

C6611755

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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.
C6611755

ORDER NO.
5716

20

5716 C6611755

UPC
0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611755

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		K.R.
	Magnaflux Bolt	3 28 91		11
615	Rollmark Caliber			98
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	PH

op. #	BARBER - M24 0035421 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-10-91	AC
	G) Safety Off Force	3	3	3			5-10-91	AC
	H) Trigger Pull Test & Retainability						5-9-91	D/H
	I) Firing Pin Indent	.021	.022	.022			5-10-91	AC
	J) Assemble Stock						5-10-91	RW
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/10/91	RW
	M) Iron Sight Alignment						5/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/10/91	RW
	O) Attach Scope to Rifle						5/10/91	RW
	P) Detach & Attach Scope 20 Times						5/10/91	RW
640	Gallery Target & Test						5-13-91	AF
	A) Time						5-13-91	AF
	B) Malfunctions						5-13-91	AF
	C) Pierced Primers						5-13-91	AF
	D) Optical Clarity of Scope						5-13-91	AF
645	Inspect for Live Ammo						5-13-91	AF
655	Final Inspection A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.50	2.47	2.42	2.45	2.47	5/20/91	SP
	C) Function						5-21-91	D/H
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. CGG11755

DATE 5-9-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.34	2.62	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.36	2.54	2.47	
PULL #3	2.44	2.36	2.47	2.42	
PULL #4	2.29	2.35	2.47	2.45	
PULL #5	2.24	2.35	2.61	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.42		
PULL #2	3.44	3.45		
PULL #3	3.26	3.00		
PULL #4	3.09	3.36		
PULL #5	3.28	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.26		4.03
PULL #2	4.29	4.41		4.05
PULL #3	4.29	4.02		4.01
PULL #4	4.33	4.32		4.03
PULL #5	3.93	4.37		4.05
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611755
13 May 1991

CENTROIDAL DISTANCES

0 TO	1	.289166
1 TO	2	.557345
1 TO	3	.695374
1 TO	4	.699035
1 TO	5	.314186

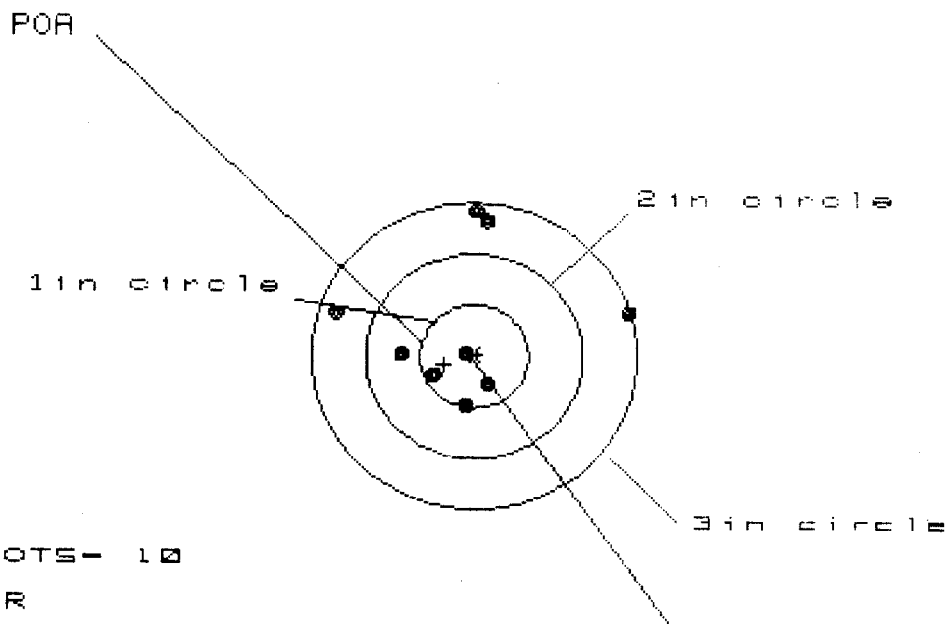
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POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2276
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2002
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .30612
 THE RME FOR THIS RIFLE IS: 1.102

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611755

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.771

VS= 4.178

GS= 4.237

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.466	1.548	.434
MINIMUM X	-1.305	-1.223	-1.029
MAXIMUM Y	1.398	1.089	1.105
MINIMUM Y	-2.780	-0.803	-0.787
CENTROID X	.279	.197	.003
CENTROID Y	.076	.385	.369
POA TO CENTROID in.	.289	.432	.369
MIN RADIUS	.108	.240	.296
MEAN RADIUS	1.046	.859	.750
MAX RADIUS	2.877	1.553	1.149
HORIZONTAL SPREAD	2.771	2.771	1.461
VERTICAL SPREAD	4.178	1.892	1.891
EXTREME SPREAD	4.237	2.771	1.891
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611755

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.771

VS= 4.178

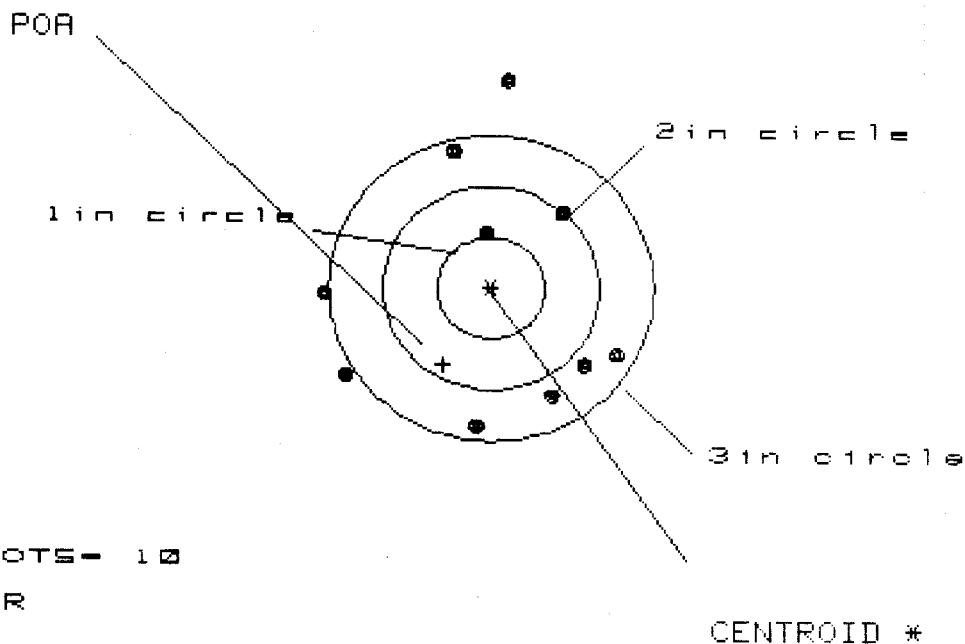
GS= 4.237

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.466	1.548	.434
MINIMUM X	-1.305	-1.223	-1.029
MAXIMUM Y	1.398	1.089	1.105
MINIMUM Y	-2.780	-.803	-.787
CENTROID X	.279	.197	.003
CENTROID Y	.076	.385	.369
POA TO CENTROID in.	.289	.432	.369
MIN RADIUS	.108	.240	.296
MEAN RADIUS	1.046	.859	.750
MAX RADIUS	2.877	1.553	1.149
HORIZONTAL SPREAD	2.771	2.771	1.469
VERTICAL SPREAD	4.178	1.892	1.892
EXTREME SPREAD	4.237	2.771	1.892
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 7

HS= 2.717

VS= 3.363

GS= 3.379

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.188	1.024
MINIMUM X	:	-1.547	-1.529	-1.693
MAXIMUM Y	:	2.018	1.616	1.539
MINIMUM Y	:	-1.345	-1.120	-1.197
CENTROID X	:	.442	.424	.588
CENTROID Y	:	.752	.527	.604
POA TO CENTROID in.	:	.872	.677	.843
MIN RADIUS	:	.581	.805	.749
MEAN RADIUS	:	1.321	1.230	1.179
MAX RADIUS	:	2.024	1.641	1.693
HORIZONTAL SPREAD	:	2.717	2.717	2.717
VERTICAL SPREAD	:	3.363	2.736	2.736
EXTREME SPREAD	:	3.379	2.775	2.775
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.823

VS = 3.021

GS = 3.405

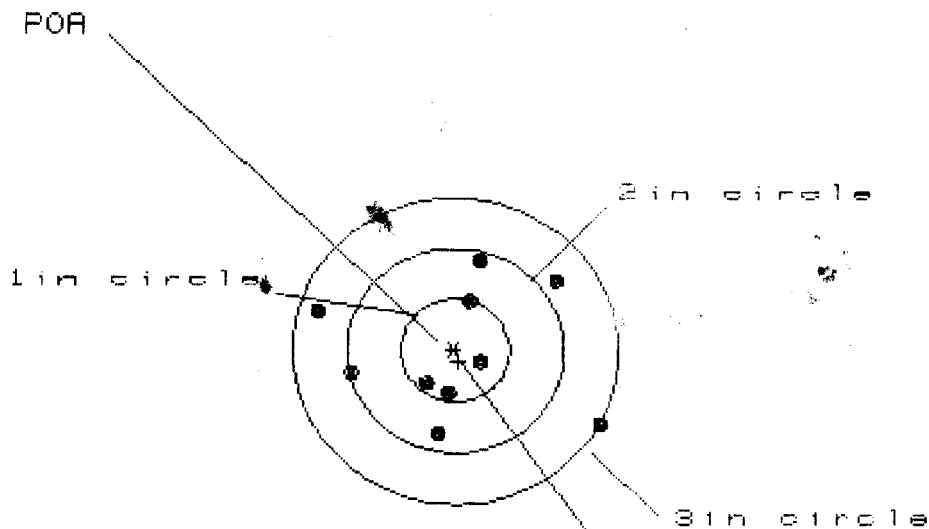
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.603	1.468	.618
MINIMUM X	:	-1.220	-1.217	-1.034
MAXIMUM Y	:	1.304	1.113	1.113
MINIMUM Y	:	-1.717	-1.139	-1.139
CENTROID X	:	-.232	-.097	-.280
CENTROID Y	:	-.401	-.210	-.210
POA TO CENTROID in.	:	.464	.232	.337
MIN RADIUS	:	.547	.393	.547
MEAN RADIUS	:	1.053	.884	.884
MAX RADIUS	:	2.106	1.468	1.468
HORIZONTAL SPREAD	:	2.823	2.685	2.685
VERTICAL SPREAD	:	3.021	2.252	2.252
EXTREME SPREAD	:	3.405	2.721	2.721
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in = 10

HS= 2.601

VS= 1.722

GS= 2.806

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.299
MINIMUM X	-1.302
MAXIMUM Y	.911
MINIMUM Y	-.811
CENTROID X	-.033
CENTROID Y	.113
POA TO CENTROID in.	.117
MIN RADIUS	.278
MEAN RADIUS	.839
MAX RADIUS	1.459
HORIZONTAL SPREAD	2.601
VERTICAL SPREAD	1.722
EXTREME SPREAD	2.806
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10