

C6498764

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498764

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	9	90	RW
610	Dis-assemble Gun	9	90	RW
612	Magnaflux Barrel Action	5-15-90		BER
	Magnaflux Bolt	5-15-90		BER
615	Rollmark Caliber	5-15-90		GS
617	Drill and Tap Sight Holes		5/17/90	LB
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-85-90	TA
	Apply Coating (Bolt)			TA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	JU

BARBER - M24 0007287		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			7/24/90	RL
	G) Safety Off Force	3	3	3			7/24/90	RL
	H) Trigger Pull Test & Retainability						8/23/90	RL
	I) Firing Pin Indent	.023	.0235	.0235			7/24/90	RL
	J) Assemble Stock						8/1/90	RW
	K) Assemble Swivel Studs						8/29/90	RL
	L) Attach Front and Rear Sight Assemblies						8/1/90	RW
	M) Iron Sight Alignment						8/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/90	RW
	O) Attach Scope to Rifle						8/1/90	RW
	P) Detach & Attach Scope 20 Times						8/1/90	RW
640	Gallery Target & Test						8-6-90	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8-6-90	KJ
655	Final Inspection							
	A) Headspace						8/29/90	RL
	B) Trigger Pull	2.31	2.35	2.19	2.22	2.27	8/23/90	RL
	C) Function						9/10/90	RL
660	Pack						9/20/90	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498764DATE 8/23/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.19	2.29	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.19	2.12	2.35	
PULL #3	2.34	2.29	2.09	2.19	
PULL #4	2.26	2.32	2.04	2.22	
PULL #5	2.23	2.21	2.10	2.27	
TOTAL	11.80	11.20	10.69	11.34	
AVG.	2.36	2.24	2.138	2.268	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.24		
PULL #2	3.39	3.38		
PULL #3	3.48	3.32		
PULL #4	3.43	3.30		
PULL #5	3.32	3.23		
TOTAL	16.77	16.52		
AVG.	3.354	3.304		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.21		4.18
PULL #2	4.19	4.20		4.23
PULL #3	4.21	4.24		4.26
PULL #4	4.24	4.21		4.20
PULL #5	4.21	4.22		4.22
TOTAL	21.07	21.08		21.09
AVG.	4.214	4.216		4.218

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498764
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.168716
1 TO	2	.705839
1 TO	3	.94066
1 TO	4	.46964
1 TO	5	.166373

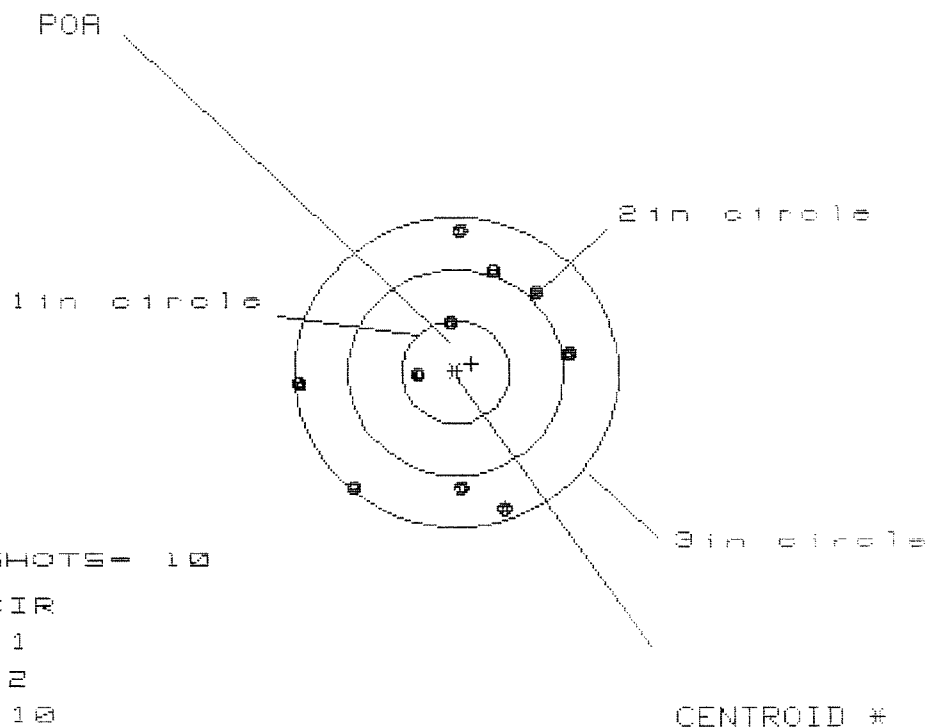
3
B₄₂ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2212
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0126
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .221559
THE AMR FOR THIS RIFLE IS: .982

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B764

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 10

HS= 2.519

VS= 2.769

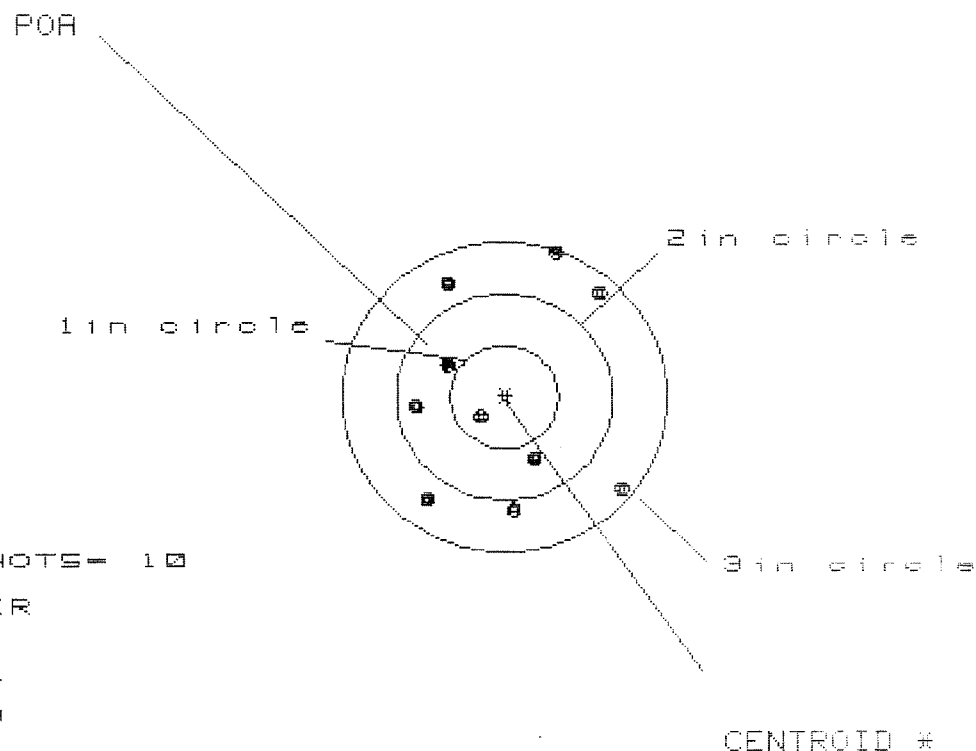
GS= 2.796

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	.972	.779
MINIMUM X	:	-1.441	-1.547	-.637
MAXIMUM Y	:	1.403	1.277	1.252
MINIMUM Y	:	-1.366	-1.492	-1.517
CENTROID X	:	-.148	-.042	.151
CENTROID Y	:	-.081	.045	.070
FOR TO CENTROID in.	:	.168	.062	.166
MIN RADIUS	:	.341	.427	.519
MEAN RADIUS	:	1.095	1.033	.955
MAX RADIUS	:	1.474	1.560	1.525
HORIZONTAL SPREAD	:	2.519	2.519	1.416
VERTICAL SPREAD	:	2.769	2.769	2.769
EXTREME SPREAD	:	2.796	2.796	2.796
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	2		
NUMBER IN THREE INCH CIRCLE =	:	10		

6 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.933

VS = 2.505

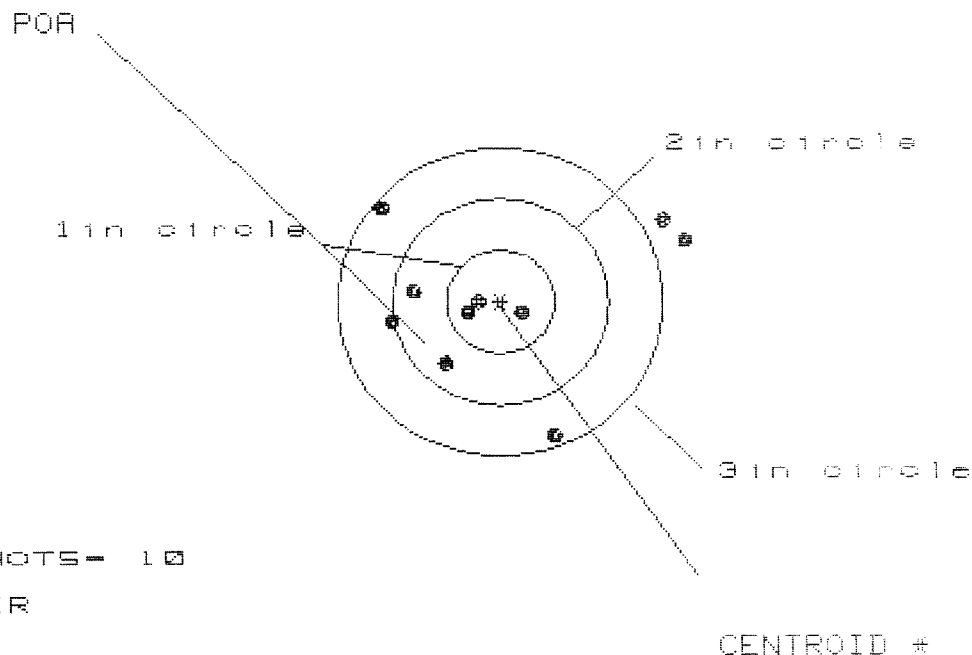
GS = 2.753

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.118	1.176	1.131
MINIMUM X	:	-.815	-.757	-.610
MAXIMUM Y	:	1.441	1.282	1.187
MINIMUM Y	:	-1.065	-.904	-.999
CENTROID X	:	.520	.462	.315
CENTROID Y	:	-.309	-.470	-.375
POA TO CENTROID in.	:	.605	.659	.490
MIN RADIUS	:	.300	.194	.108
MEAN RADIUS	:	1.036	.945	.860
MAX RADIUS	:	1.532	1.544	1.574
HORIZONTAL SPREAD	:	1.933	1.933	1.741
VERTICAL SPREAD	:	2.505	2.186	2.186
EXTREME SPREAD	:	2.753	2.638	2.634
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.838

VS= 2.201

GS= 2.854

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.743
MINIMUM X	:	-1.095
MAXIMUM Y	:	.892
MINIMUM Y	:	-1.309
CENTROID X	:	.503
CENTROID Y	:	.598
POA TO CENTROID in.	:	.781
MIN RADIUS	:	.238
MEAN RADIUS	:	.976
MAX RADIUS	:	1.841
HORIZONTAL SPREAD	:	2.838
VERTICAL SPREAD	:	2.201
EXTREME SPREAD	:	2.854
NUMBER IN ONE INCH CIRCLE =	:	3
NUMBER IN TWO INCH CIRCLE =	:	6
NUMBER IN THREE INCH CIRCLE =	:	8

6 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498764

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 3.232

VS = 2.100

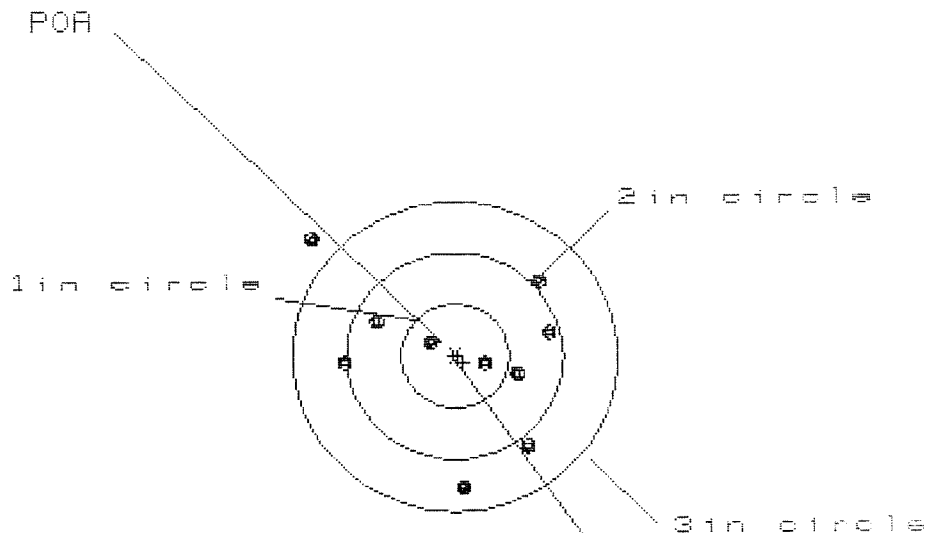
GS = 3.247

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.074	1.517	1.644
MINIMUM X	:	-1.158	-.928	-.738
MAXIMUM Y	:	1.170	1.200	1.295
MINIMUM Y	:	-.930	-.900	-.805
CENTROID X	:	.303	.073	-.117
CENTROID Y	:	-.212	-.242	-.337
POA TO CENTROID in.	:	.370	.253	.356
MIN RADIUS	:	.490	.286	.113
MEAN RADIUS	:	1.176	1.001	.844
MAX RADIUS	:	2.091	1.695	1.787
HORIZONTAL SPREAD	:	3.232	2.445	2.382
VERTICAL SPREAD	:	2.100	2.100	2.100
EXTREME SPREAD	:	3.247	2.632	2.506
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.163

VS = 2.418

GS = 2.872

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.837	.690	.681
MINIMUM X	:	-1.326	-1.221	-1.230
MAXIMUM Y	:	1.133	.831	.686
MINIMUM Y	:	-1.285	-1.159	-.918
CENTROID X	:	-.072	.075	.084
CENTROID Y	:	.067	-.059	.086
POA TO CENTROID in.	:	.098	.096	.120
MIN RADIUS	:	.257	.168	.169
MEAN RADIUS	:	.913	.798	.736
MAX RADIUS	:	1.744	1.223	1.232
HORIZONTAL SPREAD	:	2.163	1.911	1.911
VERTICAL SPREAD	:	2.418	1.990	1.605
EXTREME SPREAD	:	2.872	2.112	2.004
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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

MODEL 700™ H24

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.

SERIAL NO.
C6498764

ORDER NO.
5716

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UPC