

C6649015

MODEL 700™ M24

Model **SMS**™

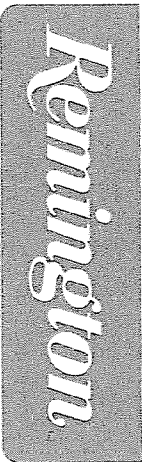
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

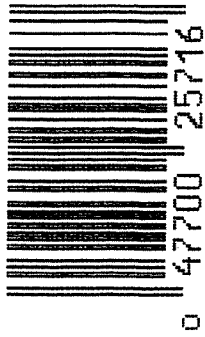
DU PONT

SERIAL NO. C6649015	Q5
ORDER NO. 5716	

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



UPC



CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649015

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KA
600	Proof		7/24/91	KA
607	Check Headspace		7/24/91	KA
610	Dis-assemble Gun		7/24/91	KA
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	KA
	Apply Coating (Bolt)		8-27-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KA
	C) Inspect Ejector Hole for Chamfer		9/4/91	KA
	D) Oil Firing Pin Ass'y		9/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9-5-91	D/H

op. #	BARBER M24 0030655	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	7	6			9-5-91	DH
	G) Safety Off Force	3	3	3			9-5-91	DH
	H) Trigger Pull Test & Retainability						9-5-91	DH
	I) Firing Pin Indent	.020	.020	.020			9-5-91	DH
	J) Assemble Stock						9/5/91	KK
	K) Assemble Swivel Studs						9-12-91	A
	L) Attach Front and Rear Sight Assemblies						9/5/91	KK
	M) Iron Sight Alignment						9/5/91	KK
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	KK
	O) Attach Scope to Rifle						9/5/91	KK
	P) Detach & Attach Scope 20 Times						9/5/91	KK
640	Gallery Target & Test						9/6/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/6/91	KT
655	Final Inspection						9-12-91	A
	A) Headspace							
	B) Trigger Pull	2.43	2.52	2.44	2.48	2.40	9/12/91	JH
	C) Function						9-12-91	K
660	Pack						9-12-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649015

DATE 9-5-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.46	2.60	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.44	2.46	2.52	
PULL #3	2.50	2.44	2.51	2.44	
PULL #4	2.42	2.42	2.32	2.48	
PULL #5	2.51	2.39	2.39	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.25		
PULL #2	3.29	3.25		
PULL #3	3.22	3.25		
PULL #4	3.24	3.25		
PULL #5	3.18	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	4.41	4.15		4.07
PULL #2	4.20	4.39		4.30
PULL #3	4.34	4.46		4.13
PULL #4	4.32	4.23		4.13
PULL #5	4.54	4.25		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649015
 7 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.162049
1 TO	2	.331228
1 TO	3	.555993
1 TO	4	.267959
1 TO	5	.289886

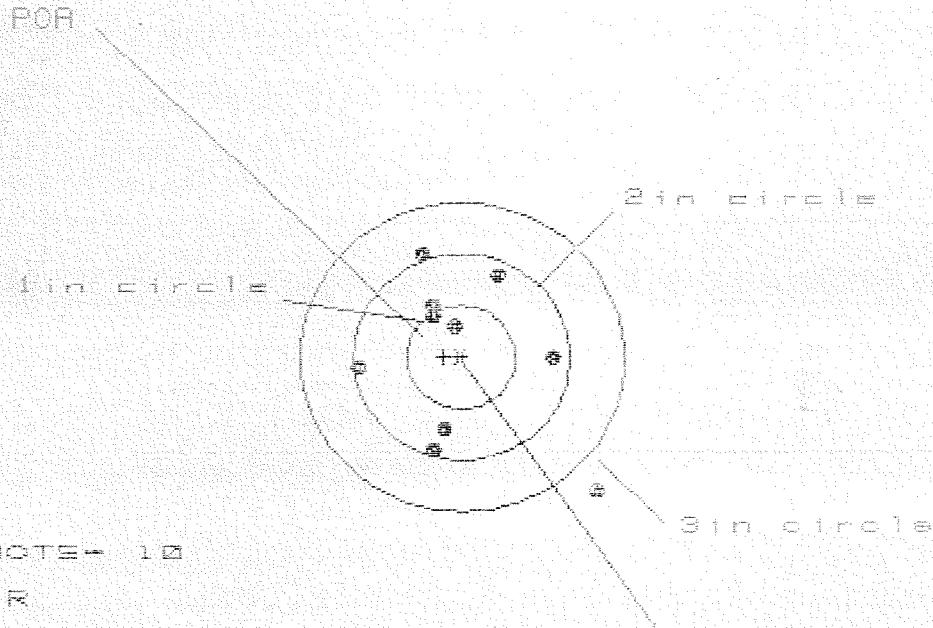
$\frac{1}{32}$ 5 <----POA

AVERAGE COORDINATE FOR THIS RIFLE IS: .0468
 AVERAGE COORDINATE FOR THIS RIFLE IS: -.05
 AVERAGE COORDINATE POI RADIUS FOR THIS RIFLE IS: .000000
 AVERAGE COORDINATE FOR THIS RIFLE IS: .8922

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649015

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

HZ CH

H1 = 0

H2 = 0

H3 = 0

H4 = 0.100

V0 = 0.269

G0 = 0.730

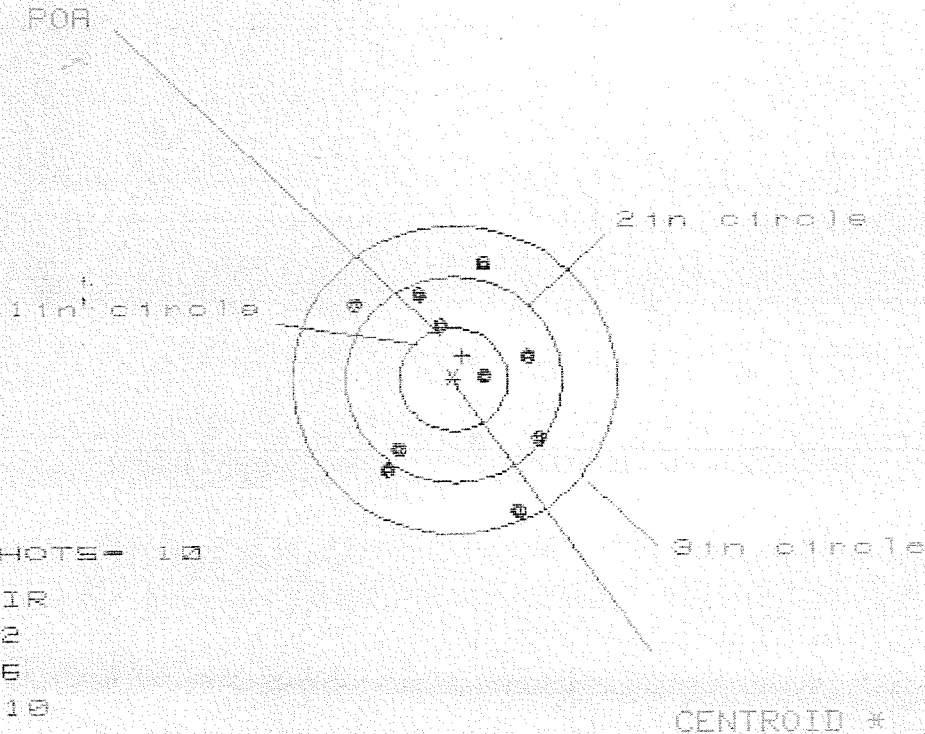
CENTROID *

PATTERN #				
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.203	.986	.962	
MINIMUM X	-.929	-.795	-.819	
MAXIMUM Y	.996	.854	.759	
MINIMUM Y	-1.273	-1.037	-.930	
CENTROID X	.162	.028	.052	
CENTROID Y	-.004	.138	.031	
POA TO CENTROID in.	.162	.141	.061	
MIN RADIUS	.301	.141	.246	
MEAN RADIUS	.839	.682	.677	
MAX RADIUS	1.752	1.047	.962	
HORIZONTAL SPREAD	2.132	1.781	1.781	
VERTICAL SPREAD	2.269	1.891	1.689	
EXTREME SPREAD	2.736	1.892	1.803	
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.636

VS = 2.442

GS = 2.517

PATTERN #

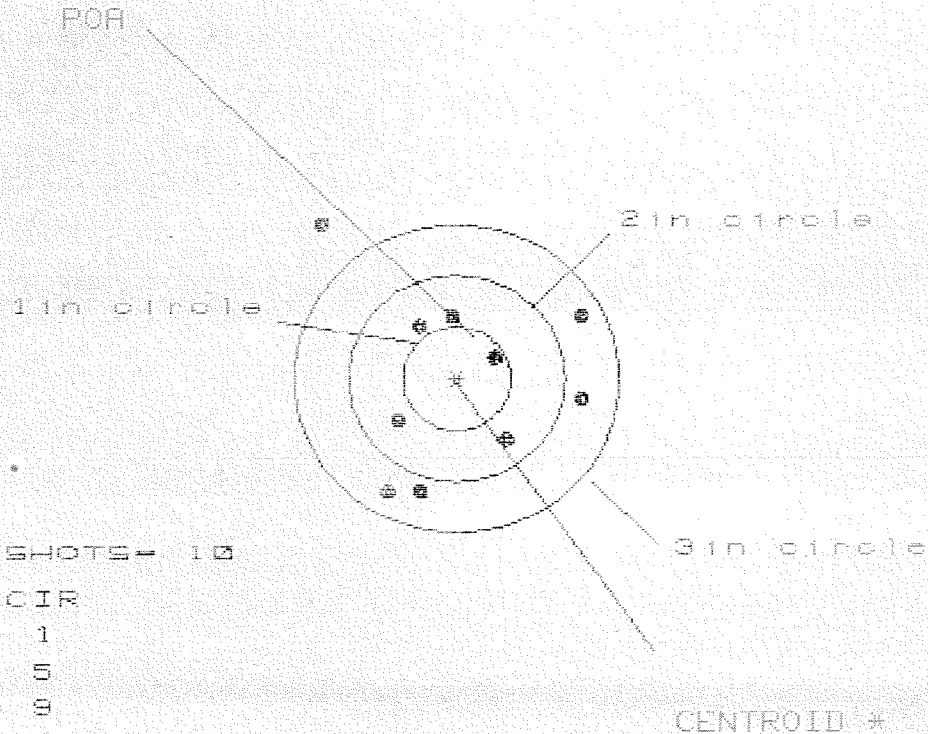
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.740	.800	.695
MINIMUM X	-.896	-.836	-.697
MAXIMUM Y	1.130	.984	1.060
MINIMUM Y	-1.312	-1.033	-.957
CENTROID X	-.082	-.142	-.037
CENTROID Y	-.228	-.082	-.158
POA TO CENTROID in.	.242	.163	.162
MIN RADIUS	.309	.343	.264
MEAN RADIUS	.908	.835	.798
MAX RADIUS	1.419	1.191	1.184
HORIZONTAL SPREAD	1.636	1.636	1.392
VERTICAL SPREAD	2.442	2.017	2.017
EXTREME SPREAD	2.517	2.231	2.231
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Sep 1991

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CENTERFIRE PATTERNS # 3



PATTERN # 3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.199	1.060	1.170
MINIMUM X	-1.256	-.779	-.647
MAXIMUM Y	1.456	.795	.849
MINIMUM Y	-1.135	-.974	-.874
CENTROID X	-.356	-.217	-.349
CENTROID Y	-.206	-.367	-.467
POA TO CENTROID in.	.411	.427	.583
MIN RADIUS	.385	.397	.502
MEAN RADIUS	.990	.875	.813
MAX RADIUS	1.923	1.325	1.172
HORIZONTAL SPREAD	2.455	1.839	1.817
VERTICAL SPREAD	2.591	1.769	1.723
EXTREME SPREAD	2.938	2.552	2.048
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

