

C6648934

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

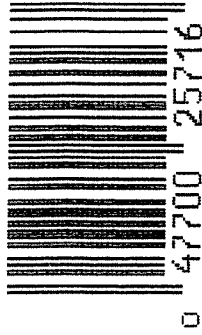
MODEL 700™ M24

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. C6648934	ORDER NO. 5716
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LPC



CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648934

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	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	LB
	Apply Coating (Bolt)		8-23-91	LB
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	FM

op. #	BARBER - M24 0033501	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	6			9/11/91	JH
	G) Safety Off Force	3	3	5			9/11/91	JH
	H) Trigger Pull Test & Retainability						9/11/91	JH
	I) Firing Pin Indent	.0215	.021	.021			9/11/91	JH
	J) Assemble Stock						9/12/91	RW
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						9/12/91	RW
	M) Iron Sight Alignment						9/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/14/91	RW
	O) Attach Scope to Rifle						9/12/91	RW
	P) Detach & Attach Scope 20 Times						9/12/91	RW
640	Gallery Target & Test						9/12/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/12/91	KT
655	Final Inspection							
	A) Headspace						9/13/91	JH
	B) Trigger Pull	2.17	2.24	2.32	2.36	2.34	9/13/91	JH
	C) Function						9/13/91	JH
660	Pack						9-19-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6648934

DATE 9-11-98

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.55	2.54	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.35	2.48	2.29	
PULL #3	2.59	2.57	2.44	2.32	
PULL #4	2.59	2.59	2.60	2.36	
PULL #5	2.54	2.60	2.61	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.54		
PULL #2	3.44	3.50		
PULL #3	3.42	3.45		
PULL #4	3.46	3.52		
PULL #5	3.37	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	4.47	4.20		4.39
PULL #2	4.62	4.20		4.56
PULL #3	4.56	4.25		4.54
PULL #4	4.62	4.48		4.45
PULL #5	4.52	4.47		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648934
13 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0290689
1 TO	2	.103097
1 TO	3	.105081
1 TO	4	.0390512
1 TO	5	.123693

←----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0378
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0196
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0425793
THE AMR FOR THIS RIFLE IS: 1.029

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B934

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 7

HE = 2.445

VS = 3.492

GS = 3.664

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.950	.987	.835
MINIMUM X	-1.495	-1.390	-1.542
MAXIMUM Y	1.950	1.341	1.288
MINIMUM Y	-1.542	-1.326	-1.158
CENTROID X	-.022	-.127	.025
CENTROID Y	-.019	-.235	-.403
POA TO CENTROID in.	.029	.268	.404
MIN RADIUS	.722	.502	.571
MEAN RADIUS	1.237	1.102	.967
MAX RADIUS	2.169	1.810	1.569
HORIZONTAL SPREAD	2.445	2.377	2.377
VERTICAL SPREAD	3.492	2.667	2.446
EXTREME SPREAD	3.664	2.909	2.456
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B334

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.256

VS = 3.249

GS = 3.654

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.412	.866	.853
MINIMUM X	-.844	-.687	-.700
MAXIMUM Y	2.000	.927	.799
MINIMUM Y	-1.249	-1.027	-.755
CENTROID X	-.087	-.164	-.151
CENTROID Y	.083	-.139	-.011
POA TO CENTROID in.	.083	.215	.152
MIN RADIUS	.382	.180	.211
MEAN RADIUS	.972	.752	.714
MAX RADIUS	2.448	1.069	1.139
HORIZONTAL SPREAD	2.256	1.553	1.553
VERTICAL SPREAD	3.249	1.954	1.554
EXTREME SPREAD	3.654	1.959	1.849
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648334

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 4.660

VS= 1.753

GS= 4.701

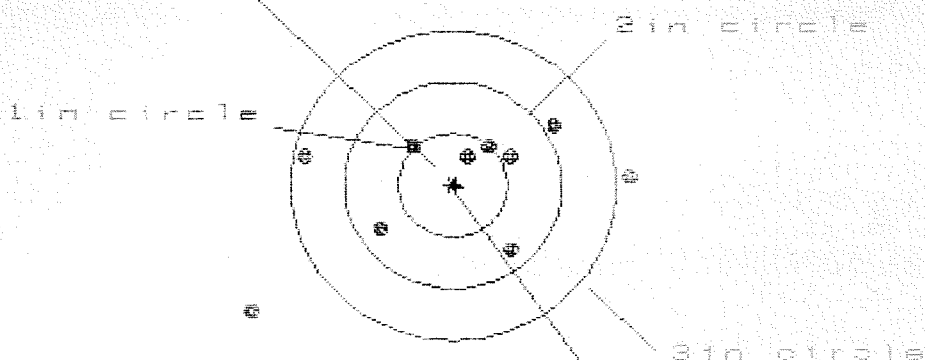
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.330
MINIMUM X	-2.330
MAXIMUM Y	.763
MINIMUM Y	-.990
CENTROID X	.007
CENTROID Y	.082
POA TO CENTROID in.	.083
MIN RADIUS	.248
MEAN RADIUS	.996
MAX RADIUS	2.451
HORIZONTAL SPREAD	4.660
VERTICAL SPREAD	1.753
EXTREME SPREAD	4.701
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B334

CENTERFIRE PATTERNS # 4

POB



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.512

VS = 1.841

GS = 3.747

CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.678
MINIMUM X	-1.834
MAXIMUM Y	.618
MINIMUM Y	-1.223
CENTROID X	-.031
CENTROID Y	.019
POB TO CENTROID in.	.036
MIN RADIUS	.334
MEAN RADIUS	1.000
MAX RADIUS	2.205
HORIZONTAL SPREAD	3.512
VERTICAL SPREAD	1.841
EXTREME SPREAD	3.747
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08646934

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.175

VS = 3.374

GS = 3.448

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.218	1.223	1.142
MINIMUM X	-1.957	-1.952	-1.834
MAXIMUM Y	1.794	.983	.738
MINIMUM Y	-1.588	-1.388	-.935
CENTROID X	-.136	-.141	-.059
CENTROID Y	-.067	-.267	-.094
POA TO CENTROID in.	.152	.382	.111
MIN RADIUS	.164	.341	.152
MEAN RADIUS	.936	.846	.731
MAX RADIUS	1.795	1.528	1.414
HORIZONTAL SPREAD	2.175	2.175	2.175
VERTICAL SPREAD	3.374	2.283	1.565
EXTREME SPREAD	3.448	2.688	2.688
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		