

C6636284

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

MOD. _____ GA. _____ GUN # 6284
 CAL. _____

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
VF	1st	Ejector Sticks Safe Bind Bolt Release Stuck N.F.G.	KS
	6/11		
	2nd	polish Ejector filed Stock new bolt release	KS
	3rd		
	9/6	100 Rd Test	RW
	14/	OK	
	19/	—	
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

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

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

MODEL 700TM M24

SERIAL NO. C6636284

ORDER NO. 5716

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

06

5716 C6636284

UPC 0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636284

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCD
	Magnaflux Bolt	5 8 9 1		KCD
615	Rollmark Caliber	5 8 9 1		G.S.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		LB
620	Apply Coatings (Barrel Action)		5-29-91	PA
	Apply Coating (Bolt)		5-29-91	PA
625	Final Assembly A) Clean inside of Bolt Assembly		4/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KS
	C) Inspect Ejector Hole for Chamfer		4/4/91	KS
	D) Oil Firing Pin Ass'y		4/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	BU

op. #	BARBER M24 0032598	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-10-91	JH
	G) Safety Off Force	4	4	4			6-10-91	JH
	H) Trigger Pull Test & Retainability						6-10-91	JH
	I) Firing Pin Indent	.021	.021	.021			6-10-91	JH
	J) Assemble Stock						6-10-91	KS
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6-10-91	KS
	M) Iron Sight Alignment						6-10-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-10-91	KS
	O) Attach Scope to Rifle						6-10-91	KS
	P) Detach & Attach Scope 20 Times						6-10-91	KS
640	Gallery Target & Test						6-11-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-11-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.70	2.58	2.56	2.56	2.58	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636284DATE 6-10-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.62	2.50	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.60	2.65	2.58	
PULL #3	2.55	2.48	2.49	2.66	
PULL #4	2.54	2.58	2.44	2.56	
PULL #5	2.56	2.36	2.50	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.46		
PULL #2	3.61	3.28		
PULL #3	3.67	3.31		
PULL #4	3.50	3.41		
PULL #5	3.59	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.22		4.24
PULL #2	4.19	4.38		4.64
PULL #3	4.23	4.15		4.61
PULL #4	4.51	4.31		4.68
PULL #5	4.57	4.35		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636284
15 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.112929
1 TO	2	.240337
1 TO	3	.182661
1 TO	4	.0861626
1 TO	5	.231138

1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0872
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0354
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0941116
THE AMR FOR THIS RIFLE IS: .9448

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B4.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 0

2in = 6

3in = 10

HS = 1.726

VS = 2.241

GS = 2.249

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.796	.718
MINIMUM X	:	-.895	-.930	-1.008
MAXIMUM Y	:	1.087	.959	.821
MINIMUM Y	:	-1.154	-1.107	-1.058
CENTROID X	:	.087	.122	.200
CENTROID Y	:	.072	.200	.339
POA TO CENTROID in.	:	.113	.234	.393
MIN RADIUS	:	.533	.527	.525
MEAN RADIUS	:	.961	.920	.847
MAX RADIUS	:	1.196	1.273	1.236
HORIZONTAL SPREAD	:	1.726	1.726	1.726
VERTICAL SPREAD	:	2.241	2.066	1.878
EXTREME SPREAD	:	2.249	2.118	1.890
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B4.1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.915

VS = 3.147

GS = 3.154

CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.519	1.519	.965
MINIMUM X		-1.396	-1.396	-1.206
MAXIMUM Y		1.476	1.290	1.237
MINIMUM Y		-1.671	-0.977	-1.030
CENTROID X		.186	.186	-.004
CENTROID Y		-.147	.039	.092
POA TO CENTROID in.		.237	.190	.092
MIN RADIUS		.145	.076	.268
MEAN RADIUS		.999	.902	.827
MAX RADIUS		1.671	1.578	1.241
HORIZONTAL SPREAD		2.915	2.915	2.171
VERTICAL SPREAD		3.147	2.267	2.267
EXTREME SPREAD		3.154	3.016	2.302
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636264.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 1.937

VS = 2.938

GS = 2.965

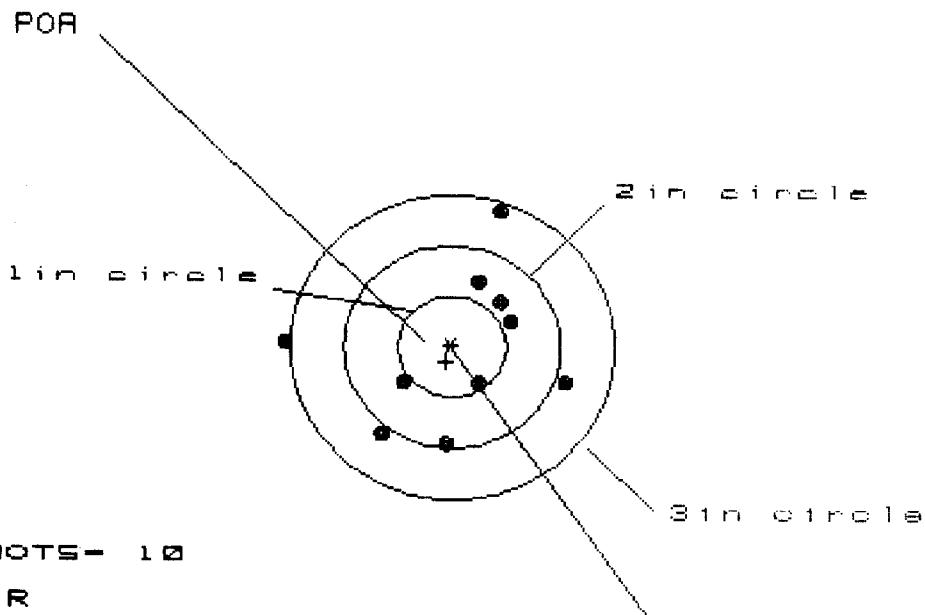
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.166	1.165	1.212
MINIMUM X	-.771	-.772	-.725
MAXIMUM Y	1.532	1.128	.973
MINIMUM Y	-1.406	-1.236	-1.171
CENTROID X	.013	.014	-.033
CENTROID Y	-.095	-.265	-.110
POA TO CENTROID in.	.095	.265	.115
MIN RADIUS	.297	.321	.249
MEAN RADIUS	.975	.908	.840
MAX RADIUS	1.532	1.337	1.213
HORIZONTAL SPREAD	1.937	1.937	1.937
VERTICAL SPREAD	2.938	2.364	2.144
EXTREME SPREAD	2.965	2.607	2.192
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36264.1

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.567

VS = 2.276

GS = 2.601

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.837	.867
MINIMUM X	:	-1.557	-.863	-.833
MAXIMUM Y	:	1.342	1.352	.810
MINIMUM Y	:	-.934	-.924	-.755
CENTROID X	:	.055	.228	.198
CENTROID Y	:	.152	.142	-.027
POA TO CENTROID in.	:	.162	.268	.200
MIN RADIUS	:	.423	.364	.202
MEAN RADIUS	:	.891	.790	.706
MAX RADIUS	:	1.560	1.373	1.070
HORIZONTAL SPREAD	:	2.567	1.700	1.700
VERTICAL SPREAD	:	2.276	2.276	1.565
EXTREME SPREAD	:	2.601	2.454	1.780
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636264.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.542

VS = 1.733

GS = 2.827

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.626	.413	.463
MINIMUM X		-1.916	-1.121	-1.069
MAXIMUM Y		.750	.778	.658
MINIMUM Y		-.983	-.955	-.819
CENTROID X		.095	.308	.256
CENTROID Y		-.159	-.187	-.068
POA TO CENTROID in.		.185	.360	.265
MIN RADIUS		.450	.255	.328
MEAN RADIUS		.898	.719	.682
MAX RADIUS		1.932	1.307	1.203
HORIZONTAL SPREAD		2.542	1.534	1.532
VERTICAL SPREAD		1.733	1.733	1.477
EXTREME SPREAD		2.827	2.236	2.056
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636284
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.36844
1 TO	2	.309273
1 TO	3	.218002
1 TO	4	.223036
1 TO	5	.549364

15 <----POA

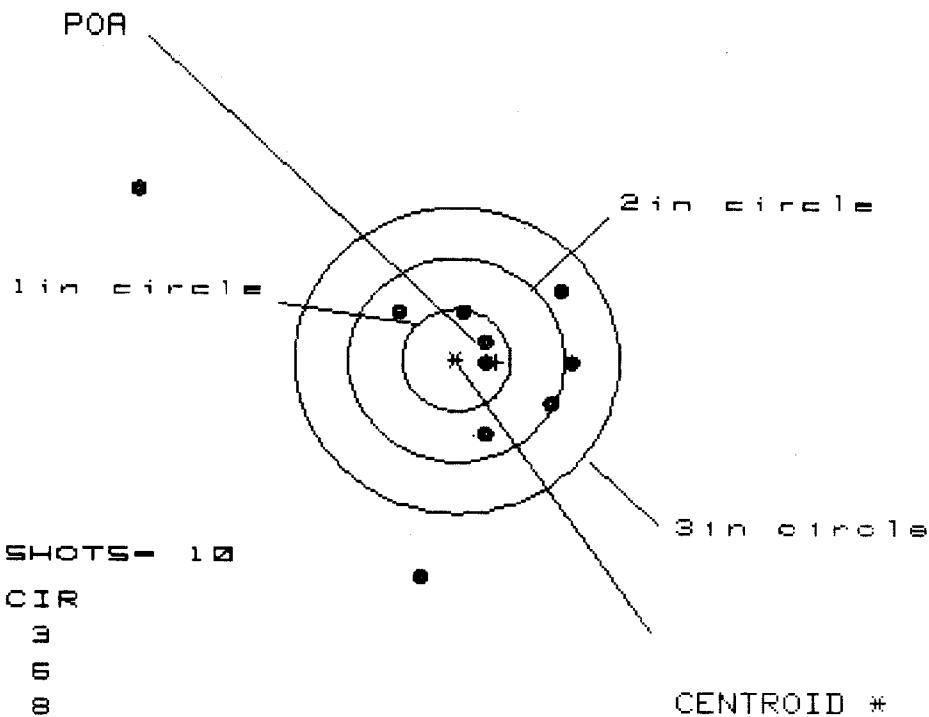
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2492
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1342
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .283038

THE AMR FOR THIS RIFLE IS: 1.352

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86362B4

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 4.024

VS= 3.769

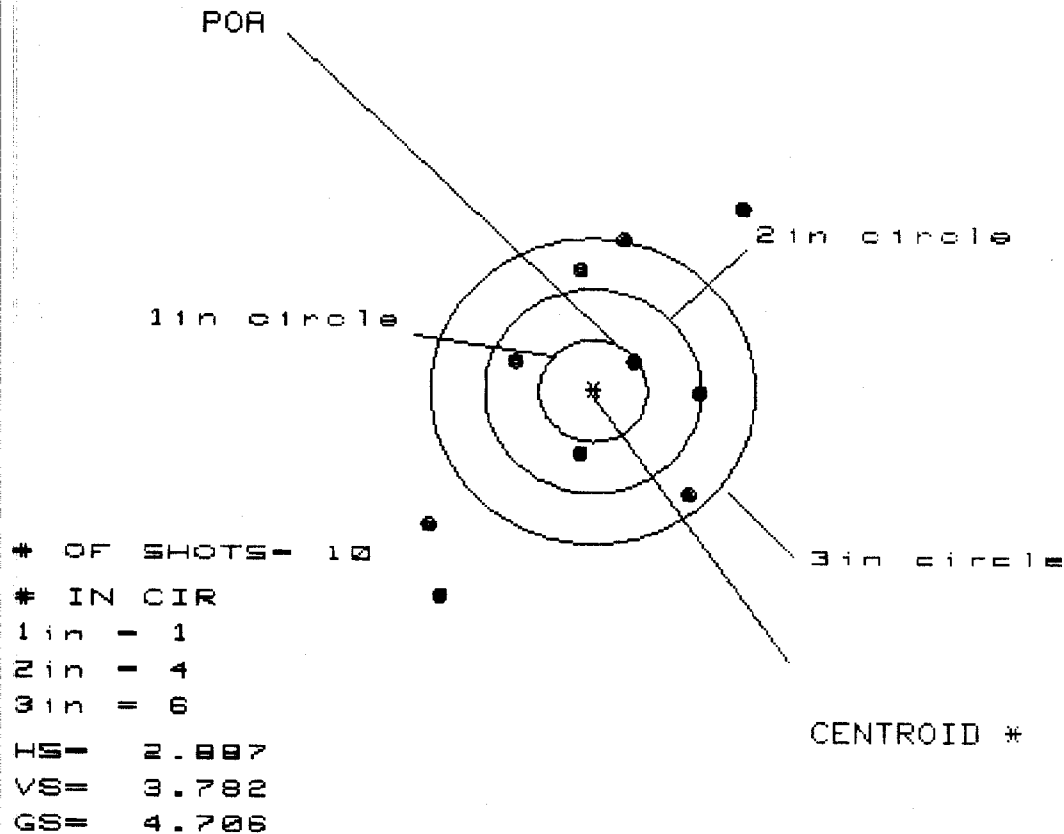
GS= 4.632

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.047	.716	.639
MINIMUM X	-2.977	-.875	-.952
MAXIMUM Y	1.636	.851	.607
MINIMUM Y	-2.133	-1.951	-.826
CENTROID X	-.368	-.037	.040
CENTROID Y	.018	-.164	.080
POA TO CENTROID in.	.368	.168	.090
MIN RADIUS	.293	.127	.164
MEAN RADIUS	1.137	.809	.609
MAX RADIUS	3.397	2.046	1.033
HORIZONTAL SPREAD	4.024	1.591	1.591
VERTICAL SPREAD	3.769	2.802	1.433
EXTREME SPREAD	4.632	3.078	1.668
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B4

CENTERFIRE PATTERNS # 2

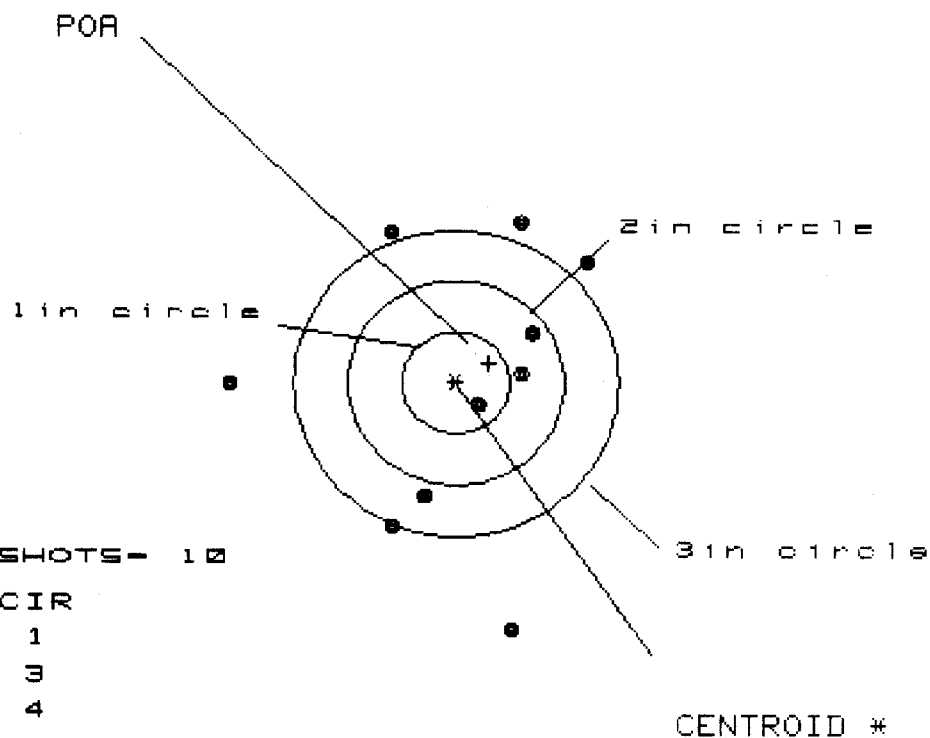


PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.200	.942
MINIMUM X	-1.527	-1.687	-1.537
MAXIMUM Y	1.750	1.524	1.472
MINIMUM Y	-2.032	-1.553	-1.362
CENTROID X	-.381	-.221	-.371
CENTROID Y	-.291	-.065	-.256
POA TO CENTROID in.	.480	.231	.451
MIN RADIUS	.482	.244	.455
MEAN RADIUS	1.364	1.198	1.114
MAX RADIUS	2.490	2.293	2.054
HORIZONTAL SPREAD	2.887	2.887	2.479
VERTICAL SPREAD	3.782	3.077	2.834
EXTREME SPREAD	4.706	4.219	3.382
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636264

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 4

HS = 3.284

VS = 3.984

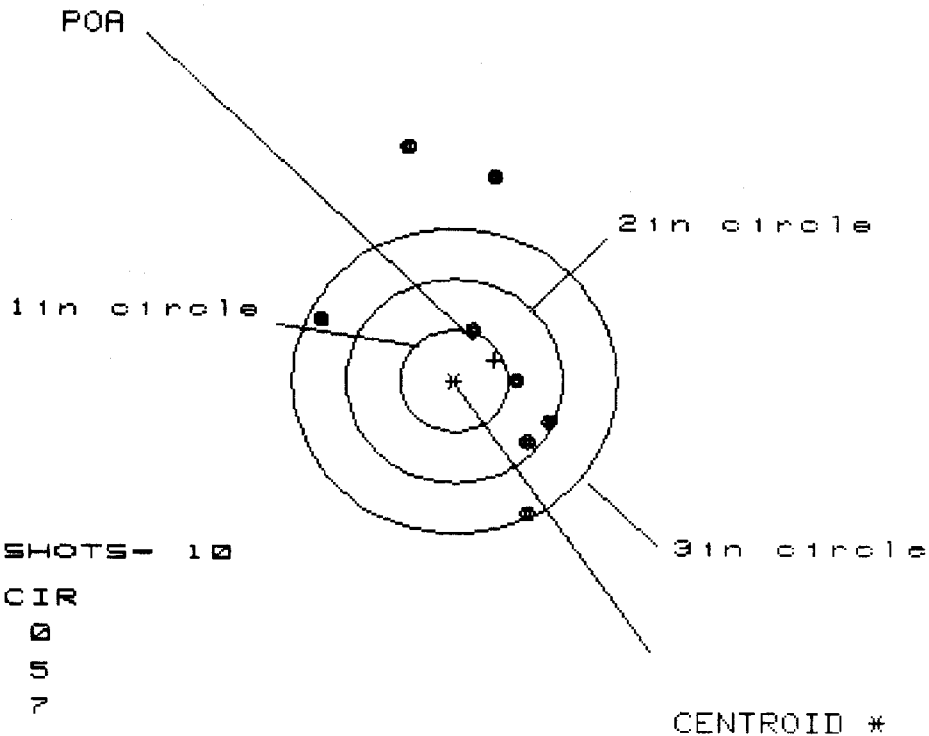
GS = 4.041

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.222	.964
MINIMUM X	:	-2.113	-2.062	-.819
MAXIMUM Y	:	1.615	1.352	1.318
MINIMUM Y	:	-2.369	-1.654	-1.688
CENTROID X	:	-.306	-.357	-.099
CENTROID Y	:	-.191	.072	.106
POA TO CENTROID in.	:	.360	.364	.145
MIN RADIUS	:	.240	.489	.394
MEAN RADIUS	:	1.395	1.285	1.122
MAX RADIUS	:	2.413	2.080	1.876
HORIZONTAL SPREAD	:	3.284	3.284	1.783
VERTICAL SPREAD	:	3.984	3.006	3.006
EXTREME SPREAD	:	4.041	3.504	3.235
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636284

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 0

2in - 5

3in - 7

HS- 2.748

VS- 6.052

GS- 6.208

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.714	.632
MINIMUM X	-1.830	-1.456	-1.538
MAXIMUM Y	2.283	1.864	1.843
MINIMUM Y	-3.769	-1.668	-1.434
CENTROID X	-.372	-.168	-.086
CENTROID Y	-.205	.214	-.019
POA TO CENTROID in.	.425	.272	.088
MIN RADIUS	.535	.109	.314
MEAN RADIUS	1.495	1.086	.963
MAX RADIUS	4.190	1.977	1.846
HORIZONTAL SPREAD	2.748	2.170	2.170
VERTICAL SPREAD	6.052	3.532	3.277
EXTREME SPREAD	6.208	3.711	3.290
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636284

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 7

HS = 3.592

VS = 2.971

GS = 4.226

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.552	1.325	1.117
MINIMUM X	:	-2.040	-1.117	-.951
MAXIMUM Y	:	1.254	1.095	1.173
MINIMUM Y	:	-1.717	-1.876	-1.798
CENTROID X	:	.181	.408	.242
CENTROID Y	:	-.002	.157	.079
POA TO CENTROID in.	:	.181	.437	.255
MIN RADIUS	:	.634	.873	.706
MEAN RADIUS	:	1.370	1.221	1.179
MAX RADIUS	:	2.496	1.903	1.804
HORIZONTAL SPREAD	:	3.592	2.442	2.068
VERTICAL SPREAD	:	2.971	2.971	2.971
EXTREME SPREAD	:	4.226	2.997	2.979
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	