

C6611756

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM 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.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6611756	20
ORDER NO. 5716	



5716 C6611756

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 66611756

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1/10/91	KA
600	Proof		1/10/91	KA
607	Check Headspace		1/10/91	KA
610	Dis-assemble Gun		1/10/91	KA
612	Magnaflux Barrel Action		1/17/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GLS
617	Drill and Tap Sight Holes	1 18 91		FB
618	Polish Barrel	1 18 91		WLB
620	Apply Coatings (Barrel Action)		2-17-91	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/22/91	KA
	C) Inspect Ejector Hole for Chamfer		2/22/91	KA
	D) Oil Firing Pin Ass'y		2/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2-25-91	DH

op. #	BARBER - M24 0035432 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	6	6			2-26-91	DH
	G) Safety Off Force	3	3	3			2-26-91	DH
	H) Trigger Pull Test & Retainability						2-26-91	DH
	I) Firing Pin Indent	.0215	.021	.021			2-26-91	DH
	J) Assemble Stock						2/26/91	✓
	K) Assemble Swivel Studs						3-1-91	DH
	L) Attach Front and Rear Sight Assemblies						2/26/91	✓
	M) Iron Sight Alignment						2/26/91	✓
	N) Detach Front & Rear Sights & place in numbered container						2/26/91	✓
	O) Attach Scope to Rifle						2/26/91	✓
	P) Detach & Attach Scope 20 Times						2/26/91	✓
640	Gallery Target & Test						2/26/91	✓
	A) Time							2
	B) Malfunctions							13
	C) Pierced Primers							14
	D) Optical Clarity of Scope							19
645	Inspect for Live Ammo						2/26/91	19
655	Final Inspection							
	A) Headspace						3-1-91	DH
	B) Trigger Pull	2.31	2.35	2.38	2.30	2.33	2/27/91	✓
	C) Function						3-1-91	DH
660	Pack						3-1-91	✓

SWS TRIGGER PULL TEST

BARBER - M24 0035433

AVERAGE PULL-FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C661175DATE 2-26-91TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.76	2.58	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.67	2.61	2.35	
PULL #3	2.63	2.66	2.61	2.38	
PULL #4	2.65	2.70	2.63	2.30	
PULL #5	2.66	2.49	2.32	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.35		
PULL #2	3.29	3.20		
PULL #3	3.25	3.26		
PULL #4	3.20	3.24		
PULL #5	3.21	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.38		4.31
PULL #2	4.40	4.22		4.22
PULL #3	4.31	4.25		4.30
PULL #4	4.38	4.30		4.30
PULL #5	4.25	4.27		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611756
27 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.218509
1 TO	2	.397334
1 TO	3	.276154
1 TO	4	.48073
1 TO	5	.641718

3
341 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.102
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .106982
THE AMR FOR THIS RIFLE IS: 1.042

27 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6811756

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 7

HS= 4.041

VS= 5.731

GS= 6.468

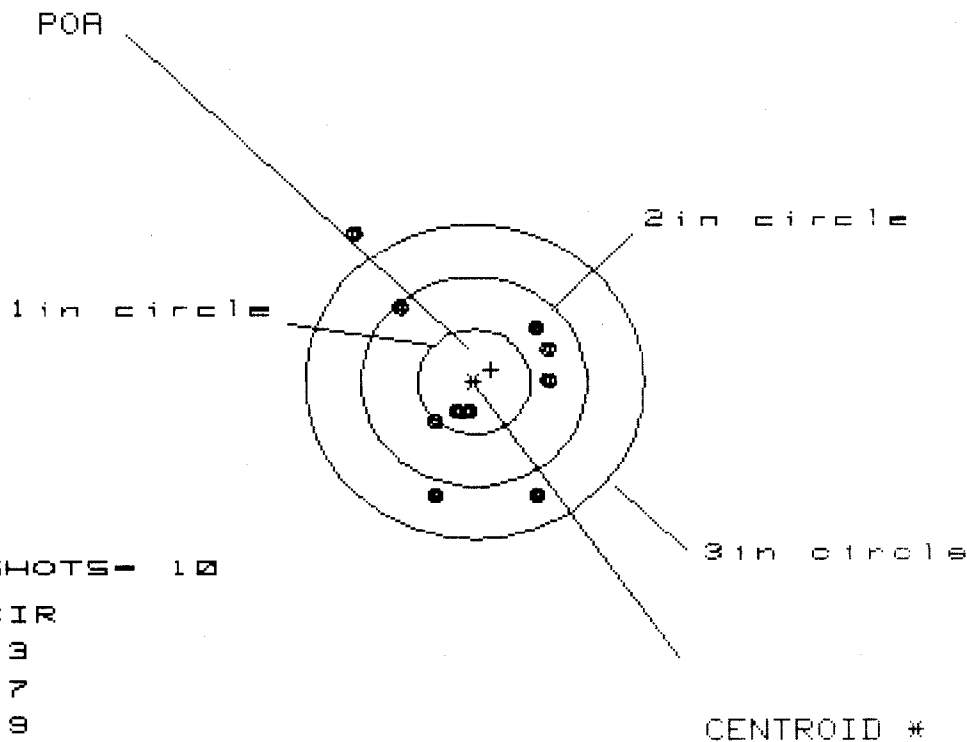
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.484	.745	.715
MINIMUM X	:	-1.557	-1.281	-1.311
MAXIMUM Y	:	2.612	.988	.635
MINIMUM Y	:	-3.119	-2.829	-.733
CENTROID X	:	.215	-.061	-.031
CENTROID Y	:	.039	-.251	.102
POA TO CENTROID in.	:	.219	.258	.107
MIN RADIUS	:	.082	.169	.278
MEAN RADIUS	:	1.198	.983	.690
MAX RADIUS	:	3.604	2.839	1.327
HORIZONTAL SPREAD	:	4.041	2.026	2.026
VERTICAL SPREAD	:	5.731	3.817	1.368
EXTREME SPREAD	:	6.468	3.905	2.064
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.756

VS= 2.553

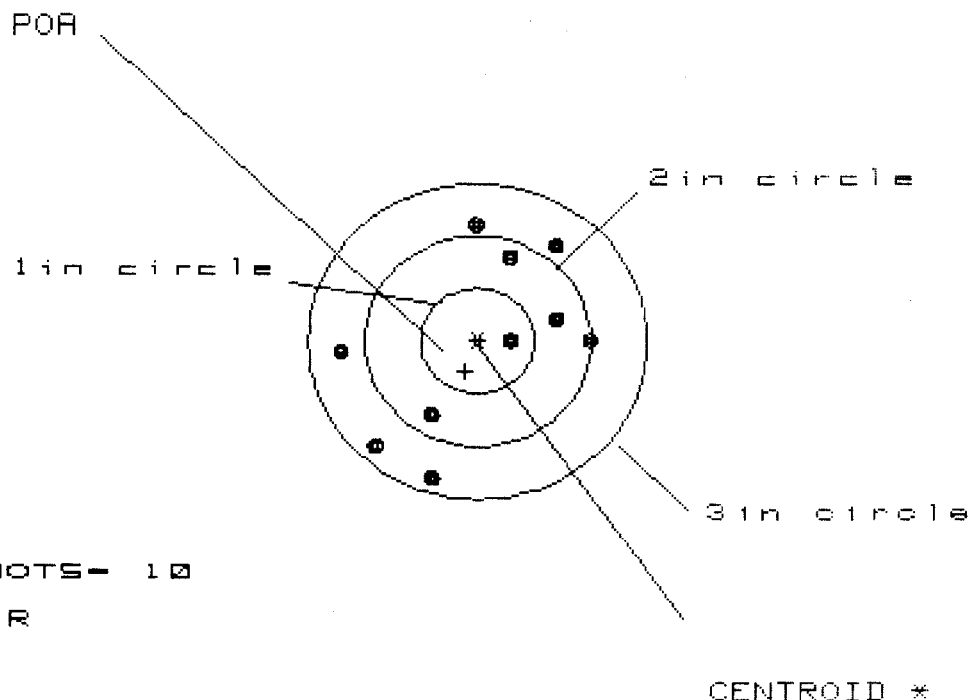
GS= 2.981

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.696	.578	.627
MINIMUM X	:	-1.060	-.758	-.709
MAXIMUM Y	:	1.464	.872	.759
MINIMUM Y	:	-1.089	-.926	-1.039
CENTROID X	:	-.150	-.032	-.081
CENTROID Y	:	-.118	-.281	-.168
POA TO CENTROID in.	:	.191	.283	.187
MIN RADIUS	:	.290	.188	.256
MEAN RADIUS	:	.835	.694	.660
MAX RADIUS	:	1.808	1.156	1.113
HORIZONTAL SPREAD	:	1.756	1.336	1.336
VERTICAL SPREAD	:	2.553	1.798	1.798
EXTREME SPREAD	:	2.981	2.119	1.880
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS= 2.176

VS= 2.410

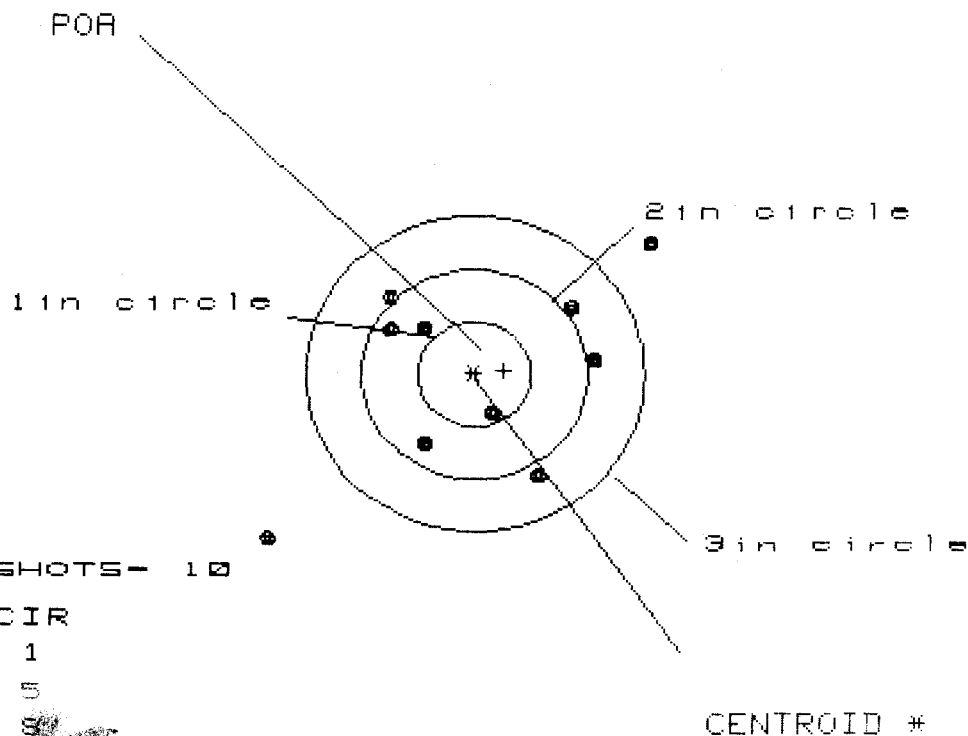
GS= 2.508

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.947	.826
MINIMUM X	:	-1.178	-1.229	-1.350
MAXIMUM Y	:	1.108	.963	.826
MINIMUM Y	:	-1.302	-1.102	-1.024
CENTROID X	:	.109	.160	.281
CENTROID Y	:	.294	.439	.576
POA TO CENTROID in.	:	.314	.467	.641
MIN RADIUS	:	.331	.325	.342
MEAN RADIUS	:	.997	.932	.823
MAX RADIUS	:	1.378	1.469	1.403
HORIZONTAL SPREAD	:	2.176	2.176	2.176
VERTICAL SPREAD	:	2.410	2.065	1.850
EXTREME SPREAD	:	2.508	2.485	2.181
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.374

VS= 2.757

GS= 4.357

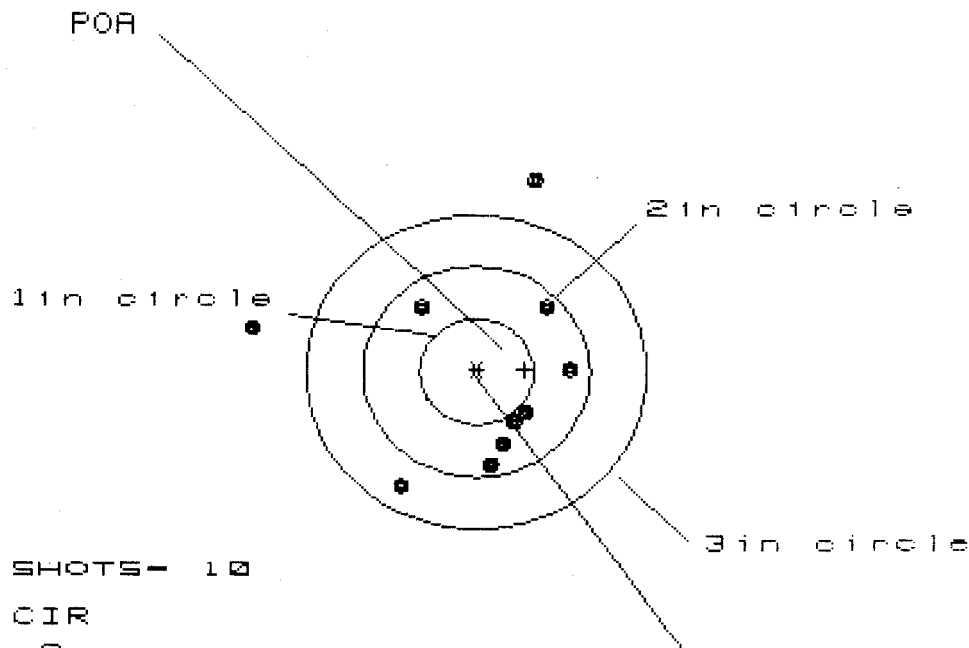
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.519	1.312	1.021
MINIMUM X	:	-1.855	-.990	-.825
MAXIMUM Y	:	1.227	1.057	.664
MINIMUM Y	:	-1.530	-1.159	-1.027
CENTROID X	:	-.260	-.053	-.218
CENTROID Y	:	-.035	.135	.003
POA TO CENTROID in.	:	.262	.145	.218
MIN RADIUS	:	.416	.344	.435
MEAN RADIUS	:	1.128	.986	.868
MAX RADIUS	:	2.405	1.685	1.166
HORIZONTAL SPREAD	:	3.374	2.302	1.846
VERTICAL SPREAD	:	2.757	2.216	1.691
EXTREME SPREAD	:	4.357	2.685	2.136
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 3

HS= 2.826

VS= 2.950

GS= 3.168

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.830	.608	.644
MINIMUM X	:	-1.996	-.871	-.835
MAXIMUM Y	:	1.869	1.912	.909
MINIMUM Y	:	-1.081	-1.038	-.798
CENTROID X	:	-.424	-.202	-.238
CENTROID Y	:	-.020	-.063	-.302
POA TO CENTROID in.	:	.424	.212	.385
MIN RADIUS	:	.587	.418	.250
MEAN RADIUS	:	1.054	.889	.693
MAX RADIUS	:	2.034	1.934	1.156
HORIZONTAL SPREAD	:	2.826	1.479	1.479
VERTICAL SPREAD	:	2.950	2.950	1.708
EXTREME SPREAD	:	3.168	3.168	2.118
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	