

C6649089

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

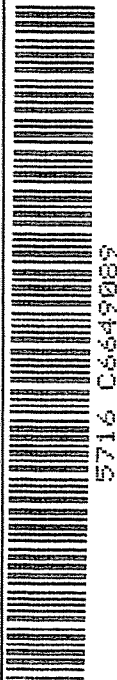
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6649089

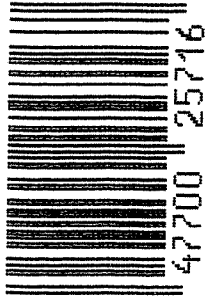
ORDER NO.
5716

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



5716 C6649089

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649089

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KH
600	Proof		6/26/91	KH
607	Check Headspace		6/26/91	KH
610	Dis-assemble Gun		6/26/91	KH
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KH
	C) Inspect Ejector Hole for Chamfer		8/22/91	KH
	D) Oil Firing Pin Ass'y		8/22/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8-23-91	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			8-23-91	DH
	G) Safety Off Force	2 1/2	3	2 1/2			8-23-91	DH
	H) Trigger Pull Test & Retainability						8-23-91	DH
	I) Firing Pin Indent	.022	.022	.023			8-23-91	DH
	J) Assemble Stock						9/4/91	KS
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/4/91	KS
	M) Iron Sight Alignment						9/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	KS
	O) Attach Scope to Rifle						9/4/91	KS
	P) Detach & Attach Scope 20 Times						9/4/91	KS
640	Gallery Target & Test						9-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-5-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	2.66	2.54	2.41	2.52	2.47	9-6-91	KS
	C) Function						9-12-91	DH
660	Pack						9-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6649089

DATE 8-23-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.39	2.59	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.42	2.46	2.54	
PULL #3	2.41	2.37	2.88	2.41	
PULL #4	2.41	2.53	2.50	2.52	
PULL #5	2.28	2.44	2.60	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.28		
PULL #2	3.25	3.30		
PULL #3	3.16	3.34		
PULL #4	3.34	3.33		
PULL #5	3.36	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.26		4.21
PULL #2	4.16	4.14		4.31
PULL #3	4.23	4.25		4.13
PULL #4	4.14	4.23		4.23
PULL #5	4.28	4.24		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649089
5 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.0729452
1 TO 2	.199249
1 TO 3	.172192
1 TO 4	.520895
1 TO 5	.302372

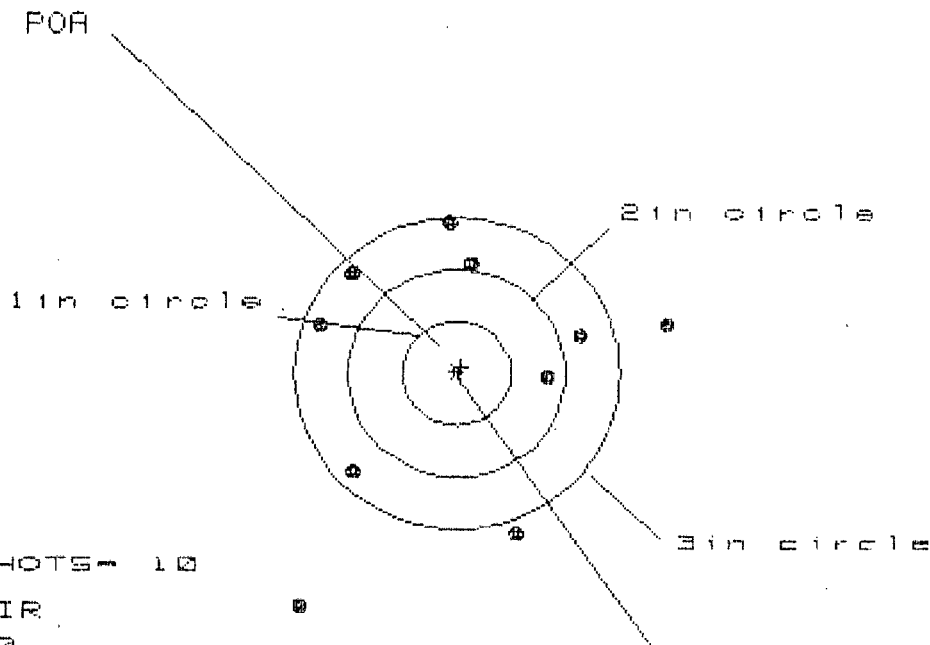
354 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1312
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0444
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138509
THE AMR FOR THIS RIFLE IS: .9652

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649083

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 10

2in = 1

3in = 7

HS = 3.370

VS = 3.662

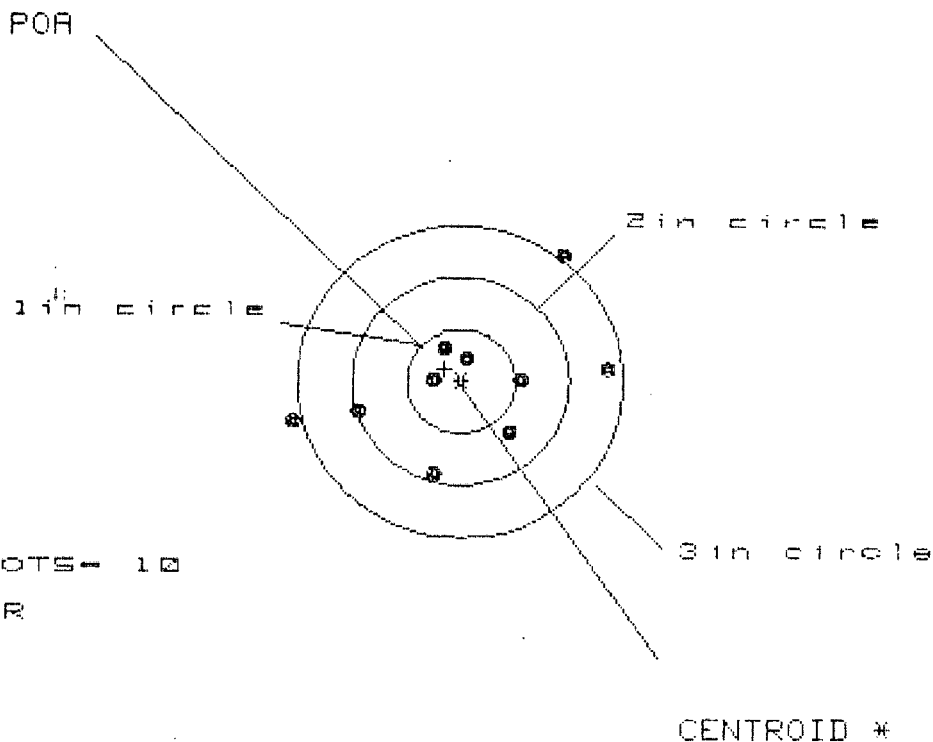
GS = 4.304

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.924	1.763	1.205
MINIMUM X	:	-1.446	-1.389	-1.168
MAXIMUM Y	:	1.427	1.179	1.203
MINIMUM Y	:	-2.235	-1.749	-1.725
CENTROID X	:	-.040	.121	-.100
CENTROID Y	:	-.061	.107	.163
POA TO CENTROID in.	:	.073	.223	.191
MIN RADIUS	:	.803	.686	.866
MEAN RADIUS	:	1.470	1.285	1.222
MAX RADIUS	:	2.662	1.799	1.840
HORIZONTAL SPREAD	:	3.370	3.152	2.373
VERTICAL SPREAD	:	3.662	2.928	2.928
EXTREME SPREAD	:	4.304	3.194	3.005
NUMBER IN ONE INCH CIRCLE	=	10	9	8
NUMBER IN TWO INCH CIRCLE	=	1	1	1
NUMBER IN THREE INCH CIRCLE	=	7	7	7

5 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.867

VS = 2.170

GS = 3.031

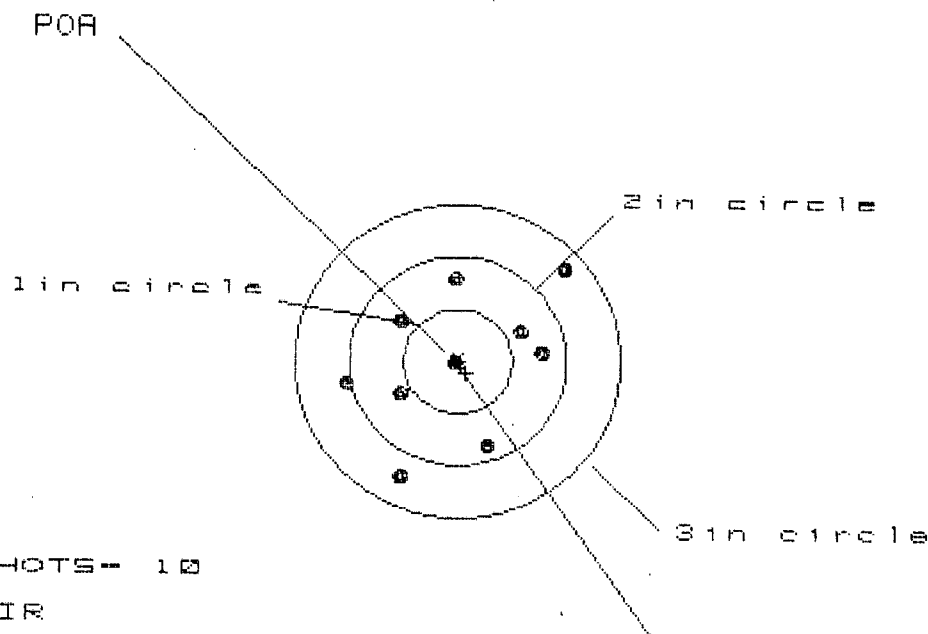
CENTROID *

PATTERN #	:	12	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.129	1.229
MINIMUM X	:	-1.564	-1.152	-1.052
MAXIMUM Y	:	1.258	1.213	.474
MINIMUM Y	:	-.912	-.957	-.806
CENTROID X	:	.150	.324	.224
CENTROID Y	:	-.121	-.076	-.227
POR TO CENTROID in.	:	.193	.332	.319
MIN RADIUS	:	.270	.267	.372
MEAN RADIUS	:	.864	.777	.688
MAX RADIUS	:	1.616	1.450	1.250
HORIZONTAL SPREAD	:	2.867	2.281	2.281
VERTICAL SPREAD	:	2.170	2.170	1.280
EXTREME SPREAD	:	3.031	2.510	2.321
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS-- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 1.950

VS= 2.045

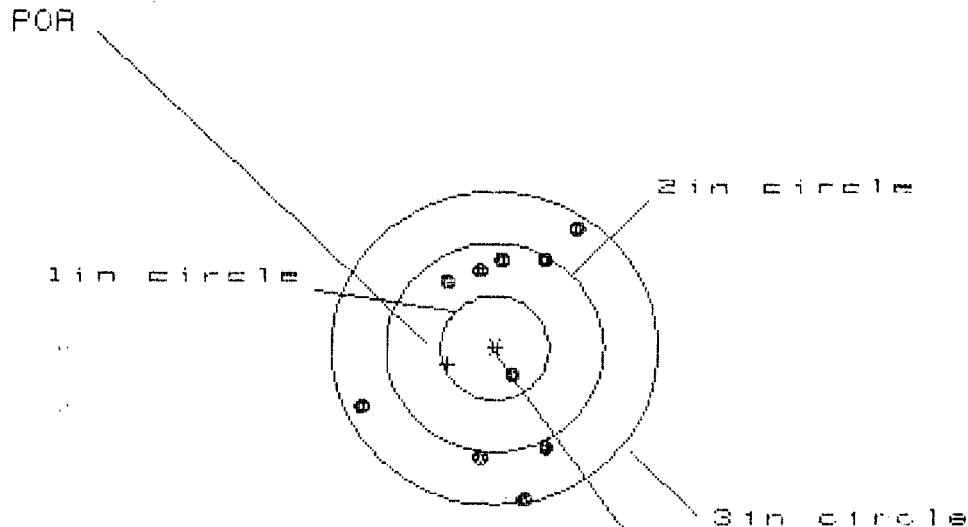
GS= 2.519

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.972	.863	.815
MINIMUM X	-.978	-.870	-.918
MAXIMUM Y	.896	.912	.780
MINIMUM Y	-1.149	-1.049	-.802
CENTROID X	-.073	-.181	-.133
CENTROID Y	.108	.008	.140
POA TO CENTROID in.	.131	.182	.193
MIN RADIUS	.048	.099	.067
MEAN RADIUS	.786	.724	.660
MAX RADIUS	1.322	1.120	.943
HORIZONTAL SPREAD	1.950	1.733	1.733
VERTICAL SPREAD	2.045	1.961	1.582
EXTREME SPREAD	2.519	2.022	1.753
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

5 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.977

VS= 2.547

GS= 2.600

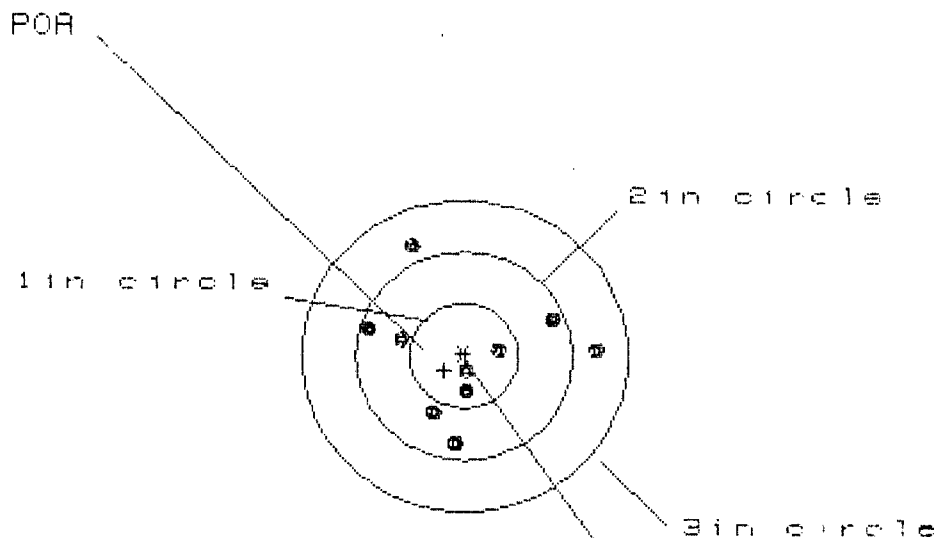
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	::	10	9	8
MAXIMUM X	:	.744	.769	.618
MINIMUM X	:	-1.233	-1.208	-.597
MAXIMUM Y	:	1.105	.945	.860
MINIMUM Y	:	-1.442	-1.198	-1.284
CENTROID X	:	.434	.409	.560
CENTROID Y	:	.155	.315	.400
POR TO CENTROID in.	:	.461	.516	.689
MIN RADIUS	:	.298	.457	.520
MEAN RADIUS	:	1.001	.930	.853
MAX RADIUS	:	1.459	1.390	1.313
HORIZONTAL SPREAD	:	1.977	1.977	1.215
VERTICAL SPREAD	:	2.547	2.143	2.143
EXTREME SPREAD	:	2.600	2.564	2.323
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Sep 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 2.119

VS = 1.921

GS = 2.130

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	.929	.889
MINIMUM X	-.928	-.796	-.836
MAXIMUM Y	1.043	1.045	.467
MINIMUM Y	-.878	-.876	-.745
CENTROID X	.185	.052	.092
CENTROID Y	.141	.139	.008
POA TO CENTROID in.	.232	.148	.092
MIN RADIUS	.142	.214	.126
MEAN RADIUS	.705	.651	.561
MAX RADIUS	1.191	1.093	1.004
HORIZONTAL SPREAD	2.119	1.725	1.725
VERTICAL SPREAD	1.921	1.921	1.212
EXTREME SPREAD	2.130	1.958	1.728
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	