

C6648946

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.

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

MODEL 700™ M24

SERIAL NO. C6648946

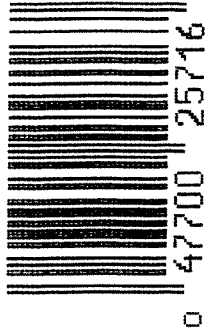
ORDER NO. 5716

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

Ø6



LPC



CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648946

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	2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		7-28-91	DA
	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		7-7-91	DH

op. #	BARBER - M24 0033638	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9-7-91	DH
	G) Safety Off Force	2	2	2			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.021	.020	.021			9-7-91	DH
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						9/18/91	RW
	M) Iron Sight Alignment						9/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	RW
	O) Attach Scope to Rifle						9/10/91	RW
	P) Detach & Attach Scope 20 Times						9/10/91	RW
640	Gallery Target & Test						9-10-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-10-91	AF
655	Final Inspection							
	A) Headspace						9/13/91	JH
	B) Trigger Pull	2.51	2.56	2.61	2.69	2.70	9-12-91	JH
	C) Function						9/13/91	JH
660	Pack						9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. Q6648946

DATE 9-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.40	2.40	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.46	2.45	2.56	
PULL #3	2.46	2.35	2.44	2.61	
PULL #4	2.49	2.44	2.47	2.69	
PULL #5	2.38	2.35	2.46	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.11		
PULL #2	3.26	3.12		
PULL #3	3.19	3.03		
PULL #4	3.11	3.09		
PULL #5	3.16	3.06		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.00		4.09
PULL #2	4.24	4.38		4.21
PULL #3	4.11	4.22		4.15
PULL #4	4.13	4.27		4.18
PULL #5	4.07	4.14		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648946
11 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.317833
1 TO	2	.377171
1 TO	3	.409866
1 TO	4	.406315
1 TO	5	.457578

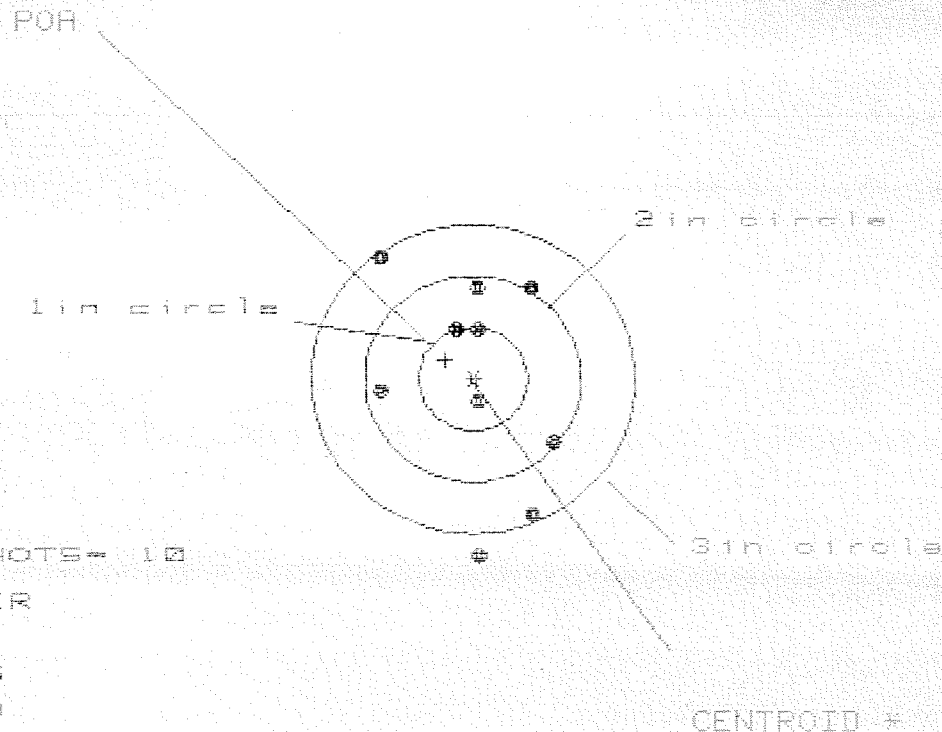
Set: <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1706
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .178733
THE AMR FOR THIS RIFLE IS: .941

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648946

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.565

VS= 2.859

GS= 2.991

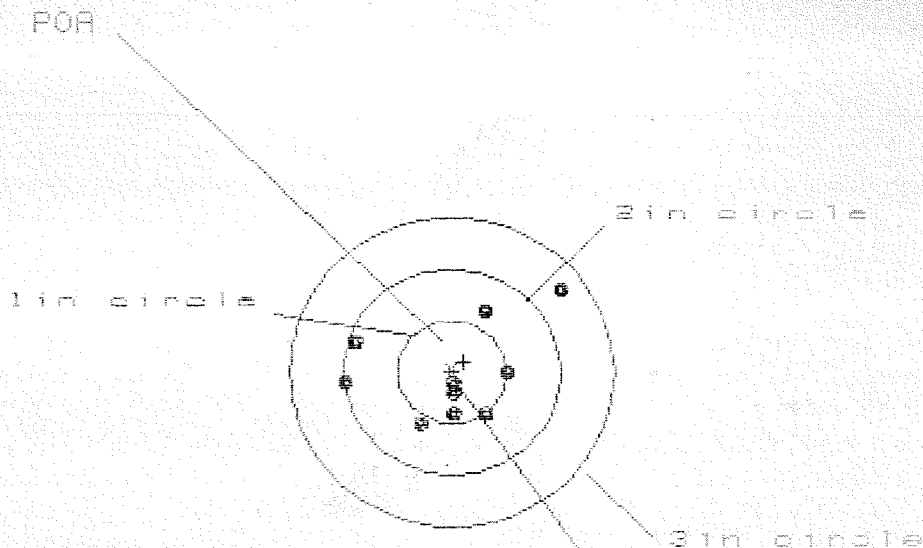
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.694	.695	.586
MINIMUM X	-.871	-.870	-.960
MAXIMUM Y	1.180	.993	.843
MINIMUM Y	-1.679	-1.537	-1.413
CENTROID X	.257	.256	.365
CENTROID Y	-.187	-.000	-.124
POR TO CENTROID in.	.318	.256	.383
MIN RADIUS	.235	.342	.299
MEAN RADIUS	.963	.850	.802
MAX RADIUS	1.679	1.614	1.464
HORIZONTAL SPREAD	1.565	1.565	1.546
VERTICAL SPREAD	2.859	2.530	2.256
EXTREME SPREAD	2.991	2.874	2.290
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

11 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 10

HS= 1.953

VS= 1.293

GS= 2.126

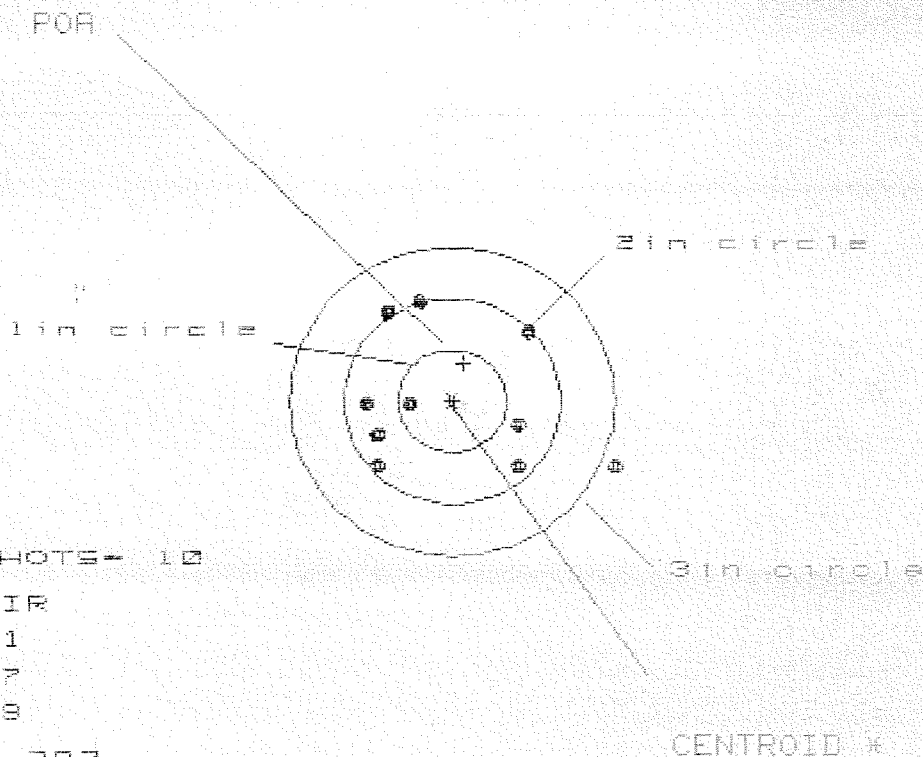
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.966	.633	.523
MINIMUM X	-.987	-.880	-.846
MAXIMUM Y	.790	.662	.667
MINIMUM Y	-.503	-.415	-.410
CENTROID X	-.110	-.217	-.107
CENTROID Y	-.100	-.188	-.193
POA TO CENTROID in.	.149	.287	.221
MIN RADIUS	.068	.152	.054
MEAN RADIUS	.610	.533	.457
MAX RADIUS	1.248	.881	.915
HORIZONTAL SPREAD	1.953	1.513	1.359
VERTICAL SPREAD	1.293	1.077	1.077
EXTREME SPREAD	2.126	1.516	1.384
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

11 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.283

VS= 1.611

GS= 2.604

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.533	.841	.785
MINIMUM X	-.750	-.579	-.635
MAXIMUM Y	.952	.884	.982
MINIMUM Y	-.659	-.727	-.629
CENTROID X	-.108	-.279	-.223
CENTROID Y	-.373	-.305	-.403
POA TO CENTROID in.	.388	.413	.461
MIN RADIUS	.365	.205	.252
MEAN RADIUS	.909	.790	.774
MAX RADIUS	1.650	1.059	1.072
HORIZONTAL SPREAD	2.283	1.420	1.420
VERTICAL SPREAD	1.611	1.611	1.611
EXTREME SPREAD	2.604	1.944	1.875
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

11 Sep 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HE= 2.581

VS= 3.444

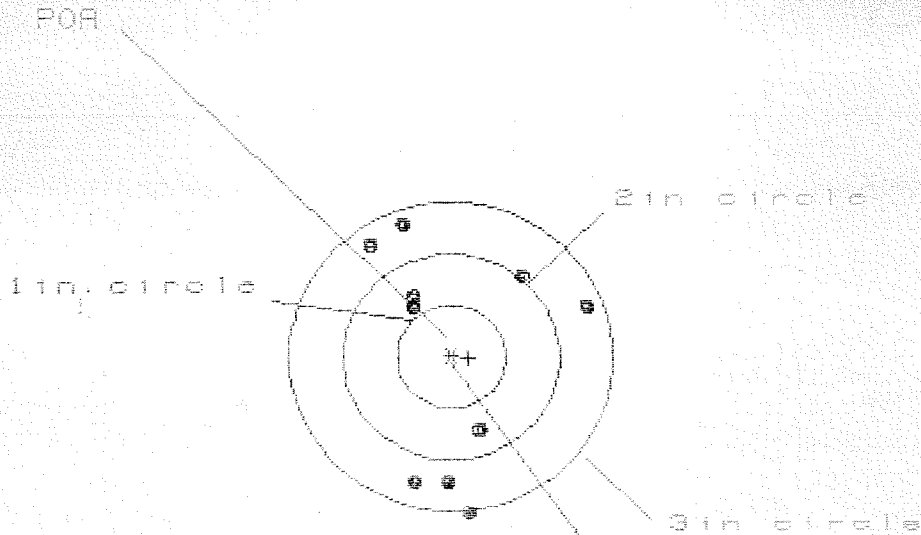
GS= 4.058

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.157	1.004	.807
MINIMUM X	-1.423	-1.577	-.914
MAXIMUM Y	1.589	1.383	1.226
MINIMUM Y	-1.855	-1.262	-.753
CENTROID X	-.149	.004	.201
CENTROID Y	-.203	.003	.160
POA TO CENTROID in.	.252	.005	.257
MIN RADIUS	.231	.366	.190
MEAN RADIUS	1.119	.960	.813
MAX RADIUS	2.314	2.020	1.293
HORIZONTAL SPREAD	2.581	2.581	1.721
VERTICAL SPREAD	3.444	2.645	1.979
EXTREME SPREAD	4.058	3.431	2.156
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

13 Sep 1993

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 1.936

VS= 2.783

GS= 2.829

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.231
MINIMUM X	-0.785
MAXIMUM Y	1.282
MINIMUM Y	-1.508
CENTROID X	-0.156
CENTROID Y	0.010
POA TO CENTROID in.	0.157
MIN RADIUS	0.588
MEAN RADIUS	1.104
MAX RADIUS	1.505
HORIZONTAL SPREAD	1.936
VERTICAL SPREAD	2.783
EXTREME SPREAD	2.829
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	9