

C6523497

MODEL 700™ M24

Model **SMS**™

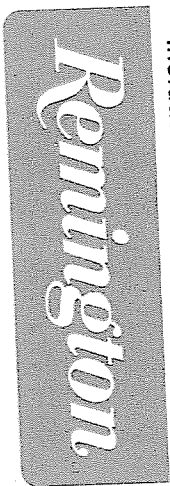
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

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

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

MODEL 700TM M24	SERIAL NO. C6523497
	ORDER NO. 5716

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

01


5716 C6523497

UPC


0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523497

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/10/90	KL
600	Proof		1/10/90	KL
607	Check Headspace		1/10/90	KL
610	Dis-assemble Gun		1/10/90	KL
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	SL
617	Drill and Tap Sight Holes		10/4/90	LB
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	JA
	Apply Coating (Bolt)		10-20-90	JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10/23/90	KL

BARBER - M24 0029123

op. #	OP. NAME	READINGS				DATE	INIT	
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2		10/25/90	WB	
	G) Safety Off Force	2	2	2		10/21/90	WB	
	H) Trigger Pull Test & Retainability					10/23/90	JY	
	I) Firing Pin Indent	.0205	.021	.021		10/25/90	WB	
	J) Assemble Stock					10/25/90	Kd	
	K) Assemble Swivel Studs					11-20-90	928	
	L) Attach Front and Rear Sight Assemblies					10/25/90	Kd	
	M) Iron Sight Alignment					10/25/90	Kd	
	N) Detach Front & Rear Sights & place in numbered container					10/25/90	Kd	
	O) Attach Scope to Rifle					10/25/90	Kd	
	P) Detach & Attach Scope 20 Times					10/25/90	Kd	
640	Gallery Target & Test					10-26-90	KT	
	A) Time					10-26-90	KT	
	B) Malfunctions					10/26-90	KT	
	C) Pierced Primers					10/26/90	KT	
	D) Optical Clarity of Scope					10/26/90	KT	
645	Inspect for Live Ammo					10/26/90	KT	
655	Final Inspection					11-20-90	928	
	A) Headspace							
	B) Trigger Pull	232	245	240	243	229	11-20-90	928
	C) Function						11-20-90	928
660	Pack					12/7/90	D/H	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523497

DATE 10/23/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.34	2.23	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.33	2.50	2.45	
PULL #3	2.39	2.23	2.45	2.40	
PULL #4	2.42	2.48	2.44	2.43	
PULL #5	2.50	2.47	2.50	2.29	
TOTAL	12.26	11.85	12.12		
AVG.	2.452	2.37	2.424		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.16		
PULL #2	3.19	3.27		
PULL #3	3.26	3.24		
PULL #4	3.30	3.12		
PULL #5	3.33	3.33		
TOTAL	16.21	16.12		
AVG.	3.242	3.224		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.46		4.38
PULL #2	4.43	4.43		4.50
PULL #3	4.24	4.32		4.32
PULL #4	4.12	4.46		4.48
PULL #5	4.17	4.33		4.40
TOTAL	21.2	22.00		22.08
AVG.	4.24	4.4		4.416

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523497
26 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0917824
1 TO	2	.514566
1 TO	3	.173349
1 TO	4	.225178
1 TO	5	.440247

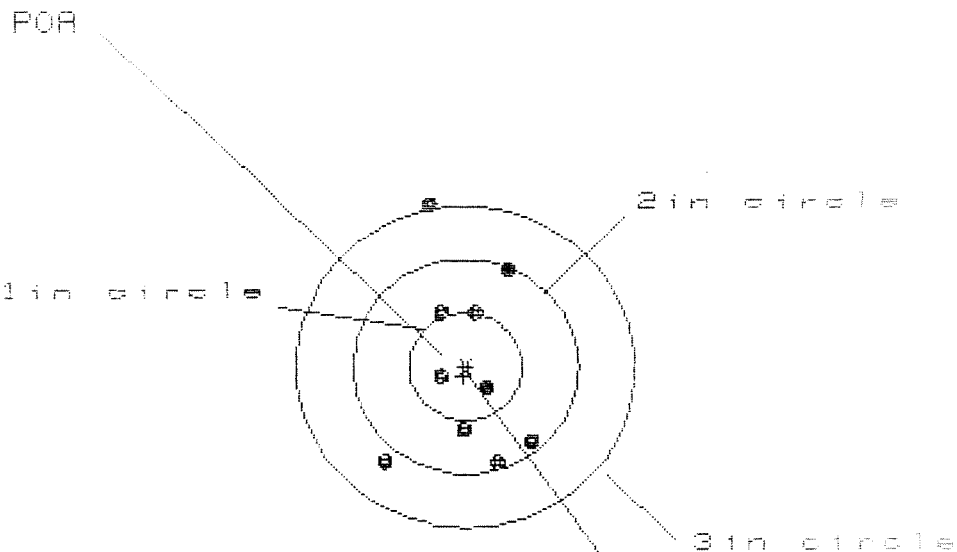
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0288
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .151954
THE AMR FOR THIS RIFLE IS: .7486

26 Oct 1996

FILE:/PATTERNING/CENTERFIRE_PATT/08523497

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.323

VS= 2.452

GS= 2.505

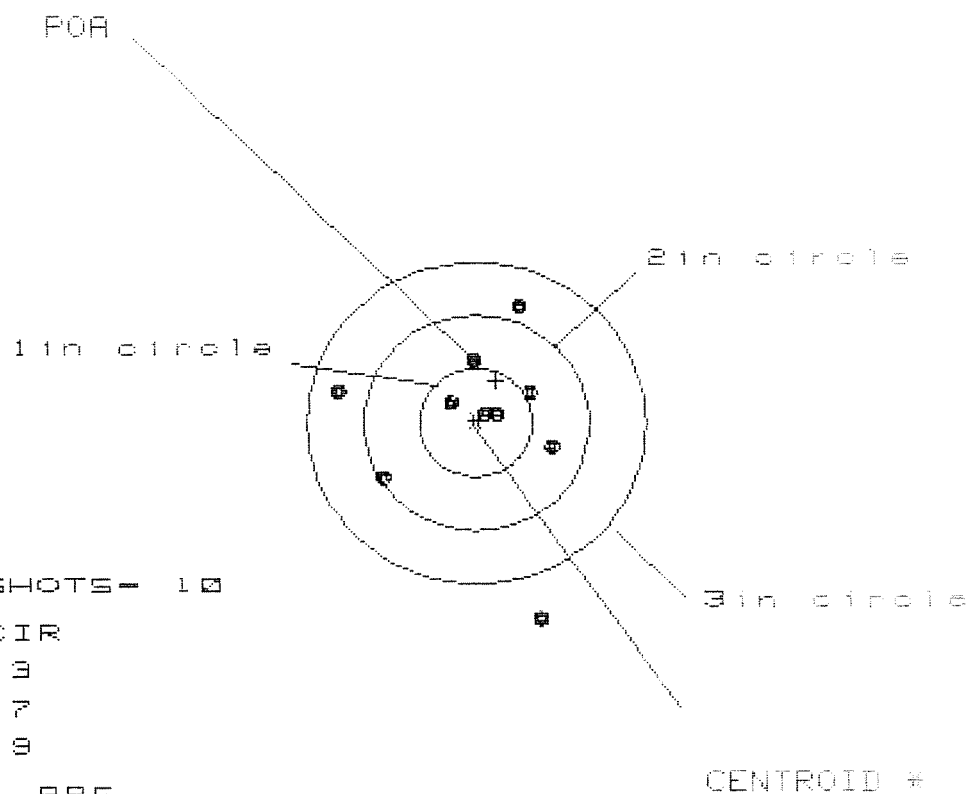
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.606	.568	.474
MINIMUM X	-.717	-.755	-.390
MAXIMUM Y	1.530	1.042	.948
MINIMUM Y	-.922	-.752	-.815
CENTROID X	.018	.056	.150
CENTROID Y	.090	-.080	.014
POA TO CENTROID in.	.092	.098	.151
MIN RADIUS	.244	.177	.160
MEAN RADIUS	.780	.669	.621
MAX RADIUS	1.567	1.094	.977
HORIZONTAL SPREAD	1.323	1.323	.864
VERTICAL SPREAD	2.452	1.794	1.763
EXTREME SPREAD	2.505	2.097	1.764
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

26 Oct 1988

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.886

VS= 2.941

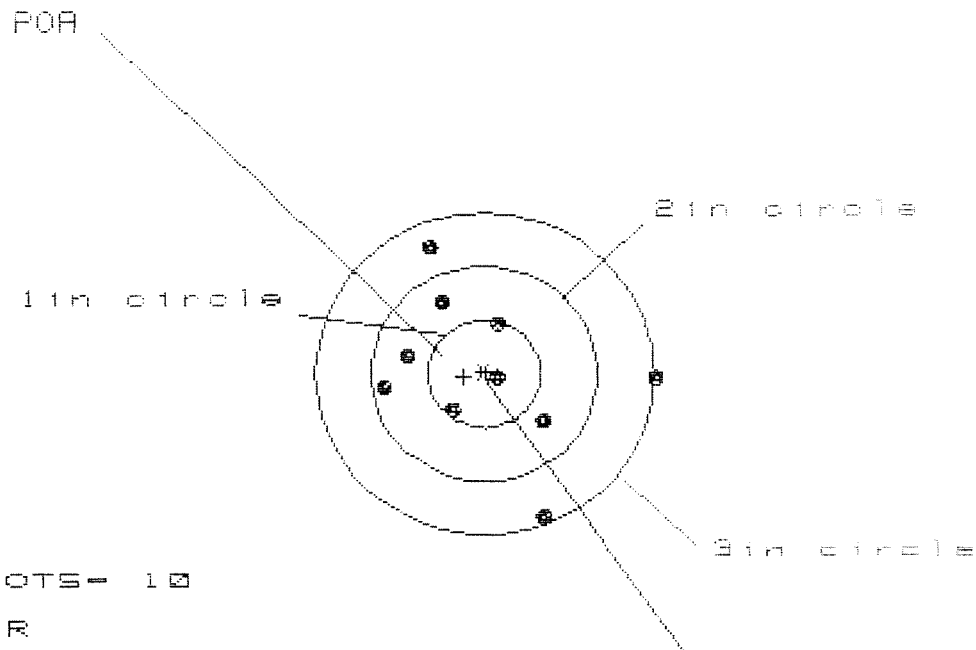
GS= 2.945

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.650	.710	.563
MINIMUM X	:	-1.236	-1.176	-.885
MAXIMUM Y	:	1.094	.888	.900
MINIMUM Y	:	-1.847	-.717	-.705
CENTROID X	:	-.175	-.235	-.088
CENTROID Y	:	-.387	-.181	-.193
POA TO CENTROID in.	:	.425	.297	.212
MIN RADIUS	:	.103	.166	.112
MEAN RADIUS	:	.764	.612	.511
MAX RADIUS	:	1.923	1.180	1.132
HORIZONTAL SPREAD	:	1.886	1.886	1.448
VERTICAL SPREAD	:	2.941	1.605	1.605
EXTREME SPREAD	:	2.945	1.989	1.989
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Oct 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.417

VS= 2.551

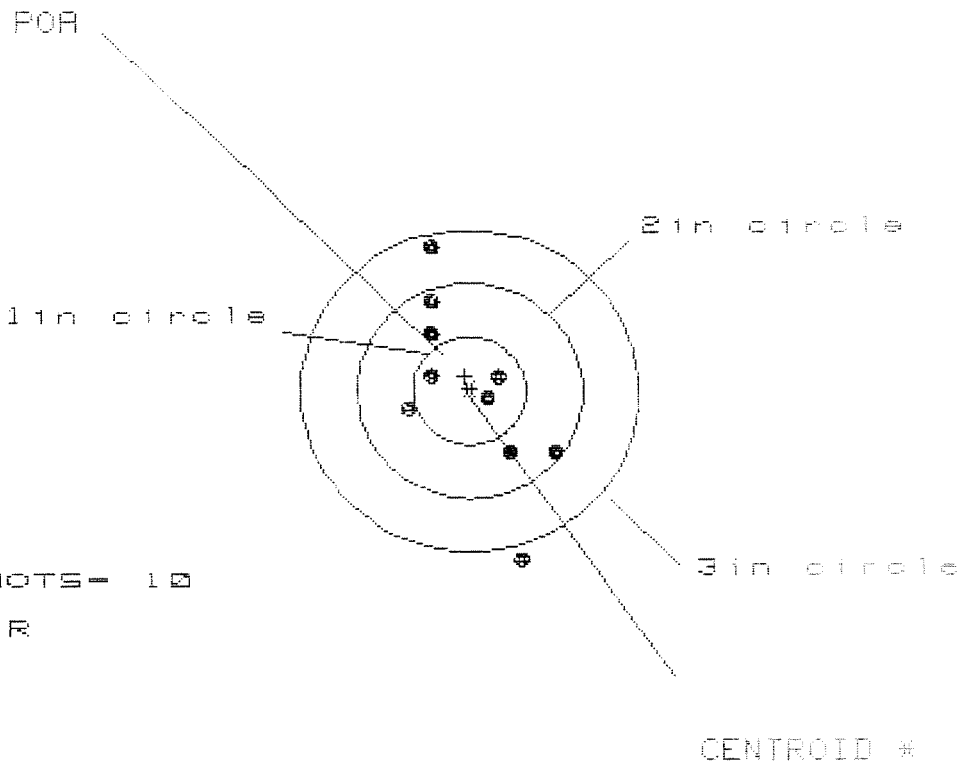
GS= 2.716

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.498	.703	.783
MINIMUM X	-.919	-.752	-.672
MAXIMUM Y	1.181	1.180	1.008
MINIMUM Y	-1.370	-1.371	-.581
CENTROID X	.181	.014	-.066
CENTROID Y	.031	.032	.204
POA TO CENTROID in.	.183	.035	.214
MIN RADIUS	.108	.265	.409
MEAN RADIUS	.831	.747	.641
MAX RADIUS	1.498	1.513	1.031
HORIZONTAL SPREAD	2.417	1.455	1.455
VERTICAL SPREAD	2.551	2.551	1.589
EXTREME SPREAD	2.716	2.716	1.875
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

26 Oct 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.239

VS= 2.831

GS= 2.943

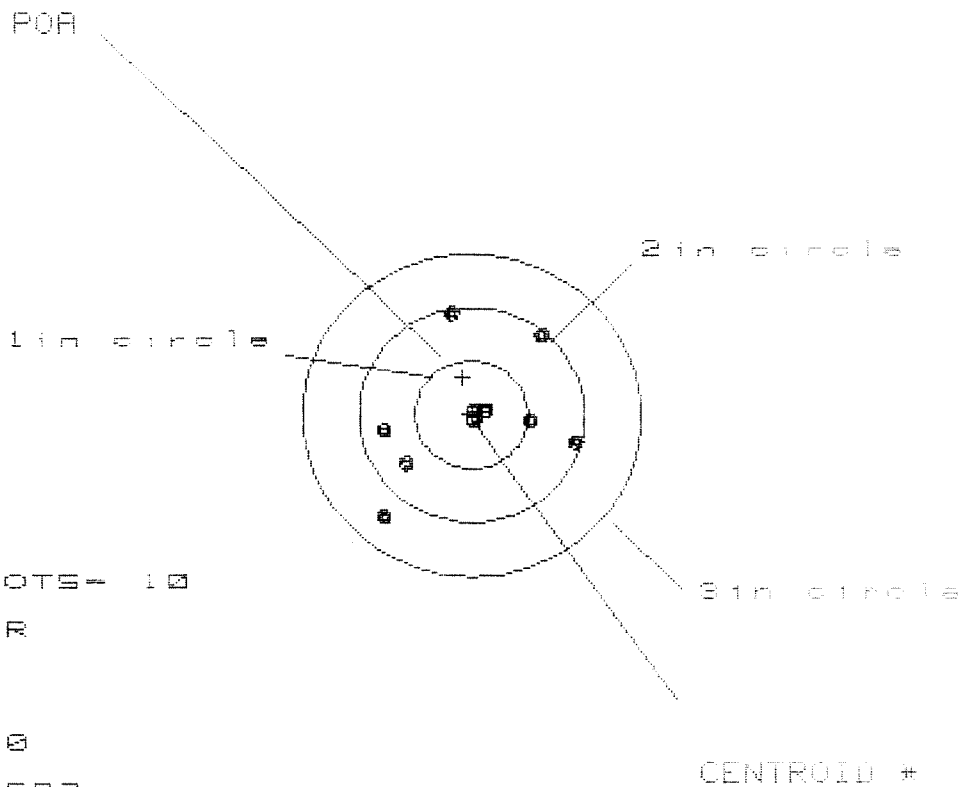
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.724	.771	.738
MINIMUM X	:	-.515	-.468	-.509
MAXIMUM Y	:	1.311	1.142	.762
MINIMUM Y	:	-1.520	-.717	-.574
CENTROID X	:	.041	-.006	.035
CENTROID Y	:	-.134	.035	-.108
POA TO CENTROID in.	:	.140	.036	.113
MIN RADIUS	:	.165	.290	.185
MEAN RADIUS	:	.729	.628	.543
MAX RADIUS	:	1.579	1.188	.914
HORIZONTAL SPREAD	:	1.239	1.239	1.239
VERTICAL SPREAD	:	2.831	1.859	1.336
EXTREME SPREAD	:	2.943	2.138	1.658
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Oct 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10
IN CIR
1 in = 3
2 in = 9
3 in = 10
HS= 1.687
VS= 1.889
GS= 2.149

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.861	.827
MINIMUM X	:	-.743	-.813	-.847
MAXIMUM Y	:	.969	.867	.786
MINIMUM Y	:	-.928	-.510	-.482
CENTROID X	:	.079	.162	.196
CENTROID Y	:	-.346	-.244	-.352
POR TO CENTROID in.	:	.355	.292	.403
MIN RADIUS	:	.088	.045	.100
MEAN RADIUS	:	.639	.568	.521
MAX RADIUS	:	1.183	.932	.987
HORIZONTAL SPREAD	:	1.687	1.674	1.674
VERTICAL SPREAD	:	1.889	1.377	1.182
EXTREME SPREAD	:	2.149	1.678	1.678
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	