

C6636298

MODEL 700™ M24

Model **SMS**™

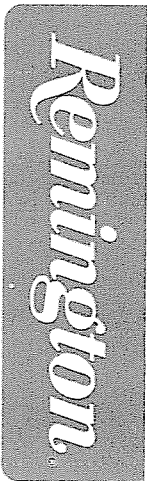
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

SERIAL NO.
C6606298

ORDER NO.
5716

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

20

UPC

0 47700 25716 7

5716 C6606298

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636298

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	GS
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL	7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-25-91	JH

op. #	BARBER - M24 0032755		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5	5	5			7-26-91	DH
	G) Safety Off Force		2 $\frac{3}{4}$	2 $\frac{1}{2}$	2 $\frac{1}{2}$			7-26-91	DH
	H) Trigger Pull Test & Retainability							7-25-91	JH
	I) Firing Pin Indent		.020	.020	.020			7-26-91	DH
	J) Assemble Stock							7/31/91	RW
	K) Assemble Swivel Studs							8-6-91	L
	L) Attach Front and Rear Sight Assemblies							7/31/91	RW
	M) Iron Sight Alignment							7/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container							7/31/91	RW
	O) Attach Scope to Rifle							7/31/91	RW
	P) Detach & Attach Scope 20 Times							7/31/91	RW
640	Gallery Target & Test							7-31-91	NF
	A) Time							"	NF
	B) Malfunctions							"	NF
	C) Pierced Primers							"	NF
	D) Optical Clarity of Scope							"	NF
645	Inspect for Live Ammo							7-31-91	NF
655	Final Inspection								
	A) Headspace							8-6-91	AC
	B) Trigger Pull		2.30	2.38	2.29	2.40	2.20	8-5-91	JH
	C) Function							8-6-91	AC
660	Pack							9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636298

DATE 7-25-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.54	2.40	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.47	2.44	2.38	
PULL #3	2.40	2.53	2.38	2.29	
PULL #4	2.41	2.44	2.44	2.40	
PULL #5	2.40	2.39	2.42	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.36		
PULL #2	3.39	3.33		
PULL #3	3.31	3.25		
PULL #4	3.31	3.40		
PULL #5	3.29	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.46		4.27
PULL #2	4.27	4.51		4.21
PULL #3	4.36	4.43		4.37
PULL #4	4.44	4.41		4.34
PULL #5	4.37	4.25		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636298
31 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.242012
1 TO	2	.210297
1 TO	3	.711765
1 TO	4	.386078
1 TO	5	.171012

3
45 <----POA

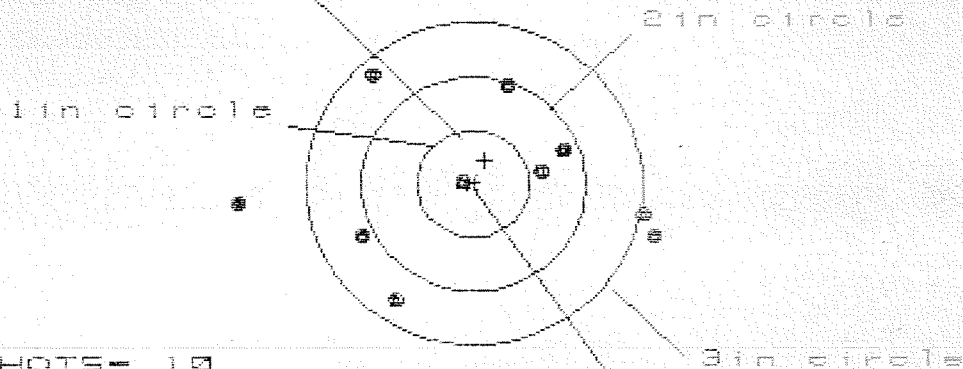
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0114
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0206349
THE AMR FOR THIS RIFLE IS: 1.117

31 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636298

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.620

VS = 2.145

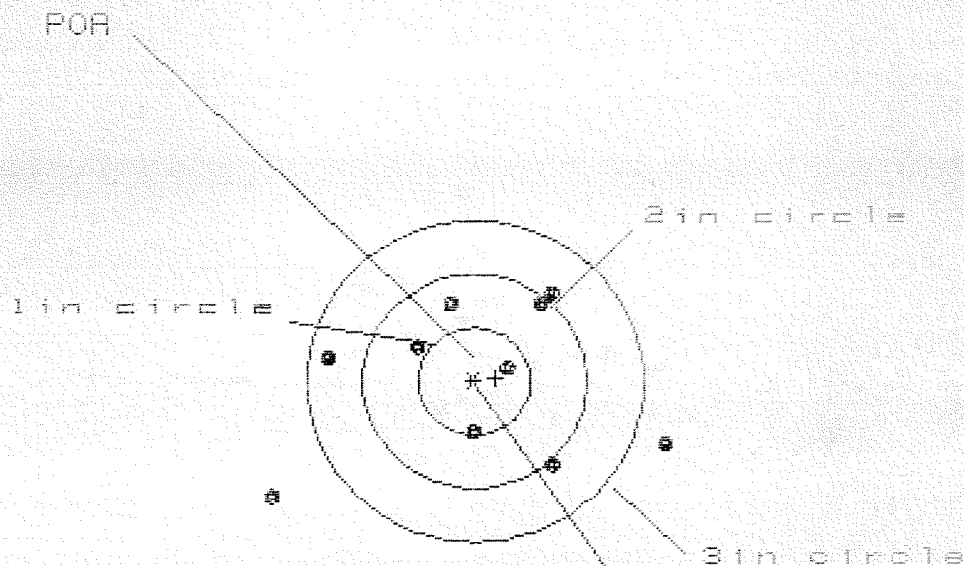
GS = 3.632

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.561	1.333	1.411
MINIMUM X	:	-2.059	-1.241	-1.075
MAXIMUM Y	:	1.067	1.049	.990
MINIMUM Y	:	-1.078	-1.096	-1.155
CENTROID X	:	-.103	.125	-.041
CENTROID Y	:	-.219	-.201	-.142
POA TO CENTROID in.	:	.242	.237	.147
MIN RADIUS	:	.117	.344	.187
MEAN RADIUS	:	1.157	1.034	.978
MAX RADIUS	:	2.065	1.531	1.455
HORIZONTAL SPREAD	:	3.620	2.574	2.486
VERTICAL SPREAD	:	2.145	2.145	2.145
EXTREME SPREAD	:	3.632	2.882	2.715
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.570

VS= 1.865

GS= 3.604

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.734	1.530	.681
MINIMUM X	-1.836	-1.553	-1.361
MAXIMUM Y	.786	.666	.578
MINIMUM Y	-1.079	-.854	-.942
CENTROID X	-.191	.013	-.179
CENTROID Y	-.028	.092	.180
POA TO CENTROID in.	.193	.093	.254
MIN RADIUS	.274	.073	.282
MEAN RADIUS	1.043	.882	.780
MAX RADIUS	2.130	1.684	1.361
HORIZONTAL SPREAD	3.570	3.093	2.042
VERTICAL SPREAD	1.865	1.520	1.520
EXTREME SPREAD	3.604	3.185	2.253
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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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 = 8

HS = 2.981

VS = 2.489

GS = 3.223

CENTROID *

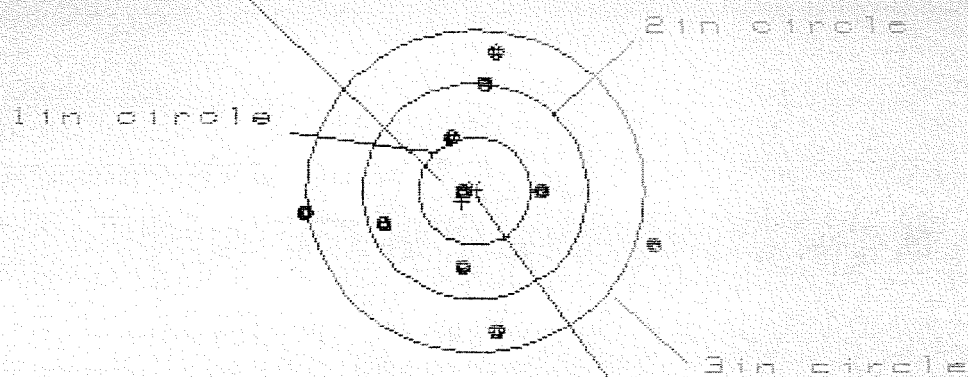
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.962	.957	.919
MINIMUM X	:	-1.020	-.802	-.840
MAXIMUM Y	:	1.409	1.449	1.037
MINIMUM Y	:	-1.080	-1.040	-.859
CENTROID X	:	.232	.015	.053
CENTROID Y	:	.409	.369	.188
POA TO CENTROID in.	:	.470	.369	.195
MIN RADIUS	:	.214	.359	.294
MEAN RADIUS	:	1.015	.887	.792
MAX RADIUS	:	1.994	1.481	1.288
HORIZONTAL SPREAD	:	2.981	1.759	1.759
VERTICAL SPREAD	:	2.489	2.489	1.896
EXTREME SPREAD	:	3.223	2.521	2.422
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 3.087

VS = 2.671

GS = 3.086

CENTROID #

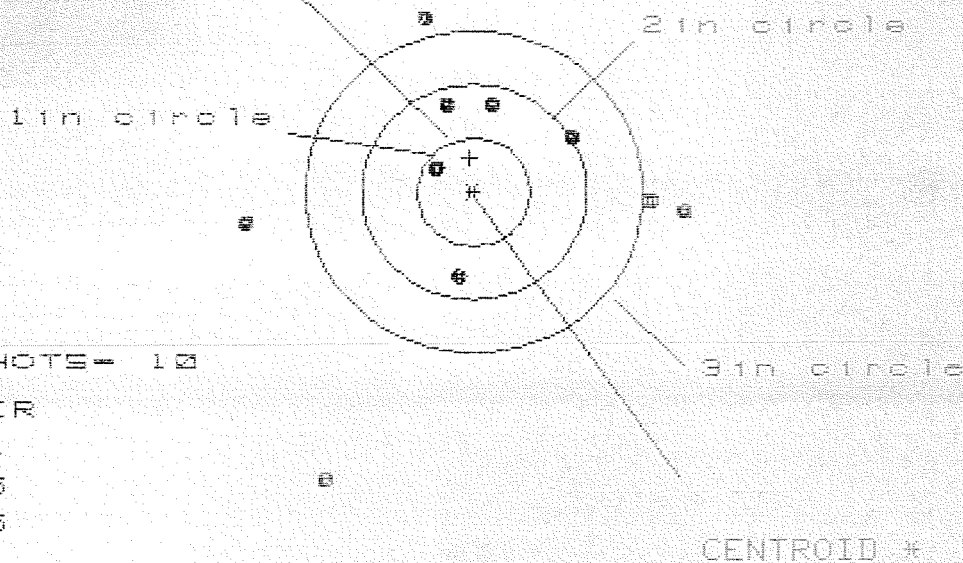
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.588	.779	.614
MINIMUM X	-1.499	-1.323	-.812
MAXIMUM Y	1.341	1.291	1.258
MINIMUM Y	-1.330	-1.380	-1.413
CENTROID X	.113	-.063	.102
CENTROID Y	.101	.151	.184
POA TO CENTROID in.	.152	.164	.210
MIN RADIUS	.100	.084	.095
MEAN RADIUS	.963	.873	.801
MAX RADIUS	1.651	1.433	1.430
HORIZONTAL SPREAD	3.087	2.102	1.426
VERTICAL SPREAD	2.671	2.671	2.671
EXTREME SPREAD	3.096	2.672	2.672
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 5

HS = 3.910

VS = 4.373

GS = 4.472

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.900	1.747	1.477
MINIMUM X	-2.010	-2.163	-0.861
MAXIMUM Y	1.655	1.353	1.282
MINIMUM Y	-2.718	-1.081	-1.152
CENTROID X	.035	.188	.458
CENTROID Y	-.320	-.018	.053
POA TO CENTROID in.	.322	.189	.461
MIN RADIUS	.370	.488	.429
MEAN RADIUS	1.409	1.163	1.016
MAX RADIUS	3.045	2.236	1.573
HORIZONTAL SPREAD	3.910	3.910	2.338
VERTICAL SPREAD	4.373	2.434	2.434
EXTREME SPREAD	4.472	3.911	2.965
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	5		