

C6648931

MODEL 706™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

DU PONT

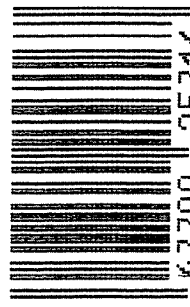
SERIAL NO. C6648931	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6648931

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *PC6648931*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	 7 2 9 1		Rw
600	Proof	7 2 9 1		Rw
607	Check Headspace	7 2 9 1		Rw
610	Dis-assemble Gun	7 2 9 1		Rw
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/29/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/29/91	Rw
	D) Oil Firing Pin Ass'y		8/29/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/91	JS

op. #	BARBER M24 0033467	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	JP
	G) Safety Off Force	3	3	3			9/11/91	JP
	H) Trigger Pull Test & Retainability						9/11/91	JP
	I) Firing Pin Indent	.0215	.023	.023			9/11/91	JP
	J) Assemble Stock						9/12/91	JP
	K) Assemble Swivel Studs						9/13/91	JP
	L) Attach Front and Rear Sight Assemblies						9/12/91	JP
	M) Iron Sight Alignment						9/12/91	JP
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	JP
	O) Attach Scope to Rifle						9/12/91	JP
	P) Detach & Attach Scope 20 Times						9/12/91	JP
640	Gallery Target & Test						9-12-91	JP
	A) Time						"	JP
	B) Malfunctions						"	JP
	C) Pierced Primers						"	JP
	D) Optical Clarity of Scope						"	JP
645	Inspect for Live Ammo						9-12-91	JP
655	Final Inspection							
	A) Headspace						9/13/91	JP
	B) Trigger Pull	2.43	2.42	2.58	2.48	2.53	9/13/91	JP
	C) Function						9/13/91	JP
660	Pack						9-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6648931

DATE 9-11-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.28	2.35	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.28	2.38	2.42	
PULL #3	2.36	2.40	2.40	2.58	
PULL #4	2.33	2.27	2.22	2.48	
PULL #5	2.33	2.32	2.38	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.65		
PULL #2	3.61	3.64		
PULL #3	3.54	3.57		
PULL #4	3.54	3.61		
PULL #5	3.52	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.34		4.41
PULL #2	4.30	4.36		4.44
PULL #3	4.36	4.42		4.40
PULL #4	4.44	4.40		4.45
PULL #5	4.35	4.40		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648931
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.342253
1 TO	2	.2991
1 TO	3	.160863
1 TO	4	.294749
1 TO	5	.59023

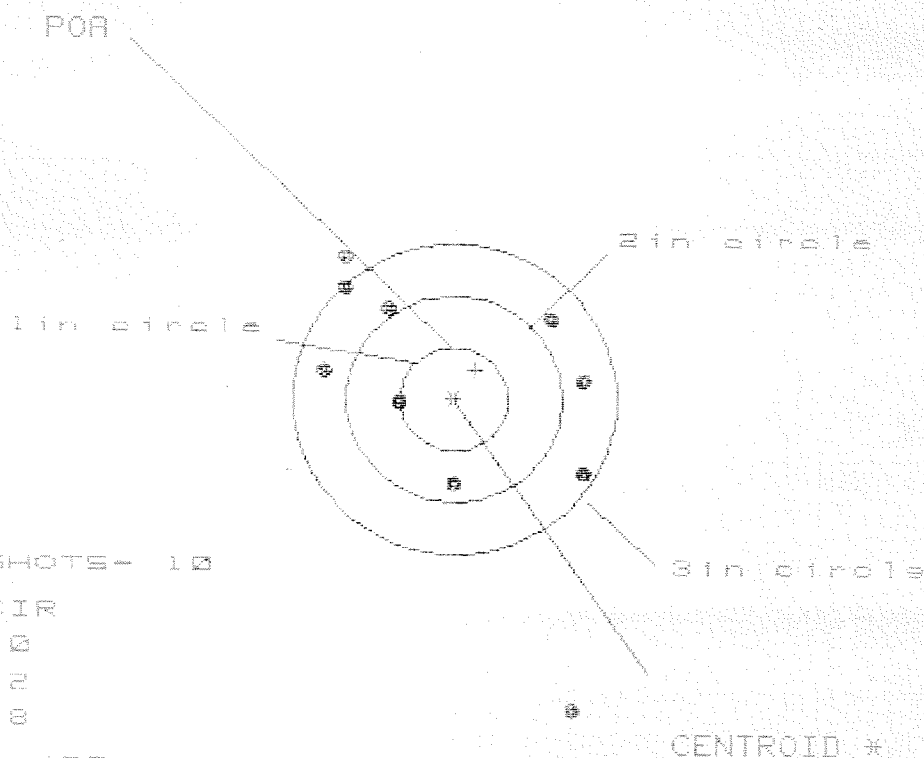
←---FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0966
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0436
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105984
THE AMR FOR THIS RIFLE IS: 1.117

12 Sep 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6848331

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.465

VS= 4.484

GS= 4.941

PATTERN #

SHOTS (BEST OF)

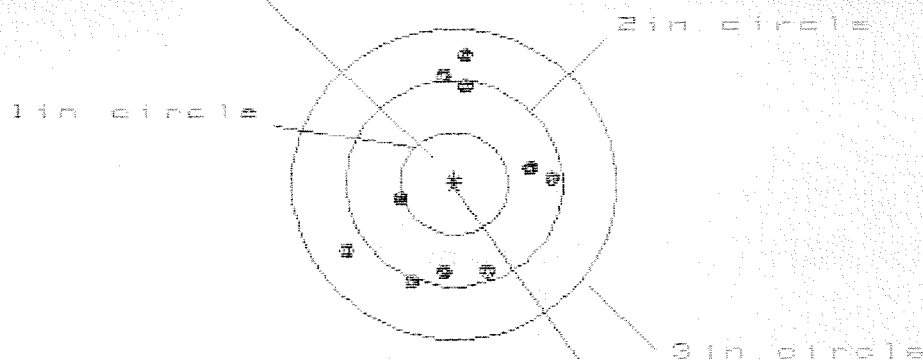
	10	9	8
MAXIMUM X	1.239	1.359	1.250
MINIMUM X	-1.226	-1.106	-1.215
MAXIMUM Y	1.430	1.091	.878
MINIMUM Y	-0.854	-1.116	-.980
CENTROID X	-.191	-.311	-.202
CENTROID Y	-.284	.055	-.081
POR TO CENTROID in.	.342	.316	.218
MIN RADIUS	.533	.571	.581
MEAN RADIUS	1.390	1.134	1.102
MAX RADIUS	3.240	1.695	1.527
HORIZONTAL SPREAD	2.465	2.465	2.465
VERTICAL SPREAD	4.484	2.207	1.858
EXTREME SPREAD	4.941	3.069	2.871
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	8	

12 Sep 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 1.805

VS= 2.257

GS= 2.298

CENTROID *

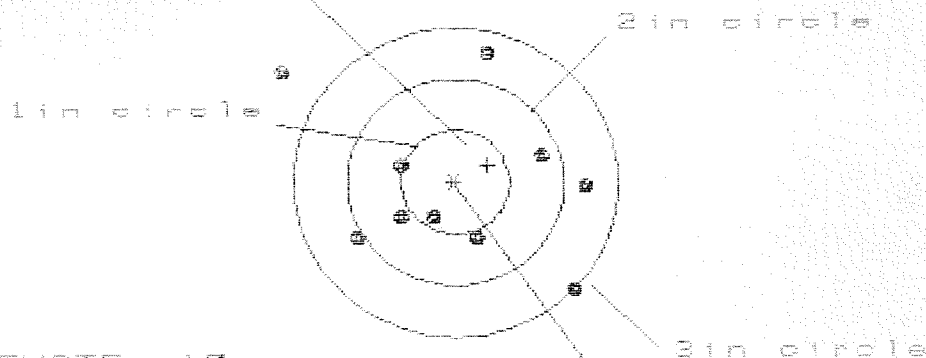
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.856	.865	.747
MINIMUM X	-.949	-.940	-.645
MAXIMUM Y	1.296	1.165	1.106
MINIMUM Y	-.961	-.817	-.876
CENTROID X	-.001	-.010	.108
CENTROID Y	-.053	-.197	-.138
POA TO CENTROID in.	.053	.197	.175
MIN RADIUS	.557	.527	.640
MEAN RADIUS	.934	.876	.849
MAX RADIUS	1.298	1.173	1.135
HORIZONTAL SPREAD	1.805	1.805	1.392
VERTICAL SPREAD	2.257	1.982	1.982
EXTREME SPREAD	2.298	1.994	1.994
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

12 Sep 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.843

VS= 2.353

GS= 3.495

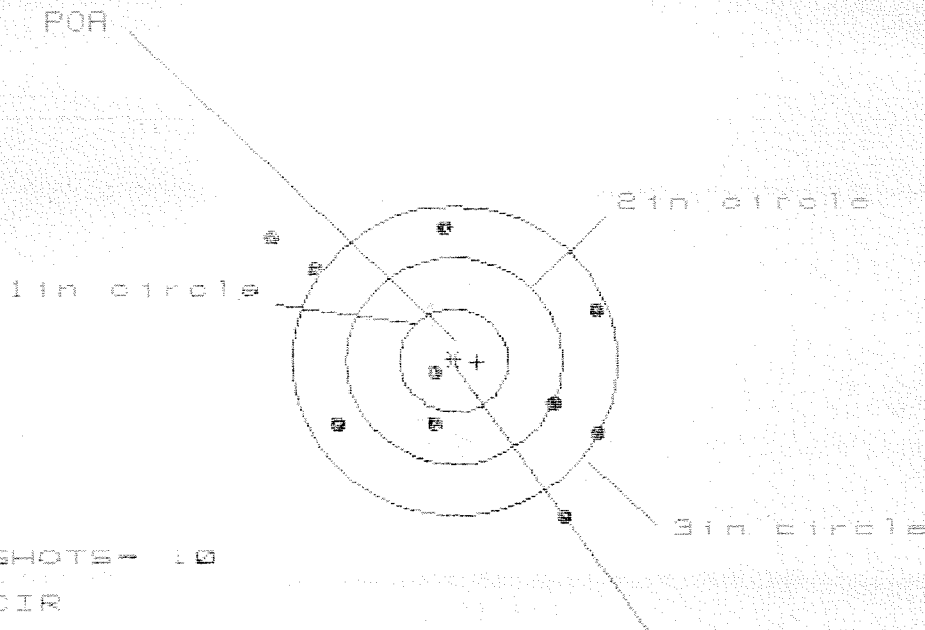
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.202	1.020	1.130
MINIMUM X	-1.641	-1.068	-0.950
MAXIMUM Y	1.305	1.425	1.309
MINIMUM Y	-1.048	-0.928	-0.521
CENTROID X	-0.297	-0.115	-0.233
CENTROID Y	-0.163	-0.283	-0.167
POA TO CENTROID in.	0.339	0.306	0.287
MIN RADIUS	0.354	0.370	0.384
MEAN RADIUS	0.984	0.863	0.797
MAX RADIUS	1.968	1.429	1.328
HORIZONTAL SPREAD	2.843	2.088	2.088
VERTICAL SPREAD	2.353	2.353	1.830
EXTREME SPREAD	3.495	2.499	2.173
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

12 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.015

VS= 2.785

GS= 3.817

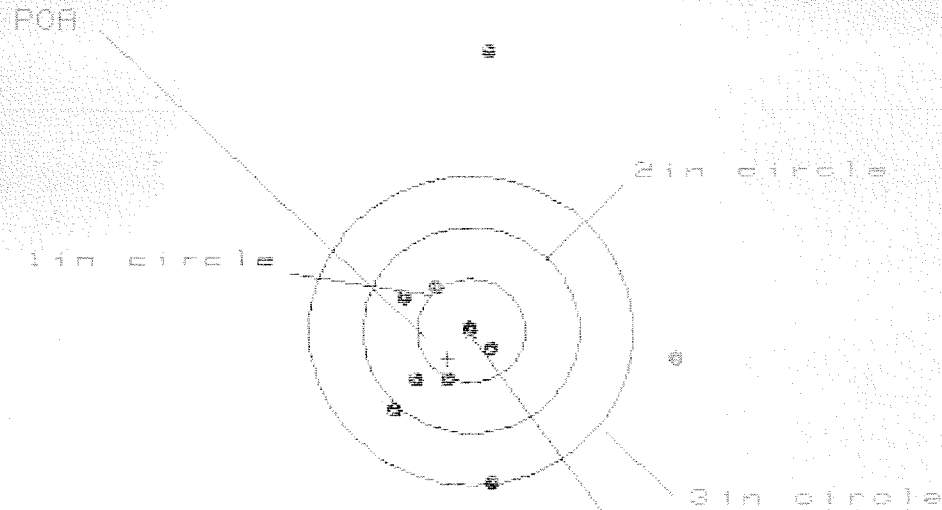
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.171	1.278
MINIMUM X	-1.660	-1.582	-1.395
MAXIMUM Y	1.308	1.438	1.270
MINIMUM Y	-1.482	-1.347	-1.772
CENTROID X	-.212	-.028	-.135
CENTROID Y	.010	-.125	.043
POA TO CENTROID in.	.213	.128	.142
MIN RADIUS	.275	.410	.357
MEAN RADIUS	1.281	1.177	1.124
MAX RADIUS	2.056	1.835	1.652
HORIZONTAL SPREAD	3.015	2.673	2.673
VERTICAL SPREAD	2.785	2.785	2.042
EXTREME SPREAD	3.817	3.367	3.145
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

12 Sep 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.620

VS= 4.170

GS= 4.170

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.887	1.907	.463
MINIMUM X	-.733	-.713	-.475
MAXIMUM Y	2.715	.722	.726
MINIMUM Y	-1.455	-1.153	-1.149
CENTROID X	.218	.198	-.040
CENTROID Y	.272	-.030	-.035
POA TO CENTROID in.	.349	.201	.053
MIN RADIUS	.081	.234	.182
MEAN RADIUS	.997	.777	.593
MAX RADIUS	2.721	1.907	1.238
HORIZONTAL SPREAD	2.620	2.620	.938
VERTICAL SPREAD	4.170	1.875	1.875
EXTREME SPREAD	4.170	2.663	2.013
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	