

C6498805

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498806

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	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TA
	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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/18/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/18/90	WB
	H) Trigger Pull Test & Retainability						8/18/90	WB
	I) Firing Pin Indent	.023	.023	.023			8/18/90	WB
	J) Assemble Stock						8/24/90	RW
	K) Assemble Swivel Studs						8/31/90	928
	L) Attach Front and Rear Sight Assemblies						8/24/90	RW
	M) Iron Sight Alignment						8/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	RW
	O) Attach Scope to Rifle						8/24/90	WB
	P) Detach & Attach Scope 20 Times						8/24/90	WB
640	Gallery Target & Test						8-24-90	A
	A) Time						8-24-90	A
	B) Malfunctions						8-24-90	A
	C) Pierced Primers						8-24-90	A
	D) Optical Clarity of Scope						8-24-90	A
645	Inspect for Live Ammo						8-24-90	A
655	Final Inspection							
	A) Headspace						8/31/90	928
	B) Trigger Pull	2.42	2.37	2.50	2.50	2.50	8/31/90	941
	C) Function						8/31/90	928
660	Pack						9/20/90	15

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498806

DATE Aug 18 / 1990

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.50	2.44	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.44	2.50	2.37	
PULL #3	2.56	2.46	2.43	2.50	
PULL #4	2.48	2.48	2.51	2.50	
PULL #5	2.43	2.47	2.45	2.50	
TOTAL	12.63	12.35	12.33	12.29	
AVG.	2.52	2.47	2.46	2.458	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.07		
PULL #2	3.19	3.07		
PULL #3	3.18	3.05		
PULL #4	3.13	3.25		
PULL #5	3.11	3.20		
TOTAL	15.79	15.64		
AVG.	3.18	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.25		4.29
PULL #2	4.17	4.20		4.20
PULL #3	4.11	4.15		4.25
PULL #4	4.21	4.22		4.20
PULL #5	4.16	4.14		4.08
TOTAL	20.81	20.96		21.02
AVG.	4.16	4.19		4.20

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498806
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.516902
1 TO	2	.266908
1 TO	3	.364936
1 TO	4	.785525
1 TO	5	.585212

1
4
4

<----POR

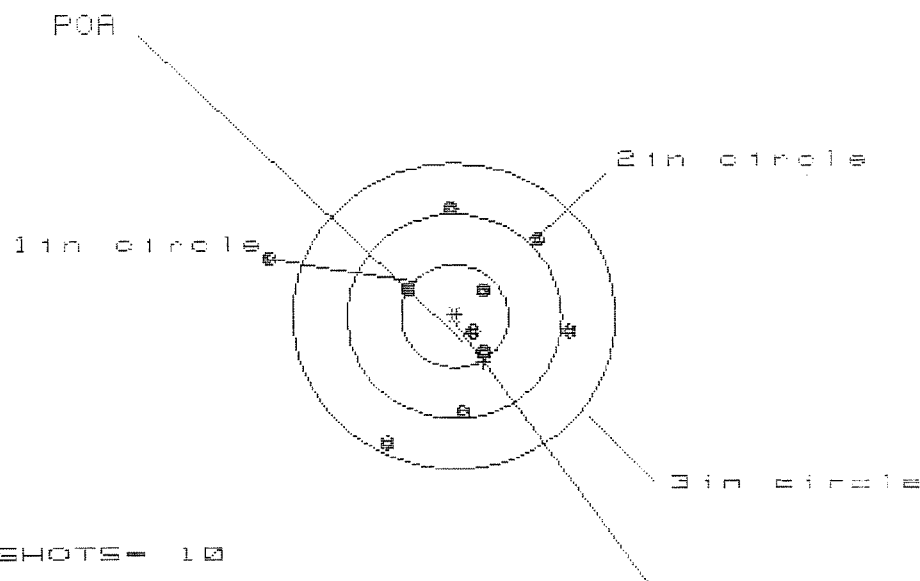
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .15989

THE AMR FOR THIS RIFLE IS: .9792

24 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06498806

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 9

HS = 2.0000

VS = 2.244

GS = 2.885

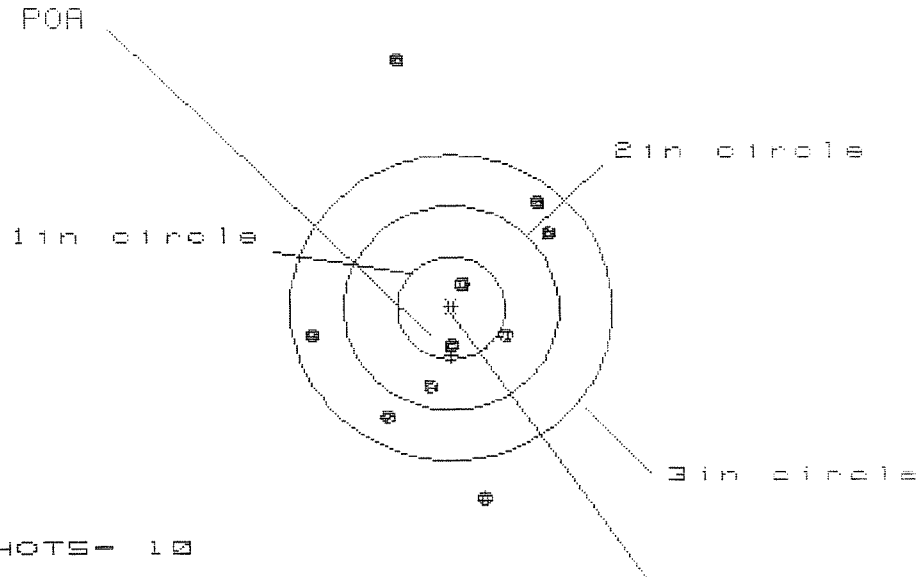
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.102	.914	.817
MINIMUM X	:	-1.698	-.771	-.721
MAXIMUM Y	:	1.008	1.073	.927
MINIMUM Y	:	-1.236	-1.171	-1.024
CENTROID X	:	-.268	-.080	.017
CENTROID Y	:	.442	.377	.523
POA TO CENTROID in.	:	.517	.385	.523
MIN RADIUS	:	.264	.099	.179
MEAN RADIUS	:	.894	.753	.669
MAX RADIUS	:	1.797	1.402	1.050
HORIZONTAL SPREAD	:	2.800	1.685	1.538
VERTICAL SPREAD	:	2.244	2.244	1.951
EXTREME SPREAD	:	2.885	2.430	1.952
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

24 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.153

VS= 4.243

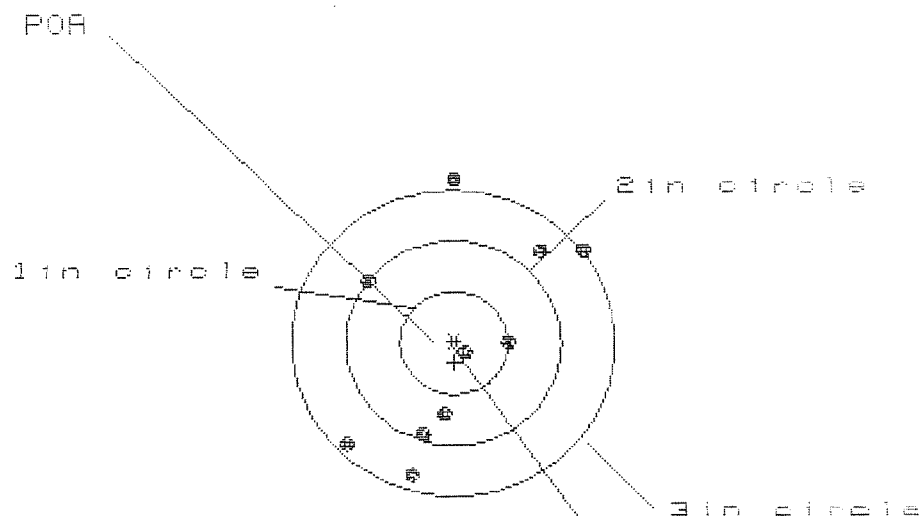
GS= 4.330

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.859	.800	.835
MINIMUM X	:	-1.294	-1.353	-1.318
MAXIMUM Y	:	2.403	1.337	1.141
MINIMUM Y	:	-1.840	-1.573	-1.008
CENTROID X	:	-.002	.057	.022
CENTROID Y	:	.464	.197	.393
POA TO CENTROID in.	:	.464	.205	.394
MIN RADIUS	:	.285	.095	.277
MEAN RADIUS	:	1.128	.932	.858
MAX RADIUS	:	2.461	1.597	1.382
HORIZONTAL SPREAD	:	2.153	2.153	2.153
VERTICAL SPREAD	:	4.243	2.910	2.149
EXTREME SPREAD	:	4.330	2.947	2.543
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 2.127

VS = 2.917

GS = 2.941

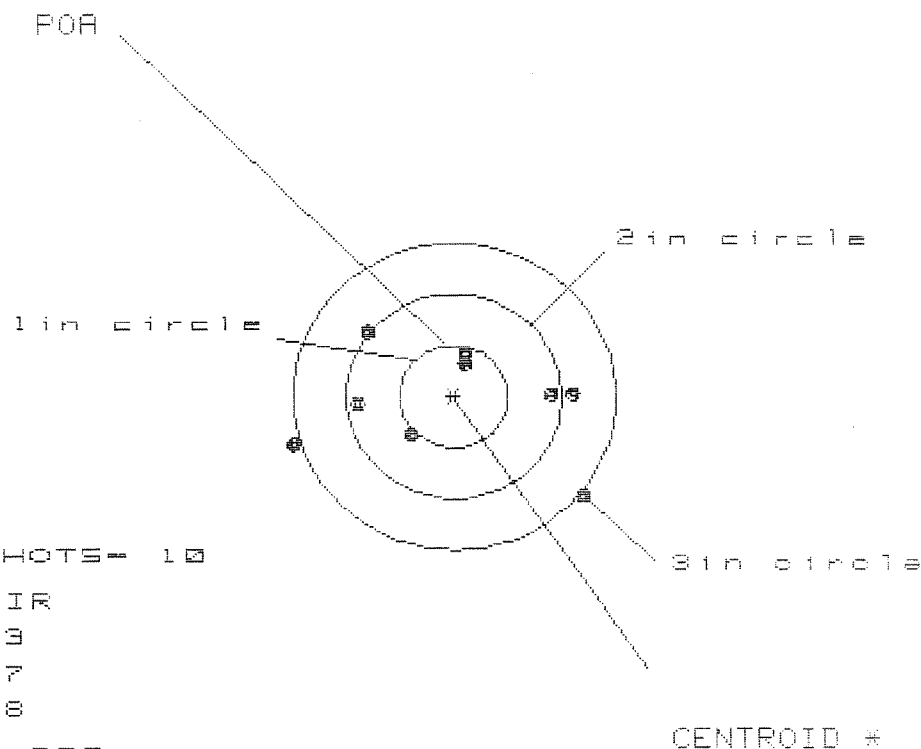
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.176	1.171	.996
MINIMUM X	:	-.951	-.956	-.809
MAXIMUM Y	:	1.611	1.130	1.265
MINIMUM Y	:	-1.306	-1.127	-.992
CENTROID X	:	-.005	-.000	-.147
CENTROID Y	:	.189	.010	-.125
POA TO CENTROID in.	:	.189	.010	.193
MIN RADIUS	:	.119	.121	.319
MEAN RADIUS	:	1.050	.962	.868
MAX RADIUS	:	1.611	1.595	1.610
HORIZONTAL SPREAD	:	2.127	2.127	1.885
VERTICAL SPREAD	:	2.917	2.257	2.257
EXTREME SPREAD	:	2.941	2.855	2.658
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

24 Aug 1998

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.689

VS = 1.619

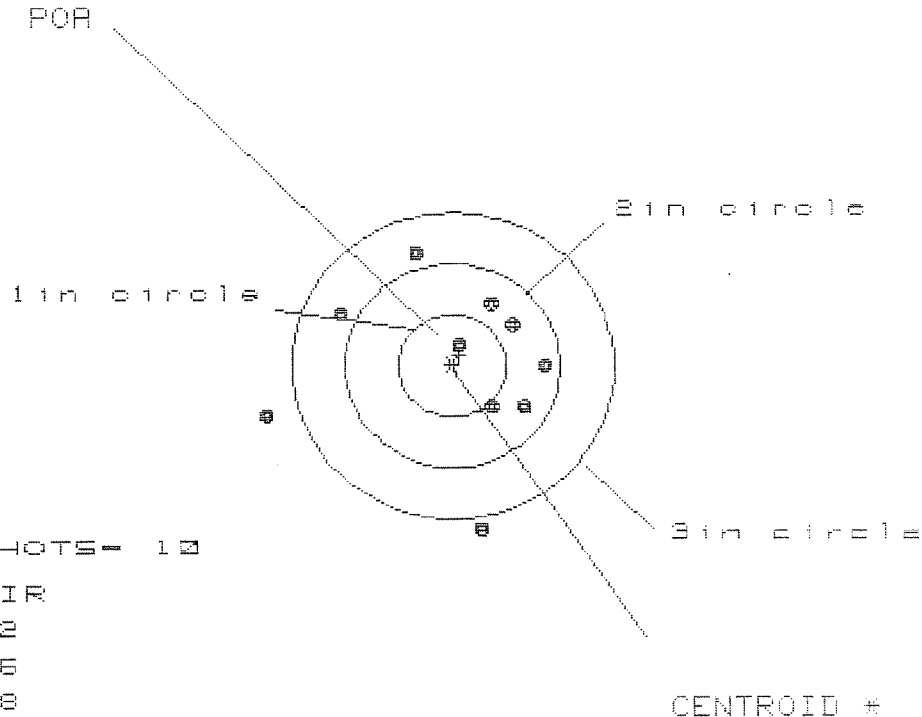
GS = 2.734

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.191
MINIMUM X	:	-1.498
MAXIMUM Y	:	.649
MINIMUM Y	:	-.970
CENTROID X	:	-.103
CENTROID Y	:	-.326
POA TO CENTROID in.	:	.342
MIN RADIUS	:	.332
MEAN RADIUS	:	.877
MAX RADIUS	:	1.571
HORIZONTAL SPREAD	:	2.689
VERTICAL SPREAD	:	1.619
EXTREME SPREAD	:	2.734
NUMBER IN ONE INCH CIRCLE	=	3
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	8

24 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 8

HS= 2.545

VS= 2.715

GS= 2.773

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.831

.641

.649

MINIMUM X

:

-1.714

-1.243

-1.235

MAXIMUM Y

:

1.090

1.038

.828

MINIMUM Y

:

-1.625

-1.677

-.703

CENTROID X

:

-.060

.130

.122

CENTROID Y

:

-.105

-.053

.157

POR TO CENTROID in.:

:

.121

.141

.199

MIN RADIUS

:

.203

.200

.146

MEAN RADIUS

:

.947

.803

.670

MAX RADIUS

:

1.777

1.678

1.268

HORIZONTAL SPREAD

:

2.545

1.884

1.884

VERTICAL SPREAD

:

2.715

2.715

1.531

EXTREME SPREAD

:

2.773

2.773

1.975

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8

Remington



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

MODEL 700™ M24

SERIAL NO.
C6498806

ORDER NO.
5716

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

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5716 C6498806

UPC



0 47700 25716 7

BARBER - M24 0008056

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KINZER V. REMINGTON

BARBER - M24 00080908095