

C6649072

MODEL 700™ M24

Model **SMS** II

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

SERIAL NO.
 C6649072

ORDER NO.
5716

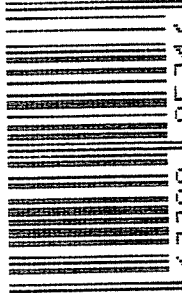
MADE IN LILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649072

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649072

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	Kel
600	Proof		6/25/91	Kel
607	Check Headspace		6/25/91	Kel
610	Dis-assemble Gun		6/25/91	Kel
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	GS.
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/91	Kel
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/91	Kel
	C) Inspect Ejector Hole for Chamfer		8/1/91	Kel
	D) Oil Firing Pin Ass'y		8/1/91	Kel
	E) Adjust Trigger Pull to Min Setting and Stake		8-2-91	JK

op. #	BARBER - M24 0031328 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-2-91	JH
	G) Safety Off Force	4	4	4			8-2-91	JH
	H) Trigger Pull Test & Retainability						8-2-91	JH
	I) Firing Pin Indent	.0205	.0205	.0205			8-2-91	JH
	J) Assemble Stock						8/7/91	KS
	K) Assemble Swivel Studs						8-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/7/91	KS
	M) Iron Sight Alignment						8/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	KS
	O) Attach Scope to Rifle						8/7/91	KS
	P) Detach & Attach Scope 20 Times						8/7/91	KS
640	Gallery Target & Test						8/8/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/8/91	KT
655	Final Inspection							
	A) Headspace						8-8-91	D/H
	B) Trigger Pull	2.33	2.24	2.35	2.36	2.32	8-9-91	JH
	C) Function						8-8-91	D/H
660	Pack						9-19-91	VF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>spot ok</i> <i>test</i> <i>8-9-91</i>	<i>AC</i>
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 4072

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
1st	1st	Extractor Stick	KS
		Shim Bress	
	2nd		
	3rd		
4th			

FUNCTION _____ RD 6654 Rev 1

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#SERIAL NO. C-6649072DATE 8-2-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.63	2.60	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.53	2.58	2.24	
PULL #3	2.61	2.54	2.50	2.35	
PULL #4	2.57	2.60	2.53	2.36	
PULL #5	2.57	2.58	2.53	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.38		
PULL #2	3.36	3.43		
PULL #3	3.49	3.42		
PULL #4	3.37	3.38		
PULL #5	3.37	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.68	4.39		4.54
PULL #2	4.41	4.60		4.42
PULL #3	4.35	4.61		4.48
PULL #4	4.45	4.52		4.47
PULL #5	4.37	4.64		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649872
8 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.35223
1 TO 2	.0567274
1 TO 3	.441346
1 TO 4	.639088
1 TO 5	.643666

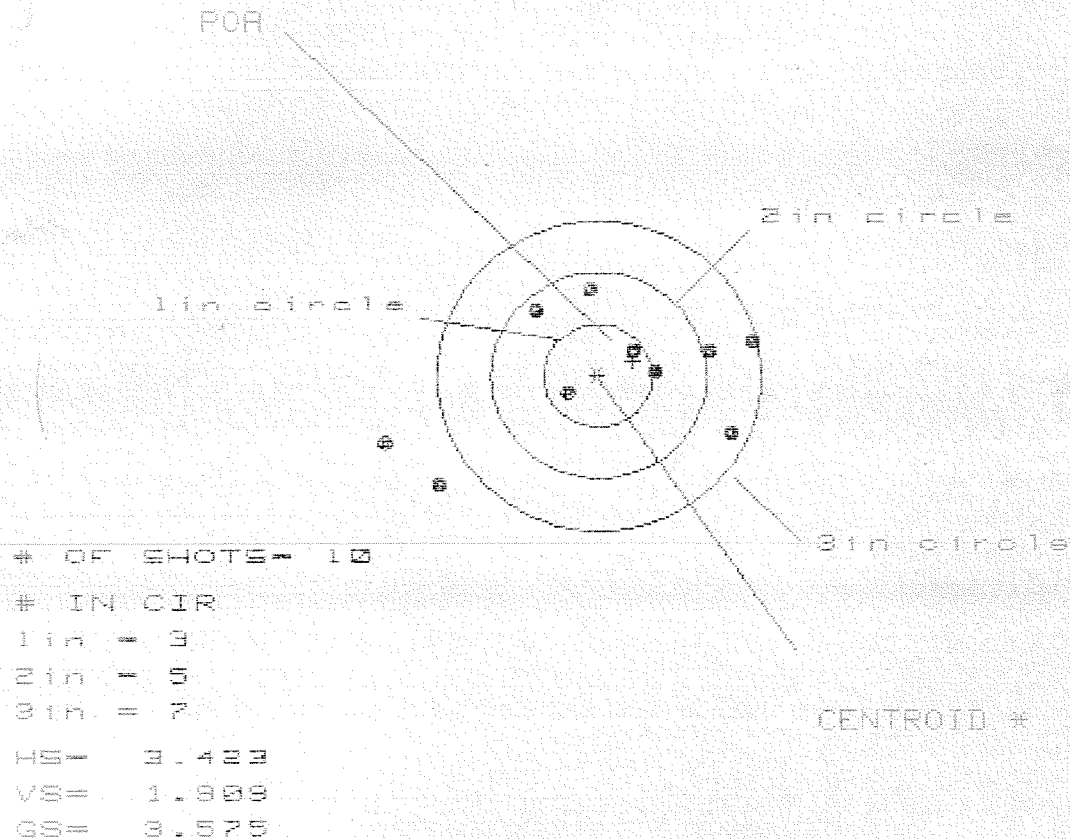
2
4
5 <---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1243
THE AMP FOR THIS RIFLE IS: .9722

E Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649072

CENTERFIRE PATTERNS # 1



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.458	1.240	1.030
MINIMUM X	-1.965	-1.675	-1.034
MAXIMUM Y	.809	.737	.590
MINIMUM Y	-1.100	-1.172	-.727
CENTROID X	-.321	-.103	.107
CENTROID Y	-.145	-.073	.074
FOR TO CENTROID in.	.352	.126	.130
MIN RADIUS	.336	.135	.147
MEAN RADIUS	1.063	.894	.712
MAX RADIUS	2.068	2.045	1.135
HORIZONTAL SPREAD	3.423	2.915	2.065
VERTICAL SPREAD	1.909	1.909	1.317
EXTREME SPREAD	3.575	3.272	2.164
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.932

VS= 2.133

GS= 2.947

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.159	1.034	.809
MINIMUM X	-1.673	-1.798	-1.623
MAXIMUM Y	1.327	.716	.698
MINIMUM Y	-.806	-.659	-.677
CENTROID X	.312	.438	.663
CENTROID Y	-.057	-.204	-.186
POA TO CENTROID in.	.318	.483	.688
MIN RADIUS	.340	.452	.640
MEAN RADIUS	1.101	1.005	.868
MAX RADIUS	1.742	1.804	1.657
HORIZONTAL SPREAD	2.832	2.832	2.432
VERTICAL SPREAD	2.133	1.375	1.275
EXTREME SPREAD	2.947	2.930	2.449
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 3.651

VS = 3.617

GS = 3.793

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.391	1.447	.938
MINIMUM X	-1.260	-1.204	-1.024
MAXIMUM Y	1.042	.756	.663
MINIMUM Y	-2.575	-.744	-.747
CENTROID X	.270	.214	.034
CENTROID Y	-.400	-.114	-.021
POB TO CENTROID in.	.483	.243	.040
MIN RADIUS	.569	.387	.249
MEAN RADIUS	1.094	.853	.737
MAX RADIUS	2.623	1.627	1.154
HORIZONTAL SPREAD	2.651	2.651	1.961
VERTICAL SPREAD	3.617	1.500	1.410
EXTREME SPREAD	3.793	2.668	2.002
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 2.322

VS= 1.473

GS= 2.568

CENTROID +

PATTERN #

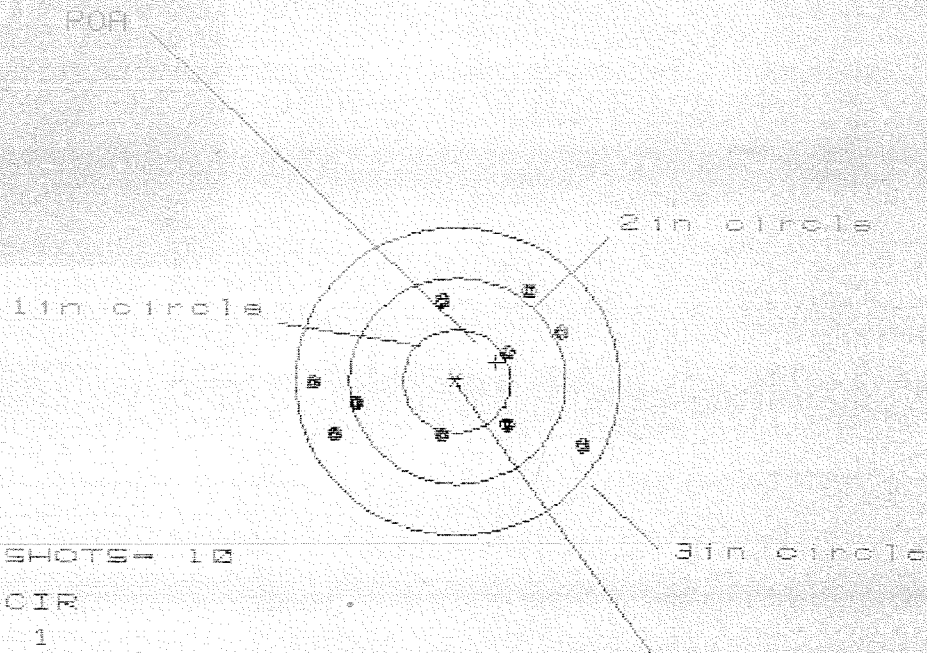
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.058	.918	.245
MINIMUM X	-1.264	-.565	-.451
MAXIMUM Y	.882	.829	.899
MINIMUM Y	-.591	-.644	-.574
CENTROID X	-.016	.124	.010
CENTROID Y	.174	.227	.157
POB TO CENTROID in.	.174	.259	.157
MIN RADIUS	.182	.235	.166
MEAN RADIUS	.650	.575	.487
MAX RADIUS	1.352	1.076	.899
HORIZONTAL SPREAD	2.322	1.483	.696
VERTICAL SPREAD	1.473	1.473	1.473
EXTREME SPREAD	2.568	1.679	1.491
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.428

VS= 1.491

GS= 2.494

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.134

1.003

.825

MINIMUM X

-1.294

-1.425

-1.245

MAXIMUM Y

.913

.850

.841

MINIMUM Y

-.578

-.641

-.650

CENTROID X

-.364

-.233

-.055

CENTROID Y

-.182

-.119

-.110

POA TO CENTROID IN.

.407

.261

.123

MIN RADIUS

.493

.347

.203

MEAN RADIUS

.953

.892

.791

MAX RADIUS

1.312

1.427

1.281

HORIZONTAL SPREAD

2.428

2.428

2.070

VERTICAL SPREAD

1.491

1.491

1.491

EXTREME SPREAD

2.494

2.494

2.099

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

10