

C6636162

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

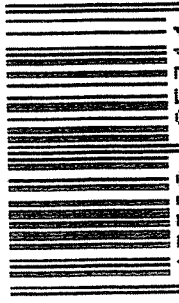
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

DU PONT

SERIAL NO. C6636162	ORDER NO. 5716
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UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636162

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	K.B.
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	GB
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)		5-10-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	CS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	CS
	C) Inspect Ejector Hole for Chamfer		5/28/91	CS
	D) Oil Firing Pin Ass'y		5/28/91	CS
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	YH

op. #	BARBER - M24 0038422 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/30/91	JU
	G) Safety Off Force	4	4	4			5/30/91	JU
	H) Trigger Pull Test & Retainability						5/30/91	JU
	I) Firing Pin Indent	021	2022	2022			5/30/91	JU
	J) Assemble Stock						5/30/91	KS
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/30/91	KS
	M) Iron Sight Alignment						5/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/30/91	KS
	O) Attach Scope to Rifle						5/30/91	KS
	P) Detach & Attach Scope 20 Times						5/30/91	KS
640	Gallery Target & Test						6-4-91	AC
	A) Time						6-4-91	AC
	B) Malfunctions						6-4-91	AC
	C) Pierced Primers						6-4-91	AC
	D) Optical Clarity of Scope						6-4-91	AC
645	Inspect for Live Ammo						6-4-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.22	2.23	2.25	2.26	2.28	6-8-91	JU
	C) Function						6-8-91	D/H
660	Pack						6-20-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636162

DATE 5/30/91

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.21	2.50	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.60	2.48	2.23	
PULL #3	2.18	2.42	2.51	2.25	
PULL #4	2.52	2.43	2.44	2.26	
PULL #5	2.56	2.47	2.45	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.58		
PULL #2	3.65	3.24		
PULL #3	3.53	3.21		
PULL #4	3.54	3.54		
PULL #5	3.51	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.31		4.23
PULL #2	4.26	4.24		4.25
PULL #3	4.37	4.39		4.37
PULL #4	4.25	4.40		4.44
PULL #5	4.31	4.36		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636162
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.462212
1 TO	2	.600007
1 TO	3	.495698
1 TO	4	.465027
1 TO	5	.223271

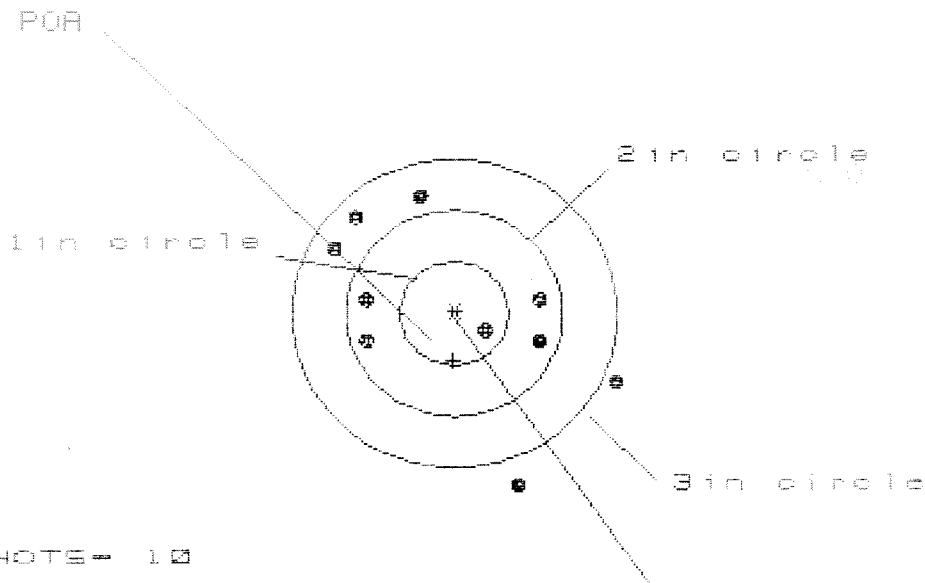
2 51
4 8 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1354
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .2254
THE AMP FOR THIS RIFLE IS: .9214

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C06636152

CENTERFIRE PATTERNS # 1

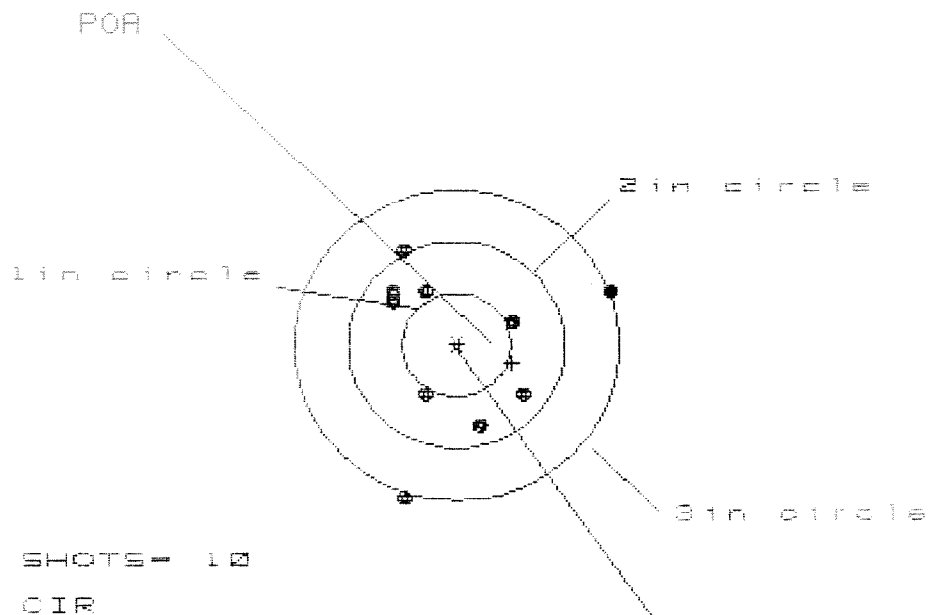


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.474	1.539	1.057
MINIMUM X	-1.151	-1.086	-.893
MAXIMUM Y	1.176	.994	.892
MINIMUM Y	-1.645	-.814	-.590
CENTROID X	.014	-.051	-.244
CENTROID Y	.462	.644	.746
POA TO CENTROID in.	.462	.646	.785
MIN RADIUS	.321	.481	.587
MEAN RADIUS	1.081	1.001	.887
MAX RADIUS	1.747	1.741	1.210
HORIZONTAL SPREAD	2.625	2.625	1.950
VERTICAL SPREAD	2.821	1.808	1.482
EXTREME SPREAD	3.029	2.901	2.151
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

4 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 2.003

VS= 2.429

GS= 2.757

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.397	1.340	.764
MINIMUM X	:	-.606	-.663	-.496
MAXIMUM Y	:	.954	.790	.834
MINIMUM Y	:	-1.475	-.954	-.910
CENTROID X	:	-.514	-.457	-.624
CENTROID Y	:	.177	.341	.297
POA TO CENTROID in.	:	.544	.570	.691
MIN RADIUS	:	.519	.454	.441
MEAN RADIUS	:	.881	.793	.695
MAX RADIUS	:	1.563	1.384	.959
HORIZONTAL SPREAD	:	2.003	2.003	1.200
VERTICAL SPREAD	:	2.429	1.744	1.744
EXTREME SPREAD	:	2.757	2.003	1.868
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836162

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 2.315

VS= 2.482

GS= 2.704

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.664	.778	.854
MINIMUM X	-.651	-.466	-.390
MAXIMUM Y	1.459	1.459	.718
MINIMUM Y	-1.023	-1.023	-.841
CENTROID X	.055	-.130	-.206
CENTROID Y	-.032	-.032	-.214
POA TO CENTROID in.	.063	.134	.298
MIN RADIUS	.291	.297	.202
MEAN RADIUS	.874	.753	.615
MAX RADIUS	1.664	1.581	.992
HORIZONTAL SPREAD	2.315	1.244	1.244
VERTICAL SPREAD	2.482	2.482	1.559
EXTREME SPREAD	2.704	2.704	1.831
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638182

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 4.443

VS = 1.302

GS = 4.443

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.142	1.887	1.591
MINIMUM X	:	-2.301	-1.199	-.963
MAXIMUM Y	:	.766	.708	.633
MINIMUM Y	:	-.536	-.594	-.310
CENTROID X	:	-.121	.134	-.102
CENTROID Y	:	.017	.075	.150
POA TO CENTROID in.	:	.123	.154	.181
MIN RADIUS	:	.127	.241	.154
MEAN RADIUS	:	.951	.834	.624
MAX RADIUS	:	2.360	1.978	1.592
HORIZONTAL SPREAD	:	4.443	3.086	2.554
VERTICAL SPREAD	:	1.302	1.302	.943
EXTREME SPREAD	:	4.443	3.349	2.619
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.063

VS= 1.883

GS= 2.296

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.859
MINIMUM X	-1.204
MAXIMUM Y	.709
MINIMUM Y	-1.174
CENTROID X	-.111
CENTROID Y	.277
POA TO CENTROID in.	.298
MIN RADIUS	.139
MEAN RADIUS	.820
MAX RADIUS	1.218
HORIZONTAL SPREAD	2.063
VERTICAL SPREAD	1.883
EXTREME SPREAD	2.296
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10