

C6636209

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

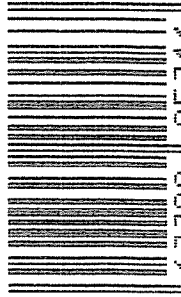
Remington

Remington® MODEL 700™ M24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marquis Deposee.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
UPPONT REG. U.S. PAT. & T.M. OFF.		SERIAL NO. C6636209
20		ORDER NO. 5716



5716 C6636209

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636209

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	JS
617	Drill and Tap Sight Holes		JUL 2 1991	WB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JH

op. #	BARBER - M24 0031761 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-13-91	JH
	G) Safety Off Force	3	3	3			8-13-91	JH
	H) Trigger Pull Test & Retainability						8-13-91	JH
	I) Firing Pin Indent	.022	.0225	.0225			8-13-91	JH
	J) Assemble Stock						8/14/91	RW
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/14/91	RW
	M) Iron Sight Alignment						8/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	RW
	O) Attach Scope to Rifle						8/14/91	RW
	P) Detach & Attach Scope 20 Times						8/14/91	RW
640	Gallery Target & Test						8-14-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-14-91	AF
655	Final Inspection							
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.24	2.48	2.52	2.50	2.55	8-15-91	JH
	C) Function						8-15-91	DH
660	Pack						9-18-91	AF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636209
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.098387
1 TO	2	.343105
1 TO	3	.0904489
1 TO	4	.192938
1 TO	5	.15905

←----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0274
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0318308
THE AMR FOR THIS RIFLE IS: .0592

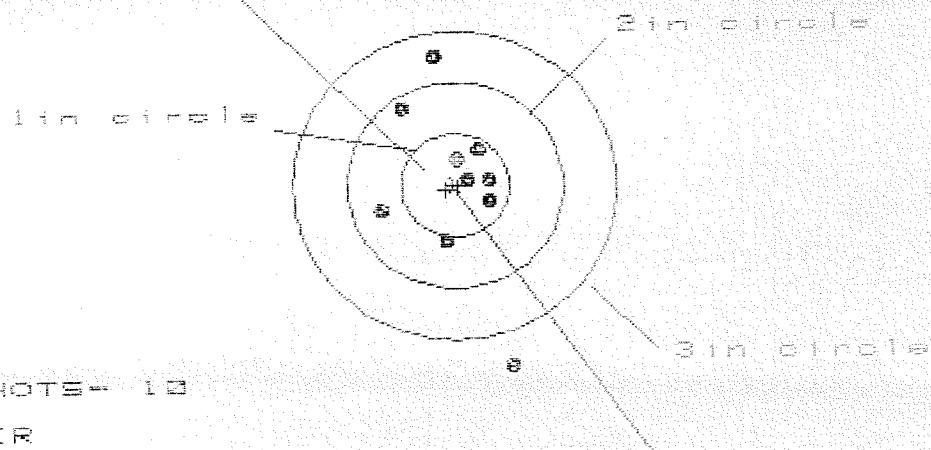
23 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8636203

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.119

VS= 2.939

GS= 3.010

CENTROID *

PATTERN #

1

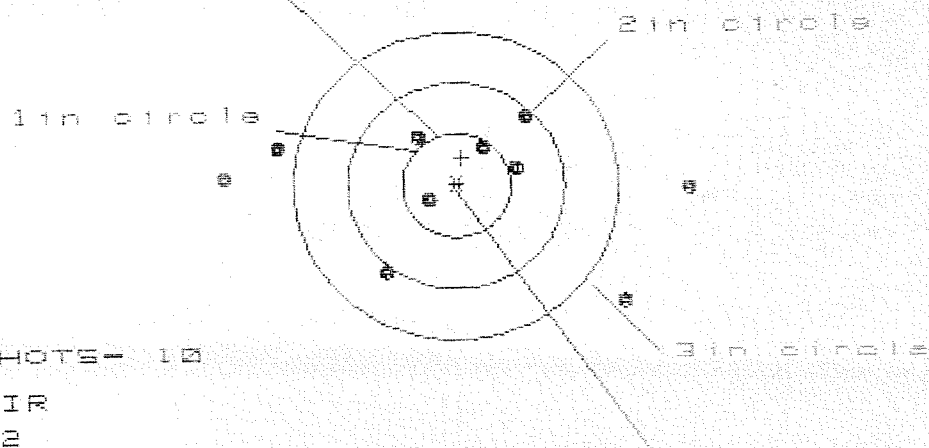
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.471	.358	.342
MINIMUM X	-.648	-.595	-.611
MAXIMUM Y	1.213	1.021	.682
MINIMUM Y	-1.726	-.688	-.560
CENTROID X	.088	.035	.051
CENTROID Y	.044	.236	.108
POA TO CENTROID in.	.098	.239	.120
MIN RADIUS	.067	.078	.108
MEAN RADIUS	.648	.516	.436
MAX RADIUS	1.789	1.029	.808
HORIZONTAL SPREAD	1.119	.953	.953
VERTICAL SPREAD	2.939	1.709	1.242
EXTREME SPREAD	3.010	1.712	1.300
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS= 4.291

VS= 1.818

GS= 4.292

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.138	1.899	1.542
MINIMUM X	-2.153	-1.901	-1.664
MAXIMUM Y	.682	.691	.690
MINIMUM Y	-1.136	-1.127	-1.129
CENTROID X	-.048	.191	-.046
CENTROID Y	-.271	-.280	-.278
POR TO CENTROID in.	.276	.339	.282
MIN RADIUS	.261	.308	.259
MEAN RADIUS	1.180	1.067	.939
MAX RADIUS	2.154	1.934	1.911
HORIZONTAL SPREAD	4.291	3.800	3.206
VERTICAL SPREAD	1.818	1.818	1.818
EXTREME SPREAD	4.292	3.818	3.532
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	6	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

CENTROID *

HS= 1.379

VS= 1.550

GS= 1.914

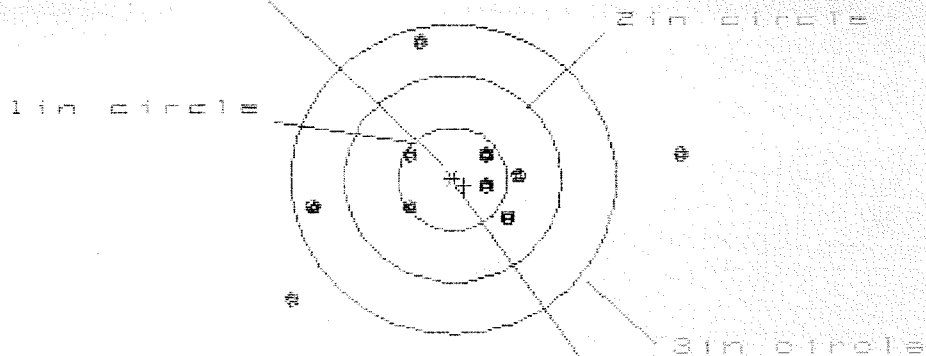
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.781	.754	.392
MINIMUM X	-.598	-.511	-.417
MAXIMUM Y	.841	.834	.776
MINIMUM Y	-.709	-.616	-.674
CENTROID X	-.002	-.009	-.183
CENTROID Y	.035	.058	.000
POA TO CENTROID in.	.035	.106	.183
MIN RADIUS	.167	.260	.216
MEAN RADIUS	.621	.562	.503
MAX RADIUS	1.148	.886	.788
HORIZONTAL SPREAD	1.379	1.265	.889
VERTICAL SPREAD	1.550	1.450	1.450
EXTREME SPREAD	1.914	1.481	1.466
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4

POB



OF SHOTS - 18

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 3.618

VS = 2.423

GS = 3.880

CENTROID #

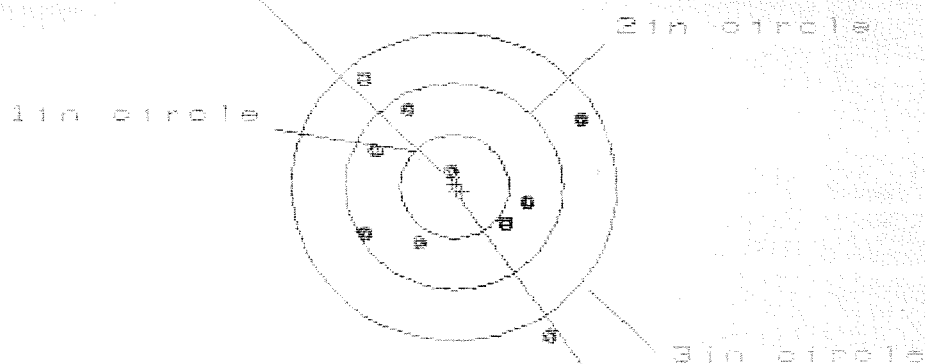
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.152	.793	.639
MINIMUM X	-1.466	-1.227	-1.236
MAXIMUM Y	1.288	1.317	1.179
MINIMUM Y	-1.135	-1.106	-.430
CENTROID X	-.104	-.343	-.190
CENTROID Y	.063	.034	.172
POB TO CENTROID in.	.121	.345	.256
MIN RADIUS	.349	.261	.327
MEAN RADIUS	.942	.818	.683
MAX RADIUS	2.168	1.652	1.286
HORIZONTAL SPREAD	3.618	2.020	1.875
VERTICAL SPREAD	2.423	2.423	1.609
EXTREME SPREAD	3.880	2.705	1.896
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 1.983

VS = 2.586

GS = 3.062

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.133	1.234	1.141
MINIMUM X	-0.850	-0.749	-0.788
MAXIMUM Y	1.027	0.862	0.698
MINIMUM Y	-1.479	-0.741	-0.633
CENTROID X	-0.071	-0.172	-0.079
CENTROID Y	0.048	0.213	0.105
FOR TO CENTROID in.	0.086	0.274	0.131
MIN RADIUS	0.137	0.111	0.081
MEAN RADIUS	0.905	0.800	0.743
MAX RADIUS	1.737	1.345	1.310
HORIZONTAL SPREAD	1.983	1.983	1.929
VERTICAL SPREAD	2.586	1.603	1.331
EXTREME SPREAD	3.062	2.257	2.257
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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

SERIAL NO C-6636209DATE 8-13-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.44	2.35	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.31	2.28	2.48	
PULL #3	2.44	2.32	2.33	2.52	
PULL #4	2.44	2.32	2.40	2.50	
PULL #5	2.41	2.30	2.36	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.26		
PULL #2	3.31	3.40		
PULL #3	3.27	3.55		
PULL #4	3.18	3.34		
PULL #5	3.22	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.51		4.26
PULL #2	4.28	4.47		4.44
PULL #3	4.40	4.52		4.35
PULL #4	4.20	4.29		4.32
PULL #5	4.17	4.28		4.38
TOTAL				
AVG.				