

C6648989

MODEL 700™ M24

Model SMS™

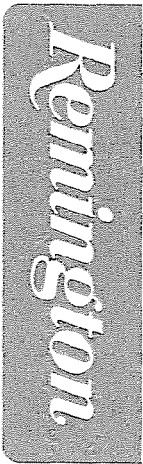
Action

Barrel Length

Capacity

Order No. 5716

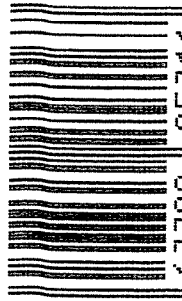
*Includes 1 in chamber.



CIII

Remington[®] REG. U.S. PAT. & TM. OFF. DU PONT VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM M24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.	SERIAL NO. C6648989 ORDER NO. 5716

UPC



0 47700 25716 7



5716 C6648989

CONTRACT # DAAA21-87-C-0086

GFMGUN SERIAL # *C6648989*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		<i>Rw</i>
600	Proof	7 2 9 1		<i>Rw</i>
607	Check Headspace	7 2 9 1		<i>Rw</i>
610	Dis-assemble Gun	7 2 9 1		<i>Rw</i>
612	Magnaflux Barrel Action		JUL 22 1991	<i>GL</i>
	Magnaflux Bolt		JUL 22 1991	<i>GL</i>
615	Rollmark Caliber		JUL 22 1991	<i>GL</i>
617	Drill and Tap Sight Holes		JUL 22 1991	<i>LB</i>
618	Polish Barrel		7/22/91	<i>WB</i>
620	Apply Coatings (Barrel Action)		8-23-91	<i>LB</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	<i>Rw</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	<i>Rw</i>
	C) Inspect Ejector Hole for Chamfer		8/29/91	<i>Rw</i>
	D) Oil Firing Pin Ass'y		8/29/91	<i>Rw</i>
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/91	<i>GL</i>

op. #	BARBER M24 0030357	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/11/91	JK
	G) Safety Off Force	3	3	3			9/11/91	JK
	H) Trigger Pull Test & Retainability						9/11/91	JK
	I) Firing Pin Indent	1022	1022	1022			9/11/91	JK
	J) Assemble Stock						9/13/91	RW
	K) Assemble Swivel Studs						9-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/13/91	RW
	M) Iron Sight Alignment						9/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/13/91	RW
	O) Attach Scope to Rifle						9/13/91	RW
	P) Detach & Attach Scope 20 Times						9/13/91	RW
640	Gallery Target & Test						9-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-13-91	NF
655	Final Inspection							
	A) Headspace						9-14-91	D/H
	B) Trigger Pull	2.54	2.30	2.34	2.37	2.44	9-14-91	D/H
	C) Function						9-14-91	D/H
660	Pack						9-19-91	NF

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

SERIAL NO C-6648/989
DATE 9-11-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.30	2.36	254	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.30	2.38	230	
PULL #3	2.43	2.33	2.32	234	
PULL #4	2.24	2.37	2.44	237	
PULL #5	2.30	2.34	2.35	244	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.37		
PULL #2	3.33	3.36		
PULL #3	3.34	3.27		
PULL #4	3.35	3.25		
PULL #5	3.34	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.58		4.53
PULL #2	4.31	4.58		4.48
PULL #3	4.27	4.55		4.50
PULL #4	4.59	4.64		4.52
PULL #5	4.56	4.48		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648989
13 Sep 1991

CENTROIDAL DISTANCES

Ø TO	1	.108853
1 TO	2	.13
1 TO	3	.490799
1 TO	4	.394614
1 TO	5	.396128

5
5

<----POA

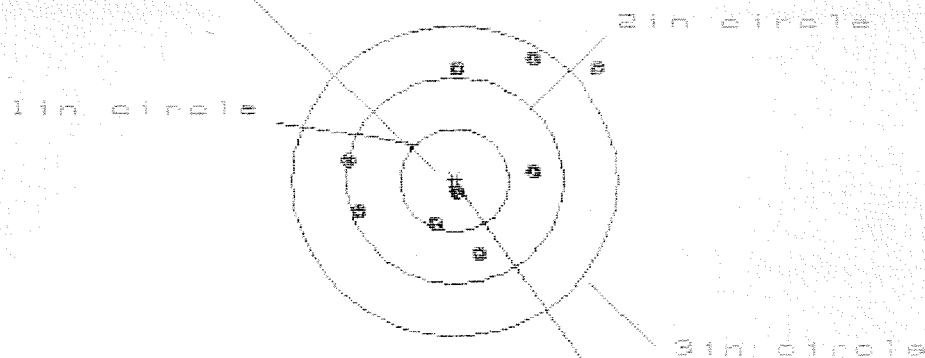
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0462
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1554
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162122
THE AMP FOR THIS RIFLE IS: .9488

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8548983

CENTERFIRE PATTERNS # 1

POB



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 8

HS= 2.353

VS= 3.292

GS= 3.981

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.341	1.243	1.765
MINIMUM X	-1.012	-1.110	-1.955
MAXIMUM Y	1.184	.950	1.059
MINIMUM Y	-2.108	-1.896	-1.787
CENTROID X	-.020	.078	-.077
CENTROID Y	.107	.341	.232
POB TO CENTROID in.	.108	.350	.245
MIN RADIUS	.133	.358	.271
MEAN RADIUS	1.041	.921	.817
MAX RADIUS	2.283	1.516	1.285
HORIZONTAL SPREAD	2.353	2.353	1.720
VERTICAL SPREAD	3.292	1.946	1.846
EXTREME SPREAD	3.981	2.616	2.135
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646969

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.240

VS = 2.404

GS = 2.436

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.397

1.448

.847

MINIMUM X

-.843

-.792

-.511

MAXIMUM Y

.927

.763

.782

MINIMUM Y

-1.477

-.575

-.555

CENTROID X

.084

.033

-.148

CENTROID Y

.029

.193

.173

POR TO CENTROID in.

.089

.196

.228

MIN RADIUS

.444

.379

.237

MEAN RADIUS

.821

.707

.563

MAX RADIUS

1.546

1.457

1.013

HORIZONTAL SPREAD

2.240

2.240

1.458

VERTICAL SPREAD

2.404

1.338

1.338

EXTREME SPREAD

2.436

2.290

1.480

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86463B3

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.502

VS= 2.776

GS= 3.555

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.325	1.194	1.199
MINIMUM X	-1.177	-1.164	-1.014
MAXIMUM Y	.993	.795	.620
MINIMUM Y	-1.783	-1.395	-.608
CENTROID X	-.048	.083	-.067
CENTROID Y	-.383	-.185	-.011
POA TO CENTROID in.	.386	.203	.067
MIN RADIUS	.188	.168	.313
MEAN RADIUS	.971	.820	.684
MAX RADIUS	2.136	1.837	1.301
HORIZONTAL SPREAD	2.502	2.358	2.213
VERTICAL SPREAD	2.776	2.190	1.228
EXTREME SPREAD	3.555	2.791	2.288
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B363

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 1.222

VS = 3.596

GS = 3.601

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.613	.623	.613
MINIMUM X	-.609	-.599	-.609
MAXIMUM Y	1.891	1.324	1.137
MINIMUM Y	-1.705	-1.495	-1.236
CENTROID X	.146	.136	.146
CENTROID Y	-.251	-.461	-.274
POA TO CENTROID in.	.290	.480	.310
MIN RADIUS	.212	.278	.211
MEAN RADIUS	1.062	.968	.878
MAX RADIUS	1.893	1.498	1.380
HORIZONTAL SPREAD	1.222	1.222	1.222
VERTICAL SPREAD	3.596	2.819	2.373
EXTREME SPREAD	3.601	2.866	2.669
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66489B3

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.382

VS = 2.845

GS = 3.228

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.327	1.381	1.255
MINIMUM X	-1.055	-1.001	-0.990
MAXIMUM Y	.983	.776	.489
MINIMUM Y	-1.857	-1.564	-1.466
CENTROID X	-.069	.015	.141
CENTROID Y	-.279	-.072	-.170
POR TO CENTROID in.	.287	.074	.220
MIN RADIUS	.140	.285	.131
MEAN RADIUS	.849	.700	.614
MAX RADIUS	1.918	1.460	1.311
HORIZONTAL SPREAD	2.382	2.382	2.245
VERTICAL SPREAD	2.840	1.340	.875
EXTREME SPREAD	3.228	2.691	2.247
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	