

C6648947

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

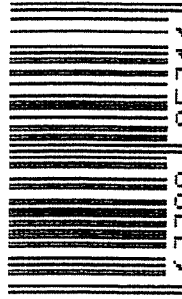
Remington

Remington REG. U.S. PAT. & TM. OFF.  VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24	SERIAL NO. C6648947
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.	ORDER NO. 5716



5716 C6648947

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648947

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			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		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	JA
	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		9-6-91	PI/H

op. #	BARBER M24 0033649	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 $\frac{3}{4}$	5 $\frac{1}{2}$			9-6-91	D/H
	G) Safety Off Force	3	2 $\frac{1}{4}$	3			9-6-91	D/H
	H) Trigger Pull Test & Retainability						9-6-91	D/H
	I) Firing Pin Indent	.020	.022	.023			9-6-91	D/H
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/10/91	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						9-11-91	D/H
	A) Time						9-11-91	D/H
	B) Malfunctions						9-11-91	D/H
	C) Pierced Primers						9-11-91	D/H
	D) Optical Clarity of Scope						9-11-91	D/H
645	Inspect for Live Ammo						9-11-91	D/H
655	Final Inspection							
	A) Headspace						9-12-91	D/H
	B) Trigger Pull	2.31	2.35	2.39	2.42	2.41	9-12-91	D/H
	C) Function						9-12-91	D/H
660	Pack						9-12-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CCG 48947

DATE 9-6-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.59	2.60	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.68	2.62	2.63	2.35	
PULL #3	2.60	2.60	2.61	2.39	
PULL #4	2.69	2.57	2.57	2.42	
PULL #5	2.70	2.70	2.58	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.39		
PULL #2	3.30	3.42		
PULL #3	3.36	3.38		
PULL #4	3.38	3.32		
PULL #5	3.43	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.65		4.11
PULL #2	4.16	4.61		4.10
PULL #3	4.22	4.39		3.95
PULL #4	4.28	4.64		4.02
PULL #5	4.38	4.68		3.99
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648947
11 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.129468
1 TO	2	.326451
1 TO	3	.198816
1 TO	4	.133405
1 TO	5	.249257

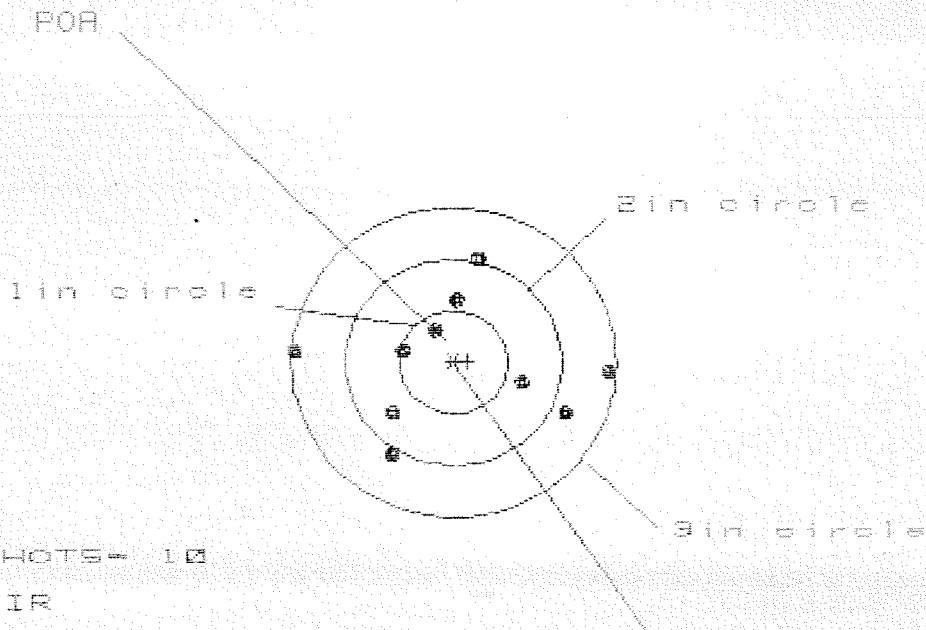
412 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0948
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .106807
THE AMR FOR THIS RIFLE IS: .8532

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648947

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.892

VS= 1.886

GS= 2.899

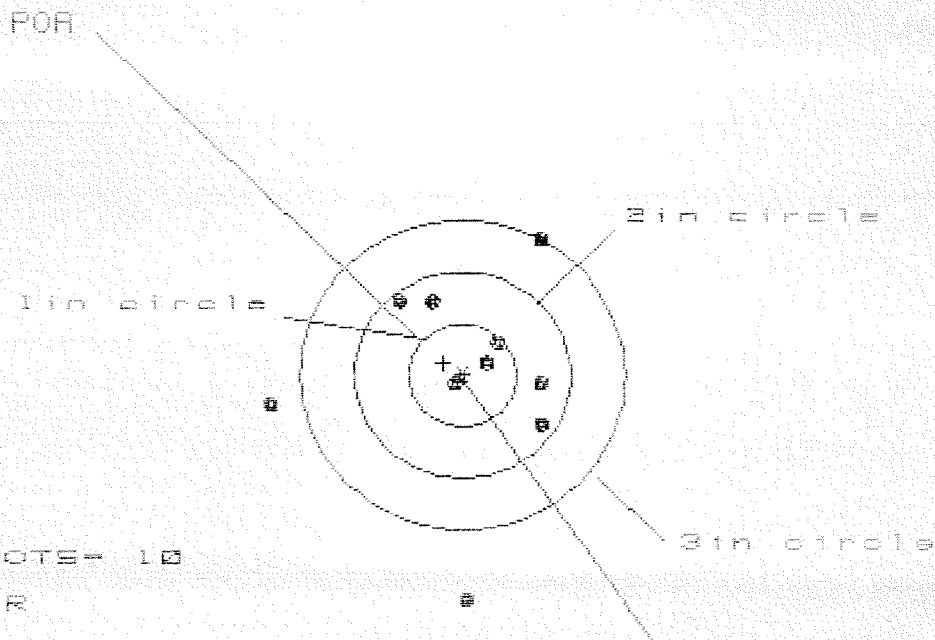
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.440	1.279	1.041
MINIMUM X	-1.452	-.776	-.616
MAXIMUM Y	1.043	1.050	1.035
MINIMUM Y	-.843	-.836	-.851
CENTROID X	-.129	.032	-.128
CENTROID Y	-.011	-.018	-.003
POA TO CENTROID in.	.130	.037	.128
MIN RADIUS	.391	.491	.385
MEAN RADIUS	.900	.843	.762
MAX RADIUS	1.453	1.285	1.140
HORIZONTAL SPREAD	2.892	2.055	1.657
VERTICAL SPREAD	1.886	1.886	1.886
EXTREME SPREAD	2.899	2.175	2.064
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

11 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HE= 2.547

VS= 3.515

GS= 3.590

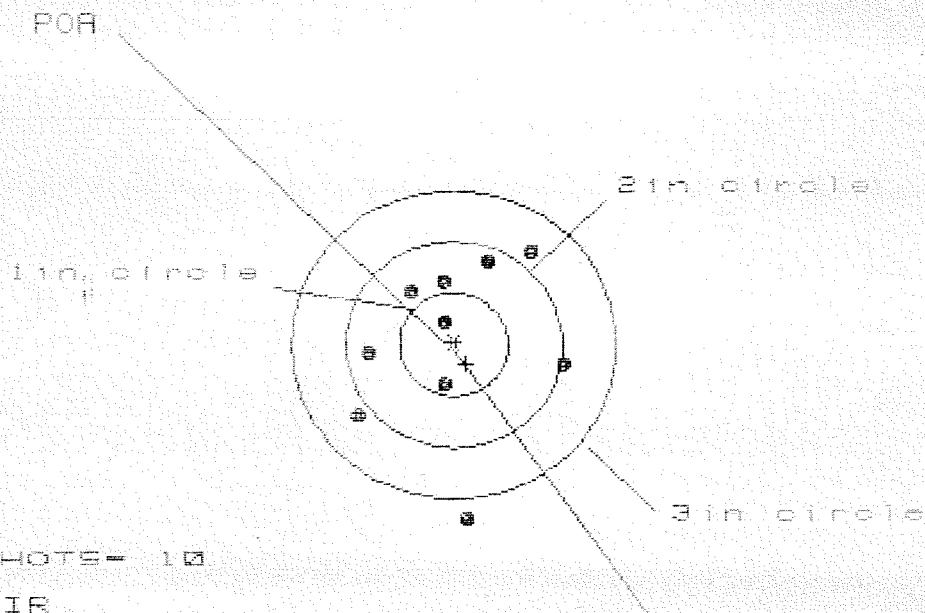
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.756	.760	.536
MINIMUM X	-1.790	-1.787	-.820
MAXIMUM Y	1.291	1.044	.982
MINIMUM Y	-2.224	-.741	-.803
CENTROID X	.178	.174	.398
CENTROID Y	-.122	.125	.187
POR TO CENTROID in.	.215	.215	.439
MIN RADIUS	.131	.245	.117
MEAN RADIUS	.955	.789	.617
MAX RADIUS	2.224	1.854	1.119
HORIZONTAL SPREAD	2.547	2.547	1.356
VERTICAL SPREAD	3.515	1.785	1.785
EXTREME SPREAD	3.590	2.975	1.787
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

(1 Sep 1991)

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 1.832

VS = 2.577

GS = 2.638

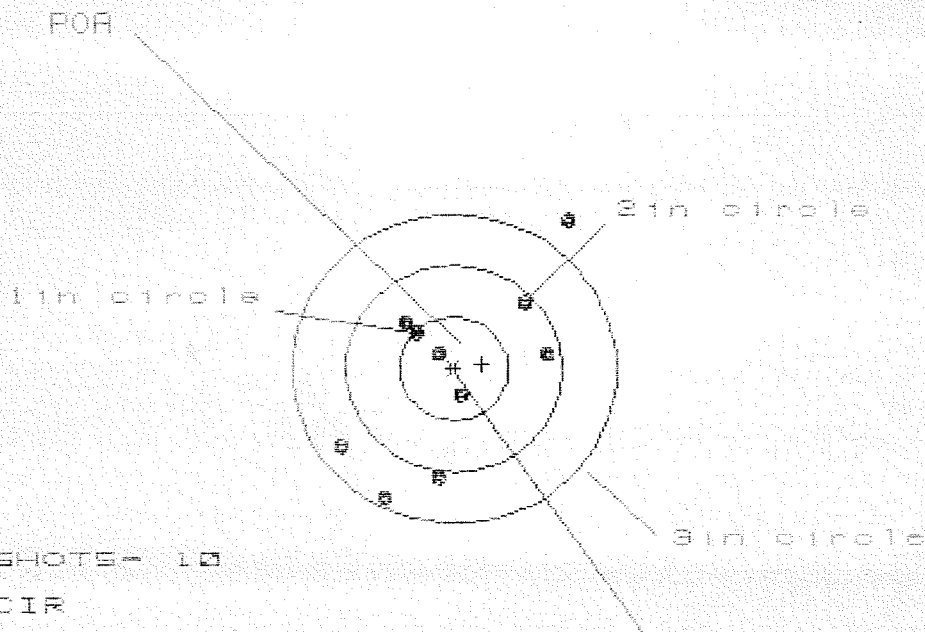
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.987	1.003	1.093
MINIMUM X	-.845	-.829	-.739
MAXIMUM Y	.933	.750	.721
MINIMUM Y	-1.644	-.870	-.776
CENTROID X	-.111	-.127	-.217
CENTROID Y	.187	.370	.276
POA TO CENTROID in.	.217	.391	.351
MIN RADIUS	.195	.039	.111
MEAN RADIUS	.839	.705	.667
MAX RADIUS	1.650	1.202	1.134
HORIZONTAL SPREAD	1.832	1.832	1.832
VERTICAL SPREAD	2.577	1.620	1.497
EXTREME SPREAD	2.638	2.243	1.899
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.092

VS= 2.697

GS= 3.197

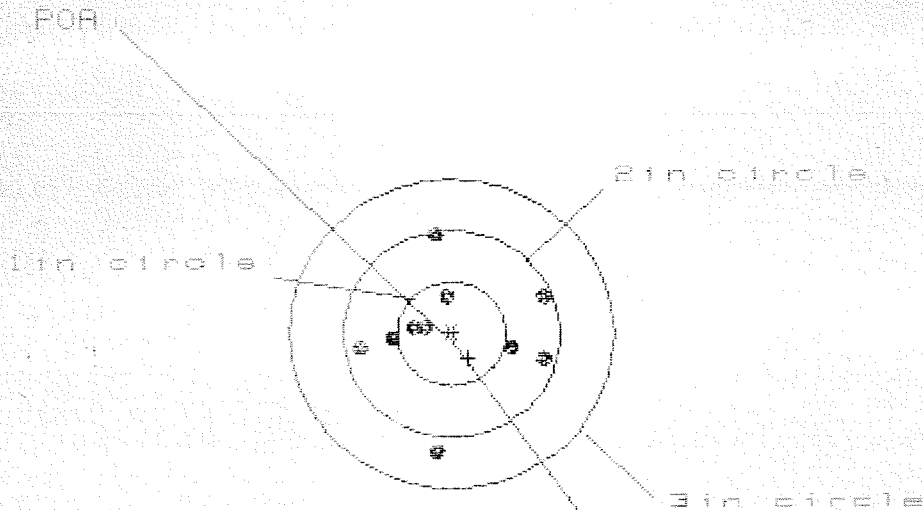
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.097	.983	.920
MINIMUM X	:	-.995	-.873	-.936
MAXIMUM Y	:	1.452	.842	.706
MINIMUM Y	:	-1.245	-1.084	-.988
CENTROID X	:	-.259	-.380	-.317
CENTROID Y	:	-.045	-.206	-.070
POA TO CENTROID in.	:	.262	.432	.325
MIN RADIUS	:	.185	.239	.164
MEAN RADIUS	:	.896	.791	.715
MAX RADIUS	:	1.819	1.193	1.180
HORIZONTAL SPREAD	:	2.092	1.856	1.856
VERTICAL SPREAD	:	2.697	1.926	1.694
EXTREME SPREAD	:	3.197	2.335	2.216
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.689

VS= 2.050

GS= 2.051

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.876
MINIMUM X	-.813
MAXIMUM Y	.950
MINIMUM Y	-1.100
CENTROID X	-.154
CENTROID Y	.237
POA TO CENTROID in.	.282
MIN RADIUS	.264
MEAN RADIUS	.676
MAX RADIUS	1.115
HORIZONTAL SPREAD	1.689
VERTICAL SPREAD	2.050
EXTREME SPREAD	2.051
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10