

06587674

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

|R 94-18765

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL
36201-502

CUST NO: 098397 C.O.D

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			
MAIN FAULT						

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400025041

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6587674DATE May 17 1996TESTER A Cooper

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.55	2.56	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.52	2.44	
PULL #3	2.78	2.62	2.66	
PULL #4	2.57	2.58	2.70	
PULL #5	2.54	2.56	2.76	
TOTAL	12.92	12.84	13.25	
AVG.	2.58	2.56	2.65	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.04	3.22	
PULL #2	3.04	3.21	
PULL #3	3.01	3.21	
PULL #4	3.06	3.18	
PULL #5	3.02	3.25	
TOTAL	15.17	16.07	
AVG.	3.03	3.21	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.19		4.11
PULL #2	4.21	4.17		4.04
PULL #3	4.18	4.16		4.16
PULL #4	4.15	4.14		4.04
PULL #5	4.19	4.22		4.13
TOTAL	20.87	20.88		20.58
AVG.	4.17	4.17		4.11

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587674
10 Apr 1900

CENTROIDAL DISTANCES

0 TO 1	.389782
1 TO 2	.199582
1 TO 3	.322591
1 TO 4	.202054
1 TO 5	.199249

11 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2372
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243906

THE AMR FOR THIS RIFLE IS: 1.012

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587674

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 1

2in - 8

3in = 10

HS- 1.522

VS= 2.234

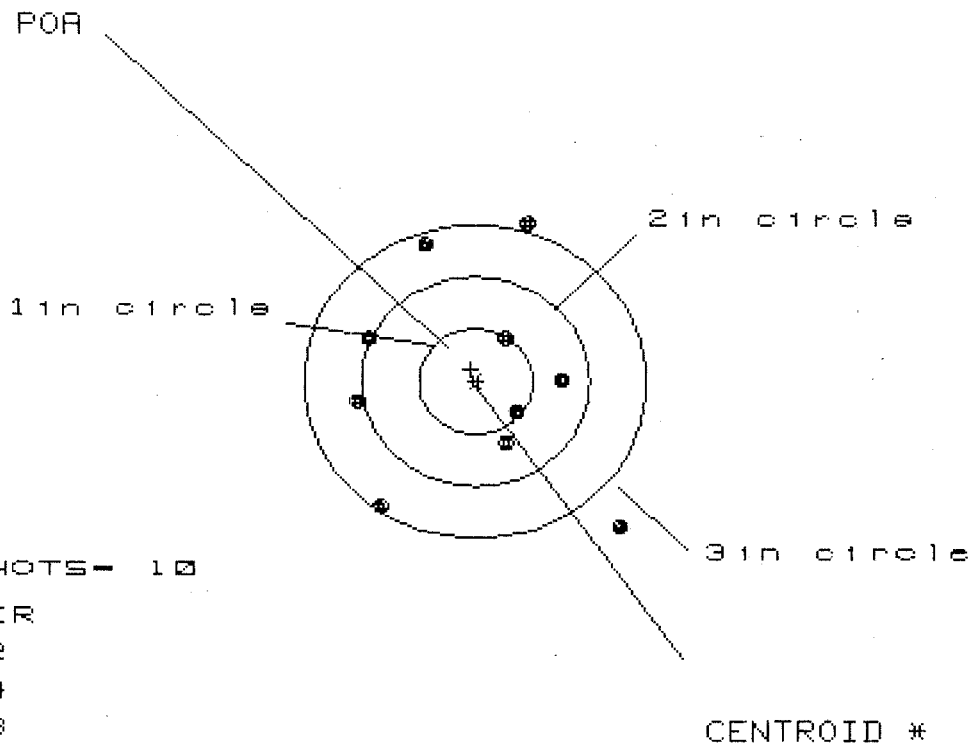
GS= 2.236

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.743	.693	.642
MINIMUM X	:	-.779	-.829	-.880
MAXIMUM Y	:	1.284	.777	.676
MINIMUM Y	:	-.950	-.808	-.492
CENTROID X	:	.164	.214	.265
CENTROID Y	:	-.115	-.257	-.156
POA TO CENTROID in.	:	.200	.334	.307
MIN RADIUS	:	.423	.442	.412
MEAN RADIUS	:	.767	.691	.653
MAX RADIUS	:	1.359	.906	.887
HORIZONTAL SPREAD	:	1.522	1.522	1.522
VERTICAL SPREAD	:	2.234	1.585	1.168
EXTREME SPREAD	:	2.236	1.600	1.564
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587874

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.316

VS= 2.953

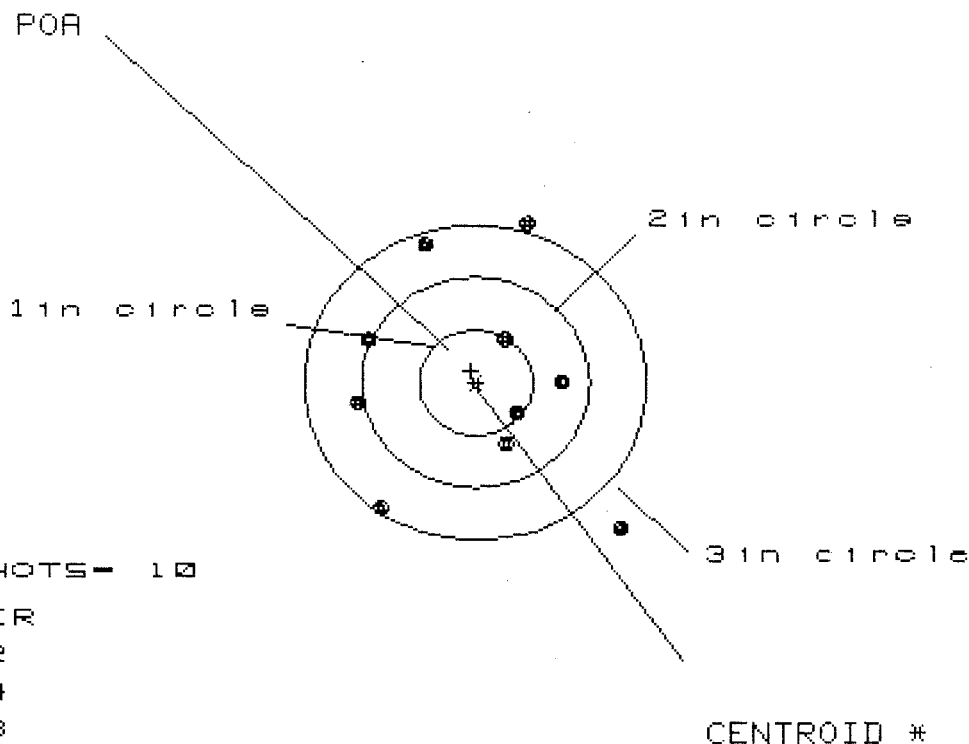
GS= 3.222

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	.882	.957
MINIMUM X	:	-1.023	-.879	-.804
MAXIMUM Y	:	1.534	1.376	1.287
MINIMUM Y	:	-1.419	-1.320	-1.148
CENTROID X	:	.040	-.104	-.179
CENTROID Y	:	-.115	.043	-.129
POA TO CENTROID in.	:	.121	.112	.221
MIN RADIUS	:	.437	.443	.604
MEAN RADIUS	:	1.064	.975	.900
MAX RADIUS	:	1.920	1.501	1.313
HORIZONTAL SPREAD	:	2.316	1.761	1.761
VERTICAL SPREAD	:	2.953	2.696	2.435
EXTREME SPREAD	:	3.222	2.980	2.458
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Apr 1900

FILE:/PATTERNING/CENTERFIRE_PATT/08587674

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.316

VS= 2.953

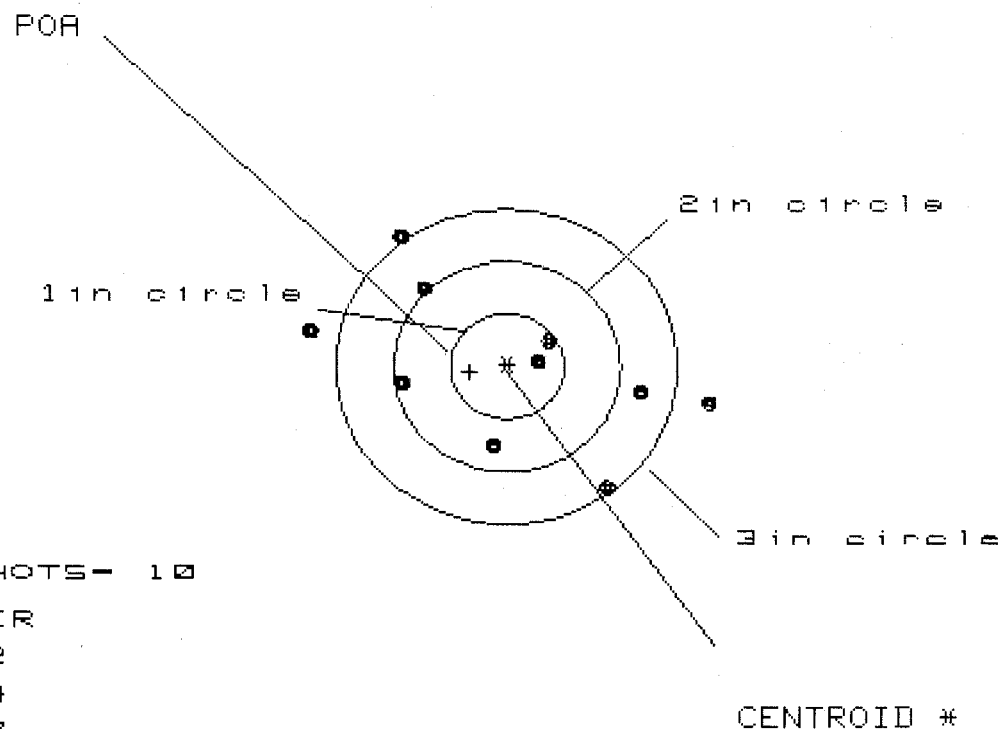
GS= 3.222

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	.882	.957
MINIMUM X	:	-1.023	-.879	-.804
MAXIMUM Y	:	1.534	1.376	1.287
MINIMUM Y	:	-1.419	-1.320	-1.148
CENTROID X	:	.040	-.104	-.179
CENTROID Y	:	-.115	.043	-.129
POA TO CENTROID in.	:	.121	.112	.221
MIN RADIUS	:	.437	.443	.604
MEAN RADIUS	:	1.064	.975	.900
MAX RADIUS	:	1.920	1.501	1.313
HORIZONTAL SPREAD	:	2.316	1.761	1.761
VERTICAL SPREAD	:	2.953	2.696	2.435
EXTREME SPREAD	:	3.222	2.980	2.458
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587674

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.455

VS= 2.338

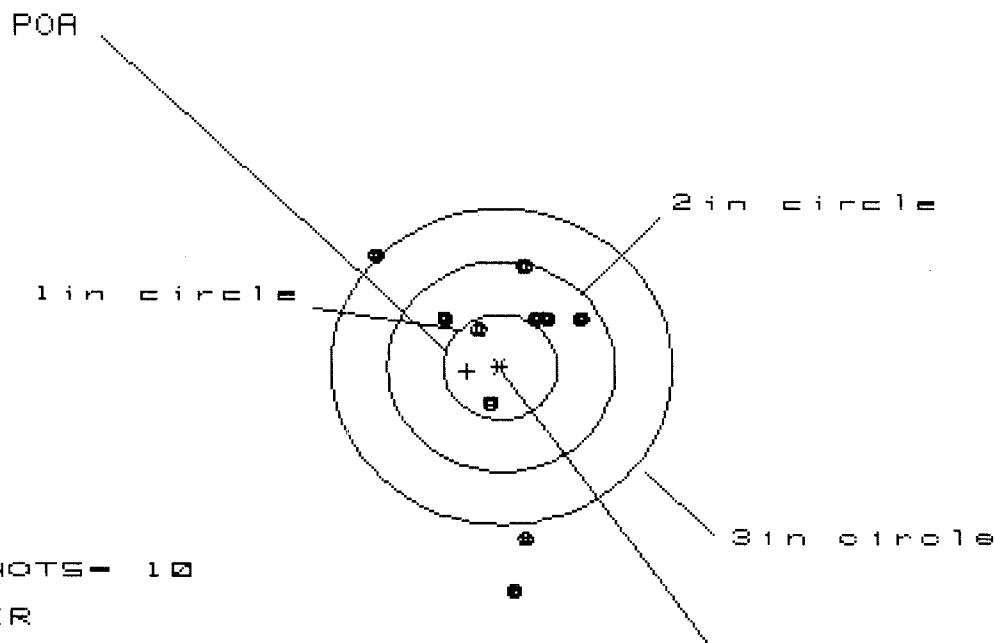
GS= 3.551

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.771	1.402	1.215
MINIMUM X	:	-1.694	-1.498	-.928
MAXIMUM Y	:	1.236	1.193	1.235
MINIMUM Y	:	-1.102	-1.145	-1.103
CENTROID X	:	.326	.130	.317
CENTROID Y	:	.052	.095	.053
POA TO CENTROID in.	:	.330	.161	.321
MIN RADIUS	:	.237	.426	.246
MEAN RADIUS	:	1.115	1.042	.951
MAX RADIUS	:	1.814	1.541	1.542
HORIZONTAL SPREAD	:	3.465	2.900	2.143
VERTICAL SPREAD	:	2.338	2.338	2.338
EXTREME SPREAD	:	3.551	2.960	2.930
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587674

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 7

3 in = 7

CENTROID *

HS- 1.783

VS= 3.188

GS= 3.396

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.705	.715	.737
MINIMUM X	:	-1.078	-1.068	-1.046
MAXIMUM Y	:	1.080	.846	.607
MINIMUM Y	:	-2.108	-1.910	-.857
CENTROID X	:	.295	.285	.263
CENTROID Y	:	.041	.275	.514
POA TO CENTROID in.	:	.298	.396	.577
MIN RADIUS	:	.382	.203	.210
MEAN RADIUS	:	.974	.777	.600
MAX RADIUS	:	2.110	1.918	1.210
HORIZONTAL SPREAD	:	1.783	1.783	1.783
VERTICAL SPREAD	:	3.188	2.756	1.464
EXTREME SPREAD	:	3.396	3.022	1.878
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587674

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	5	5			6/8/96	WB
	G) Safety Off Force	3	3	3			6/8/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.024	.023			6/8/96	WB
	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	2.76	2.90	2.76	2.85	2.80	6/20/96	AW
	C) Function							
660	Pack							

Remington[®]

MODEL 700TM M24

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

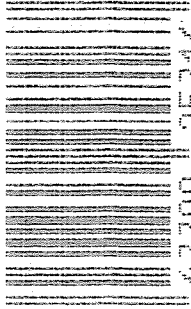
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6587674

ORDER NO.
5716

LPC



0 4700 25716 7



5716 C6587674

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587674

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	RW
600	Proof	1019	90	RW
607	Check Headspace	1019	90	RW
610	Dis-assemble Gun	1019	90	RW
612	Magnaflux Barrel Action		10/23/90	AKR
	Magnaflux Bolt		10/23/90	KR
615	Rollmark Caliber		10/23/90	JS
617	Drill and Tap Sight Holes		10/26/90	FRB
618	Polish Barrel <i>PB</i>		10/29/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/14/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-9-91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	5.0	4.75			1/8/91	KJ
	G) Safety Off Force	3.0	3.0	3.0			1/8/91	KJ
	H) Trigger Pull Test & Retainability						1-9-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/8/91	KJ
	J) Assemble Stock						1/5/91	RW
	K) Assemble Swivel Studs						1-16-91	JH
	L) Attach Front and Rear Sight Assemblies						1/15/91	RW
	M) Iron Sight Alignment						1/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/15/91	RW
	O) Attach Scope to Rifle						1/15/91	RW
	P) Detach & Attach Scope 20 Times						1/15/91	RW
640	Gallery Target & Test						1-15-91	DH
	A) Time						1-15-91	DH
	B) Malfunctions						1-15-91	DH
	C) Pierced Primers						1-15-91	DH
	D) Optical Clarity of Scope						1-15-91	DH
645	Inspect for Live Ammo						1-15-91	DH
655	Final Inspection							
	A) Headspace						1-16-91	JH
	B) Trigger Pull	2.48	2.55	2.49	2.46	2.51	1-16-91	JH
	C) Function						1-16-91	JH
660	Pack						3/15/91	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587674

DATE 1-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.50	2.48	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.36	2.32	2.55	
PULL #3	2.42	2.50	2.43	2.49	
PULL #4	2.30	2.44	2.40	2.46	
PULL #5	2.46	2.28	2.50	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.31		
PULL #2	3.46	3.36		
PULL #3	3.43	3.33		
PULL #4	3.36	3.48		
PULL #5	3.48	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.23		4.23
PULL #2	4.27	4.29		4.16
PULL #3	4.10	4.50		4.41
PULL #4	4.24	4.21		4.20
PULL #5	4.29	4.41		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587674
16 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.208543
1 TO	2	.219611
1 TO	3	.431259
1 TO	4	.24973
1 TO	5	.236444

453
8453 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .173
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2806
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .329644

THE AMR FOR THIS RIFLE IS: .9394

16 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587674

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS= 2.244

VS= 2.540

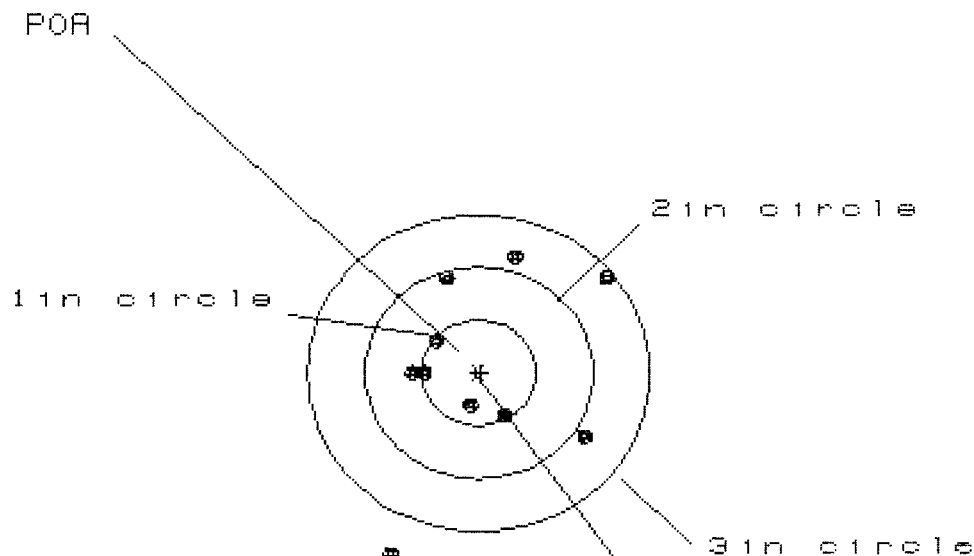
GS= 2.540

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.268	1.325
MINIMUM X	:	-1.024	-.976	-.918
MAXIMUM Y	:	1.231	1.086	.983
MINIMUM Y	:	-1.308	-1.020	-.884
CENTROID X	:	.107	.059	.001
CENTROID Y	:	.179	.324	.188
POA TO CENTROID in.	:	.208	.329	.188
MIN RADIUS	:	.274	.354	.208
MEAN RADIUS	:	.934	.880	.813
MAX RADIUS	:	1.377	1.275	1.353
HORIZONTAL SPREAD	:	2.244	2.244	2.244
VERTICAL SPREAD	:	2.540	2.106	1.867
EXTREME SPREAD	:	2.540	2.245	2.245
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

16 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587674

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.880

VS= 2.796

GS= 3.185

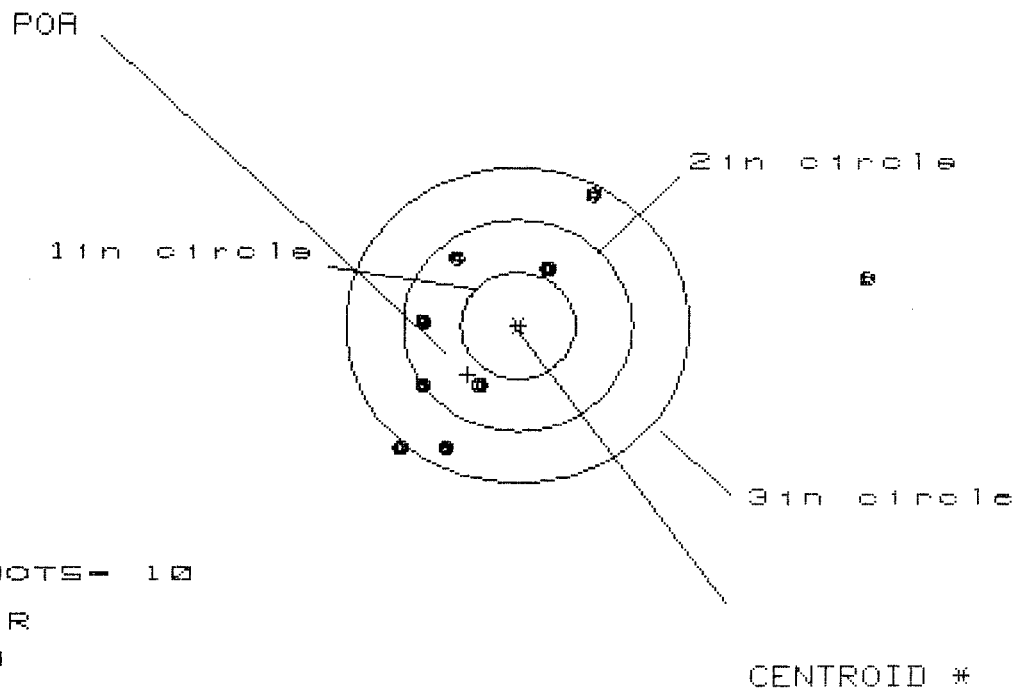
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.084	.995	.963
MINIMUM X	:	-.796	-.639	-.514
MAXIMUM Y	:	1.085	.894	.978
MINIMUM Y	:	-1.712	-.785	-.701
CENTROID X	:	-.023	.066	-.059
CENTROID Y	:	.002	.192	.108
POA TO CENTROID in.	:	.023	.203	.123
MIN RADIUS	:	.333	.501	.400
MEAN RADIUS	:	.874	.776	.681
MAX RADIUS	:	1.888	1.200	1.191
HORIZONTAL SPREAD	:	1.880	1.634	1.477
VERTICAL SPREAD	:	2.796	1.679	1.679
EXTREME SPREAD	:	3.185	1.890	1.890
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

16 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587674

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 4.150

VS= 2.419

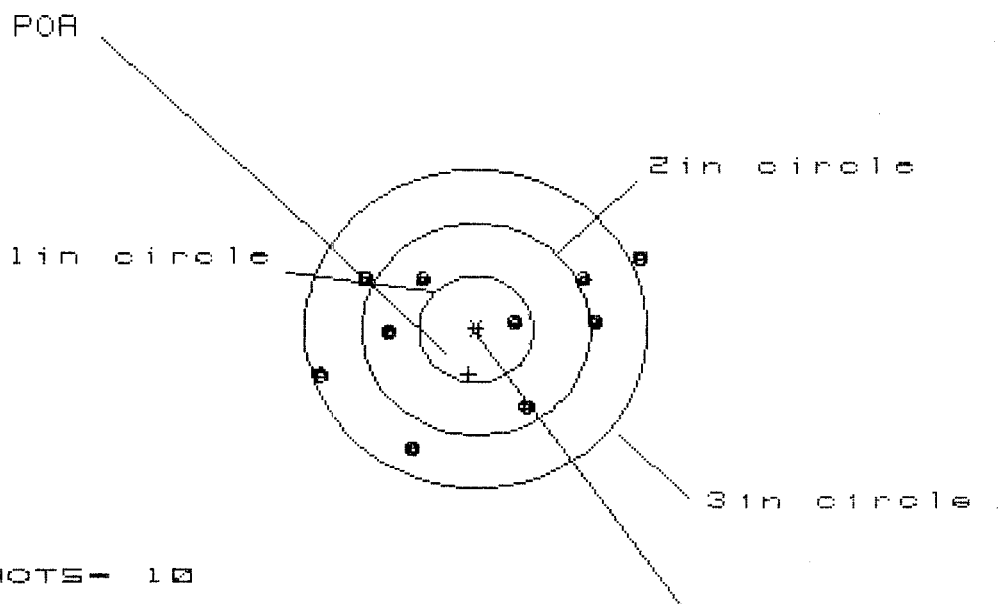
GS= 4.441

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	3.111	.998	.911
MINIMUM X	:	-1.039	-.693	-.576
MAXIMUM Y	:	1.218	1.266	1.129
MINIMUM Y	:	-1.201	-1.153	-1.290
CENTROID X	:	.435	.089	.176
CENTROID Y	:	.459	.411	.548
POA TO CENTROID in.	:	.633	.421	.576
MIN RADIUS	:	.581	.456	.538
MEAN RADIUS	:	1.193	.903	.851
MAX RADIUS	:	3.141	1.612	1.450
HORIZONTAL SPREAD	:	4.150	1.691	1.487
VERTICAL SPREAD	:	2.419	2.419	2.419
EXTREME SPREAD	:	4.441	2.907	2.755
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587674

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.801

VS= 1.778

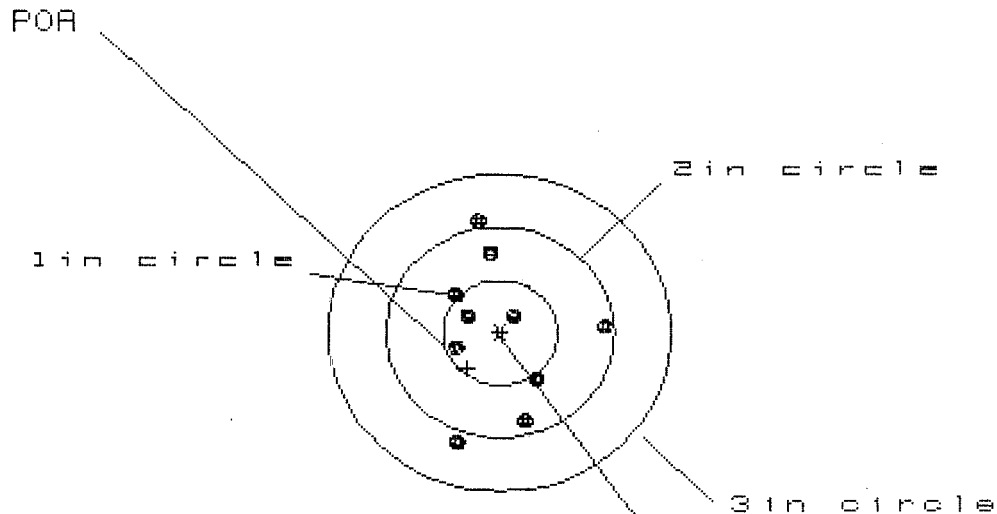
GS= 3.010

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.401	1.212	1.057
MINIMUM X	:	-1.400	-1.245	-.921
MAXIMUM Y	:	.694	.551	.510
MINIMUM Y	:	-1.084	-1.007	-1.048
CENTROID X	:	.064	-.091	.064
CENTROID Y	:	.425	.348	.390
POA TO CENTROID in.	:	.430	.360	.395
MIN RADIUS	:	.326	.499	.340
MEAN RADIUS	:	1.007	.939	.883
MAX RADIUS	:	1.563	1.288	1.213
HORIZONTAL SPREAD	:	2.801	2.457	1.978
VERTICAL SPREAD	:	1.778	1.558	1.558
EXTREME SPREAD	:	3.010	2.524	2.215
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

16 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587674

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.352

VS = 2.150

GS = 2.157

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.947	.908	.881
MINIMUM X	:	-.405	-.444	-.471
MAXIMUM Y	:	1.073	.953	.811
MINIMUM Y	:	-1.077	-.976	-.856
CENTROID X	:	.282	.321	.348
CENTROID Y	:	.338	.458	.338
POA TO CENTROID in.	:	.440	.559	.485
MIN RADIUS	:	.218	.108	.185
MEAN RADIUS	:	.689	.626	.587
MAX RADIUS	:	1.132	.989	.881
HORIZONTAL SPREAD	:	1.352	1.352	1.352
VERTICAL SPREAD	:	2.150	1.929	1.667
EXTREME SPREAD	:	2.157	1.966	1.689
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	