

C6611436

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

DU PONT
REGISTERED TRADE MARK

SERIAL NO.
C6611436

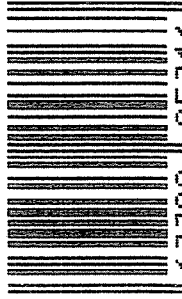
ORDER NO.
5716

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



5716 C6611436

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611436**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	KL
600	Proof		3/18/91	KL
607	Check Headspace		3/18/91	KL
610	Dis-assemble Gun		3/18/91	KL
612	Magnaflux Barrel Action		3/23/91	KR
	Magnaflux Bolt		4	KR
615	Rollmark Caliber		4	GS
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/23/91	KS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/23/91	KS
	C) Inspect Ejector Hole for Chamfer		4/23/91	KS
	D) Oil Firing Pin Ass'y		4/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	KS

op. #	BARBER - M24 0076835	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/24/91	JA
	G) Safety Off Force	3	3	3			4/24/91	JA
	H) Trigger Pull Test & Retainability						4/24/91	JA
	I) Firing Pin Indent	.023	.023	.023			4/24/91	JA
	J) Assemble Stock						4/25/91	KS
	K) Assemble Swivel Studs						5-16-91	DH
	L) Attach Front and Rear Sight Assemblies						4/26/91	KS
	M) Iron Sight Alignment						4/26/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/26/91	KS
	O) Attach Scope to Rifle						4/26/91	KS
	P) Detach & Attach Scope 20 Times						4/26/91	KS
640	Gallery Target & Test						4-29-91	DH
	A) Time						4-29-91	DH
	B) Malfunctions						4-29-91	DH
	C) Pierced Primers						4-29-91	DH
	D) Optical Clarity of Scope						4-29-91	DH
645	Inspect for Live Ammo						4-29-91	DH
655	Final Inspection							
	A) Headspace						5-16-91	DH
	B) Trigger Pull	2.56	2.55	2.56	2.53	2.57	5-16-91	JA
	C) Function						5-16-91	DH
660	Pack						6-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611436DATE 4/24/91 (9)TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.17	2.33	2.56	MIN. SETTING,
PULL #2	2.31	2.33	2.30	2.55	NO AVG. OF 5
PULL #3	2.35	2.26	2.28	2.56	READINGS ACCEPT-
PULL #4	2.31	2.39	2.40	2.53	ABLE LESS THAN 2#
PULL #5	2.33	2.13	2.40	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.51	3.35			
PULL #2	3.56	3.58			
PULL #3	3.37	3.45			
PULL #4	3.39	3.45			
PULL #5	3.43	3.47			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.58		4.58
PULL #2	4.28	4.55		4.40
PULL #3	4.40	4.21		4.43
PULL #4	4.24	4.38		4.40
PULL #5	4.36	4.30		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611436
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.145962
1 TO	2	.249201
1 TO	3	.16225
1 TO	4	.0164924
1 TO	5	.329014

Fig 5 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1398
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0268
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142346
THE BDR FOR THIS RIFLE IS: .6436

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611436

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS = 2.242

VS = 2.776

GS = 2.776

CENTROID *

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.096	1.137	.986
MINIMUM X	-1.246	-1.205	-.759
MAXIMUM Y	1.582	1.300	1.276
MINIMUM Y	-1.194	-1.018	-1.042
CENTROID X	.124	.083	.234
CENTROID Y	.077	-.099	-.074
POA TO CENTROID in.	.146	.129	.245
MIN RADIUS	.554	.436	.382
MEAN RADIUS	1.054	.968	.925
MAX RADIUS	1.624	1.403	1.330
HORIZONTAL SPREAD	2.342	2.342	1.745
VERTICAL SPREAD	2.776	2.318	2.318
EXTREME SPREAD	2.776	2.346	2.345
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611436

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 2.399

VS = 2.189

GS = 2.415

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.951	.790	.774
MINIMUM X	-1.448	-.534	-.550
MAXIMUM Y	1.177	1.176	.678
MINIMUM Y	-1.011	-1.013	-.865
CENTROID X	-.125	.036	.052
CENTROID Y	.067	.068	-.079
POA TO CENTROID in.	.141	.077	.095
MIN RADIUS	.254	.248	.338
MEAN RADIUS	.798	.727	.673
MAX RADIUS	1.448	1.184	.893
HORIZONTAL SPREAD	2.399	1.324	1.324
VERTICAL SPREAD	2.189	2.189	1.544
EXTREME SPREAD	2.415	2.219	1.726
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811436

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= .855

VS= 1.866

GS= 1.885

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.335	.318	.331
MINIMUM X	-.621	-.638	-.625
MAXIMUM Y	1.091	.749	.667
MINIMUM Y	-.775	-.654	-.550
CENTROID X	.133	.149	.136
CENTROID Y	-.085	-.206	-.124
POA TO CENTROID in.	.157	.254	.184
MIN RADIUS	.316	.271	.340
MEAN RADIUS	.587	.506	.493
MAX RADIUS	1.100	.832	.753
HORIZONTAL SPREAD	.956	.956	.956
VERTICAL SPREAD	1.866	1.403	1.217
EXTREME SPREAD	1.885	1.479	1.313
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

29 Apr 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.487

VS = 2.266

GS = 2.343

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.599	.637	.582
MINIMUM X	-.888	-.850	-.905
MAXIMUM Y	1.358	.681	.596
MINIMUM Y	-.908	-.758	-.843
CENTROID X	.128	.090	.145
CENTROID Y	.093	-.057	.028
POA TO CENTROID in.	.158	.107	.148
MIN RADIUS	.130	.285	.189
MEAN RADIUS	.729	.657	.621
MAX RADIUS	1.400	.885	.919
HORIZONTAL SPREAD	1.487	1.487	1.487
VERTICAL SPREAD	2.266	1.439	1.439
EXTREME SPREAD	2.343	1.644	1.644
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811436

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.002

VS= 1.855

GS= 3.303

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.536
MINIMUM X	-1.466
MAXIMUM Y	.736
MINIMUM Y	-1.119
CENTROID X	.439
CENTROID Y	-.018
POA TO CENTROID in.	.440
MIN RADIUS	.279
MEAN RADIUS	1.050
MAX RADIUS	1.900
HORIZONTAL SPREAD	3.002
VERTICAL SPREAD	1.855
EXTREME SPREAD	3.303
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 9