

C6498796

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700[™] M24

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.

REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6498796

ORDER NO.
5716

01

5716 C6498796

UPC

0 47700 125716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498796

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	G.S.
617	Drill and Tap Sight Holes		7/13/90	WB
618	Polish Barrel AB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	WB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/18/90	WB

BARBER - M24 0007896

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4			8/18/90	WB
	G) Safety Off Force	2 1/4	2	2			8/18/90	WB
	H) Trigger Pull Test & Retainability						8/18/90	WB
	I) Firing Pin Indent	.0225	.023	.0225			8/18/90	WB
	J) Assemble Stock						8/23/90	RW
	K) Assemble Swivel Studs						8/31/90	28
	L) Attach Front and Rear Sight Assemblies						8/23/90	RW
	M) Iron Sight Alignment						8/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/23/90	RW
	O) Attach Scope to Rifle						8/23/90	RW
	P) Detach & Attach Scope 20 Times						8/23/90	RW
640	Gallery Target & Test						8/23/90	NF
	A) Time						8/23/90	NF
	B) Malfunctions						8/23/90	NF
	C) Pierced Primers						8/23/90	NF
	D) Optical Clarity of Scope						8/23/90	NF
645	Inspect for Live Ammo						8/23/90	NF
655	Final Inspection							
	A) Headspace						8/31/90	28
	B) Trigger Pull	2.27	2.30	2.22	2.27	2.22	8/31/90	28
	C) Function						8/31/90	28
660	Pack						9/20/90	NF

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

SERIAL NO. C6498796
DATE Aug 18, 1990
TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	³ 2.66	² 2.64	² 2.52	¹ 2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.68	2.63	2.49	2.30	
PULL #3	2.46	2.66	2.57	2.22	
PULL #4	2.75	2.71	2.69	2.27	
PULL #5	2.85	2.66	2.61	2.22	
TOTAL	13.40	13.30	12.88	11.28	
AVG.	2.68	2.60	2.57	2.256	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	³ 3.76 3.40	³ 3.14		
PULL #2	3.12	3.18		
PULL #3	3.14	3.19		
PULL #4	3.09	3.07		
PULL #5	3.11	3.12		
TOTAL	15.62	15.70		
AVG.	3.12	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	¹ 4.27	² 4.19		³ 4.29
PULL #2	4.12	4.07		4.44
PULL #3	4.30	4.33		4.39
PULL #4	4.36	4.21		4.45
PULL #5	4.33	4.39		4.48
TOTAL	21.38	21.19		22.05
AVG.	4.27	4.24		4.41

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498796
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.518684
1 TO	2	.656948
1 TO	3	.340812
1 TO	4	1.17039
1 TO	5	.309231

4
+2 <----POA
15
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2226
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226344
THE AMR FOR THIS RIFLE IS: .7716

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498798

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 2.055

VS= 1.739

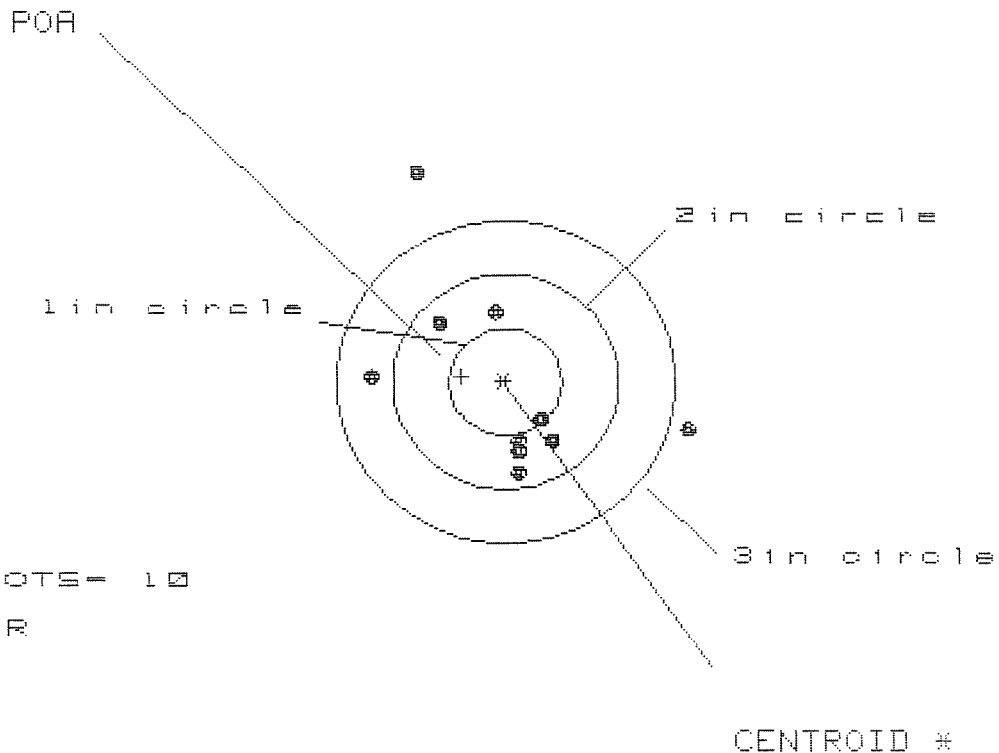
GS= 2.056

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.698	.547	.500
MINIMUM X	-1.357	-.375	-.320
MAXIMUM Y	.791	.775	.654
MINIMUM Y	-.948	-.964	-.376
CENTROID X	-.083	.068	.115
CENTROID Y	-.512	-.496	-.375
POA TO CENTROID in.	.519	.500	.392
MIN RADIUS	.193	.171	.120
MEAN RADIUS	.614	.511	.448
MAX RADIUS	1.365	1.034	.706
HORIZONTAL SPREAD	2.055	.922	.820
VERTICAL SPREAD	1.739	1.739	1.030
EXTREME SPREAD	2.056	1.769	1.170
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 2.799

VS= 2.738

GS= 3.358

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.583	1.495	.490
MINIMUM X	:	-1.216	-1.304	-1.118
MAXIMUM Y	:	1.923	.913	.885
MINIMUM Y	:	-.815	-.601	-.629
CENTROID X	:	.387	.475	.289
CENTROID Y	:	-.053	-.267	-.238
POA TO CENTROID in.	:	.390	.545	.374
MIN RADIUS	:	.447	.259	.365
MEAN RADIUS	:	.948	.749	.680
MAX RADIUS	:	2.083	1.512	1.134
HORIZONTAL SPREAD	:	2.799	2.799	1.608
VERTICAL SPREAD	:	2.738	1.514	1.514
EXTREME SPREAD	:	3.358	2.835	1.685
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 3.018

VS= 1.030

GS= 3.085

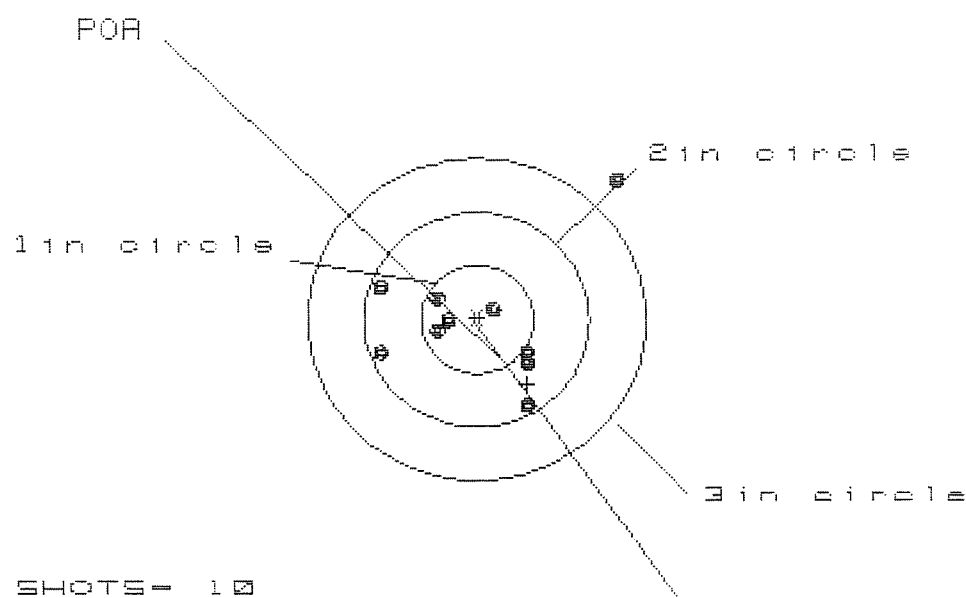
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	1.001	.800
MINIMUM X	:	-1.815	-1.608	-.643
MAXIMUM Y	:	.532	.573	.516
MINIMUM Y	:	-.498	-.457	-.512
CENTROID X	:	-.231	-.029	.172
CENTROID Y	:	-.819	-.860	-.803
POA TO CENTROID in.	:	.851	.860	.821
MIN RADIUS	:	.245	.187	.348
MEAN RADIUS	:	.866	.732	.609
MAX RADIUS	:	1.852	1.672	.884
HORIZONTAL SPREAD	:	3.018	2.609	1.443
VERTICAL SPREAD	:	1.030	1.030	1.028
EXTREME SPREAD	:	3.085	2.695	1.667
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 9

HS= 2.141

VS= 2.059

GS= 2.651

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.250	.631	.537
MINIMUM X	:	-.891	-.753	-.789
MAXIMUM Y	:	1.271	.423	.404
MINIMUM Y	:	-.788	-.647	-.666
CENTROID X	:	-.445	-.583	-.489
CENTROID Y	:	.601	.460	.479
POA TO CENTROID in.	:	.748	.743	.685
MIN RADIUS	:	.178	.165	.216
MEAN RADIUS	:	.690	.548	.519
MAX RADIUS	:	1.782	.859	.886
HORIZONTAL SPREAD	:	2.141	1.384	1.326
VERTICAL SPREAD	:	2.059	1.070	1.070
EXTREME SPREAD	:	2.651	1.652	1.652
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.379

VS= 2.025

GS= 2.455

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.392	.705	.742
MINIMUM X	:	-.987	-.833	-.796
MAXIMUM Y	:	1.145	1.066	.382
MINIMUM Y	:	-.880	-.959	-.826
CENTROID X	:	.167	.013	-.024
CENTROID Y	:	-.330	-.251	-.384
POA TO CENTROID in.	:	.370	.251	.385
MIN RADIUS	:	.265	.168	.112
MEAN RADIUS	:	.740	.613	.551
MAX RADIUS	:	1.565	1.191	1.111
HORIZONTAL SPREAD	:	2.379	1.538	1.538
VERTICAL SPREAD	:	2.025	2.025	1.208
EXTREME SPREAD	:	2.455	2.066	1.748
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	