

05636310

MODEL 700™ M24

Model SMS™

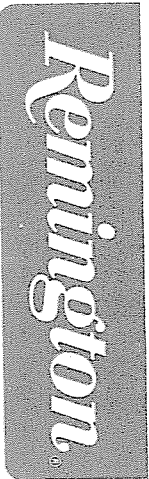
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington®

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

DUPONT

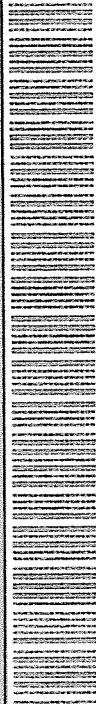
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6606310

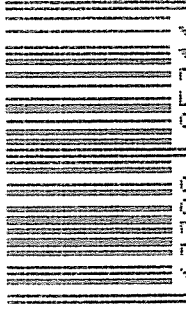
ORDER NO.
5716

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



5716 C6606310

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636310

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KH
600	Proof		6/25/91	KH
607	Check Headspace		6/25/91	KH
610	Dis-assemble Gun		6/25/91	KH
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	SS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-30-91	SS

op. #	BARBER - M24 0032891 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-31-91	DH
	G) Safety Off Force	4	4	4			7-31-91	DH
	H) Trigger Pull Test & Retainability						7-30-91	JD
	I) Firing Pin Indent	.021	.022	.022			7-31-91	DH
	J) Assemble Stock						8/1/91	KR
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/1/91	KR
	M) Iron Sight Alignment						8/1/91	KR
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	KR
	O) Attach Scope to Rifle						8/1/91	KR
	P) Detach & Attach Scope 20 Times						8/1/91	KR
640	Gallery Target & Test						8-2-91	DH
	A) Time						8-2-91	DH
	B) Malfunctions						8-2-91	DH
	C) Pierced Primers						8-2-91	DH
	D) Optical Clarity of Scope						8-2-91	DH
645	Inspect for Live Ammo						8-2-91	DH
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.55	2.60	2.61	2.56	2.63	8-5-91	JD
	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-6636310DATE 7-30-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.53	2.44	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.55	2.40	2.60	
PULL #3	2.50	2.51	2.50	2.61	
PULL #4	2.52	2.53	2.44	2.56	
PULL #5	2.53	2.41	2.39	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.42		
PULL #2	3.40	3.28		
PULL #3	3.45	3.18		
PULL #4	3.48	3.51		
PULL #5	3.39	3.43		
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	4.24		4.26
PULL #2	4.28	4.35		4.23
PULL #3	4.22	4.28		4.23
PULL #4	4.20	4.22		4.27
PULL #5	4.21	4.32		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636310
2 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.160253
1 TO 2	.47284
1 TO 3	.353135
1 TO 4	.523399
1 TO 5	.697155

52
3H <----POR

COORDINATE FOR THIS RIFLE IS: -.179
COORDINATE FOR THIS RIFLE IS: .2086
AVERAGE POI RADIUS FOR THIS RIFLE IS: .274873
SOLVE IT: .8934

FILE:/PATTERNING/CENTERFIRE_PATT/C6636310

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 9

3 in = 9

HS= 2.935

VS= 1.755

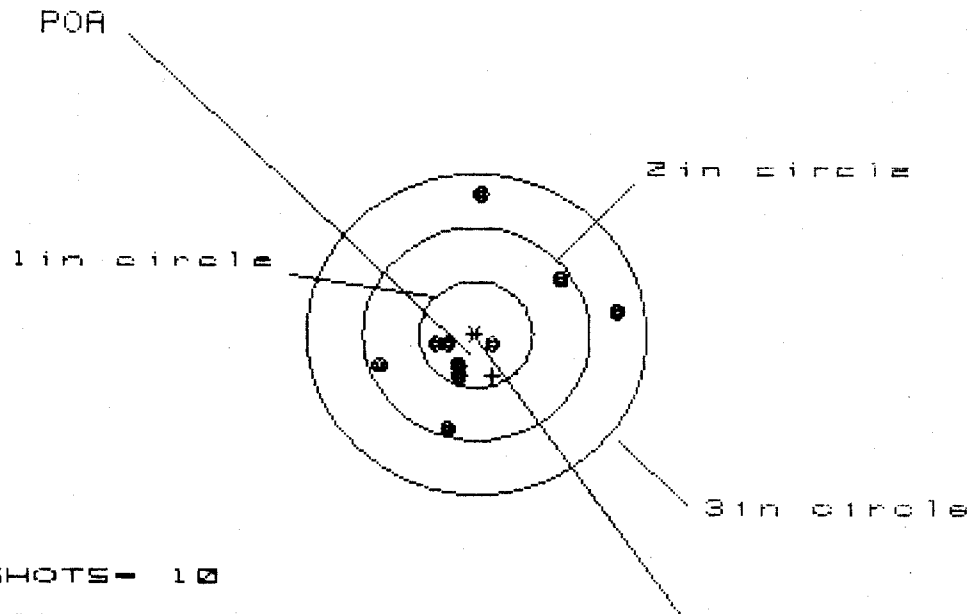
GS= 3.127

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.945	.723	.792
MINIMUM X	:	-1.991	-.665	-.596
MAXIMUM Y	:	.911	.817	.880
MINIMUM Y	:	-.844	-.770	-.707
CENTROID X	:	.159	.381	.312
CENTROID Y	:	.020	.114	.051
POA TO CENTROID in.	:	.161	.397	.316
MIN RADIUS	:	.165	.247	.163
MEAN RADIUS	:	.846	.685	.664
MAX RADIUS	:	2.163	.837	.886
HORIZONTAL SPREAD	:	2.936	1.388	1.388
VERTICAL SPREAD	:	1.755	1.587	1.587
EXTREME SPREAD	:	3.127	1.617	1.617
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636310

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS = 2.104

VS = 2.147

GS = 2.178

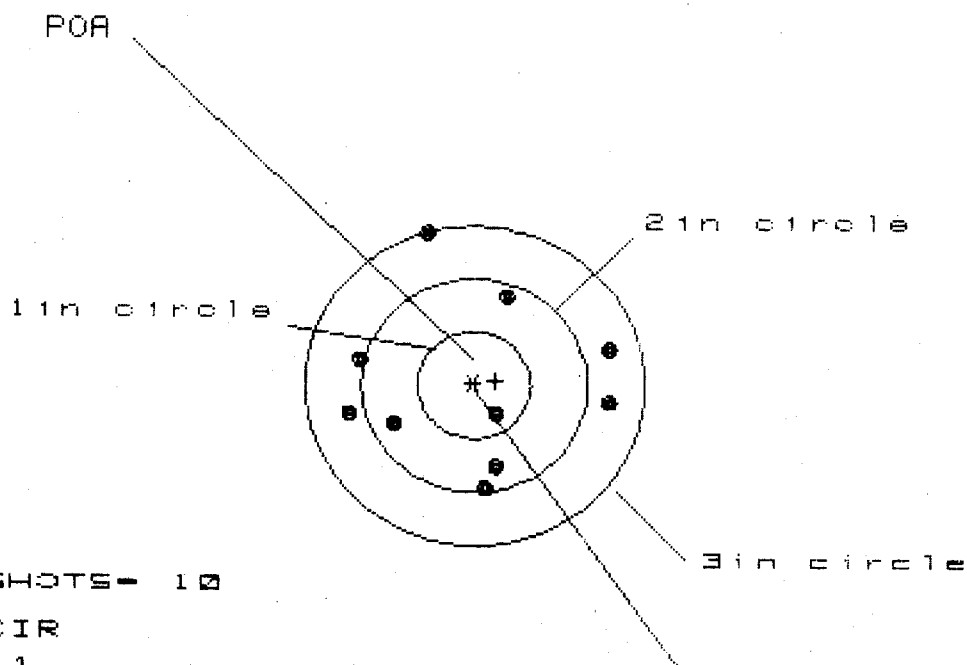
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.259	1.267	.883
MINIMUM X	:	-.845	-.837	-.679
MAXIMUM Y	:	1.295	.672	.715
MINIMUM Y	:	-.852	-.708	-.665
CENTROID X	:	-.144	-.152	-.310
CENTROID Y	:	.383	.239	.196
POA TO CENTROID in.	:	.409	.283	.367
MIN RADIUS	:	.149	.163	.059
MEAN RADIUS	:	.685	.587	.442
MAX RADIUS	:	1.297	1.313	1.136
HORIZONTAL SPREAD	:	2.104	2.104	1.562
VERTICAL SPREAD	:	2.147	1.380	1.380
EXTREME SPREAD	:	2.178	2.164	1.770
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636310

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.271

VS= 2.424

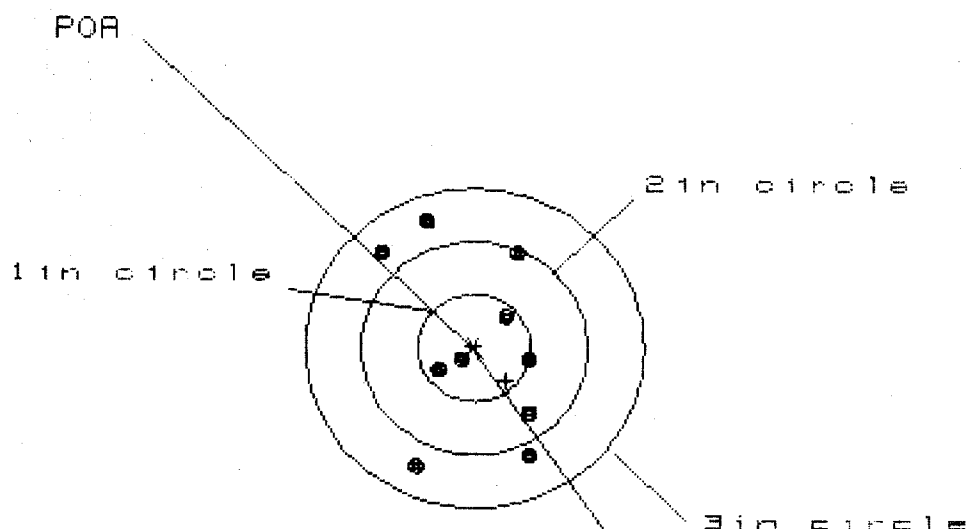
GS= 2.476

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.201	1.159	1.303
MINIMUM X	:	-1.070	-1.112	-.968
MAXIMUM Y	:	1.433	.951	1.010
MINIMUM Y	:	-.991	-.832	-.772
CENTROID X	:	-.189	-.147	-.291
CENTROID Y	:	-.040	-.199	-.258
POA TO CENTROID in.	:	.193	.247	.389
MIN RADIUS	:	.265	.119	.245
MEAN RADIUS	:	.975	.887	.832
MAX RADIUS	:	1.482	1.251	1.303
HORIZONTAL SPREAD	:	2.271	2.271	2.271
VERTICAL SPREAD	:	2.424	1.783	1.783
EXTREME SPREAD	:	2.476	2.333	2.271
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636310

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in = 10

HS= 1.360

VS= 2.294

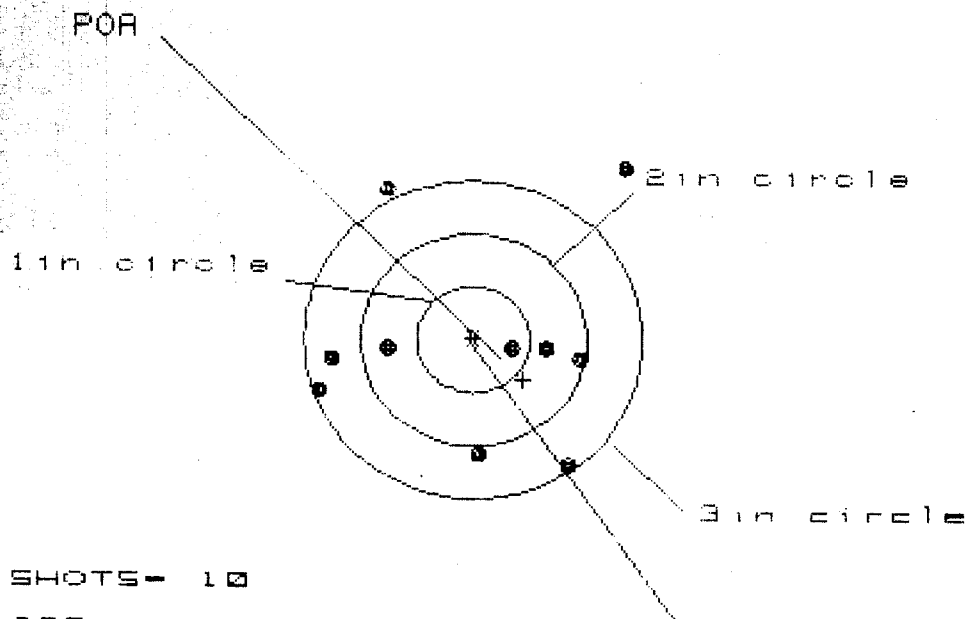
GS= 2.374

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.526	.485	.416
MINIMUM X	:	-.834	-.875	-.944
MAXIMUM Y	:	1.189	.988	.866
MINIMUM Y	:	-1.105	-.973	-1.026
CENTROID X	:	-.280	-.239	-.170
CENTROID Y	:	.305	.173	.295
POA TO CENTROID in.	:	.415	.295	.340
MIN RADIUS	:	.172	.120	.236
MEAN RADIUS	:	.794	.725	.676
MAX RADIUS	:	1.246	1.320	1.281
HORIZONTAL SPREAD	:	1.360	1.360	1.360
VERTICAL SPREAD	:	2.294	1.961	1.892
EXTREME SPREAD	:	2.374	2.288	2.288
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636310

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 4

3 in - 8

HS - 2.717

VS - 2.785

GS - 3.427

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.385	1.075	.993
MINIMUM X	:	-1.332	-1.178	-1.260
MAXIMUM Y	:	1.654	1.645	.357
MINIMUM Y	:	-1.131	-.948	-.742
CENTROID X	:	-.441	-.595	-.513
CENTROID Y	:	.375	.192	-.014
POA TO CENTROID in.	:	.579	.625	.514
MIN RADIUS	:	.337	.511	.539
MEAN RADIUS	:	1.167	1.043	.932
MAX RADIUS	:	2.157	1.770	1.260
HORIZONTAL SPREAD	:	2.717	2.253	2.253
VERTICAL SPREAD	:	2.785	2.593	1.099
EXTREME SPREAD	:	3.427	3.079	2.332
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		