

C6648949

MODEL 700™ M24

Model **SMS**™

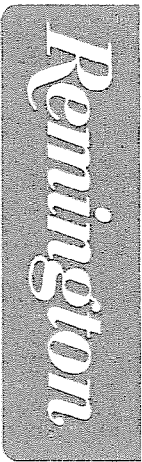
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

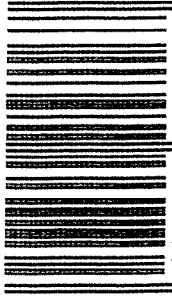


Remington® MODEL 700™ M24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
DU PONT REG. U.S. PAT. & T.M. OFF.		SERIAL NO. C6648949
Ø6		ORDER NO. 5716



5716 C6648949

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFMGUN SERIAL # *C6648949*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	Rw
600	Proof	7 2	9 1	Rw
607	Check Headspace	2	9 1	Rw
610	Dis-assemble Gun	7 2	9 1	Rw
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	1/2
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/29/91	Rw
	D) Oil Firing Pin Ass'y		8/29/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	BARBER - M24 0033672	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	7	8			9-6-91	D/H
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			9-6-91	D/H
	H) Trigger Pull Test & Retainability						9-6-91	D/H
	I) Firing Pin Indent	.021	.021	.021			9-6-91	D/H
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9/13/91	JM
	L) Attach Front and Rear Sight Assemblies						9/10/91	RW
	M) Iron Sight Alignment						9/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	RW
	O) Attach Scope to Rifle						9/10/91	RW
	P) Detach & Attach Scope 20 Times						9/10/91	RW
640	Gallery Target & Test						9-10-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-10-91	NF
655	Final Inspection							
	A) Headspace						9/13/91	JM
	B) Trigger Pull	2.25	2.27	2.27	2.29	2.29	9/12/91	JM
	C) Function						9/13/91	JM
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648949DATE 9-6-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.36	2.46	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.46	2.25	2.27	
PULL #3	2.59	2.34	2.50	2.27	
PULL #4	2.56	2.52	2.48	2.29	
PULL #5	2.46	2.28	2.49	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.13		
PULL #2	3.09	3.03		
PULL #3	3.06	3.01		
PULL #4	3.08	3.00		
PULL #5	3.06	2.99		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.10		4.08
PULL #2	4.17	4.08		4.07
PULL #3	4.10	4.03		4.15
PULL #4	3.98	4.00		4.24
PULL #5	4.01	4.02		4.09
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648949
11 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0790253
1 TO	2	.0914112
1 TO	3	.215258
1 TO	4	.449
1 TO	5	.120304

#4 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0486
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1116
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .121723
THE AMP FOR THIS RIFLE IS: .9944

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06040349

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.727

VS= 3.284

CS= 3.414

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.813	.711	.701
MINIMUM X	-.914	-.577	-.587
MAXIMUM Y	1.496	1.298	1.128
MINIMUM Y	-1.788	-1.065	-.903
CENTROID X	-.062	.040	.050
CENTROID Y	-.049	.149	-.013
POA TO CENTROID in.	.079	.155	.052
MIN RADIUS	.488	.556	.501
MEAN RADIUS	.996	.870	.801
MAX RADIUS	2.008	1.300	1.217
HORIZONTAL SPREAD	1.727	1.288	1.288
VERTICAL SPREAD	3.284	2.363	2.031
EXTREME SPREAD	3.414	2.388	2.169
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B949

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.645

VS= 1.735

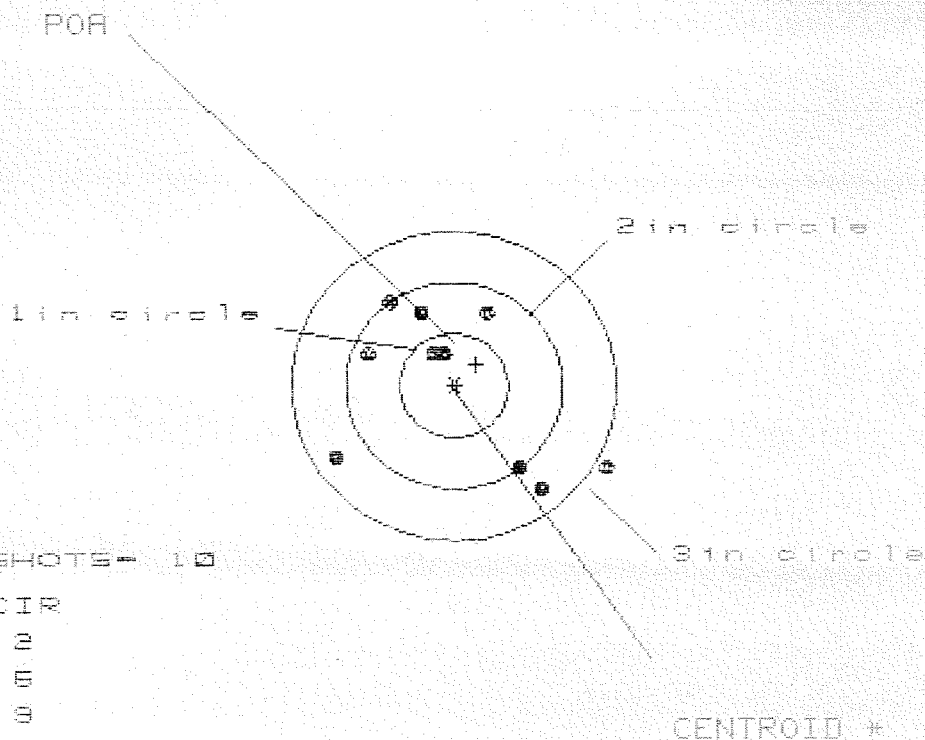
GS= 2.657

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.481	1.272	1.271
MINIMUM X	-1.164	-1.000	-.841
MAXIMUM Y	1.029	1.098	1.089
MINIMUM Y	-.706	-.637	-.499
CENTROID X	-.078	-.242	-.401
CENTROID Y	.041	-.028	-.166
POA TO CENTROID in.	.088	.244	.434
MIN RADIUS	.308	.196	.176
MEAN RADIUS	.952	.823	.655
MAX RADIUS	1.608	1.681	1.376
HORIZONTAL SPREAD	2.645	2.272	2.112
VERTICAL SPREAD	1.735	1.735	1.588
EXTREME SPREAD	2.657	2.642	2.642
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8548949

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.567

VS = 1.795

GS = 2.591

CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.432	.936	.814
MINIMUM X	-1.135	-.975	-.788
MAXIMUM Y	.818	.722	.624
MINIMUM Y	-.985	-1.073	-1.171
CENTROID X	-.286	-.366	-.244
CENTROID Y	-.289	-.121	-.023
POA TO CENTROID in.	.294	.385	.245
MIN RADIUS	.357	.224	.171
MEAN RADIUS	.939	.814	.728
MAX RADIUS	1.636	1.424	1.426
HORIZONTAL SPREAD	2.567	1.911	1.594
VERTICAL SPREAD	1.795	1.795	1.795
EXTREME SPREAD	2.591	2.265	2.265
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648949

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.602

VS= 1.935

GS= 3.109

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.097	.929	.739
MINIMUM X	-1.506	-1.519	-1.296
MAXIMUM Y	.865	.764	.733
MINIMUM Y	-1.070	-1.171	-1.202
CENTROID X	.218	.385	.575
CENTROID Y	-.400	-.299	-.260
POA TO CENTROID in.	.455	.487	.634
MIN RADIUS	.915	.757	.578
MEAN RADIUS	1.165	1.061	.940
MAX RADIUS	1.758	1.539	1.489
HORIZONTAL SPREAD	2.602	2.448	2.035
VERTICAL SPREAD	1.935	1.935	1.935
EXTREME SPREAD	3.109	2.623	2.325
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

(1 Sep 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C8B46949

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.318

VS= 2.019

GS= 3.353

CENTROID #

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.442	1.233	1.018
MINIMUM X	-1.876	-1.054	-.899
MAXIMUM Y	.942	.947	.893
MINIMUM Y	-1.077	-1.072	-1.126
CENTROID X	-.115	.094	-.060
CENTROID Y	.059	.054	.100
POA TO CENTROID in.	.129	.108	.124
MIN RADIUS	.095	.294	.135
MEAN RADIUS	.920	.814	.727
MAX RADIUS	1.877	1.503	1.441
HORIZONTAL SPREAD	3.318	2.287	1.918
VERTICAL SPREAD	2.019	2.019	2.019
EXTREME SPREAD	3.353	2.374	2.129
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	