

06636155

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

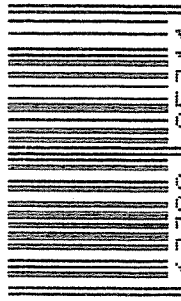
Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® REG. U.S. PAT. & TM. OFF.		DUPONT REG. U.S. PAT. & TM. OFF.	
MODEL 700™ M24		VERY IMPORTANT! Instruction Book enclosed to assure safe use of this firearm.	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		SERIAL NO. C6636155	ORDER NO. 5716

LPC



0 47700 25716 7



5716 C6636155

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636155

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/1/91	KS
600	Proof		5/1/91	ICS
607	Check Headspace		5/1/91	ICS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCD
	Magnaflux Bolt	5 8 9 1		KCD
615	Rollmark Caliber	5 8 9 1		68.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/91	KL
	C) Inspect Ejector Hole for Chamfer		8/1/91	KL
	D) Oil Firing Pin Ass'y		8/1/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		7-23-91	KL

op. #	BARBER - M24 0038338	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			7-23-91	SL
	G) Safety Off Force	4	4	4			7/23/91	SL
	H) Trigger Pull Test & Retainability						7-23-91	SL
	I) Firing Pin Indent	.023	.023	.023			7-23-91	SL
	J) Assemble Stock						8/6/91	SL
	K) Assemble Swivel Studs						8-7-91	DH
	L) Attach Front and Rear Sight Assemblies						8/6/91	SL
	M) Iron Sight Alignment						8/6/91	SL
	N) Detach Front & Rear Sights & place in numbered container						8/6/91	SL
	O) Attach Scope to Rifle						8/6/91	SL
	P) Detach & Attach Scope 20 Times						8/6/91	SL
640	Gallery Target & Test						8-7-91	DH
	A) Time						8-7-91	DH
	B) Malfunctions						8-7-91	DH
	C) Pierced Primers						8-7-91	DH
	D) Optical Clarity of Scope						8-7-91	DH
645	Inspect for Live Ammo						8-7-91	DH
655	Final Inspection							
	A) Headspace						8-7-91	DH
	B) Trigger Pull	2.11	2.18	2.20	2.15	2.20	8-7-91	SL
	C) Function						8-7-91	DH
660	Pack						7-17-91	DH

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

SERIAL NO. C6636155
DATE 8-5-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.28	2.58	2.11	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.20	2.39	2.18	
PULL #3	2.48	2.23	2.53	2.20	
PULL #4	2.39	2.20	2.43	2.15	
PULL #5	2.34	2.29	2.39	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.37		
PULL #2	3.40	3.25		
PULL #3	3.41	3.22		
PULL #4	3.42	3.37		
PULL #5	3.45	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.03		4.14
PULL #2	4.03	4.05		4.26
PULL #3	4.01	4.42		4.16
PULL #4	4.06	4.34		4.09
PULL #5	4.00	4.23		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636155
7 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.61317
1 TO	2	.725119
1 TO	3	.547828
1 TO	4	1.09081
1 TO	5	.649594

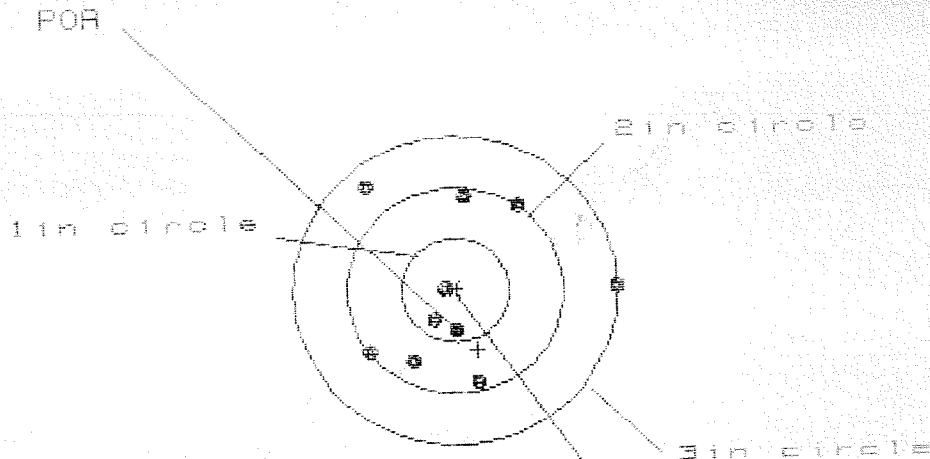
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0354
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0426568
THE ANR FOR THIS RIFLE IS: .9678

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636155

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.348

VS = 1.801

GS = 2.497

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10		
MAXIMUM X	1.503	.775	.697
MINIMUM X	-.845	-.678	-.736
MAXIMUM Y	.969	.967	1.081
MINIMUM Y	-.832	-.834	-.714
CENTROID X	-.196	-.363	-.285
CENTROID Y	.581	.583	.463
POR TO CENTROID in.	.613	.687	.543
MIN RADIUS	.124	.047	.110
MEAN RADIUS	.826	.728	.644
MAX RADIUS	1.503	1.149	1.190
HORIZONTAL SPREAD	2.348	1.453	1.453
VERTICAL SPREAD	1.801	1.801	1.795
EXTREME SPREAD	2.497	2.041	2.041
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636155

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.745

VS = 1.911

GS = 2.796

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.709
MINIMUM X	:	-2.036
MAXIMUM Y	:	1.017
MINIMUM Y	:	-.894
CENTROID X	:	-.102
CENTROID Y	:	-.138
POA TO CENTROID in.	:	.171
MIN RADIUS	:	.356
MEAN RADIUS	:	.917
MAX RADIUS	:	2.082
HORIZONTAL SPREAD	:	2.745
VERTICAL SPREAD	:	1.911
EXTREME SPREAD	:	2.796
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635155

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 1.522

VS= 3.641

GS= 3.660

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.985	.954	.963
MINIMUM X	-.537	-.568	-.559
MAXIMUM Y	2.038	1.095	.923
MINIMUM Y	-1.603	-1.376	-1.027
CENTROID X	.174	.205	.196
CENTROID Y	.177	-.050	.122
POA TO CENTROID in.	.248	.211	.231
MIN RADIUS	.523	.436	.481
MEAN RADIUS	1.007	.866	.798
MAX RADIUS	2.056	1.378	1.215
HORIZONTAL SPREAD	1.522	1.522	1.522
VERTICAL SPREAD	3.641	2.471	1.950
EXTREME SPREAD	3.660	2.471	2.055
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636155

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.965

VS = 2.730

GS = 3.250

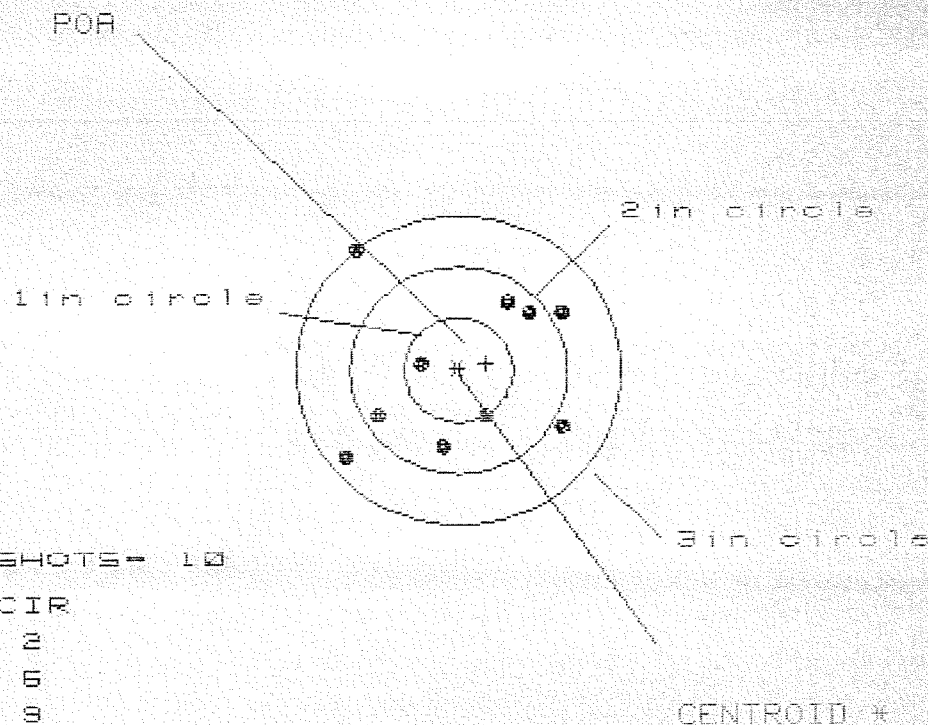
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.116	.525
MINIMUM X	:	-1.664	-1.332	-1.192
MAXIMUM Y	:	1.501	1.548	1.440
MINIMUM Y	:	-1.229	-1.182	-1.290
CENTROID X	:	.201	.386	.246
CENTROID Y	:	-.435	-.482	-.374
POA TO CENTROID in.	:	.480	.618	.448
MIN RADIUS	:	.563	.478	.607
MEAN RADIUS	:	1.182	1.102	1.065
MAX RADIUS	:	1.716	1.576	1.505
HORIZONTAL SPREAD	:	2.965	2.448	1.717
VERTICAL SPREAD	:	2.730	2.730	2.730
EXTREME SPREAD	:	3.250	2.906	2.730
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635155

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.031

VS= 1.978

GS= 2.578

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.964	.856	.709
MINIMUM X	-1.067	-1.175	-.963
MAXIMUM Y	1.158	.750	.664
MINIMUM Y	-.820	-.692	-.684
CENTROID X	-.254	-.146	.001
CENTROID Y	-.066	-.194	-.108
POA TO CENTROID in.	.262	.243	.108
MIN RADIUS	.380	.313	.352
MEAN RADIUS	.907	.823	.747
MAX RADIUS	1.507	1.363	1.036
HORIZONTAL SPREAD	2.031	2.031	1.672
VERTICAL SPREAD	1.978	1.442	1.348
EXTREME SPREAD	2.578	2.388	1.873
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636155
14 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.01
1 TO	2	.135713
1 TO	3	.182236
1 TO	4	.185744
1 TO	5	.0599416

2 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0842
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0866
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844583

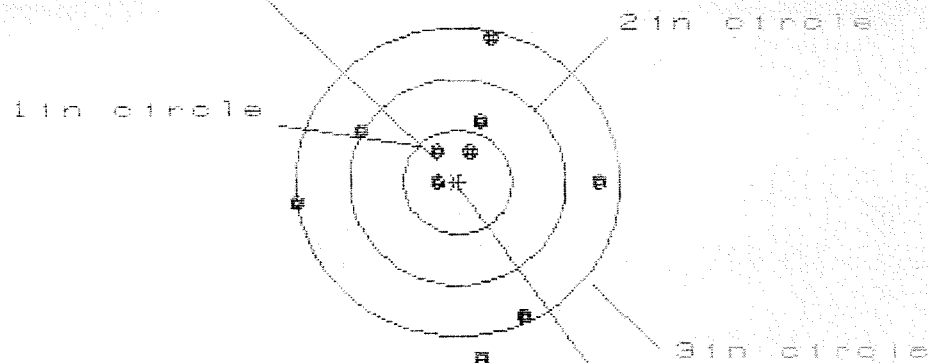
THE AMR FOR THIS RIFLE IS: 1.087

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6638155.1

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.709

VS= 3.132

GS= 3.133

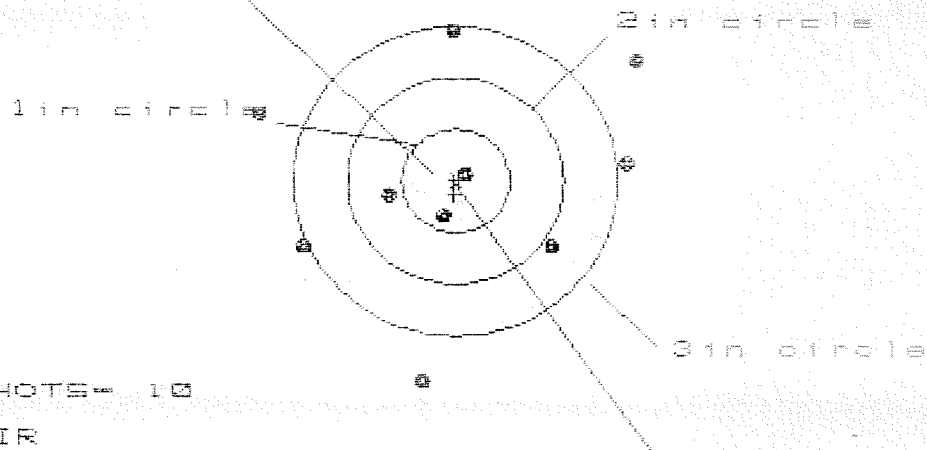
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.260	1.284	1.106
MINIMUM X	-1.449	-1.425	-1.018
MAXIMUM Y	1.414	1.223	1.180
MINIMUM Y	-1.718	-1.471	-1.514
CENTROID X	-.010	-.034	.144
CENTROID Y	-.000	.191	.234
POA TO CENTROID in.	.010	.194	.275
MIN RADIUS	.203	.149	.112
MEAN RADIUS	.985	.848	.776
MAX RADIUS	1.731	1.599	1.580
HORIZONTAL SPREAD	2.709	2.709	2.124
VERTICAL SPREAD	3.132	2.694	2.694
EXTREME SPREAD	3.133	2.713	2.711
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =			9

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08836155.1

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 4

HS = 3.449

VS = 3.406

GS = 3.663

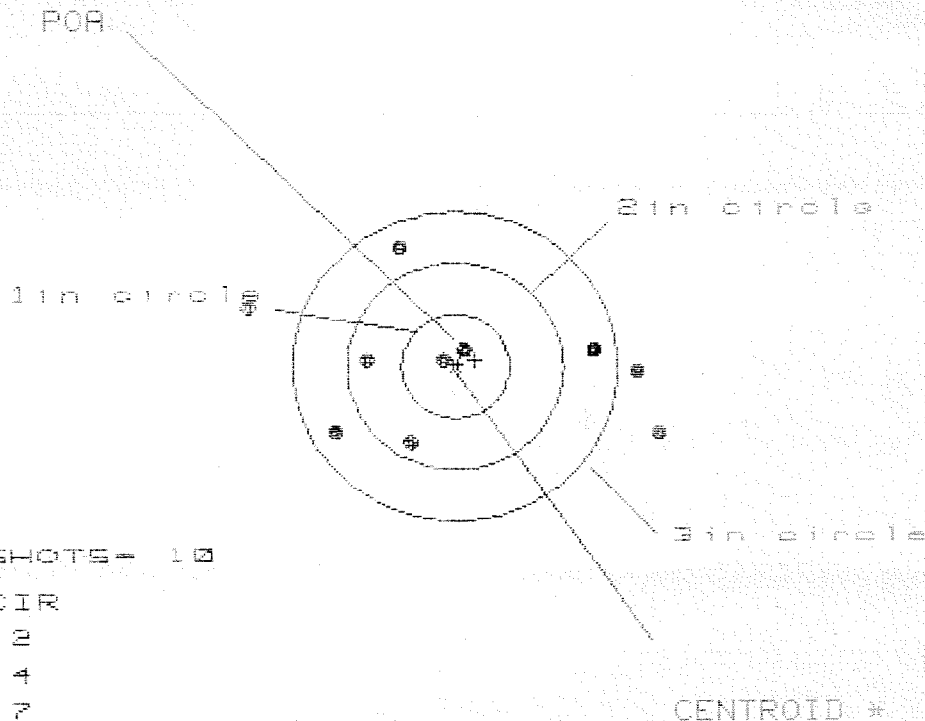
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.679
MINIMUM X	-1.770
MAXIMUM Y	1.507
MINIMUM Y	-1.899
CENTROID X	.017
CENTROID Y	.133
POA TO CENTROID in.	.134
MIN RADIUS	.143
MEAN RADIUS	1.285
MAX RADIUS	2.056
HORIZONTAL SPREAD	3.449
VERTICAL SPREAD	3.406
EXTREME SPREAD	3.663
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	4

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8838155.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.850

VS= 1.856

GS= 4.044

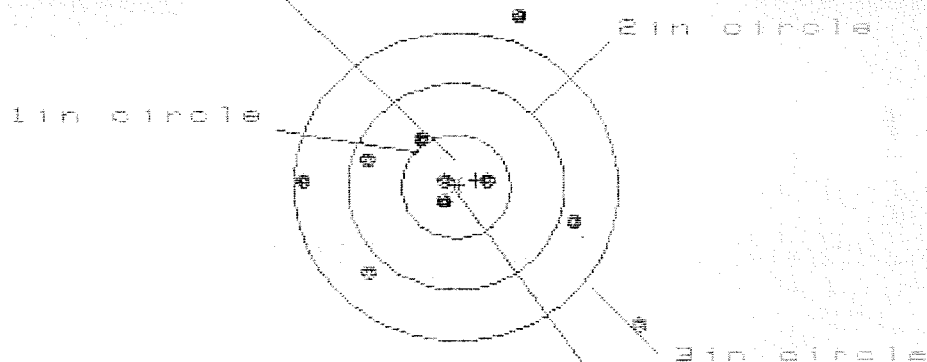
PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.911	1.930	1.714
MINIMUM X	-1.939	-1.726	-1.150
MAXIMUM Y	1.129	1.055	1.117
MINIMUM Y	-.727	-.801	-.739
CENTROID X	-.181	-.394	-.178
CENTROID Y	-.063	.011	-.051
POR TO CENTROID in.	.192	.394	.185
MIN RADIUS	.122	.107	.119
MEAN RADIUS	1.156	1.036	.938
MAX RADIUS	2.024	1.933	1.715
HORIZONTAL SPREAD	3.850	3.856	2.864
VERTICAL SPREAD	1.856	1.856	1.856
EXTREME SPREAD	4.044	3.708	2.930
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

14 Sep 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8836155.1

CENTERFIRE PATTERNS # 4

POR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 2

HS= 3.051

VS= 3.019

GS= 3.402

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.666	1.262	1.363
MINIMUM X	-1.395	-1.210	-1.109
MAXIMUM Y	1.647	1.494	1.543
MINIMUM Y	-1.372	-1.954	-1.767
CENTROID X	-1.184	-1.369	-1.470
CENTROID Y	-1.065	1.088	-1.099
POR TO CENTROID in.	1.195	1.380	1.481
MIN RADIUS	1.165	1.054	1.189
MEAN RADIUS	1.970	1.808	1.696
MAX RADIUS	2.158	1.699	1.394
HORIZONTAL SPREAD	3.061	2.472	2.472
VERTICAL SPREAD	3.019	2.448	1.310
EXTREME SPREAD	3.402	2.864	2.511
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636155.1

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 1.907

VS= 3.054

GS= 3.056

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.923
MINIMUM X	-.984
MAXIMUM Y	1.479
MINIMUM Y	-1.575
CENTROID X	-.063
CENTROID Y	.028
POR TO CENTROID in.	.069
MIN RADIUS	.280
MEAN RADIUS	1.041
MAX RADIUS	1.583
HORIZONTAL SPREAD	1.907
VERTICAL SPREAD	3.054
EXTREME SPREAD	3.056
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9