

C6648991

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

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

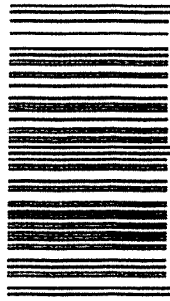
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6648991

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6648991

CONTRACT # DAAA21-87-C-0086

GFMGUN SERIAL # *C6648991*

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>GS</i>
	Magnaflux Bolt		JUL 22 1991	<i>GS</i>
615	Rollmark Caliber		JUL 22 1991	<i>GS</i>
617	Drill and Tap Sight Holes		JUL 22 1991	<i>FB</i>
618	Polish Barrel		7/28/91	<i>WB</i>
620	Apply Coatings (Barrel Action)		8-22-91	<i>DA</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		8/29/91	<i>DH</i>

op. #	BARBER M24 0030379	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9-7-91	DH
	G) Safety Off Force	3	3 1/4	3 1/4			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.021	.021	.022			9-7-91	DH
	J) Assemble Stock						9/9/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/9/91	RW
	M) Iron Sight Alignment						9/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	RW
	O) Attach Scope to Rifle						9/9/91	RW
	P) Detach & Attach Scope 20 Times						9/9/91	RW
640	Gallery Target & Test						9/9/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/9/91	KT
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	210	216	211	214	211	9-11-91	DH
	C) Function						9-12-91	DH
660	Pack						9-18-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CCG48991

DATE 9-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.42	2.51	210	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.32	2.55	216	
PULL #3	2.56	2.38	2.58	211	
PULL #4	2.44	2.34	2.60	214	
PULL #5	2.39	2.44	2.61	211	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.56		
PULL #2	3.27	3.50		
PULL #3	3.21	3.46		
PULL #4	3.42	3.23		
PULL #5	3.31	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.05		4.07
PULL #2	4.12	4.17		4.05
PULL #3	4.24	4.32		4.13
PULL #4	4.21	4.25		4.05
PULL #5	4.00	4.22		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648991
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0573847
1 TO	2	.045793
1 TO	3	.0782624
1 TO	4	.109836
1 TO	5	.181025

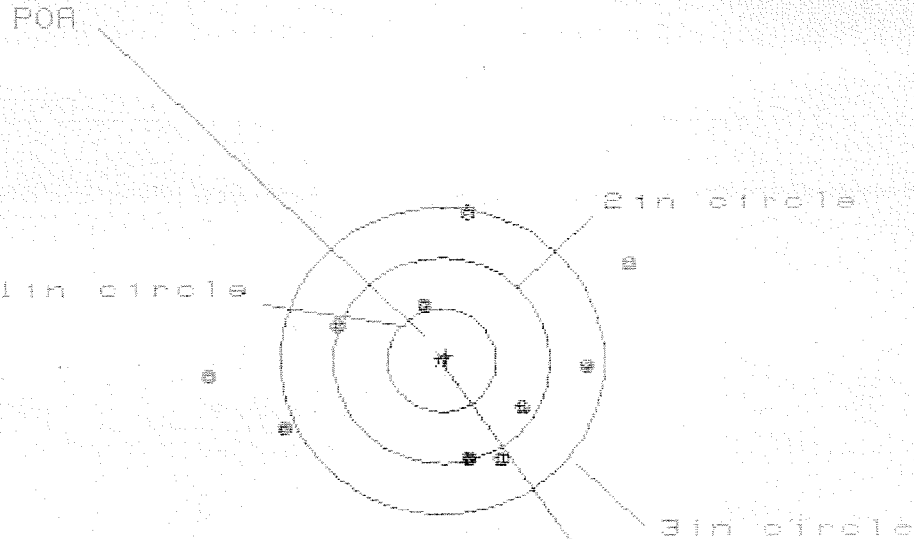
SW <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .057912
THE AMP FOR THIS RIFLE IS: .0056

8 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6548991

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.861

VS= 2.390

GS= 4.028

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.705	1.466	1.244
MINIMUM X	-2.156	-1.675	-1.492
MAXIMUM Y	1.417	1.398	1.519
MINIMUM Y	-1.973	-1.992	-1.071
CENTROID X	-1.038	.201	.010
CENTROID Y	-1.043	-1.024	-1.145
POA TO CENTROID in.	.057	.203	.146
MIN RADIUS	.539	.636	.653
MEAN RADIUS	1.296	1.176	1.094
MAX RADIUS	2.162	1.812	1.597
HORIZONTAL SPREAD	3.861	3.141	2.736
VERTICAL SPREAD	2.390	2.390	2.390
EXTREME SPREAD	4.028	3.550	2.797
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648991

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.619

VS= 2.017

GS= 3.011

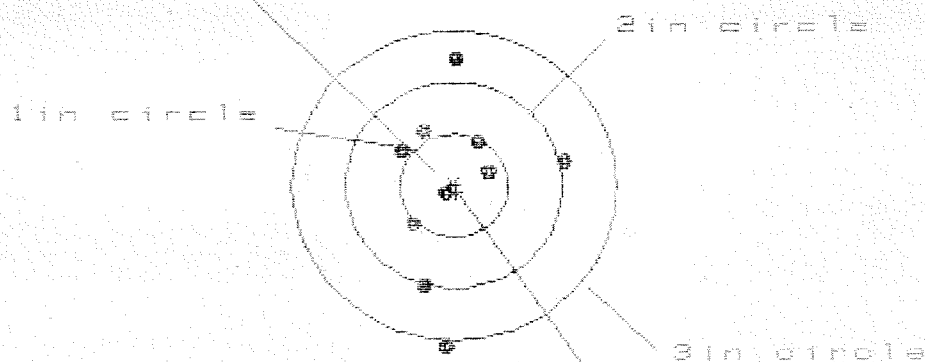
PATTERN #	1	3	9
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.568	.489	.379
MINIMUM X	-1.051	-.877	-.697
MAXIMUM Y	.941	.869	.964
MINIMUM Y	-1.077	-1.148	-1.053
CENTROID X	-.052	-.226	-.116
CENTROID Y	-.120	-.048	-.143
POR TO CENTROID in.	.130	.231	.185
MIN RADIUS	.291	.123	.253
MEAN RADIUS	.839	.699	.660
MAX RADIUS	1.696	1.248	1.119
HORIZONTAL SPREAD	2.619	1.366	1.076
VERTICAL SPREAD	2.017	2.017	2.017
EXTREME SPREAD	3.011	2.352	2.038
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

9 Sep 1991

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CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.538

VS= 2.794

GS= 2.798

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	1.035	1.036
MINIMUM X	-1.489	-1.503	-1.582
MAXIMUM Y	1.233	1.060	.514
MINIMUM Y	-1.561	-1.101	-1.969
CENTROID X	-.018	-.004	-.005
CENTROID Y	.065	.238	.106
POB TO CENTROID in.	.067	.238	.106
MIN RADIUS	.125	.268	.160
MEAN RADIUS	.758	.651	.596
MAX RADIUS	1.566	1.145	1.051
HORIZONTAL SPREAD	1.538	1.538	1.538
VERTICAL SPREAD	2.794	2.161	1.483
EXTREME SPREAD	2.798	2.184	1.769
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

5 Sep 1991

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

CENTROID #

HS = 2.252

VS = 1.120

GS = 2.326

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	.846	.714
MINIMUM X	-1.171	-1.050	-.800
MAXIMUM Y	.539	.480	.480
MINIMUM Y	-.581	-.640	-.640
CENTROID X	-.167	-.288	-.156
CENTROID Y	.084	.143	.143
POA TO CENTROID in.	.187	.321	.212
MIN RADIUS	.160	.062	.133
MEAN RADIUS	.607	.537	.453
MAX RADIUS	1.203	1.050	.933
HORIZONTAL SPREAD	2.252	1.896	1.514
VERTICAL SPREAD	1.120	1.120	1.120
EXTREME SPREAD	2.326	1.904	1.653
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		