

C6522129

MODEL 700™ M24

Model **SMS**™

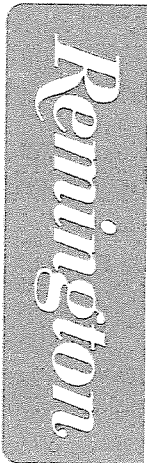
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522139

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/23/90	KCR
	Magnaflux Bolt	8/22 New BBL	8/24/90	KCR
615	Rollmark Caliber		8/21/90	CS
617	Drill and Tap Sight Holes		8/22/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/28/90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/3/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/3/90	RW
	C) Inspect Ejector Hole for Chamfer		10/3/90	RW
	D) Oil Firing Pin Ass'y		10/3/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/3/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/4/90	RW
	G) Safety Off Force	3	3	3			10/4/90	RW
	H) Trigger Pull Test & Retainability						10/3/90	RW
	I) Firing Pin Indent	.0225	.0225	.022			10/4/90	RW
	J) Assemble Stock						10/4/90	RW
	K) Assemble Swivel Studs						10/30/90	928
	L) Attach Front and Rear Sight Assemblies						10/4/90	RW
	M) Iron Sight Alignment						10/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/4/90	RW
	O) Attach Scope to Rifle						10/4/90	RW
	P) Detach & Attach Scope 20 Times						10/4/90	RW
640	Gallery Target & Test						10-9-90	DH
	A) Time						10-9-90	DH
	B) Malfunctions						10-9-90	DH
	C) Pierced Primers						10-9-90	DH
	D) Optical Clarity of Scope						10-9-90	DH
645	Inspect for Live Ammo						10-9-90	DH
655	Final Inspection							
	A) Headspace						10/30/90	928
	B) Trigger Pull	2.27	2.26	2.31	2.43	2.50	10-9-90	81
	C) Function						10/30/90	928
660	Pack						12/18/90	15

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522129

DATE 10/3/99

TESTER AW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.48	2.58	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.50	2.56	2.26	
PULL #3	2.35	2.39	2.50	2.31	
PULL #4	2.58	2.46	2.55	2.43	
PULL #5	2.56	2.47	2.52	2.50	
TOTAL	12.61	12.30	12.71	11.72	
AVG.	2.52	2.46	2.54	2.344	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.39		
PULL #2	3.33	3.36		
PULL #3	3.33	3.39		
PULL #4	3.34	3.32		
PULL #5	3.31	3.29		
TOTAL	16.61	16.75		
AVG.	3.32	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.31		4.17
PULL #2	4.34	4.34		4.26
PULL #3	4.32	4.33		4.24
PULL #4	4.37	4.34		4.21
PULL #5	4.36	4.36		4.27
TOTAL	21.75	21.68		21.15
AVG.	4.35	4.34		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522129
9 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.179922
1 TO	2	.329289
1 TO	3	.418617
1 TO	4	.607217
1 TO	5	.678616

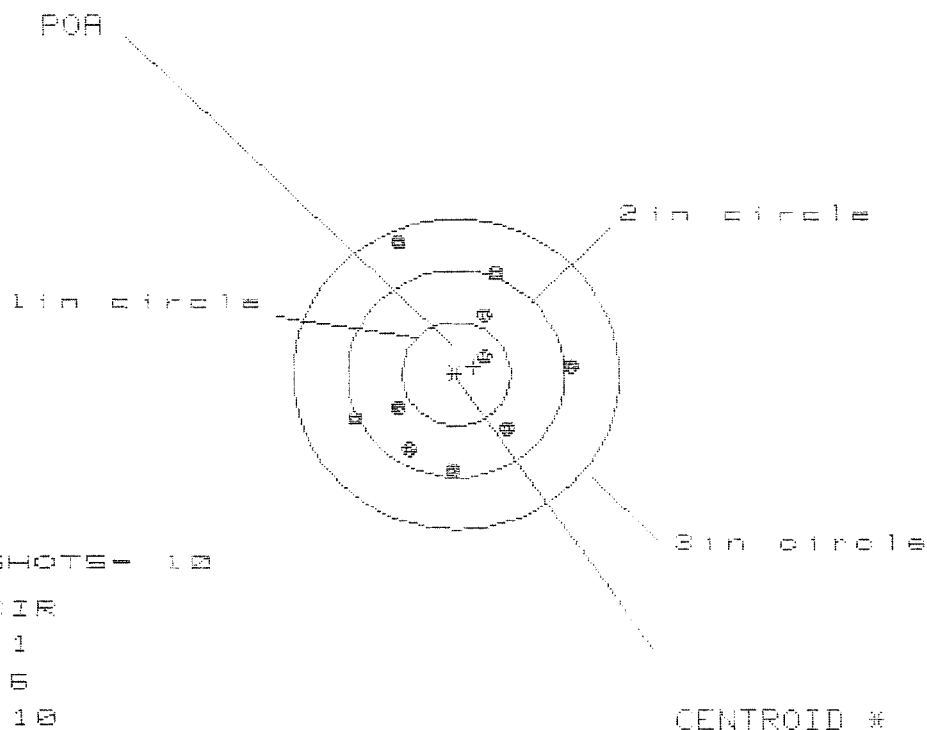
$\sqrt{\frac{1}{n} \sum_{i=1}^n x_i^2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2344
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .255472
THE AMR FOR THIS RIFLE IS: .8422

9 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06582129

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.957

VS= 2.199

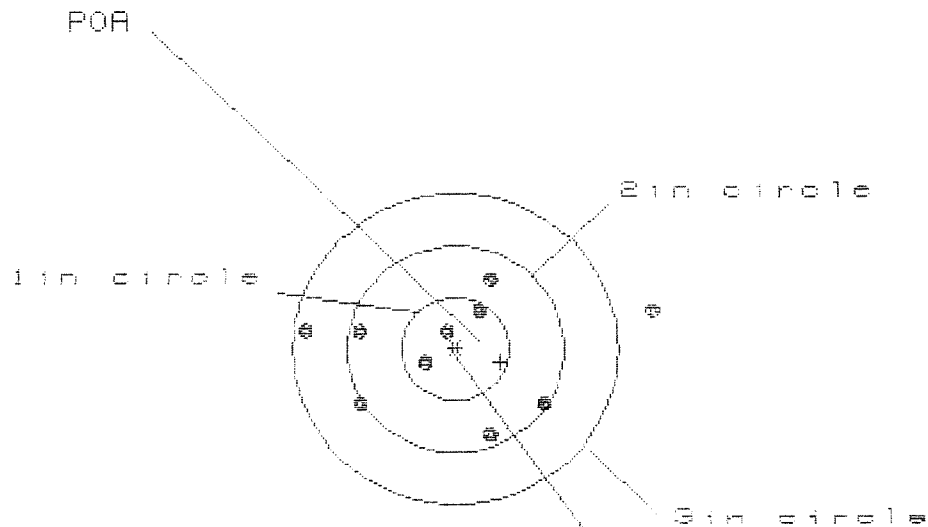
GS= 2.253

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.054	.994	.507
MINIMUM X	-.903	-.963	-.838
MAXIMUM Y	1.240	1.104	1.129
MINIMUM Y	-.959	-.822	-.797
CENTROID X	-.164	-.104	-.229
CENTROID Y	-.074	-.211	-.236
POA TO CENTROID in.	.180	.236	.328
MIN RADIUS	.328	.369	.473
MEAN RADIUS	.846	.776	.738
MAX RADIUS	1.352	1.154	1.219
HORIZONTAL SPREAD	1.957	1.957	1.345
VERTICAL SPREAD	2.199	1.926	1.926
EXTREME SPREAD	2.253	2.026	1.977
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

5 Oct 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 3.188

VS= 1.497

GS= 3.198

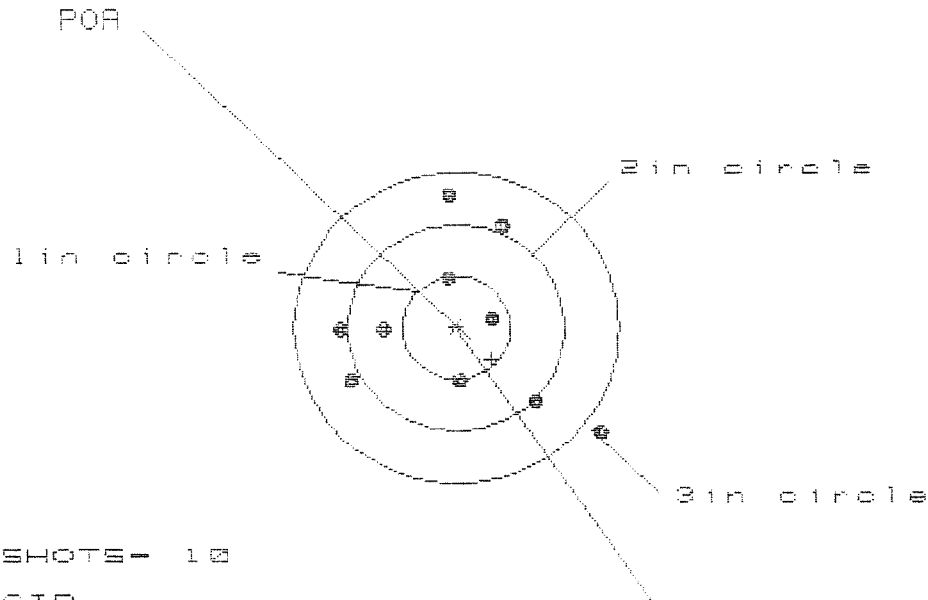
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.820
MINIMUM X	:	-1.368
MAXIMUM Y	:	.670
MINIMUM Y	:	-.827
CENTROID X	:	-.418
CENTROID Y	:	.126
POA TO CENTROID in.	:	.436
MIN RADIUS	:	.144
MEAN RADIUS	:	.855
MAX RADIUS	:	1.868
HORIZONTAL SPREAD	:	3.188
VERTICAL SPREAD	:	1.497
EXTREME SPREAD	:	3.198
NUMBER IN ONE INCH CIRCLE	=	3
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

9 Oct 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.398

VS= 2.267

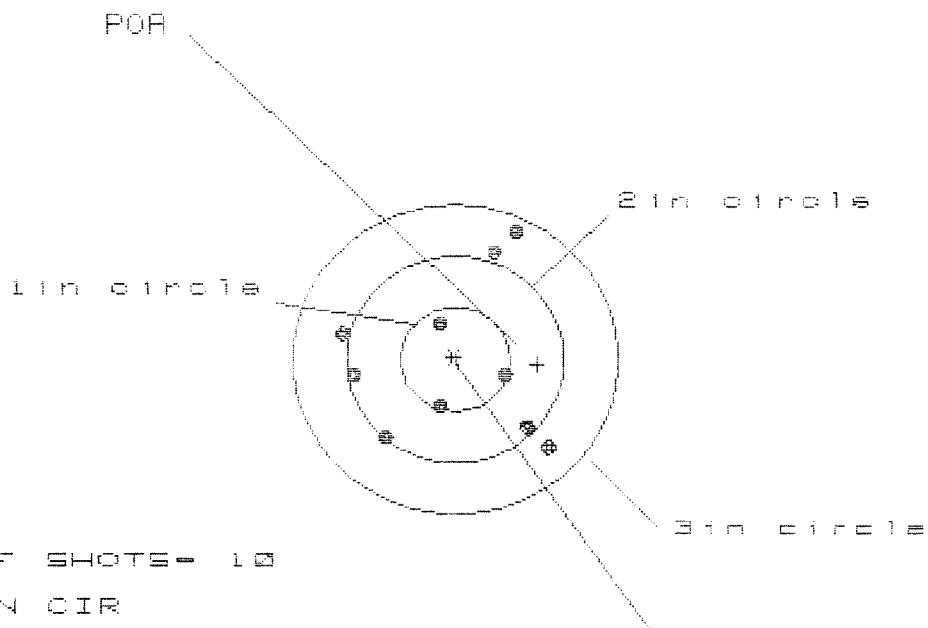
GS= 2.687

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.351	.893	.901
MINIMUM X	:	-1.047	-.897	-.889
MAXIMUM Y	:	1.239	1.125	.991
MINIMUM Y	:	-1.028	-.813	-.673
CENTROID X	:	-.326	-.476	-.484
CENTROID Y	:	.312	.426	.286
POA TO CENTROID in.	:	.451	.639	.562
MIN RADIUS	:	.313	.367	.471
MEAN RADIUS	:	.914	.811	.765
MAX RADIUS	:	1.698	1.208	1.164
HORIZONTAL SPREAD	:	2.398	1.790	1.790
VERTICAL SPREAD	:	2.267	1.938	1.654
EXTREME SPREAD	:	2.687	2.110	2.047
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.937

VS = 2.084

GS = 2.299

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.846	.912	.893
MINIMUM X	-1.091	-1.025	-1.911
MAXIMUM Y	1.253	1.229	1.142
MINIMUM Y	-.831	-.692	-.664
CENTROID X	-.758	-.824	-.938
CENTROID Y	.052	-.087	-.088
POA TO CENTROID in.	.760	.828	.938
MIN RADIUS	.391	.320	.398
MEAN RADIUS	.985	.833	.798
MAX RADIUS	1.385	1.315	1.282
HORIZONTAL SPREAD	1.937	1.937	1.744
VERTICAL SPREAD	2.084	1.921	1.806
EXTREME SPREAD	2.299	2.224	2.064
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

H0 = 1.461

V0 = 1.756

G0 = 1.858

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.877

.835

.478

MINIMUM X

:

-.584

-.626

-.522

MAXIMUM Y

:

.967

1.058

1.014

MINIMUM Y

:

-.789

-.682

-.726

CENTROID X

:

.494

.536

.432

CENTROID Y

:

.092

-.015

.029

POA TO CENTROID in.

:

.563

.537

.433

MIN RADIUS

:

.387

.322

.304

MEAN RADIUS

:

.691

.637

.596

MAX RADIUS

:

1.038

1.059

1.022

HORIZONTAL SPREAD

:

1.461

1.461

1.000

VERTICAL SPREAD

:

1.756

1.740

1.740

EXTREME SPREAD

:

1.903

1.858

1.858

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

10

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6522129

ORDER NO.
5716

Ø1

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



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UPC



BARBER - M24 0004238

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