

C6636315

MODEL 700™ M24

Model **SMS**™

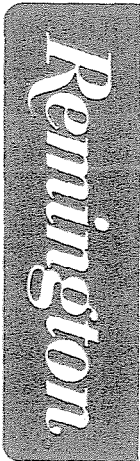
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

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

MODEL 700TM M24

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

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

SERIAL NO.
C6636315

ORDER NO.
5716

06

5716 C6636315

LPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636315

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	PA
	Apply Coating (Bolt)			P
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JH

op. #	BARBER/M24 0032948	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6-4-91	gll
	G) Safety Off Force	4	4	4			6-4-91	gll
	H) Trigger Pull Test & Retainability						6-4-91	gll
	I) Firing Pin Indent	1022	10215	10215			6-4-91	gll
	J) Assemble Stock						6/5/91	Rw
	K) Assemble Swivel Studs						6-14-91	gll
	L) Attach Front and Rear Sight Assemblies						6/5/91	Rw
	M) Iron Sight Alignment						6/5/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	Rw
	O) Attach Scope to Rifle						6/5/91	Rw
	P) Detach & Attach Scope 20 Times						6/5/91	Rw
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection							
	A) Headspace						6-14-91	gll
	B) Trigger Pull	2.43	2.39	2.40	2.39	2.43	6-13-91	gll
	C) Function						6-14-91	gll
660	Pack						6-20-91	DH

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

SERIAL NO. C-6636315
DATE 6-4-91
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.45	2.51	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.45	2.50	2.39	
PULL #3	2.56	2.46	2.48	2.40	
PULL #4	2.56	2.45	2.46	2.39	
PULL #5	2.30	2.49	2.53	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.52		
PULL #2	3.55	3.54		
PULL #3	3.54	3.50		
PULL #4	3.49	3.55		
PULL #5	3.58	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.25		4.31
PULL #2	4.36	4.18		4.28
PULL #3	4.32	4.35		4.28
PULL #4	4.43	4.21		4.28
PULL #5	4.36	4.29		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636315
6 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.474377
1 TO	2	.593918
1 TO	3	.511945
1 TO	4	.869143
1 TO	5	.700446

$\frac{1}{4^2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0632
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124615

THE AMR FOR THIS RIFLE IS: .8356

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C863B315

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.573

VS= 2.183

GS= 2.219

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.828	.876	.682
MINIMUM X	-.745	-.697	-.587
MAXIMUM Y	1.437	.722	.648
MINIMUM Y	-.746	-.586	-.525
CENTROID X	.365	.317	.207
CENTROID Y	.303	.143	.217
POA TO CENTROID in.	.474	.348	.300
MIN RADIUS	.252	.141	.136
MEAN RADIUS	.703	.566	.510
MAX RADIUS	1.500	1.054	.860
HORIZONTAL SPREAD	1.573	1.573	1.269
VERTICAL SPREAD	2.183	1.308	1.173
EXTREME SPREAD	2.219	2.009	1.689
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636315

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.432

VS= 1.609

GS= 2.601

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.293
MINIMUM X	:	-1.139
MAXIMUM Y	:	.613
MINIMUM Y	:	-.996
CENTROID X	:	.332
CENTROID Y	:	-.290
POR TO CENTROID in.	:	.441
MIN RADIUS	:	.161
MEAN RADIUS	:	.759
MAX RADIUS	:	1.350
HORIZONTAL SPREAD	:	2.432
VERTICAL SPREAD	:	1.609
EXTREME SPREAD	:	2.601
NUMBER IN ONE INCH CIRCLE	:	3
NUMBER IN TWO INCH CIRCLE	:	7
NUMBER IN THREE INCH CIRCLE	:	10

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B315

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 9

HS= 3.010

VS= 1.104

GS= 3.012

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.959	1.483	.805
MINIMUM X	-1.051	-.834	-.648
MAXIMUM Y	.569	.553	.522
MINIMUM Y	-.535	-.551	-.582
CENTROID X	.003	-.214	-.400
CENTROID Y	-.059	-.043	-.012
POA TO CENTROID in.	.059	.219	.400
MIN RADIUS	.508	.338	.204
MEAN RADIUS	.860	.661	.487
MAX RADIUS	1.964	1.505	.959
HORIZONTAL SPREAD	3.010	2.317	1.453
VERTICAL SPREAD	1.104	1.104	1.104
EXTREME SPREAD	3.012	2.317	1.668
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636315

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.033

VS= 2.541

GS= 2.738

PATTERN #	:	4
SHOTS (BEST OF)	:	10 9 8
MAXIMUM X	:	.895 .931 .877
MINIMUM X	:	-1.138 -1.152 -1.042
MAXIMUM Y	:	1.537 .816 .712
MINIMUM Y	:	-1.004 -.833 -.807
CENTROID X	:	-.284 -.190 -.300
CENTROID Y	:	-.354 -.525 -.421
POA TO CENTROID in.	:	.409 .558 .517
MIN RADIUS	:	.076 .229 .192
MEAN RADIUS	:	.821 .752 .670
MAX RADIUS	:	1.542 1.212 1.048
HORIZONTAL SPREAD	:	2.033 2.033 1.919
VERTICAL SPREAD	:	2.541 1.649 1.519
EXTREME SPREAD	:	2.738 2.195 1.924
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

8 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636315

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.641

VS= 3.579

GS= 3.937

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.970
MINIMUM X	-.671
MAXIMUM Y	1.637
MINIMUM Y	-1.942
CENTROID X	-.180
CENTROID Y	-.137
POA TO CENTROID in.	.226
MIN RADIUS	.441
MEAN RADIUS	1.037
MAX RADIUS	2.055
HORIZONTAL SPREAD	1.641
VERTICAL SPREAD	3.579
EXTREME SPREAD	3.937
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8