

4-

C6498821

79

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

SERIAL NO.

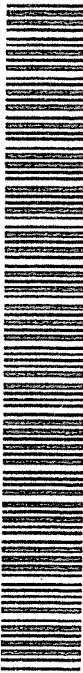
C6498821

ORDER NO.

5716

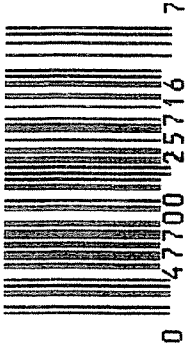
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6498821

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498821

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9 90	5-15-90	RW
600	Proof	5 9 90	5-15-90	RW
607	Check Headspace	5 9 90	5-15-90	RW
610	Dis-assemble Gun	5 9 90	5-15-90	RW
612	Magnaflux Barrel Action	5-15-90	5-15-90	BER
	Magnaflux Bolt	5-15-90	5-15-90	HER
615	Rollmark Caliber	5-15-90	5-15-90	GS
617	Drill and Tap Sight Holes		5/17/90	FB
618	Polish Barrel AB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TJX
	Apply Coating (Bolt)		5-25-90	TJX
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/5/90	JH

BARBER - M24 0008377

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			6/5/90	JH
	G) Safety Off Force	2	2	2			6/5/90	JH
	H) Trigger Pull Test & Retainability						6/5/90	JH
	I) Firing Pin Indent	.024	.0235	.0235			6/5/90	JH
	J) Assemble Stock						6/6/90	RW
	K) Assemble Swivel Studs						6/13/90	JH
	L) Attach Front and Rear Sight Assemblies						6/6/90	RW
	M) Iron Sight Alignment						6/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/90	RW
	O) Attach Scope to Rifle						6/7/90	WB
	P) Detach & Attach Scope 20 Times						6/7/90	WB
640	Gallery Target & Test						6-8-90	DH
	A) Time						6-8-90	DH
	B) Malfunctions						6-8-90	DH
	C) Pierced Primers						6-8-90	DH
	D) Optical Clarity of Scope						6-8-90	DH
645	Inspect for Live Ammo						6-8-90	DH
655	Final Inspection							
	A) Headspace						6/13/90	JH
	B) Trigger Pull	2.79	2.67	2.75	2.75	2.72	6/13/90	6S
	C) Function						6/13/90	JH
660	Pack						6-19-90	DH

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

SERIAL NO. CL498821DATE 6/5/90TESTER DM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.39	2.40	279	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.41	2.36	267	
PULL #3	2.42	2.37	2.33	275	
PULL #4	2.43	2.35	2.35	275	
PULL #5	2.40	2.37	2.40	272	
TOTAL	11.89	11.89	11.84		
AVG.	2.378	2.378	2.368		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.21		
PULL #2	3.33	3.27		
PULL #3	3.20	3.28		
PULL #4	3.28	3.36		
PULL #5	3.20	3.32		
TOTAL	16.18	16.44		
AVG.	3.236	3.288		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.21		4.36
PULL #2	4.34	4.28		4.36
PULL #3	4.33	4.36		4.31
PULL #4	4.22	4.27		4.36
PULL #5	4.30	4.34		4.45
TOTAL	21.50	21.46		21.84
AVG.	4.3	4.292		4.368

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498821
8 Jun 1990

CENTROIDAL DISTANCES

Ø TO	1	.423037
1 TO	2	.251382
1 TO	3	.293981
1 TO	4	.599443
1 TO	5	.208828

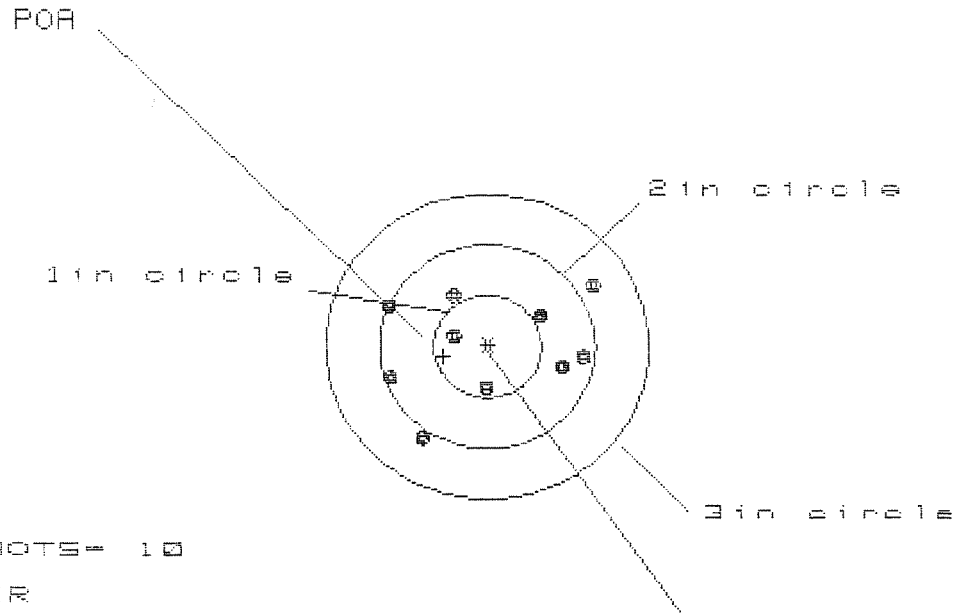
~~48~~⁴⁸¹ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .179
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179429
THE AMR FOR THIS RIFLE IS: .8068

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498821

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.896

VS= 1.417

GS= 2.105

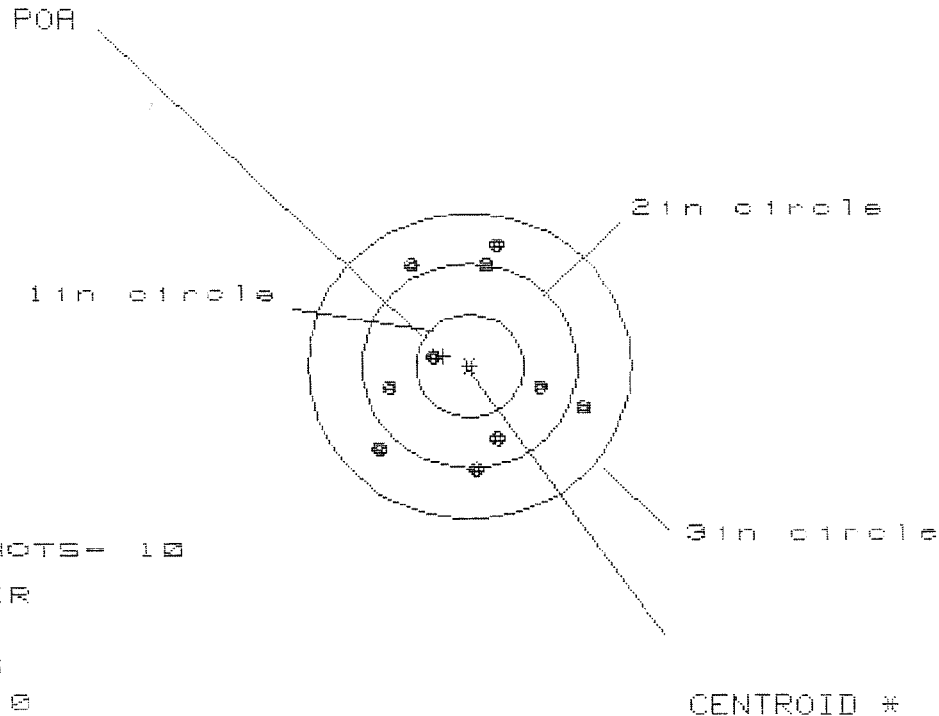
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.956	1.003	.942
MINIMUM X	-.940	-.834	-.895
MAXIMUM Y	.567	.528	.430
MINIMUM Y	-.850	-.787	-.412
CENTROID X	.412	.306	.367
CENTROID Y	.096	.033	.131
POA TO CENTROID in.	.423	.307	.390
MIN RADIUS	.319	.260	.265
MEAN RADIUS	.758	.711	.675
MAX RADIUS	1.112	1.003	.973
HORIZONTAL SPREAD	1.896	1.837	1.837
VERTICAL SPREAD	1.417	1.315	.842
EXTREME SPREAD	2.105	1.861	1.861
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498821

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.828

VS= 2.161

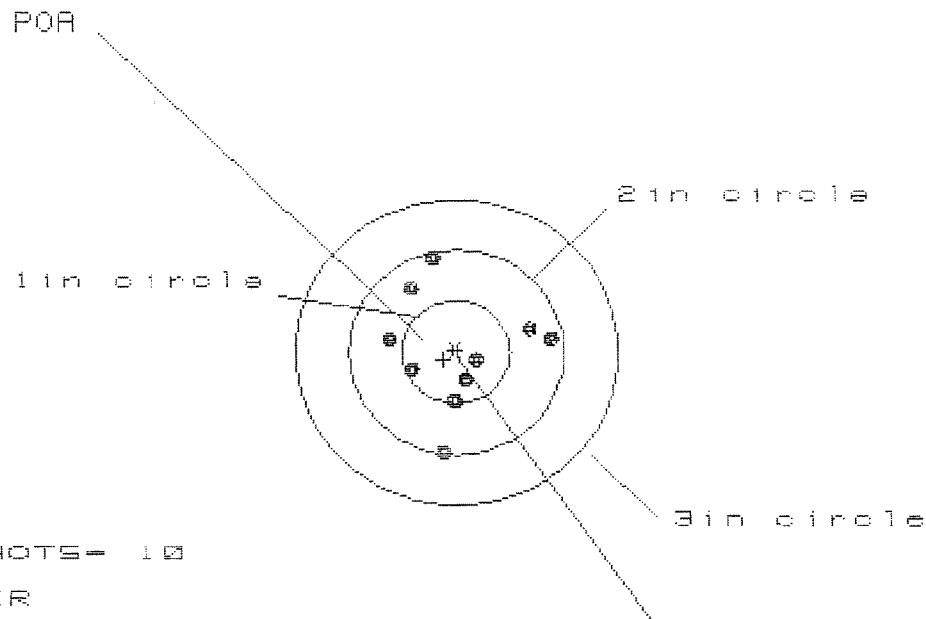
GS= 2.178

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.024	1.051	.989
MINIMUM X	:	-.804	-.777	-.839
MAXIMUM Y	:	1.152	1.158	1.246
MINIMUM Y	:	-1.009	-.881	-.736
CENTROID X	:	.244	.217	.279
CENTROID Y	:	-.091	-.219	-.364
POA TO CENTROID in.	:	.260	.309	.459
MIN RADIUS	:	.335	.361	.435
MEAN RADIUS	:	.897	.850	.780
MAX RADIUS	:	1.177	1.261	1.251
HORIZONTAL SPREAD	:	1.828	1.828	1.828
VERTICAL SPREAD	:	2.161	2.039	1.982
EXTREME SPREAD	:	2.178	2.127	1.983
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Jun 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.583

VS = 1.987

GS = 1.988

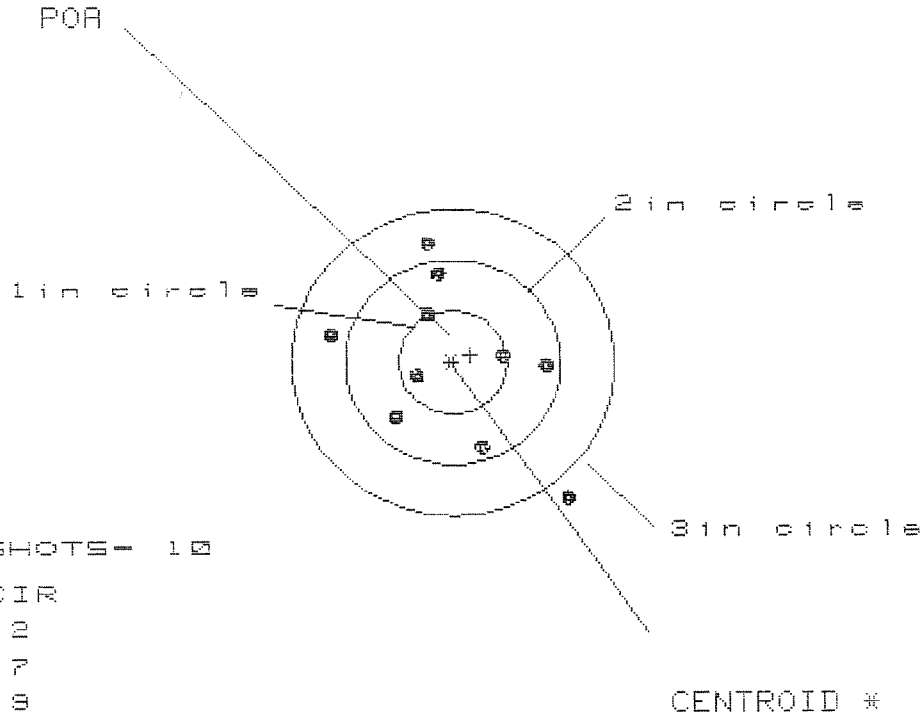
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.925	.910	.882
MINIMUM X	:	-.658	-.673	-.701
MAXIMUM Y	:	.976	.863	.632
MINIMUM Y	:	-1.011	-.603	-.495
CENTROID X	:	.119	.134	.162
CENTROID Y	:	.072	.185	.077
POA TO CENTROID in.	:	.139	.228	.179
MIN RADIUS	:	.187	.261	.158
MEAN RADIUS	:	.648	.619	.556
MAX RADIUS	:	1.020	.911	.886
HORIZONTAL SPREAD	:	1.583	1.583	1.583
VERTICAL SPREAD	:	1.987	1.466	1.127
EXTREME SPREAD	:	1.988	1.584	1.584
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Jun 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.265

VS= 2.558

GS= 2.903

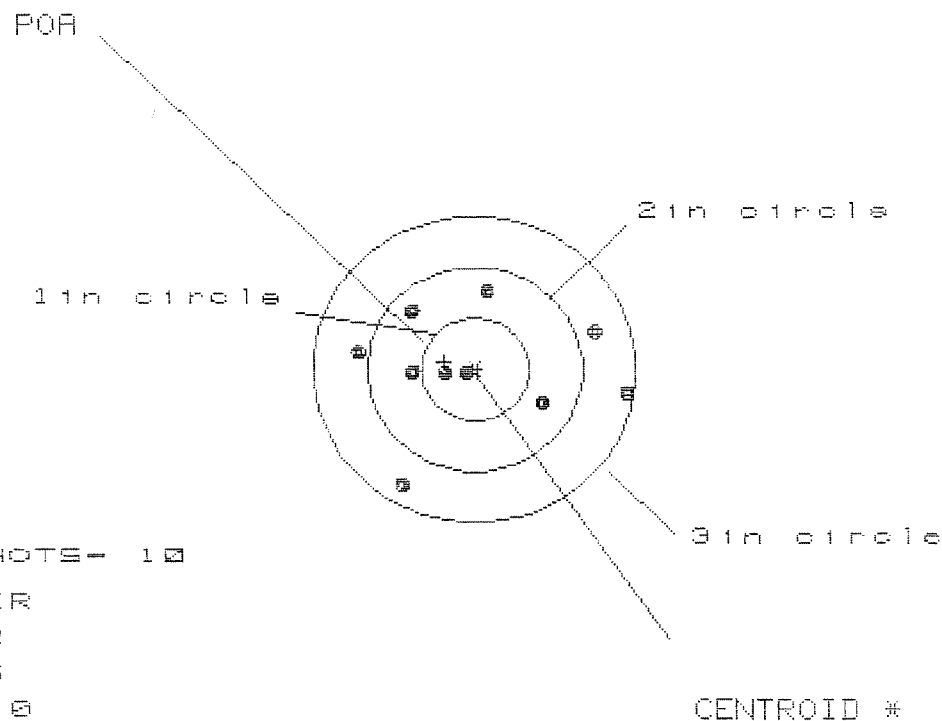
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.102	1.019	1.000
MINIMUM X	-1.163	-1.040	-1.059
MAXIMUM Y	1.195	1.043	.896
MINIMUM Y	-1.363	-1.016	-.886
CENTROID X	-.164	-.287	-.268
CENTROID Y	-.070	.081	-.049
POR TO CENTROID in.	.179	.298	.273
MIN RADIUS	.412	.371	.329
MEAN RADIUS	.902	.786	.746
MAX RADIUS	1.753	1.083	1.079
HORIZONTAL SPREAD	2.265	2.059	2.059
VERTICAL SPREAD	2.558	2.059	1.782
EXTREME SPREAD	2.903	2.125	2.079
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

8 Jun 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.560

VS= 1.888

GS= 2.584

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	1.300	1.239
MINIMUM X	:	-1.128	-.968	-1.029
MAXIMUM Y	:	.733	.710	.563
MINIMUM Y	:	-1.155	-1.178	-.473
CENTROID X	:	.284	.124	.185
CENTROID Y	:	-.069	-.046	.101
POA TO CENTROID in.	:	.292	.133	.211
MIN RADIUS	:	.094	.144	.251
MEAN RADIUS	:	.829	.730	.675
MAX RADIUS	:	1.447	1.354	1.261
HORIZONTAL SPREAD	:	2.560	2.268	2.268
VERTICAL SPREAD	:	1.888	1.888	1.036
EXTREME SPREAD	:	2.584	2.366	2.283
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	