

C6636294

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

DUPONT

MODEL 700™ M24

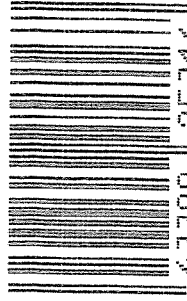
SERIAL NO.
C6606294

ORDER NO.
5716

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



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636294

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25		RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	AM

op. #	BARBER M24 0032716	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/3/91	SH
	G) Safety Off Force	4	4	4			9/3/91	SH
	H) Trigger Pull Test & Retainability						9-3-91	SH
	I) Firing Pin Indent	.0205	.020	.020			9/3/91	SH
	J) Assemble Stock						9/3/91	RW
	K) Assemble Swivel Studs						9-3-91	AC
	L) Attach Front and Rear Sight Assemblies						9/3/91	RW
	M) Iron Sight Alignment						9/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	RW
	O) Attach Scope to Rifle						9/3/91	RW
	P) Detach & Attach Scope 20 Times						9/3/91	RW
640	Gallery Target & Test						9-4-91	DH
	A) Time						9-4-91	DH
	B) Malfunctions						9-4-91	DH
	C) Pierced Primers						9-4-91	DH
	D) Optical Clarity of Scope						9-4-91	DH
645	Inspect for Live Ammo						9-4-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	260	266	254	255	261	9-6-91	SH
	C) Function						9-10-91	AC
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. 6636294

DATE 9-3-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.21	2.38	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.29	2.55	2.66	
PULL #3	2.19	2.24	2.29	2.54	
PULL #4	2.20	2.28	2.30	2.55	
PULL #5	2.35	2.30	2.33	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.22		
PULL #2	3.28	3.19		
PULL #3	3.23	3.24		
PULL #4	3.20	3.29		
PULL #5	3.28	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.41		4.39
PULL #2	4.42	4.36		4.40
PULL #3	4.25	4.46		4.44
PULL #4	4.40	4.44		4.48
PULL #5	4.41	4.48		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636294
4 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.368257
1 TO	2	.505641
1 TO	3	.331694
1 TO	4	.676114
1 TO	5	.215418

3
1 ←---FOR
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .085
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111784
THE AMR FOR THIS RIFLE IS: .9532

+ Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08836294

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.570

VS = 3.826

GS = 3.834

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.915	.873	.790
MINIMUM X	-.655	-.697	-.780
MAXIMUM Y	1.484	1.223	.648
MINIMUM Y	-2.342	-1.534	-1.381
CENTROID X	.363	.405	.488
CENTROID Y	-.862	.198	.045
POA TO CENTROID in.	.368	.450	.490
MIN RADIUS	.236	.205	.272
MEAN RADIUS	.983	.785	.699
MAX RADIUS	2.372	1.536	1.391
HORIZONTAL SPREAD	1.570	1.570	1.570
VERTICAL SPREAD	3.826	2.757	2.029
EXTREME SPREAD	3.834	2.817	2.118
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8536294

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 1.828

VS = 2.403

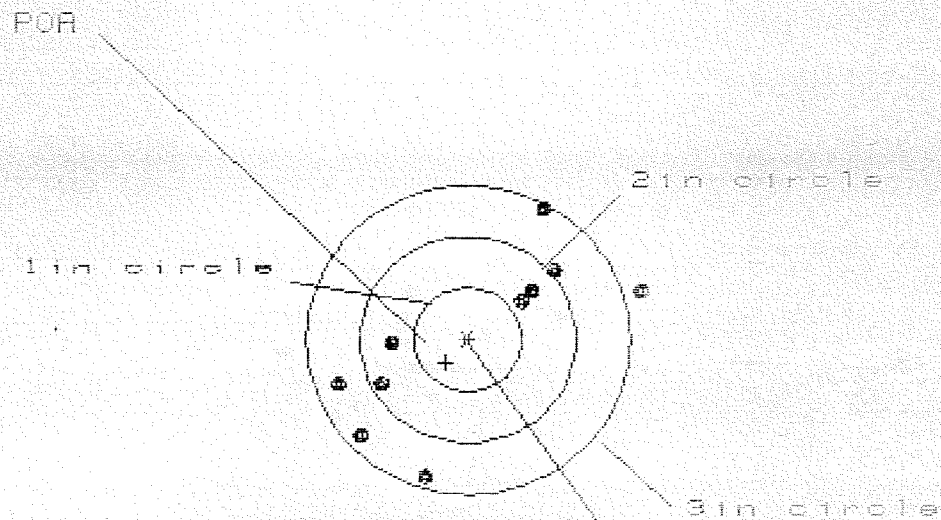
GS = 2.629

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.167	1.130	1.017
MINIMUM X	:	-.661	-.698	-.557
MAXIMUM Y	:	.902	.735	.591
MINIMUM Y	:	-1.501	-1.238	-1.382
CENTROID X	:	.011	.048	-.093
CENTROID Y	:	-.425	-.258	-.114
POA TO CENTROID in.	:	.425	.262	.147
MIN RADIUS	:	.475	.441	.259
MEAN RADIUS	:	.942	.835	.658
MAX RADIUS	:	1.538	1.616	1.401
HORIZONTAL SPREAD	:	1.828	1.828	1.574
VERTICAL SPREAD	:	2.403	1.973	1.973
EXTREME SPREAD	:	2.629	2.629	2.123
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636294

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.776

VS = 2.626

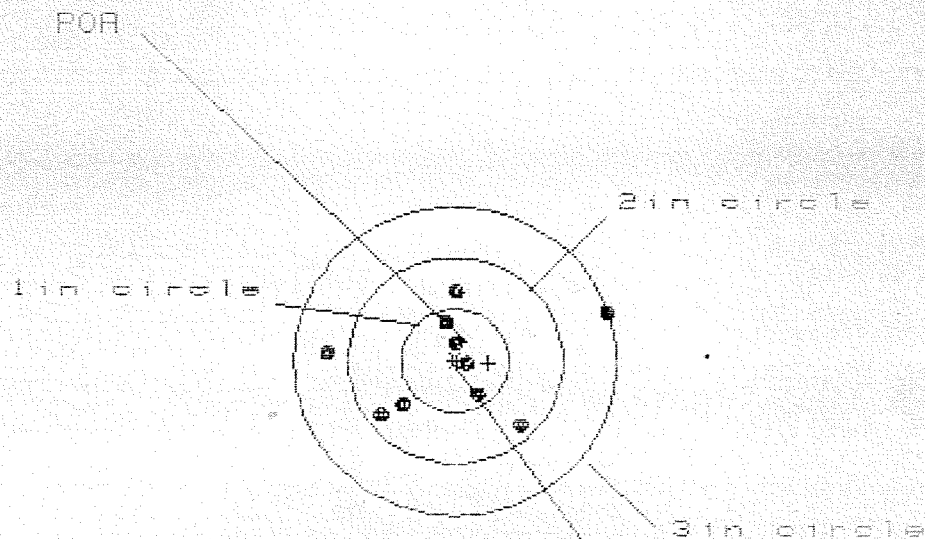
GS = 2.925

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.565
MINIMUM X	-1.211
MAXIMUM Y	1.272
MINIMUM Y	-1.354
CENTROID X	.202
CENTROID Y	.228
POA TO CENTROID in.	.305
MIN RADIUS	.581
MEAN RADIUS	1.114
MAX RADIUS	1.635
HORIZONTAL SPREAD	2.776
VERTICAL SPREAD	2.626
EXTREME SPREAD	2.925
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636294

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

CENTROID *

HS = 2.596

VS = 1.275

GS = 2.622

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.433
MINIMUM X	-1.163
MAXIMUM Y	.666
MINIMUM Y	-.609
CENTROID X	-.308
CENTROID Y	.021
POA TO CENTROID in.	.309
MIN RADIUS	.059
MEAN RADIUS	.665
MAX RADIUS	1.515
HORIZONTAL SPREAD	2.596
VERTICAL SPREAD	1.275
EXTREME SPREAD	2.622
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0636294

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.248

VS = 2.830

GS = 2.871

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.259	1.271	1.239
MINIMUM X	-.989	-.977	-1.009
MAXIMUM Y	1.140	.953	.760
MINIMUM Y	-1.690	-1.473	-.946
CENTROID X	.157	.145	.177
CENTROID Y	-.125	.062	.247
POA TO CENTROID in.	.201	.158	.304
MIN RADIUS	.440	.321	.243
MEAN RADIUS	1.062	.958	.867
MAX RADIUS	1.693	1.496	1.244
HORIZONTAL SPREAD	2.248	2.240	2.248
VERTICAL SPREAD	2.830	2.426	1.714
EXTREME SPREAD	2.871	2.577	2.253
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		