

C6522158

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



BARBER M24 0003892

Smeal®

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522158

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2		RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	L.S.
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RB		8/14/90	W.K.
620	Apply Coatings (Barrel Action)		8-22-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	GU

BARBER - M24 0003835								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	4/24/91	RM		
	G) Safety Off Force	4	4	4	4/24/91	RM		
	H) Trigger Pull Test & Retainability				4/24/91	RM		
	I) Firing Pin Indent	.0225	.0225	.0225	4/24/91	RM		
	J) Assemble Stock				4/25/91	RM		
	K) Assemble Swivel Studs				5-1-91	D/H		
	L) Attach Front and Rear Sight Assemblies				4/25/91	RM		
	M) Iron Sight Alignment				4/25/91	RM		
	N) Detach Front & Rear Sights & place in numbered container				4/25/91	RM		
	O) Attach Scope to Rifle				4/25/91	RM		
P) Detach & Attach Scope 20 Times				4/25/91	RM			
640	Gallery Target & Test				4-26-91	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				4-26-91	NF		
655	Final Inspection							
	A) Headspace				5-1-91	D/H		
	B) Trigger Pull	2.20	2.25	2.28	2.35	2.41	5/1/91	RM
	C) Function						5-1-91	D/H
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522158

DATE 4/24/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.30	2.33	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.44	2.38	2.25	
PULL #3	2.33	2.49	2.33	2.28	
PULL #4	2.41	2.28	2.40	2.35	
PULL #5	2.22	2.47	2.44	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.34		
PULL #2	3.39	3.30		
PULL #3	3.32	3.38		
PULL #4	3.30	3.40		
PULL #5	3.38	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.41		4.45
PULL #2	4.48	4.56		4.46
PULL #3	4.44	4.43		4.58
PULL #4	4.49	4.48		4.52
PULL #5	4.53	4.50		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522158
26 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.123227
1 TO	2	.163527
1 TO	3	.190541
1 TO	4	.308294
1 TO	5	.11967

#4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0788
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1748
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191741

THE AMR FOR THIS RIFLE IS: .7838

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522158

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 6

2 in = 9

3 in = 10

HS = 1.294

VS = 1.760

GS = 1.848

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.461	.427	.319
MINIMUM X	-.833	-.867	-.586
MAXIMUM Y	1.029	.525	.438
MINIMUM Y	-.731	-.617	-.551
CENTROID X	.032	.066	.174
CENTROID Y	-.119	-.233	-.298
POA TO CENTROID in.	.123	.242	.346
MIN RADIUS	.309	.260	.276
MEAN RADIUS	.576	.497	.413
MAX RADIUS	1.073	1.013	.628
HORIZONTAL SPREAD	1.294	1.294	.905
VERTICAL SPREAD	1.760	1.142	.989
EXTREME SPREAD	1.848	1.578	1.045
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522158

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.390

VS= 2.599

GS= 2.841

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.213

1.202

1.054

MINIMUM X

-1.177

-1.188

-.970

MAXIMUM Y

1.599

1.356

1.503

MINIMUM Y

-1.000

-.823

-.676

CENTROID X

.153

.164

.313

CENTROID Y

-.229

-.406

-.553

POA TO CENTROID in.

.275

.438

.635

MIN RADIUS

.139

.302

.498

MEAN RADIUS

1.065

.982

.861

MAX RADIUS

1.602

1.669

1.788

HORIZONTAL SPREAD

2.390

2.390

2.023

VERTICAL SPREAD

2.599

2.179

2.179

EXTREME SPREAD

2.841

2.841

2.655

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

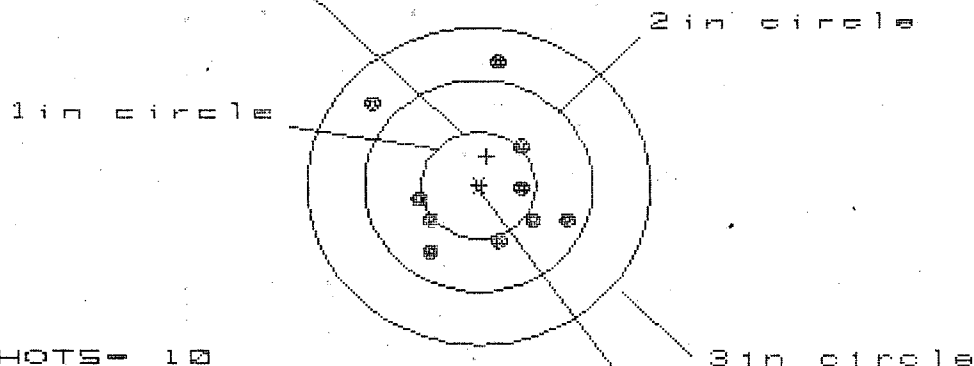
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26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522158

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS= 10

IN CIR.

1 in = 1

2 in = 8

3 in = 10

HS= 1.667

VS= 1.889

GS= 2.017

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.727
MINIMUM X	-.940
MAXIMUM Y	1.226
MINIMUM Y	-.663
CENTROID X	-.073
CENTROID Y	-.278
FOR TO CENTROID in.	.288
MIN RADIUS	.377
MEAN RADIUS	.713
MAX RADIUS	1.245
HORIZONTAL SPREAD	1.667
VERTICAL SPREAD	1.889
EXTREME SPREAD	2.017
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522158

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.334

VS= 2.007

GS= 2.848

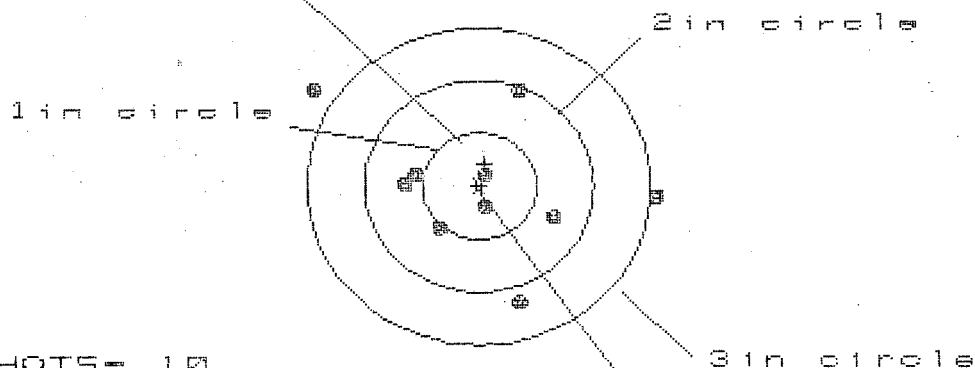
PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.892
MINIMUM X	:	-1.442
MAXIMUM Y	:	1.058
MINIMUM Y	:	-.949
CENTROID X	:	.330
CENTROID Y	:	-.040
POA TO CENTROID in.	:	.333
MIN RADIUS	:	.040
MEAN RADIUS	:	.750
MAX RADIUS	:	1.789
HORIZONTAL SPREAD	:	2.334
VERTICAL SPREAD	:	2.007
EXTREME SPREAD	:	2.948
NUMBER IN ONE INCH CIRCLE	=	3
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6522158

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.974

VS= 1.983

GS= 3.124

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.531	1.371	.681
MINIMUM X	:	-1.443	-.838	-.666
MAXIMUM Y	:	.898	.997	1.002
MINIMUM Y	:	-1.085	-.986	-.981
CENTROID X	:	-.048	.112	-.059
CENTROID Y	:	-.208	-.307	-.312
POA TO CENTROID in.	:	.214	.327	.318
MIN RADIUS	:	.105	.123	.116
MEAN RADIUS	:	.815	.721	.608
MAX RADIUS	:	1.697	1.372	1.076
HORIZONTAL SPREAD	:	2.974	2.209	1.348
VERTICAL SPREAD	:	1.983	1.983	1.983
EXTREME SPREAD	:	3.124	2.209	1.983
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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

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

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

MODEL 700TM M24

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

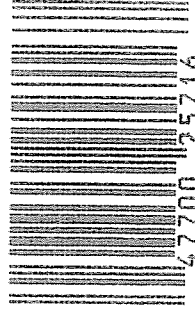
SERIAL NO.
06522159

ORDER NO.
5716



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UPC



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