

C6611791

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		SERIAL NO. C6611791
20		ORDER NO. 5716



5716 C6611791



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611791

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes	2 2 91		FB
618	Polish Barrel <i>RobB</i>	2 2 91		WB
620	Apply Coatings (Barrel Action)		2-11-91	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly		2/12/91	KS
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/12/91	KS
	C) Inspect Ejector Hole for Chamfer		2/12/91	KS
	D) Oil Firing Pin Ass'y		2/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	<i>JA</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			2/13/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	JL
	I) Firing Pin Indent	.0215	.0215	.0215			2/13/91	WB
	J) Assemble Stock						2/15/91	Kd
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/15/91	Kd
	M) Iron Sight Alignment						2/15/91	Kd
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	Kd
	O) Attach Scope to Rifle						2/15/91	Kd
	P) Detach & Attach Scope 20 Times						2/15/91	Kd
640	Gallery Target & Test						2-19-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-19-91	NF
655	Final Inspection							
	A) Headspace						2-25-91	A
	B) Trigger Pull	2.21	2.17	2.20	2.19	2.21	2/21/91	JL
	C) Function						2-25-91	Ac
660	Pack						3-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611791

DATE 2/13/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.53	2.50	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.50	2.48	2.17	
PULL #3	2.40	2.41	2.49	2.20	
PULL #4	2.42	2.32	2.51	2.19	
PULL #5	2.43	2.42	2.46	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.36		
PULL #2	3.30	3.18		
PULL #3	3.29	3.26		
PULL #4	3.26	3.25		
PULL #5	3.20	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.50		4.39
PULL #2	4.45	4.32		4.49
PULL #3	4.50	4.49		4.48
PULL #4	4.45	4.42		4.45
PULL #5	4.46	4.45		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611791
28 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.155128
1 TO	2	.271627
1 TO	3	.140132
1 TO	4	.110005
1 TO	5	.295495

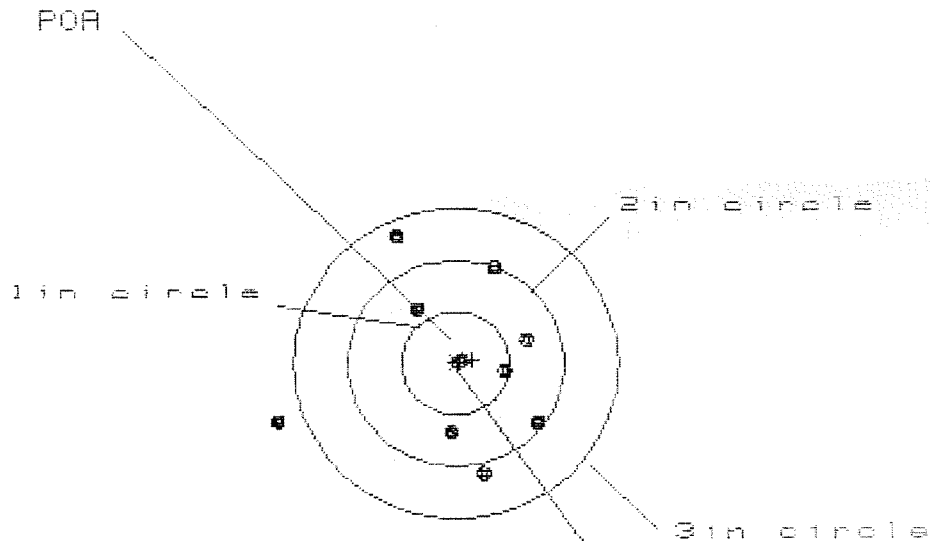
500 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1156
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0898
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146361
THE AMR FOR THIS RIFLE IS: .9752

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611791

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.352

VS = 2.357

GS = 2.494

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.717	.536	.446
MINIMUM X	:	-1.635	-.719	-.576
MAXIMUM Y	:	1.270	1.203	.986
MINIMUM Y	:	-1.087	-1.154	-1.004
CENTROID X	:	-.152	.029	.119
CENTROID Y	:	-.031	.036	-.114
POA TO CENTROID in.	:	.156	.047	.165
MIN RADIUS	:	.116	.084	.148
MEAN RADIUS	:	.861	.725	.623
MAX RADIUS	:	1.744	1.401	1.004
HORIZONTAL SPREAD	:	2.352	1.255	1.022
VERTICAL SPREAD	:	2.357	2.357	1.990
EXTREME SPREAD	:	2.494	2.494	1.991
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

CENTROID #

HS= 3.548

VS= 3.396

GS= 4.254

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.140	1.983	1.245
MINIMUM X	:	-1.408	-1.050	-.802
MAXIMUM Y	:	1.999	.960	1.050
MINIMUM Y	:	-1.397	-1.175	-1.085
CENTROID X	:	.063	.220	-.028
CENTROID Y	:	.135	-.087	-.177
POR TO CENTROID in.	:	.149	.236	.179
MIN RADIUS	:	.442	.221	.382
MEAN RADIUS	:	1.275	1.129	.976
MAX RADIUS	:	2.445	2.110	1.652
HORIZONTAL SPREAD	:	3.548	3.033	2.047
VERTICAL SPREAD	:	3.396	2.135	2.135
EXTREME SPREAD	:	4.254	3.494	2.848
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.160

VS= 2.147

GS= 2.449

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.163
MINIMUM X	-.997
MAXIMUM Y	1.029
MINIMUM Y	-1.118
CENTROID X	-.033
CENTROID Y	.043
POA TO CENTROID in.	.054
MIN RADIUS	.282
MEAN RADIUS	.898
MAX RADIUS	1.348
HORIZONTAL SPREAD	2.160
VERTICAL SPREAD	2.147
EXTREME SPREAD	2.449
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS # 4

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 4

2 in - 8

3 in - 9

HS = 1.578

VS = 2.516

GS = 2.676

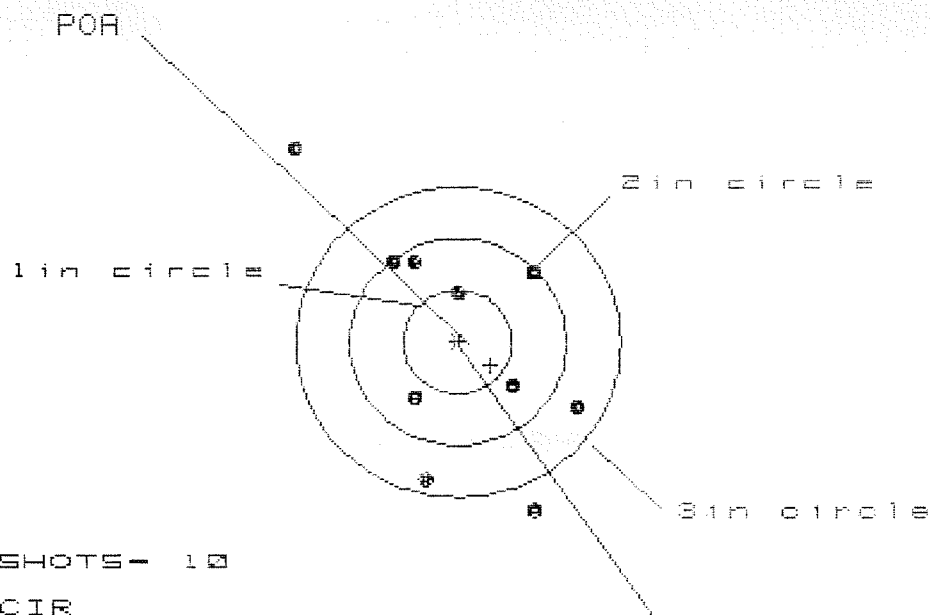
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.671	.734	.698
MINIMUM X	-.987	-.844	-.880
MAXIMUM Y	1.076	.916	.302
MINIMUM Y	-1.440	-1.025	-.910
CENTROID X	-.153	-.216	-.180
CENTROID Y	.079	.239	.124
FOR TO CENTROID in.	.172	.322	.219
MIN RADIUS	.056	.082	.049
MEAN RADIUS	.693	.578	.525
MAX RADIUS	1.546	1.083	.963
HORIZONTAL SPREAD	1.578	1.578	1.578
VERTICAL SPREAD	2.516	1.941	1.212
EXTREME SPREAD	2.676	2.043	1.589
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.614

VS= 3.461

GS= 4.071

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.140	.976	1.039
MINIMUM X	-1.474	-.761	-.698
MAXIMUM Y	1.841	1.004	.827
MINIMUM Y	-1.619	-1.415	-1.339
CENTROID X	-.303	-.139	-.202
CENTROID Y	.223	.019	.196
POA TO CENTROID in.	.376	.140	.281
MIN RADIUS	.509	.443	.539
MEAN RADIUS	1.149	1.000	.920
MAX RADIUS	2.359	1.503	1.394
HORIZONTAL SPREAD	2.614	1.737	1.737
VERTICAL SPREAD	3.461	2.419	2.166
EXTREME SPREAD	4.071	2.707	2.255
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	

BARBER - M24 0036075

NUMBER IN THREE INCH CIRCLE =

8