

06498783

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498783

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	G.S.
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		5-4-90	JA
	Apply Coating (Bolt)			
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		9-4-90	JP

BARBER - M24 0007680		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			8/26/90	JH
	G) Safety Off Force	4	4	4			7/26/90	JH
	H) Trigger Pull Test & Retainability						9-4-90	JH
	I) Firing Pin Indent	.022	.022	.022			7/26/90	JH
	J) Assemble Stock						7/30/90	RW
	K) Assemble Swivel Studs						9/5/90	JS
	L) Attach Front and Rear Sight Assemblies						7/30/90	RW
	M) Iron Sight Alignment						7/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	RW
	O) Attach Scope to Rifle						7/30/90	RW
	P) Detach & Attach Scope 20 Times						7/30/90	RW
640	Gallery Target & Test						8-8-90	RJ
	A) Time							RJ
	B) Malfunctions							RJ
	C) Pierced Primers							RJ
	D) Optical Clarity of Scope							RJ
645	Inspect for Live Ammo						8-8-90	RJ
655	Final Inspection							
	A) Headspace						9/5/90	JS
	B) Trigger Pull	2.22	2.15	2.25	2.11	2.10	9-4-90	JH
	C) Function						9/5/90	JS
660	Pack						9/20/90	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498783DATE 9-4-90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.24	2.24	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.23	2.30	2.18	
PULL #3	2.56	2.12	2.18	2.25	
PULL #4	2.32	2.38	2.18	2.11	
PULL #5	2.43	2.02	2.22	2.10	
TOTAL	12.09	10.99	11.12	10.86	
AVG.	2.418	2.198	2.224	2.172	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.34		
PULL #2	3.21	3.43		
PULL #3	3.23	3.22		
PULL #4	3.25	3.36		
PULL #5	3.25	3.37		
TOTAL	16.19	16.72		
AVG.	3.238	3.344		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.35		4.28
PULL #2	4.46	4.12		4.09
PULL #3	4.50	4.32		4.48
PULL #4	4.41	4.36		4.48
PULL #5	4.13	4.44		4.50
TOTAL	21.68	21.59		21.83
AVG.	4.336	4.318		4.366

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498783
8 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.0928924
1 TO	2	.25906
1 TO	3	.214112
1 TO	4	.252745
1 TO	5	.340278

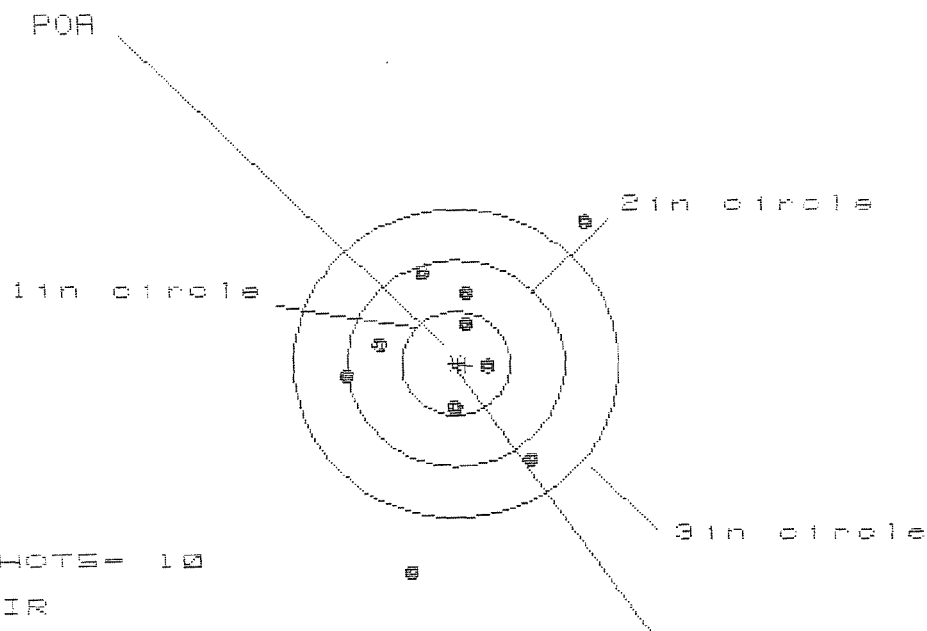
25
2# <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0748
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .196
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .209788
THE AMR FOR THIS RIFLE IS: .9148

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498783

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 2.241

VS = 3.391

CS = 3.774

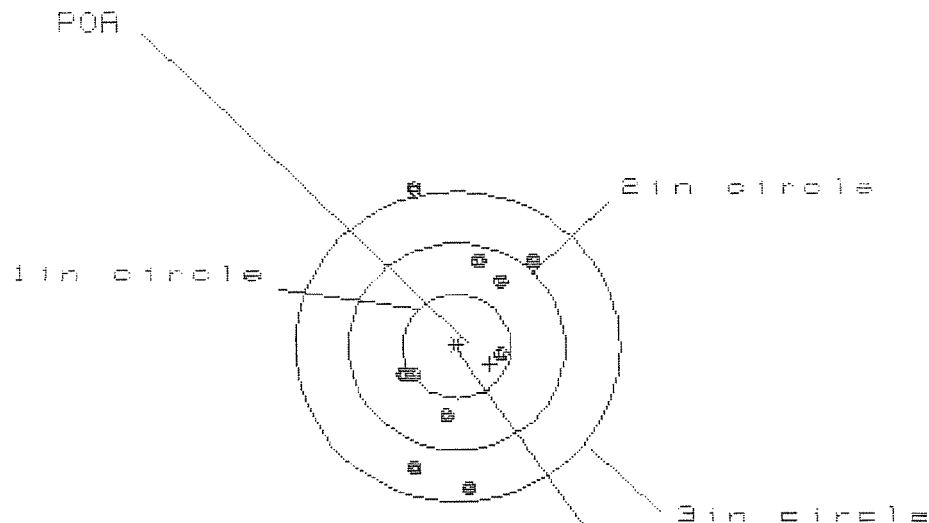
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.228	1.181	.757
MINIMUM X	-1.013	-1.060	-.913
MAXIMUM Y	1.379	1.155	.843
MINIMUM Y	-2.012	-1.131	-.987
CENTROID X	-.090	-.043	-.190
CENTROID Y	.023	.247	.102
POA TO CENTROID in.	.093	.251	.216
MIN RADIUS	.333	.210	.408
MEAN RADIUS	.965	.817	.713
MAX RADIUS	2.057	1.652	1.244
HORIZONTAL SPREAD	2.241	2.241	1.670
VERTICAL SPREAD	3.391	2.286	1.830
EXTREME SPREAD	3.774	2.723	2.053
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498783

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.167

VS= 2.862

GS= 2.903

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.674	.630	.635
MINIMUM X	-.493	-.537	-.532
MAXIMUM Y	1.521	1.028	.882
MINIMUM Y	-1.341	-1.172	-1.167
CENTROID X	-.304	-.260	-.265
CENTROID Y	.169	-.000	.146
POA TO CENTROID in.	.348	.260	.303
MIN RADIUS	.445	.408	.404
MEAN RADIUS	.900	.807	.759
MAX RADIUS	1.572	1.173	1.262
HORIZONTAL SPREAD	1.167	1.167	1.167
VERTICAL SPREAD	2.862	2.200	2.049
EXTREME SPREAD	2.903	2.279	2.279
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06498783

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.723

VS = 2.854

GS = 3.055

CENTROID *

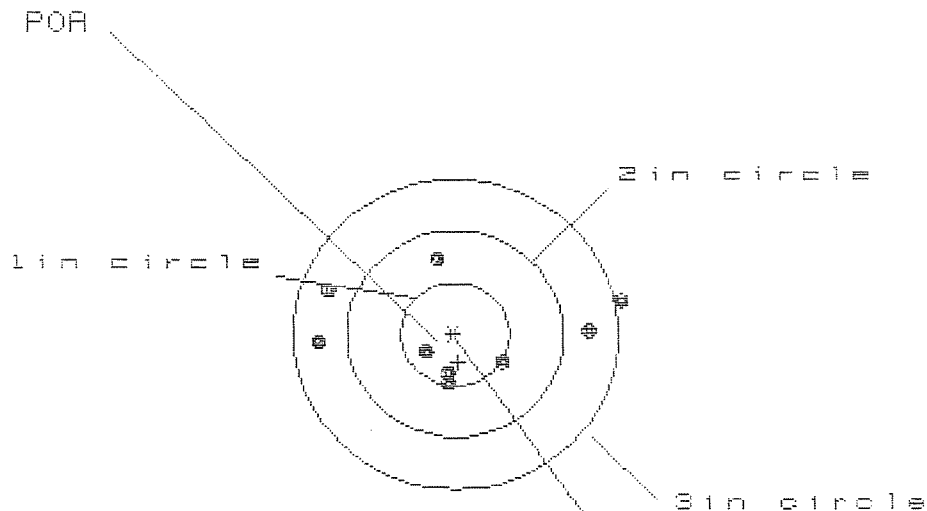
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	1.003	.982
MINIMUM X	:	-.813	-.720	-.741
MAXIMUM Y	:	1.551	.983	.841
MINIMUM Y	:	-1.303	-1.131	-.948
CENTROID X	:	.072	-.021	-.000
CENTROID Y	:	.163	-.009	.133
POR TO CENTROID in.	:	.178	.023	.133
MIN RADIUS	:	.240	.045	.184
MEAN RADIUS	:	1.019	.904	.880
MAX RADIUS	:	1.760	1.251	1.154
HORIZONTAL SPREAD	:	1.723	1.723	1.723
VERTICAL SPREAD	:	2.854	2.114	1.790
EXTREME SPREAD	:	3.055	2.241	2.241
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C649B7B3

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 2.878

VS = 1.206

CS = 2.907

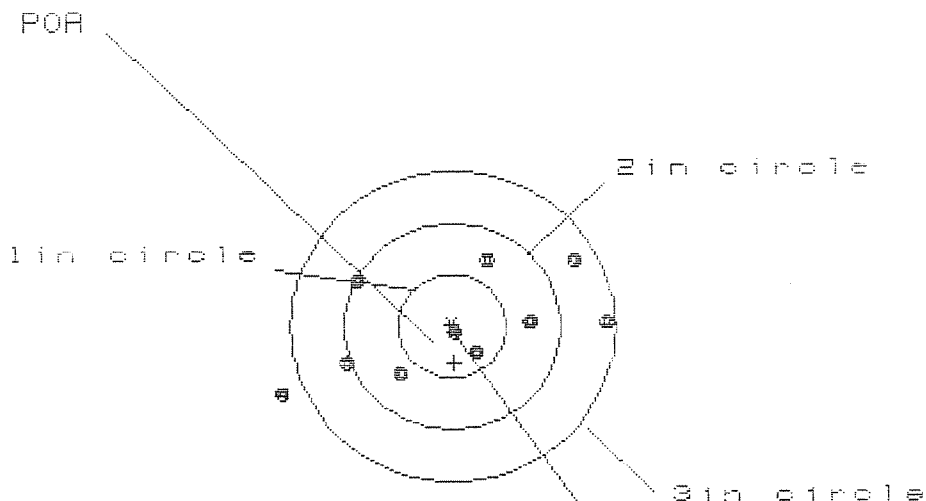
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.581	1.364	1.223
MINIMUM X	:	-1.297	-1.121	-1.115
MAXIMUM Y	:	.727	.767	.766
MINIMUM Y	:	-.479	-.439	-.440
CENTROID X	:	-.032	-.208	-.067
CENTROID Y	:	.269	.229	.230
POA TO CENTROID in.	:	.271	.309	.240
MIN RADIUS	:	.288	.150	.236
MEAN RADIUS	:	.811	.685	.633
MAX RADIUS	:	1.621	1.366	1.229
HORIZONTAL SPREAD	:	2.878	2.485	2.338
VERTICAL SPREAD	:	1.206	1.206	1.206
EXTREME SPREAD	:	2.907	2.486	2.380
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C84987B3

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.925

VS = 1.264

GS = 2.998

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.382
MINIMUM X	-1.543
MAXIMUM Y	.639
MINIMUM Y	-.625
CENTROID X	-.020
CENTROID Y	.356
POA TO CENTROID in.	.357
MIN RADIUS	.052
MEAN RADIUS	.879
MAX RADIUS	1.665
HORIZONTAL SPREAD	2.925
VERTICAL SPREAD	1.264
EXTREME SPREAD	2.998
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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

MODEL 700™ M24

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

SERIAL NO.
 C6498783

ORDER NO.
 5716

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

Q1

