

C6636336

MODEL 780™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

1111 2

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

Remington®

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

DUPONT

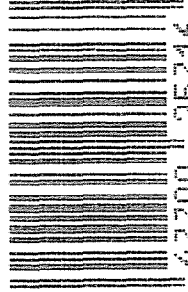
MODEL 700TH M24

SERIAL NO.
C6606036

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 2



5716 C6606036

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636336

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	LS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 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		8-7-91	DH

BARBER - M24 0033190

BARBER - M24 0033190							DATE	INIT
op. #	OP. NAME	READINGS						
625 cont.	F) Safety On Force	7	7	7			8-7-91	AC
	G) Safety Off Force	4	4	4			8-7-91	AC
	H) Trigger Pull Test & Retainability						8-7-91	DH
	I) Firing Pin Indent	.021	.021	.022			8-7-91	AC
	J) Assemble Stock						8/8/91	RW
	K) Assemble Swivel Studs						8-10-91	DH
	L) Attach Front and Rear Sight Assemblies						8/8/91	RW
	M) Iron Sight Alignment						8/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/8/91	RW
	O) Attach Scope to Rifle						8/8/91	RW
	P) Detach & Attach Scope 20 Times						8/8/91	RW
640	Gallery Target & Test						8-9-91	DH
	A) Time						8-9-91	DH
	B) Malfunctions						8-9-91	DH
	C) Pierced Primers						8-9-91	DH
	D) Optical Clarity of Scope						8-9-91	DH
645	Inspect for Live Ammo						8-9-91	DH
655	Final Inspection							
	A) Headspace						8-10-91	DH
	B) Trigger Pull	2.50	2.48	2.54	2.53	2.60	8-10-91	GU
	C) Function						8-10-91	DH
660	Pack						7-17-91	DH

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C663633CDATE 8-7-91TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.30	2.51	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.20	2.58	2.48	
PULL #3	2.35	2.31	2.54	2.54	
PULL #4	2.28	2.33	2.50	2.53	
PULL #5	2.30	2.35	2.56	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.35		
PULL #2	3.30	3.44		
PULL #3	3.37	3.43		
PULL #4	3.42	3.45		
PULL #5	3.49	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.40		4.62
PULL #2	4.57	4.67		4.59
PULL #3	4.48	4.65		4.30
PULL #4	4.46	4.55		4.45
PULL #5	4.48	4.60		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636336
9 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.394001
1 TO	2	.440274
1 TO	3	.653478
1 TO	4	.343908
1 TO	5	.403194

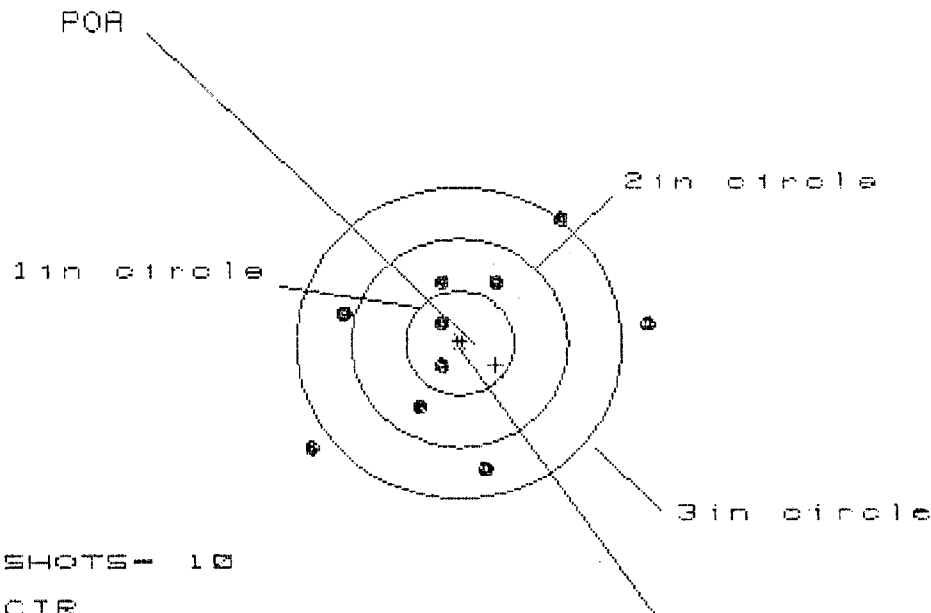
$\frac{1}{2} \frac{4}{3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2358
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.115
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .262349
THE AMR FOR THIS RIFLE IS: 1.012

9 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636336

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.124

VS = 2.355

GS = 3.331

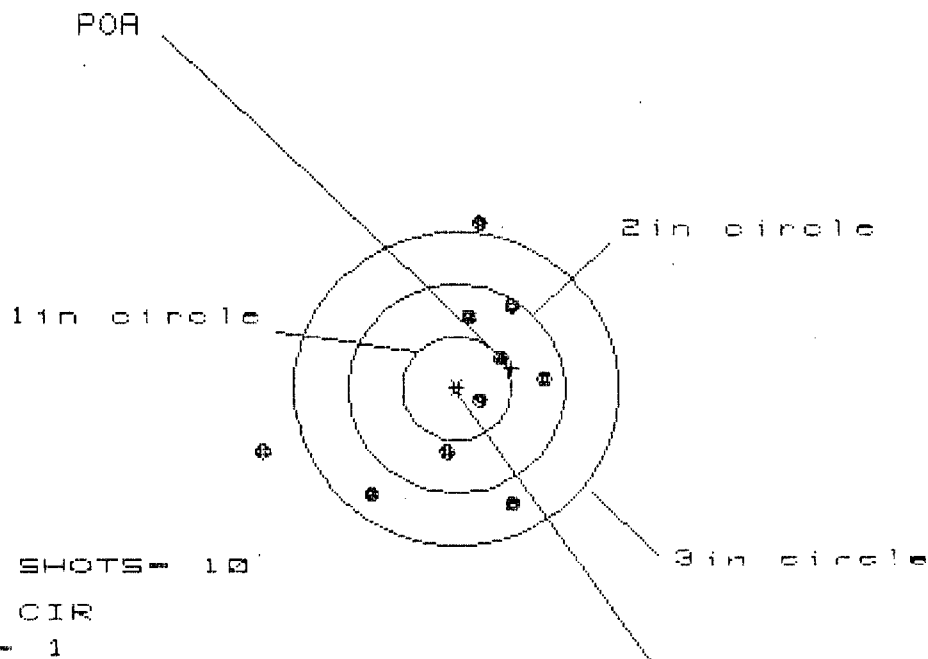
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.735	1.162	1.013
MINIMUM X	-1.389	-1.196	-1.071
MAXIMUM Y	1.170	1.189	1.068
MINIMUM Y	-1.185	-1.166	-1.287
CENTROID X	-.334	-.527	-.378
CENTROID Y	.209	.190	.311
POA TO CENTROID in.	.394	.560	.489
MIN RADIUS	.200	.177	.097
MEAN RADIUS	.980	.873	.777
MAX RADIUS	1.744	1.663	1.472
HORIZONTAL SPREAD	3.124	2.358	2.084
VERTICAL SPREAD	2.355	2.355	2.355
EXTREME SPREAD	3.331	3.194	2.464
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

9 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.592

VS = 2.622

GS = 2.956

CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.765	.562	.556
MINIMUM X	-1.827	-1.011	-1.016
MAXIMUM Y	1.562	1.493	.944
MINIMUM Y	-1.060	-1.129	-.943
CENTROID X	-.509	-.306	-.300
CENTROID Y	-.195	-.126	-.312
POA TO CENTROID in.	.545	.331	.433
MIN RADIUS	.250	.191	.011
MEAN RADIUS	.984	.827	.730
MAX RADIUS	1.931	1.509	1.380
HORIZONTAL SPREAD	2.592	1.573	1.573
VERTICAL SPREAD	2.622	2.622	1.887
EXTREME SPREAD	2.956	2.787	2.320
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

9 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.755

VS = 1.880

GS = 2.283

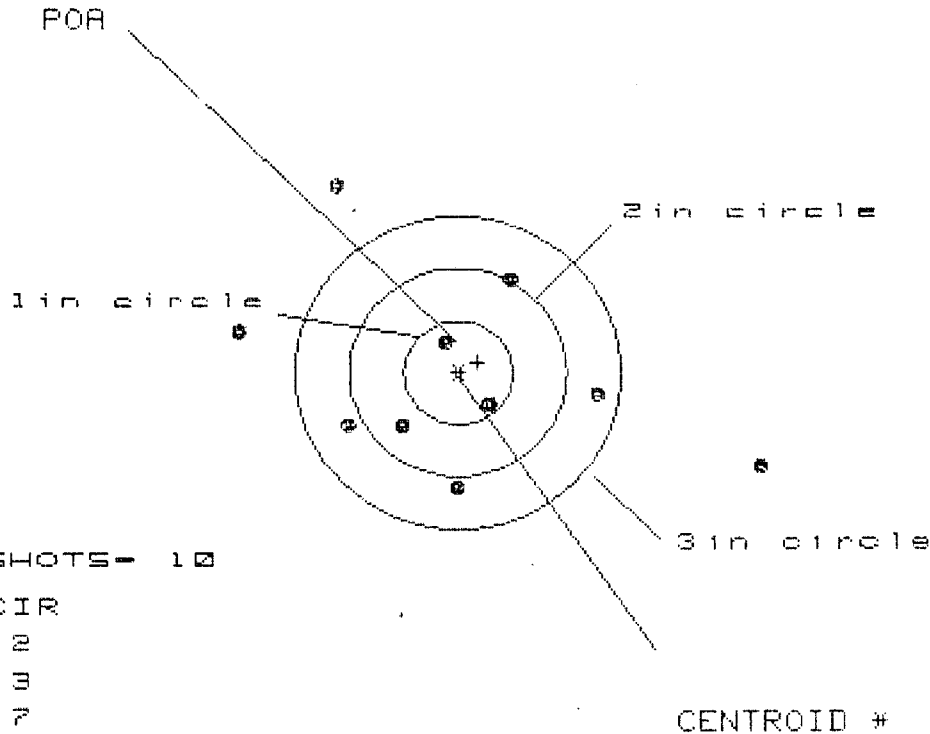
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.027	1.134	.625
MINIMUM X	-.728	-.621	-.479
MAXIMUM Y	.913	.805	.830
MINIMUM Y	-.967	-.726	-.701
CENTROID X	-.087	-.194	-.336
CENTROID Y	-.396	-.288	-.313
POA TO CENTROID in.	.405	.347	.459
MIN RADIUS	.151	.142	.150
MEAN RADIUS	.733	.647	.569
MAX RADIUS	1.366	1.151	.834
HORIZONTAL SPREAD	1.755	1.755	1.104
VERTICAL SPREAD	1.880	1.531	1.531
EXTREME SPREAD	2.283	1.931	1.568
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

9 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

IS = 4.846

VS = 2.856

GS = 5.039

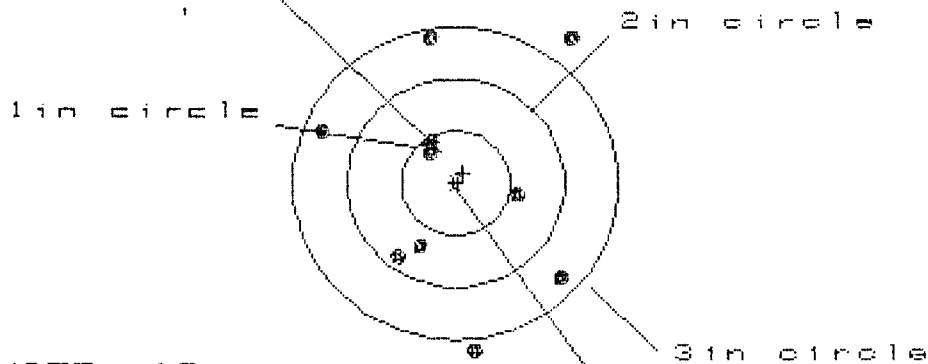
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.801	1.582	1.475
MINIMUM X	-2.045	-1.733	-1.840
MAXIMUM Y	1.802	1.698	1.047
MINIMUM Y	-1.054	-1.158	-0.946
CENTROID X	-0.181	-0.492	-0.385
CENTROID Y	-0.099	0.005	-0.207
POA TO CENTROID in.	0.206	0.492	0.437
MIN RADIUS	0.362	0.308	0.459
MEAN RADIUS	1.322	1.136	1.001
MAX RADIUS	2.954	1.901	1.922
HORIZONTAL SPREAD	4.846	3.315	3.315
VERTICAL SPREAD	2.856	2.856	1.993
EXTREME SPREAD	5.039	3.387	3.387
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

9 Aug 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.299

VS= 2.958

GS= 3.086

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	1.121	1.156
MINIMUM X	-1.259	-1.144	-1.109
MAXIMUM Y	1.373	1.514	1.335
MINIMUM Y	-1.585	-1.432	-0.922
CENTROID X	-0.068	-0.183	-0.218
CENTROID Y	-0.094	-0.247	-0.068
POA TO CENTROID in.	.116	.308	.228
MIN RADIUS	.345	.422	.241
MEAN RADIUS	1.040	.950	.864
MAX RADIUS	1.723	1.518	1.478
HORIZONTAL SPREAD	2.299	2.265	2.265
VERTICAL SPREAD	2.958	2.946	2.257
EXTREME SPREAD	3.086	2.972	2.664
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		