

C6636337

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.

MODEL 700TM M24

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

SERIAL NO. C6636337

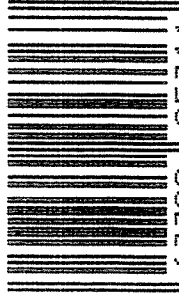
ORDER NO. 5716

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

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636337

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		GR
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		46
620	Apply Coatings (Barrel Action)		5/29/91	JA
	Apply Coating (Bolt)		5/29/91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/3/91	JH

op. #	BARBER - M24 0033201	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6/3/91	JH
	G) Safety Off Force	4	4	4			6/3/91	JH
	H) Trigger Pull Test & Retainability						6-3-91	JH
	I) Firing Pin Indent	.020	.020	.020			6/3/91	JH
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						6-5-91	A
	A) Time						6-5-91	A
	B) Malfunctions						6-5-91	A
	C) Pierced Primers						6-5-91	A
	D) Optical Clarity of Scope						6-5-91	A
645	Inspect for Live Ammo						6-5-91	A
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.26	2.27	2.19	2.31	2.65	6-8-91	JH
	C) Function						6-8-91	DH
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636337DATE 6-3-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.27	2.26	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.30	2.24	2.27	
PULL #3	2.30	2.28	2.35	2.19	
PULL #4	2.30	2.32	2.36	2.31	
PULL #5	2.27	2.28	2.26	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.15		
PULL #2	3.31	3.18		
PULL #3	3.30	3.26		
PULL #4	3.23	3.26		
PULL #5	3.28	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.34		4.34
PULL #2	4.26	4.41		4.35
PULL #3	4.31	4.31		4.35
PULL #4	4.30	4.30		4.38
PULL #5	4.32	4.37		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636337
5 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.132231
1 TO 2	.19244
1 TO 3	.399152
1 TO 4	.447404
1 TO 5	.299506

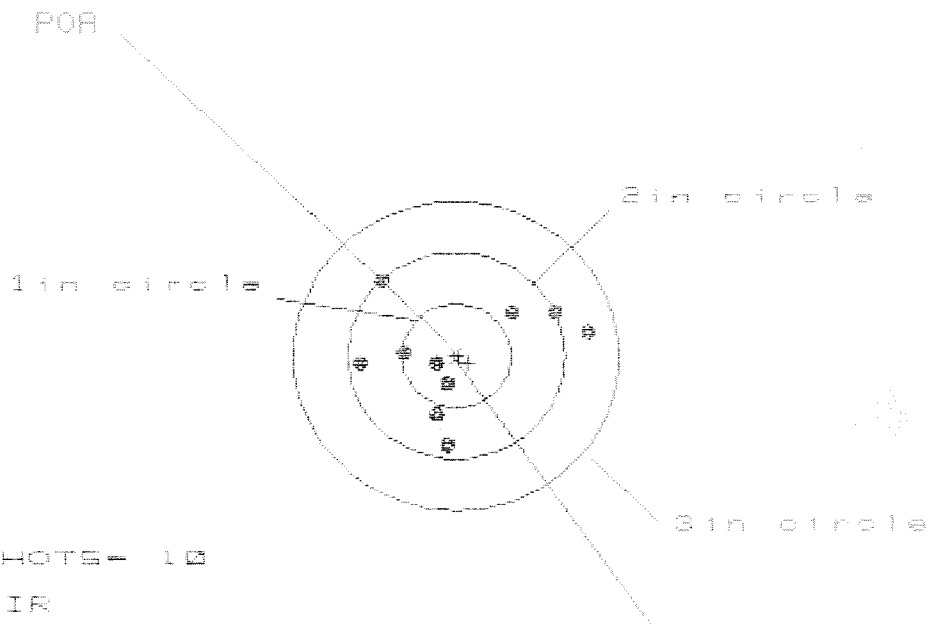
3
4 $\frac{3}{4}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0218
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0394
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .6450289
THE AMR FOR THIS RIFLE IS: .9988

5 Jun 1931

FILE:/PATTERNING/CENTERFIRE_PATT/08636337

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 2.120

VS = 1.526

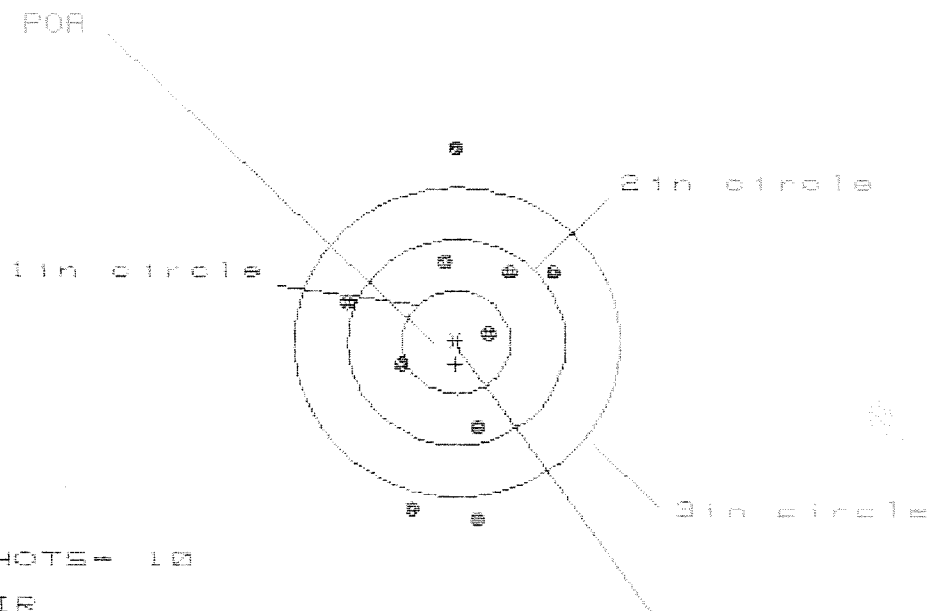
GS = 2.146

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.250	1.039	.970
MINIMUM X	-.870	-.731	-.600
MAXIMUM Y	.706	.731	.563
MINIMUM Y	-.820	-.795	-.704
CENTROID X	-.114	-.253	-.183
CENTROID Y	.067	.042	-.049
POA TO CENTROID in.	.132	.256	.190
MIN RADIUS	.222	.082	.153
MEAN RADIUS	.720	.617	.575
MAX RADIUS	1.269	1.127	1.104
HORIZONTAL SPREAD	2.120	1.770	1.770
VERTICAL SPREAD	1.526	1.526	1.267
EXTREME SPREAD	2.146	1.847	1.847
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

5 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 1.848

VS= 3.615

GS= 3.624

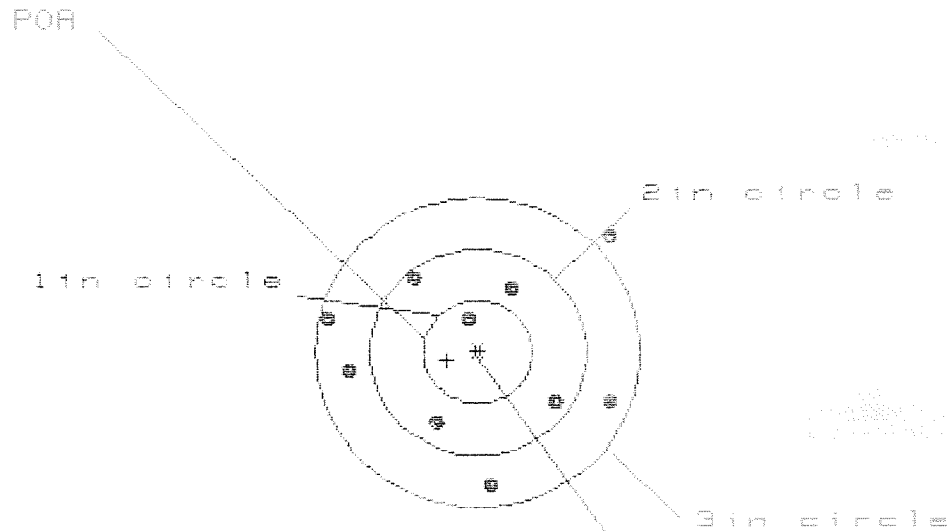
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.650	.848	.875
MINIMUM X	-.998	-1.000	-.973
MAXIMUM Y	1.874	1.958	.766
MINIMUM Y	-1.741	-1.532	-1.548
CENTROID X	.009	.011	-.016
CENTROID Y	.215	.006	.198
POR TO CENTROID in.	.215	.013	.199
MIN RADIUS	.258	.357	.286
MEAN RADIUS	1.071	.988	.888
MAX RADIUS	1.874	1.548	1.589
HORIZONTAL SPREAD	1.848	1.848	1.848
VERTICAL SPREAD	3.615	2.490	2.314
EXTREME SPREAD	3.624	2.532	2.532
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	4		

5 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.652

VS= 2.379

GS= 2.776

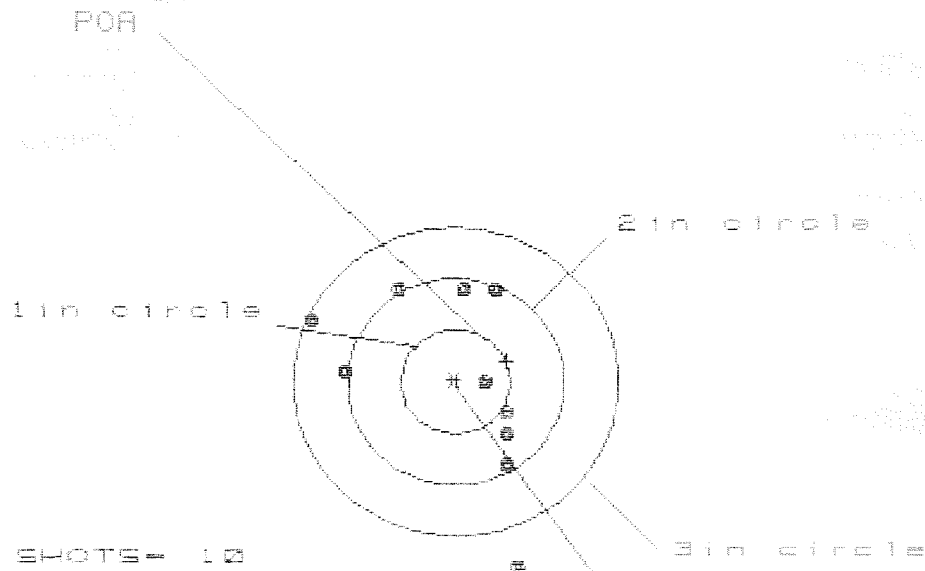
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.221	1.357	1.195
MINIMUM X	-1.430	-1.295	-1.261
MAXIMUM Y	1.129	.806	.859
MINIMUM Y	-1.250	-1.125	-1.072
CENTROID X	.285	.150	.312
CENTROID Y	.078	-.047	-.100
POA TO CENTROID in.	.295	.158	.328
MIN RADIUS	.307	.442	.487
MEAN RADIUS	1.045	.974	.918
MAX RADIUS	1.659	1.400	1.262
HORIZONTAL SPREAD	2.652	2.652	2.456
VERTICAL SPREAD	2.379	1.931	1.931
EXTREME SPREAD	2.776	2.759	2.479
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.934

VS= 2.742

GS= 3.054

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.613	.579	.422
MINIMUM X	-1.321	-1.253	-1.127
MAXIMUM Y	.936	.736	.780
MINIMUM Y	-1.806	-1.022	-.978
CENTROID X	-.473	-.541	-.384
CENTROID Y	-.200	.000	-.044
POA TO CENTROID in.	.513	.541	.387
MIN RADIUS	.321	.416	.255
MEAN RADIUS	.992	.882	.798
MAX RADIUS	1.907	1.303	1.128
HORIZONTAL SPREAD	1.934	1.832	1.549
VERTICAL SPREAD	2.742	1.758	1.758
EXTREME SPREAD	3.054	2.256	1.947
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

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CENTERFIRE PATTERNS

5

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.516

VS = 1.945

GS = 3.778

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.542
MINIMUM X	-1.974
MAXIMUM Y	.987
MINIMUM Y	-1.038
CENTROID X	.184
CENTROID Y	.037
POB TO CENTROID in.	.187
MIN RADIUS	.388
MEAN RADIUS	1.166
MAX RADIUS	2.108
HORIZONTAL SPREAD	3.516
VERTICAL SPREAD	1.945
EXTREME SPREAD	3.779
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	7