

C6594542

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

R ORDER
94-18314

BARBER - M24 0048984 18943

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

SERIAL NO. C6594542DATE 10-25-95TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.50	2.49		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.56	2.52		
PULL #3	2.26	2.42	2.66		
PULL #4	2.26	2.37	2.64		
PULL #5	2.24	2.31	2.66		
TOTAL	11.29	12.16	12.97		
AVG.	2.25	2.43	2.59		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.19		
PULL #2	3.17	3.25		
PULL #3	3.19	3.18		
PULL #4	3.20	3.19		
PULL #5	3.14	3.16		
TOTAL	15.97	15.97		
AVG.	3.19	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.08	4.25	
PULL #2	4.01	4.12	4.12	
PULL #3	4.07	4.10	4.13	
PULL #4	4.12	4.08	4.09	
PULL #5	4.12	4.12	4.10	
TOTAL	20.32	20.50	20.69	
AVG.	4.06	4.10	4.13	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594542

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			11/29	WB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			11/29	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.42	2.46	2.45	2.44	2.41	11/29	WB
	C) Function							
660	Pack							

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

Remington®

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

MODEL 700™ M24

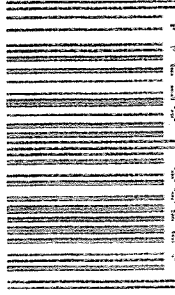
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
06594542

ORDER NO.
5716

20

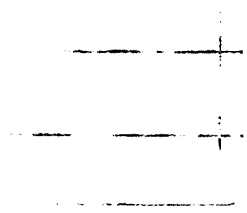
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5716 06594542



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594542

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	"
615	Rollmark Caliber		"	PLS
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-18-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-22-91	RW

op. #	BARBER - M24 0018910					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2		1/22/91	WB
	G) Safety Off Force	2	2	2		1/22/91	WB
	H) Trigger Pull Test & Retainability					1-22-91	JL
	I) Firing Pin Indent	.020	.0205	.0205		1/22/91	WB
	J) Assemble Stock					1/25/91	RW
	K) Assemble Swivel Studs					2-4-91	AC
	L) Attach Front and Rear Sight Assemblies					1/25/91	RW
	M) Iron Sight Alignment					1/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container					1/25/91	RW
	O) Attach Scope to Rifle					1/25/91	RW
	P) Detach & Attach Scope 20 Times					1/25/91	RW
640	Gallery Target & Test					1-25-91	NF
	A) Time					"	NF
	B) Malfunctions					"	NF
	C) Pierced Primers					"	NF
	D) Optical Clarity of Scope					"	NF
645	Inspect for Live Ammo					1-25-91	NF
655	Final Inspection						
	A) Headspace					2-4-91	AC
	B) Trigger Pull	2.21	2.19	2.30	2.20	2.21	2-1-91
	C) Function					2-4-91	AC
660	Pack					3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594342

DATE 1-22-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.17	2.32	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.34	2.39	2.19	
PULL #3	2.36	2.32	2.39	2.30	
PULL #4	2.36	2.40	2.51	2.20	
PULL #5	2.28	2.35	2.43	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.27		
PULL #2	3.33	3.36		
PULL #3	3.44	3.35		
PULL #4	3.40	3.25		
PULL #5	3.37	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.30		4.25
PULL #2	4.29	4.40		4.30
PULL #3	4.14	4.33		4.36
PULL #4	4.41	4.50		4.19
PULL #5	4.38	4.27		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594542
26 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.364878
1 TO	2	.116503
1 TO	3	.166012
1 TO	4	.558405
1 TO	5	.320762

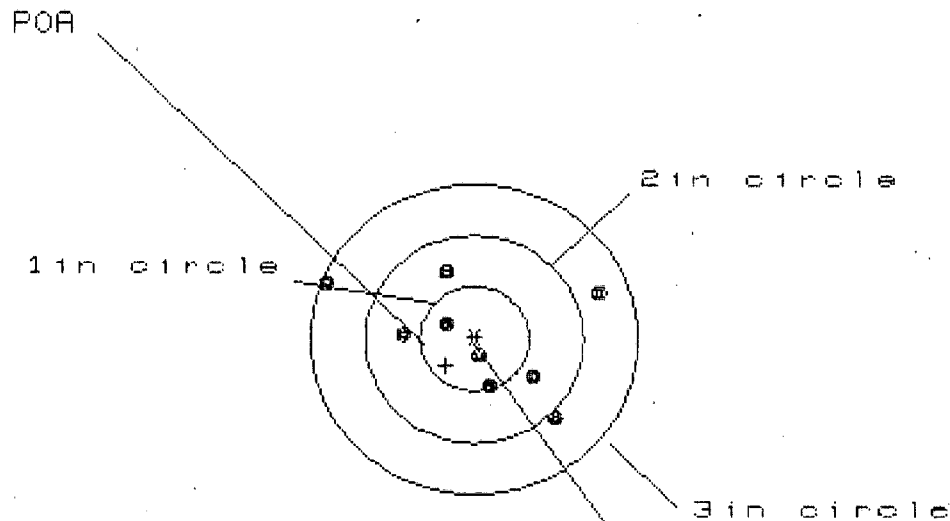
SP₄ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1624
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .107
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194481
THE AMR FOR THIS RIFLE IS: .8946

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594542

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.504

VS= 1.383

GS= 2.506

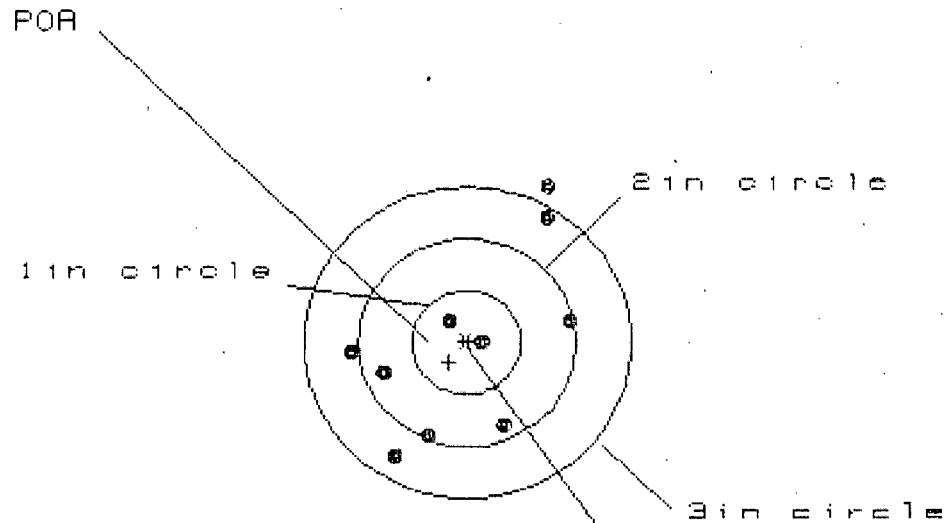
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.103	.947	.699
MINIMUM X	-1.401	-.797	-.678
MAXIMUM Y	.673	.728	.786
MINIMUM Y	-.710	-.655	-.597
CENTROID X	.260	.416	.297
CENTROID Y	.256	.201	.143
POA TO CENTROID in.	.365	.461	.330
MIN RADIUS	.140	.155	.028
MEAN RADIUS	.674	.579	.477
MAX RADIUS	1.486	1.055	.919
HORIZONTAL SPREAD	2.504	1.744	1.377
VERTICAL SPREAD	1.383	1.383	1.383
EXTREME SPREAD	2.506	1.775	1.689
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594542

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.951

VS = 2.565

GS = 2.951

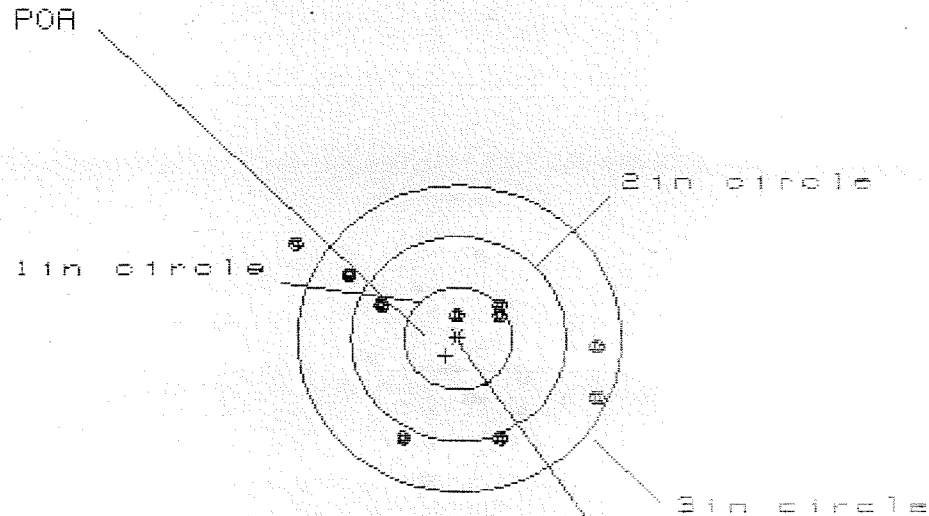
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.933	1.017	1.123
MINIMUM X	-1.018	-.934	-.828
MAXIMUM Y	1.489	1.387	.557
MINIMUM Y	-1.076	-.910	-.737
CENTROID X	.162	.078	-.028
CENTROID Y	.193	.027	-.146
POA TO CENTROID in.	.252	.082	.148
MIN RADIUS	.119	.234	.425
MEAN RADIUS	.931	.836	.724
MAX RADIUS	1.670	1.622	1.250
HORIZONTAL SPREAD	1.951	1.951	1.951
VERTICAL SPREAD	2.565	2.297	1.294
EXTREME SPREAD	2.951	2.722	2.082
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

28 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.792

VS = 1.940

GS = 3.188

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.319
MINIMUM X	-1.473
MAXIMUM Y	.922
MINIMUM Y	-1.018
CENTROID X	.118
CENTROID Y	.170
POA TO CENTROID in.	.207
MIN RADIUS	.224
MEAN RADIUS	.988
MAX RADIUS	1.738
HORIZONTAL SPREAD	2.792
VERTICAL SPREAD	1.940
EXTREME SPREAD	3.188
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534542

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 1.745

VS= 3.394

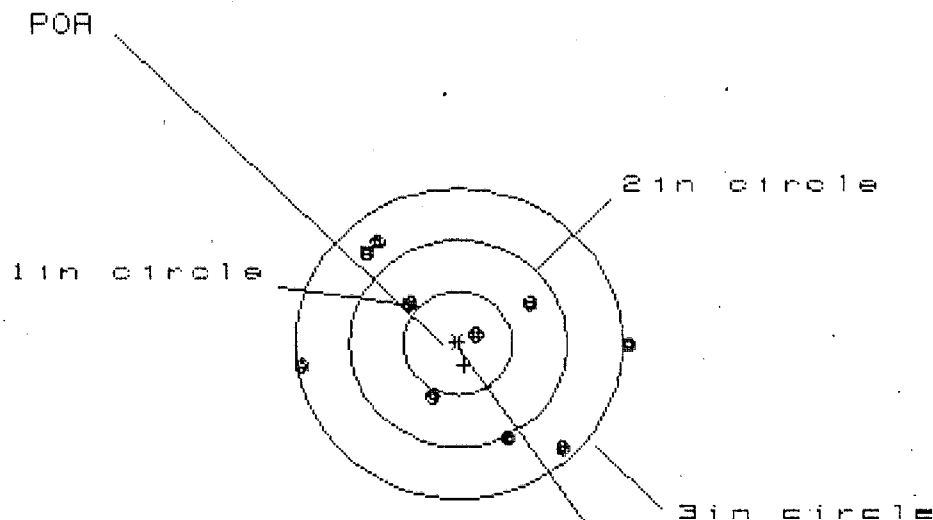
GS= 3.420

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.732	.780	.787
MINIMUM X	:	-1.012	-.965	-.958
MAXIMUM Y	:	1.418	1.198	1.043
MINIMUM Y	:	-1.976	-1.014	-.864
CENTROID X	:	.330	.283	.276
CENTROID Y	:	-.298	-.078	-.228
POA TO CENTROID in.	:	.445	.293	.358
MIN RADIUS	:	.183	.226	.129
MEAN RADIUS	:	.895	.779	.696
MAX RADIUS	:	2.022	1.199	1.189
HORIZONTAL SPREAD	:	1.745	1.745	1.745
VERTICAL SPREAD	:	3.394	2.212	1.907
EXTREME SPREAD	:	3.420	2.276	1.909
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.995

VS = 1.930

GS = 3.004

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	1.142	.977
MINIMUM X	:	-1.484	-1.316	-.795
MAXIMUM Y	:	.955	.954	.924
MINIMUM Y	:	-.976	-.976	-1.006
CENTROID X	:	-.058	-.226	-.061
CENTROID Y	:	.214	.215	.245
POA TO CENTROID in.	:	.222	.312	.253
MIN RADIUS	:	.154	.312	.145
MEAN RADIUS	:	.985	.926	.853
MAX RADIUS	:	1.511	1.502	1.403
HORIZONTAL SPREAD	:	2.995	2.458	1.772
VERTICAL SPREAD	:	1.930	1.930	1.930
EXTREME SPREAD	:	3.004	2.599	2.599
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	