

C6636263

MODEL 700™ M24

Model **SMS**™

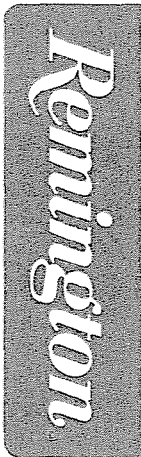
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

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

MODEL 700™ M24

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

20

SERIAL NO.
C6636263

ORDER NO.
5716

5716 C6636263

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636263

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KA
600	Proof		6/25/91	KA
607	Check Headspace		6/25/91	KA
610	Dis-assemble Gun		6/25/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GL
	Magnaflux Bolt		JUL 1 8 1991	GL
615	Rollmark Caliber		JUL 1 8 1991	GL
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	AA
	Apply Coating (Bolt)			AA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KA

op. #	BARBER - M24 0032368 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-10-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-9-91	JM
	I) Firing Pin Indent	.023	.021	.022			8-12-91	DH
	J) Assemble Stock						8/13/91	KH
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/13/91	KH
	M) Iron Sight Alignment						8/13/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/13/91	KH
	O) Attach Scope to Rifle						8/13/91	KH
	P) Detach & Attach Scope 20 Times						8/13/91	KH
640	Gallery Target & Test						8-14-91	DH
	A) Time						8-14-91	DH
	B) Malfunctions						8-14-91	DH
	C) Pierced Primers						8-14-91	DH
	D) Optical Clarity of Scope						8-14-91	DH
645	Inspect for Live Ammo						8-14-91	DH
655	Final Inspection						8-15-91	DH
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.66	2.42	2.60	2.65	2.66	8-14-91	JM
	C) Function						8-15-91	DH
660	Pack						8-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636263DATE 8-9-91TESTER JL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.60	2.44	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.55	2.30	2.42	
PULL #3	2.46	2.61	2.55	2.60	
PULL #4	2.43	2.29	2.44	2.65	
PULL #5	2.60	2.41	2.30	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.25		
PULL #2	3.21	3.18		
PULL #3	3.46	3.19		
PULL #4	3.29	3.15		
PULL #5	3.31	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.48		4.60
PULL #2	4.59	4.44		4.65
PULL #3	4.65	4.36		4.65
PULL #4	4.58	4.60		4.66
PULL #5	4.62	4.64		4.59
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636263
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0615549
1 TO	2	.35617
1 TO	3	.050774
1 TO	4	.298377
1 TO	5	.155708

$\frac{4}{2}$

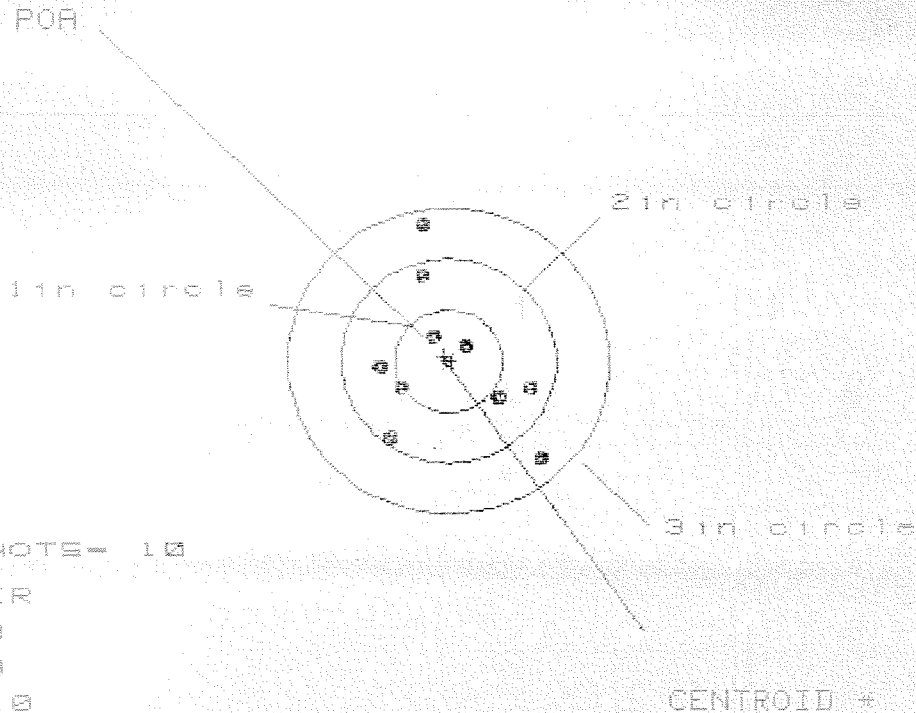
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0294
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0534183
THE AMP FOR THIS RIFLE IS: .0164

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636263

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.469

VS= 2.257

GS= 2.482

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.822	.799	.868
MINIMUM X	-.647	-.670	-.570
MAXIMUM Y	1.315	.989	.890
MINIMUM Y	-.942	-.796	-.712
CENTROID X	.042	.065	-.035
CENTROID Y	-.045	-.191	-.092
POA TO CENTROID in.	.062	.202	.098
MIN RADIUS	.211	.318	.300
MEAN RADIUS	.743	.680	.684
MAX RADIUS	1.332	1.128	.907
HORIZONTAL SPREAD	1.469	1.469	1.430
VERTICAL SPREAD	2.257	1.785	1.602
EXTREME SPREAD	2.482	2.083	1.628
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636263

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.832

VS= 2.751

GS= 3.071

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.671	.563	.404
MINIMUM X	:	-1.161	-1.269	-.951
MAXIMUM Y	:	1.600	1.093	1.004
MINIMUM Y	:	-1.151	-.973	-1.062
CENTROID X	:	.053	.161	.320
CENTROID Y	:	-.401	-.573	-.490
POA TO CENTROID in.	:	.404	.601	.585
MIN RADIUS	:	.212	.318	.248
MEAN RADIUS	:	.971	.837	.708
MAX RADIUS	:	1.875	1.453	1.383
HORIZONTAL SPREAD	:	1.832	1.832	1.355
VERTICAL SPREAD	:	2.751	2.066	2.066
EXTREME SPREAD	:	3.071	2.327	2.327
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B36253

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.644

VS= 1.947

GS= 2.024

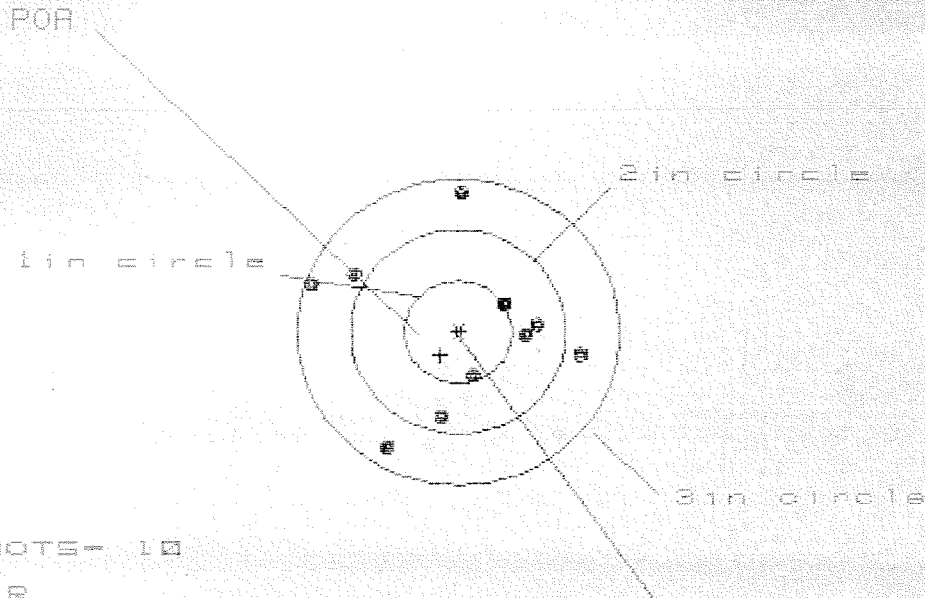
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.617	.623	.495
MINIMUM X	-1.027	-1.021	-1.053
MAXIMUM Y	1.417	.628	.652
MINIMUM Y	-.530	-.372	-.348
CENTROID X	.015	.009	.137
CENTROID Y	-.002	-.160	-.184
POA TO CENTROID in.	.016	.160	.229
MIN RADIUS	.164	.086	.057
MEAN RADIUS	.673	.564	.465
MAX RADIUS	1.418	1.039	1.066
HORIZONTAL SPREAD	1.644	1.644	1.548
VERTICAL SPREAD	1.947	1.000	1.000
EXTREME SPREAD	2.024	1.671	1.551
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8535263

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.503

VS= 2.511

GS= 2.600

CENTROID *

PATTERN #

4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.138	.987	.972
MINIMUM X	-1.365	-1.074	-1.089
MAXIMUM Y	1.351	1.401	.774
MINIMUM Y	-1.160	-1.110	-.934
CENTROID X	.169	.320	.335
CENTROID Y	.225	.175	-.001
POA TO CENTROID in.	.281	.365	.335
MIN RADIUS	.481	.404	.229
MEAN RADIUS	.961	.869	.781
MAX RADIUS	1.438	1.406	1.336
HORIZONTAL SPREAD	2.503	2.061	2.061
VERTICAL SPREAD	2.511	2.511	1.708
EXTREME SPREAD	2.600	2.600	2.208
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636263

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.806

VS= 2.112

GS= 2.468

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.131

.737

.725

MINIMUM X

-.775

-.650

-.662

MAXIMUM Y

1.267

1.179

.596

MINIMUM Y

-.845

-.933

-.786

CENTROID X

-.056

-.181

-.169

CENTROID Y

.076

.164

.017

POA TO CENTROID in.

.094

.245

.170

MIN RADIUS

.351

.205

.345

MEAN RADIUS

.734

.648

.568

MAX RADIUS

1.384

1.182

.939

HORIZONTAL SPREAD

1.906

1.387

1.387

VERTICAL SPREAD

2.112

2.112

1.382

EXTREME SPREAD

2.468

2.123

1.511

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10