

C6648955

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700™ M24

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

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

SERIAL NO.
C6648955

ORDER NO.
5716

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



5716 C6648955

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648955

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	LS
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8/27-91	KL
	Apply Coating (Bolt)			
625	Final Assembly		9/4/91	KL
	A) Clean inside of Bolt Assembly		9/4/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KL
	C) Inspect Ejector Hole for Chamfer		9/4/91	KL
	D) Oil Firing Pin Ass'y		9/4/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	KL

op. #	BARBER M24 0033739	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/9/91	JK
	G) Safety Off Force	3	3	3			9/9/91	JK
	H) Trigger Pull Test & Retainability						9/9/91	JK
	I) Firing Pin Indent	10205	021	021			9/9/91	JK
	J) Assemble Stock						9/11/91	JK
	K) Assemble Swivel Studs						9/13/91	JK
	L) Attach Front and Rear Sight Assemblies						9/11/91	JK
	M) Iron Sight Alignment						9/11/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/11/91	JK
	O) Attach Scope to Rifle						9/11/91	JK
	P) Detach & Attach Scope 20 Times						9/11/91	JK
640	Gallery Target & Test						9-12-91	DH
	A) Time						9-12-91	DH
	B) Malfunctions						9-12-91	DH
	C) Pierced Primers						9-12-91	DH
	D) Optical Clarity of Scope						9-12-91	DH
645	Inspect for Live Ammo						9-12-91	DH
655	Final Inspection							
	A) Headspace						9/13/91	JK
	B) Trigger Pull	209	2.53	2.50	2.50	2.47	9/13/91	JK
	C) Function						9/13/91	JK
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-6648955DATE 9-9-91TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.60	2.48	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.54	2.56	2.53	
PULL #3	2.64	2.56	2.58	2.50	
PULL #4	2.49	2.58	2.50	2.50	
PULL #5	2.50	2.59	2.61	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.47		
PULL #2	3.31	3.57		
PULL #3	3.28	3.62		
PULL #4	3.24	3.54		
PULL #5	3.58	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.24		4.43
PULL #2	4.28	4.21		4.57
PULL #3	4.43	4.50		4.39
PULL #4	4.38	4.45		4.52
PULL #5	4.36	4.32		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648955
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0890505
1 TO	2	.34414
1 TO	3	.0687314
1 TO	4	.0454863
1 TO	5	.328221

<----FOR

COORDINATE FOR THIS RIFLE IS: -.0408

COORDINATE FOR THIS RIFLE IS: -.0248

CORRECTION RADIUS FOR THIS RIFLE IS: .

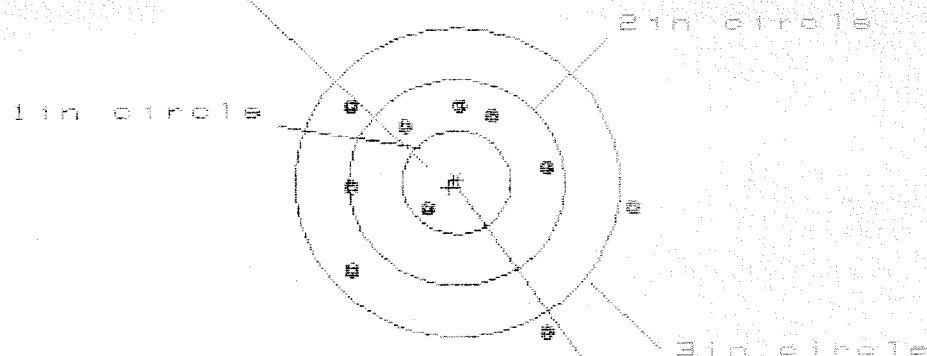
RIFLE IS: .9294

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB48955

CENTERFIRE PATTERNS # 1

POR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

CENTROID *

HE= 2.598

VS= 2.211

GS= 2.832

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POR TO CENTROID IN.

MIN RADIUS

MAX RADIUS

MIN CIRCUM

HORIZONTAL SPREAD

VERTICAL SPREAD

DIAGN. SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.602

1.699

1.114

-1.996

-1.899

-1.687

.779

.620

.574

-1.432

-1.039

-1.085

.073

-.024

-.236

.051

.210

.252

.089

.211

.346

.359

.449

.357

1.018

.909

.774

1.678

1.738

1.284

2.598

2.598

1.881

2.211

1.659

1.659

2.832

2.727

2.084

1

6

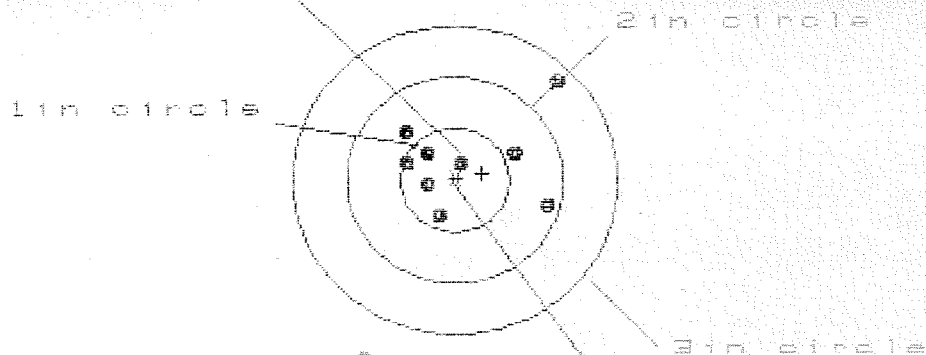
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12 Sep 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 5

2in = 8

3in = 9

HS = 1.745

VS = 2.666

GS = 3.186

CENTROID *

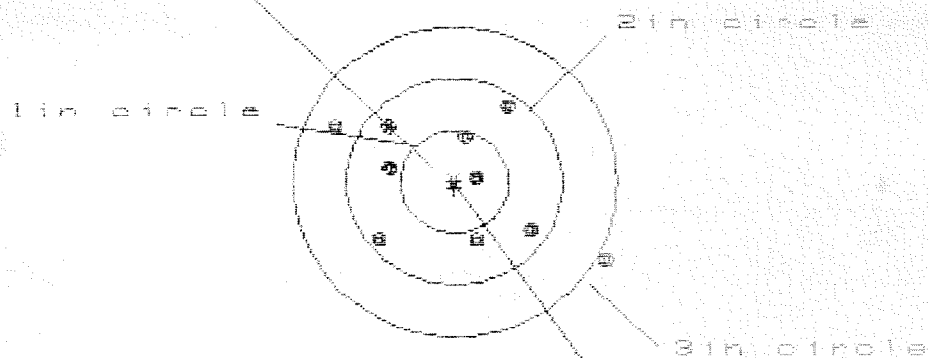
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.818	.853
MINIMUM X	-.834	-.563	-.461
MAXIMUM Y	.963	.773	.402
MINIMUM Y	-1.703	-.571	-.474
CENTROID X	-.251	-.158	-.260
CENTROID Y	-.065	.125	.028
POA TO CENTROID in.	.259	.201	.262
MIN RADIUS	.203	.032	.135
MEAN RADIUS	.710	.561	.469
MAX RADIUS	1.897	1.126	.913
HORIZONTAL SPREAD	1.745	1.381	1.314
VERTICAL SPREAD	2.666	1.344	.876
EXTREME SPREAD	3.186	1.702	1.502
NUMBER IN ONE INCH CIRCLE	=	5	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	

12 Sep 1991

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.472

VS= 1.511

GS= 2.790

CENTROID *

PATTERN #

3

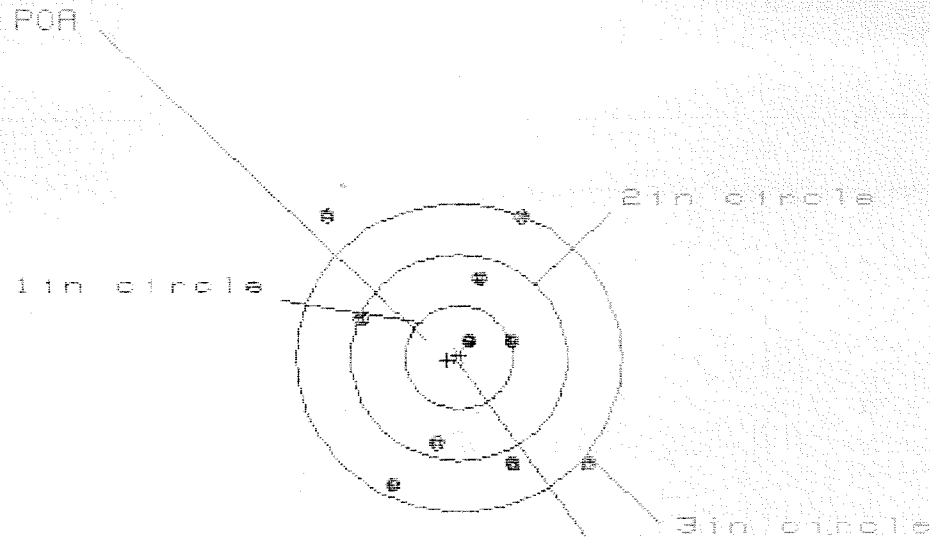
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.358	.873	.753
MINIMUM X	-1.114	-.964	-.665
MAXIMUM Y	.757	.673	.730
MINIMUM Y	-.754	-.691	-.634
CENTROID X	.005	-.145	-.025
CENTROID Y	.061	.145	.088
FOR TO CENTROID in.	.061	.205	.091
MIN RADIUS	.227	.379	.259
MEAN RADIUS	.811	.720	.664
MAX RADIUS	1.553	1.066	.919
HORIZONTAL SPREAD	2.472	1.837	1.418
VERTICAL SPREAD	1.511	1.364	1.364
EXTREME SPREAD	2.790	2.183	1.814
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

12 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.408

VS = 2.616

GS = 3.435

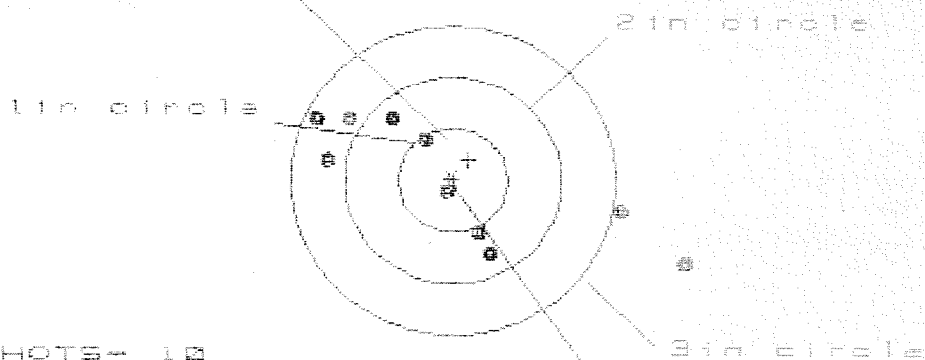
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.166	1.028	.538
MINIMUM X	-1.242	-1.093	-.965
MAXIMUM Y	1.379	1.528	1.414
MINIMUM Y	-1.237	-1.084	-1.198
CENTROID X	.111	.249	.121
CENTROID Y	.026	-.127	-.013
POA TO CENTROID in.	.114	.280	.122
MIN RADIUS	.162	.324	.196
MEAN RADIUS	1.074	.982	.915
MAX RADIUS	1.856	1.582	1.513
HORIZONTAL SPREAD	2.408	2.121	1.503
VERTICAL SPREAD	2.616	2.612	2.612
EXTREME SPREAD	3.435	2.838	2.838
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

12 Sep 1991

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.411

VS= 1.465

GS= 3.708

CENTROID *

PATTERN #	5	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	2.108	1.744	1.020	
MINIMUM X	-1.303	-1.069	-.651	
MAXIMUM Y	.646	.555	.510	
MINIMUM Y	-.819	-.830	-.876	
CENTROID X	-.142	-.376	-.594	
CENTROID Y	-.197	-.106	-.066	
POB TO CENTROID in.	.243	.391	.597	
MIN RADIUS	.114	.260	.305	
MEAN RADIUS	1.034	1.061	.722	
MAX RADIUS	2.261	1.782	1.205	
HORIZONTAL SPREAD	3.411	2.813	1.679	
VERTICAL SPREAD	1.465	1.385	1.385	
EXTREME SPREAD	3.708	2.957	2.169	
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		