4.28
PULL #4	4.02	4.31		4.22
PULL #5	4.20	4.34		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636308
14 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.145798
1 TO 2	.0516236
1 TO 3	.446126
1 TO 4	.179778
1 TO 5	.202032

3
4 <----POA

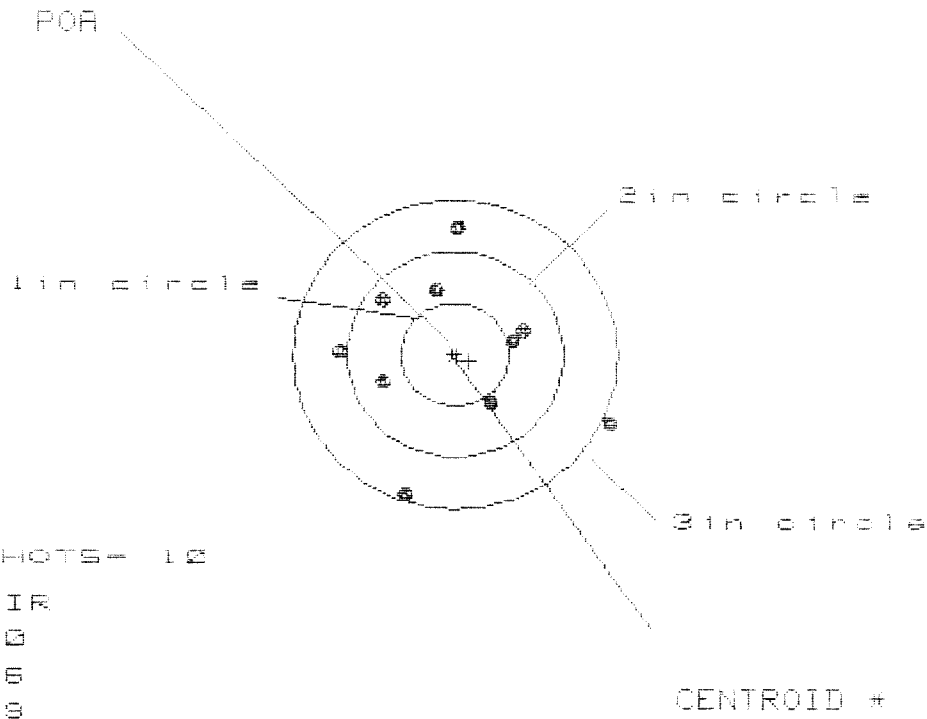
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0382
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0604
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0714661

THE AMR FOR THIS RIFLE IS: 1.012

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636308

CENTERFIRE PATTERNS # 1



OF SHOTS= 12

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 2.522

VS= 2.552

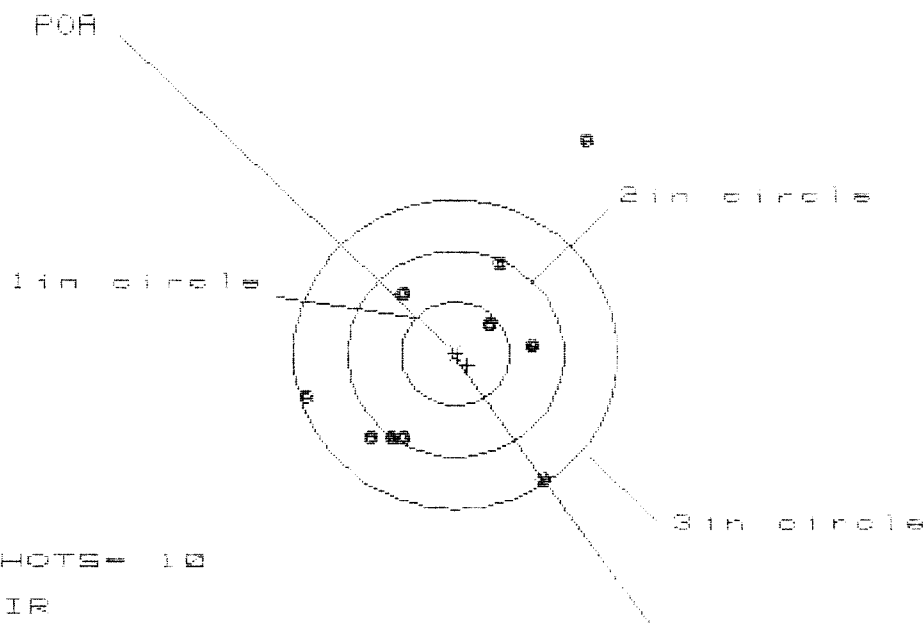
GS= 2.612

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.445	.792	.757
MINIMUM X	-1.077	-.917	-.952
MAXIMUM Y	1.192	1.123	.944
MINIMUM Y	-1.360	-1.429	-.739
CENTROID X	-.131	-.291	-.256
CENTROID Y	.064	.133	.312
POA TO CENTROID in.	.146	.320	.403
MIN RADIUS	.584	.527	.352
MEAN RADIUS	.932	.849	.749
MAX RADIUS	1.573	1.457	.971
HORIZONTAL SPREAD	2.522	1.789	1.789
VERTICAL SPREAD	2.552	2.552	1.603
EXTREME SPREAD	2.612	2.599	1.715
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

14 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.532

VS = 3.298

GS = 3.670

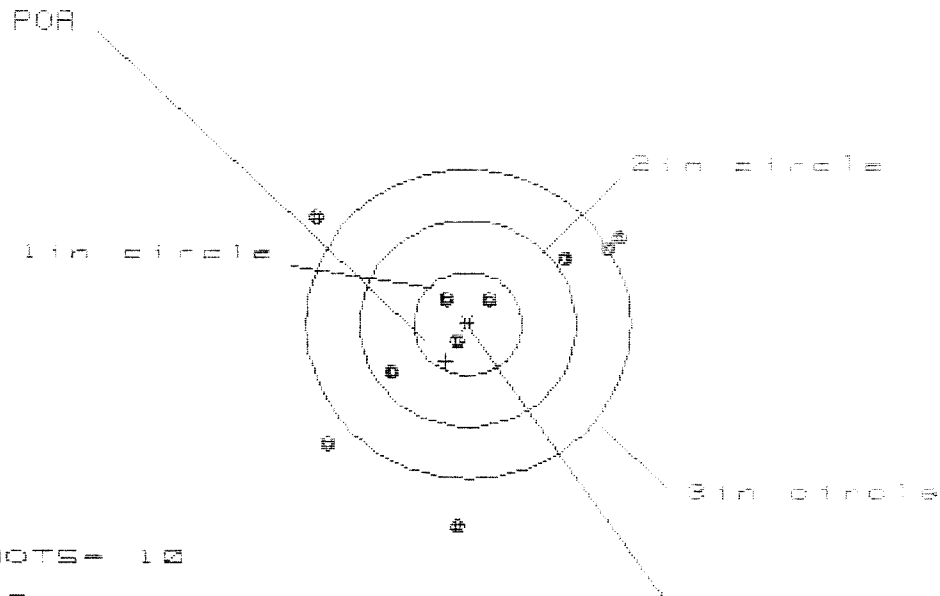
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.250
MINIMUM X	-1.382
MAXIMUM Y	2.133
MINIMUM Y	-1.165
CENTROID X	-1.112
CENTROID Y	.112
POA TO CENTROID in.	.159
MIN RADIUS	.454
MEAN RADIUS	1.123
MAX RADIUS	2.472
HORIZONTAL SPREAD	2.632
VERTICAL SPREAD	3.298
EXTREME SPREAD	3.670
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HS= 2.847

VS= 2.945

GS= 3.378

CENTROID #

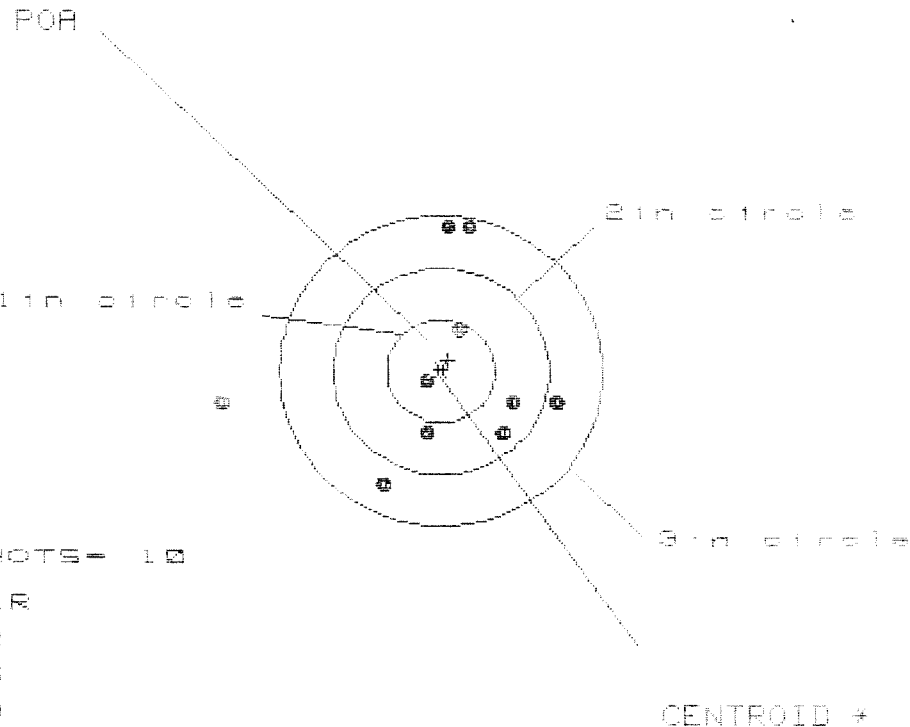
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.439	1.429	1.252
MINIMUM X	:	-1.403	-1.418	-1.493
MAXIMUM Y	:	1.005	.790	.729
MINIMUM Y	:	-1.940	-1.339	-1.240
CENTROID X	:	.201	.211	.388
CENTROID Y	:	.362	.577	.479
POA TO CENTROID in.	:	.414	.614	.616
MIN RADIUS	:	.154	.192	.117
MEAN RADIUS	:	1.120	1.016	.933
MAX RADIUS	:	1.942	1.877	1.941
HORIZONTAL SPREAD	:	2.847	2.847	2.745
VERTICAL SPREAD	:	2.945	2.129	1.969
EXTREME SPREAD	:	3.378	3.378	3.378
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

14 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 3.118

VS= 2.524

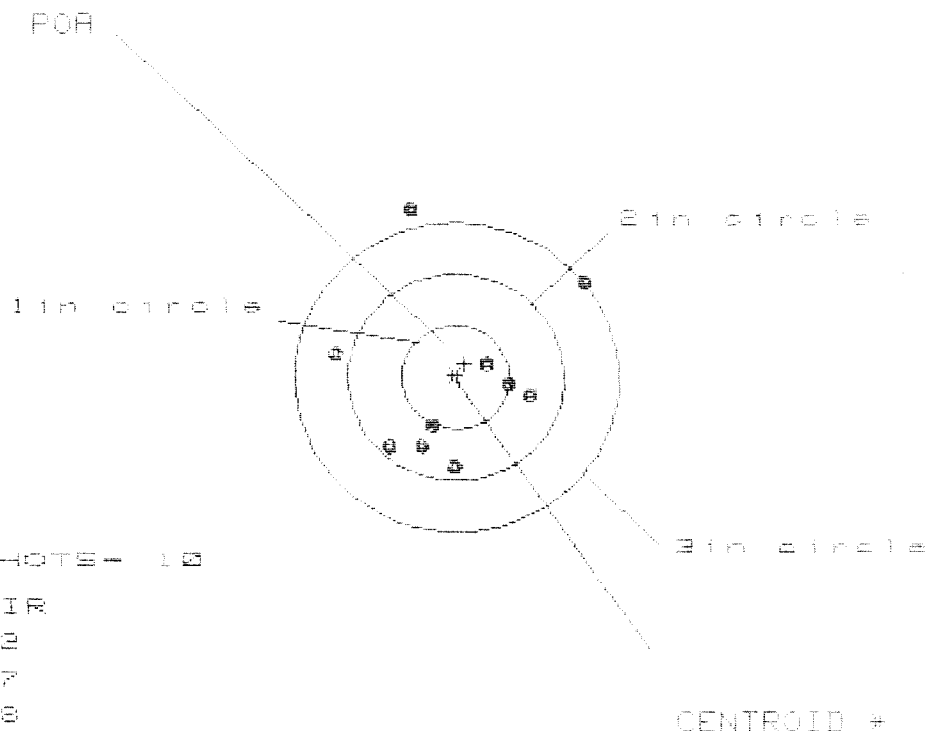
GS= 3.118

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	.841	.845
MINIMUM X	:	-2.050	-.752	-.748
MAXIMUM Y	:	1.402	1.374	1.537
MINIMUM Y	:	-1.122	-1.150	-.979
CENTROID X	:	-.067	.160	.156
CENTROID Y	:	-.104	-.076	-.247
POA TO CENTROID in.	:	.124	.177	.292
MIN RADIUS	:	.132	.347	.326
MEAN RADIUS	:	1.000	.862	.769
MAX RADIUS	:	2.066	1.377	1.547
HORIZONTAL SPREAD	:	3.118	1.593	1.593
VERTICAL SPREAD	:	2.524	2.524	2.516
EXTREME SPREAD	:	3.118	2.645	2.582
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1981

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CH

1 in = 2

2 in = 7

3 in = 8

HM = 0.000

VM = 0.450

GM = 0.500

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.192
MINIMUM X	-1.070
MAXIMUM Y	1.626
MINIMUM Y	-0.866
CENTROID X	-0.082
CENTROID Y	-0.132
POA TO CENTROID in.	.156
MIN RADIUS	.323
MEAN RADIUS	.384
MAX RADIUS	1.690
HORIZONTAL SPREAD	2.262
VERTICAL SPREAD	2.492
EXTREME SPREAD	2.538
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	8