

C6611777

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

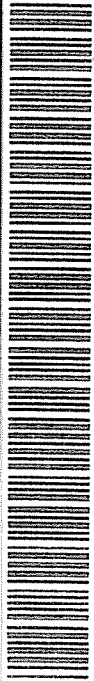
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6611777

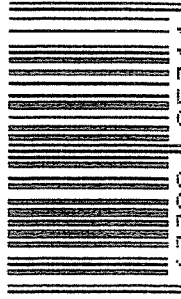
ORDER NO.
5716

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



5716 C6611777

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611777

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	"
615	Rollmark Caliber	APR 2	1991	LG
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	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		4/23/91	JK

op. #	BARBER M24 0035784	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/23/91	JU
	G) Safety Off Force	4	4	4			4/23/91	JU
	H) Trigger Pull Test & Retainability						4/23/91	JU
	I) Firing Pin Indent	.022	.0225	.0225			4/23/91	JU
	J) Assemble Stock						5/2/91	RW
	K) Assemble Swivel Studs						5-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/2/91	RW
	M) Iron Sight Alignment						5/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/2/91	RW
	O) Attach Scope to Rifle						5/2/91	RW
	P) Detach & Attach Scope 20 Times						5/2/91	RW
640	Gallery Target & Test						5-2-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-2-91	NF
655	Final Inspection							
	A) Headspace						5-14-91	D/H
	B) Trigger Pull	2.54	2.48	2.51	2.57	2.59	5/11/90	JU
	C) Function						5-14-91	D/H
660	Pack						6-14-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611777DATE 4/23/91TESTER JP.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.34	2.40	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.35	2.44	2.48	
PULL #3	2.37	2.35	2.38	2.51	
PULL #4	2.39	2.40	2.43	2.57	
PULL #5	2.32	2.38	2.44	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.15		
PULL #2	3.40	3.44		
PULL #3	3.39	3.32		
PULL #4	3.58	3.44		
PULL #5	3.51	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.53		4.25
PULL #2	4.25	4.45		4.40
PULL #3	4.21	4.30		4.39
PULL #4	4.43	4.48		4.39
PULL #5	4.45	4.51		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611777
2 May 1991

CENTROIDAL DISTANCES

0 TO	1	.140089
1 TO	2	.469315
1 TO	3	.200562
1 TO	4	.110476
1 TO	5	.145086

94
2

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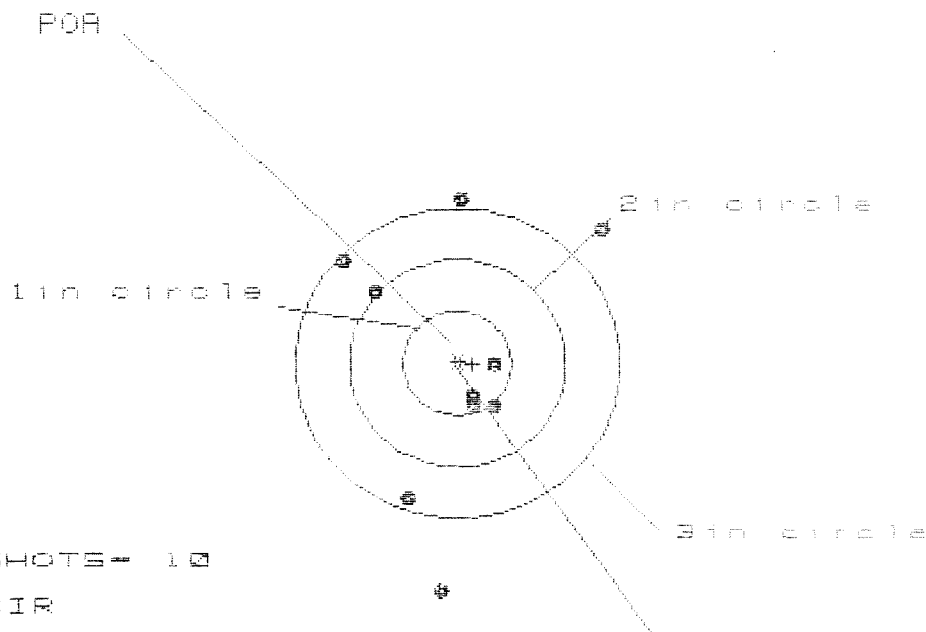
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0824
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156287

THE AMP FOR THIS RIFLE IS: 1.072

2 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611777

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 7

HS = 2.431

VS = 3.776

GS = 3.786

CENTROID =

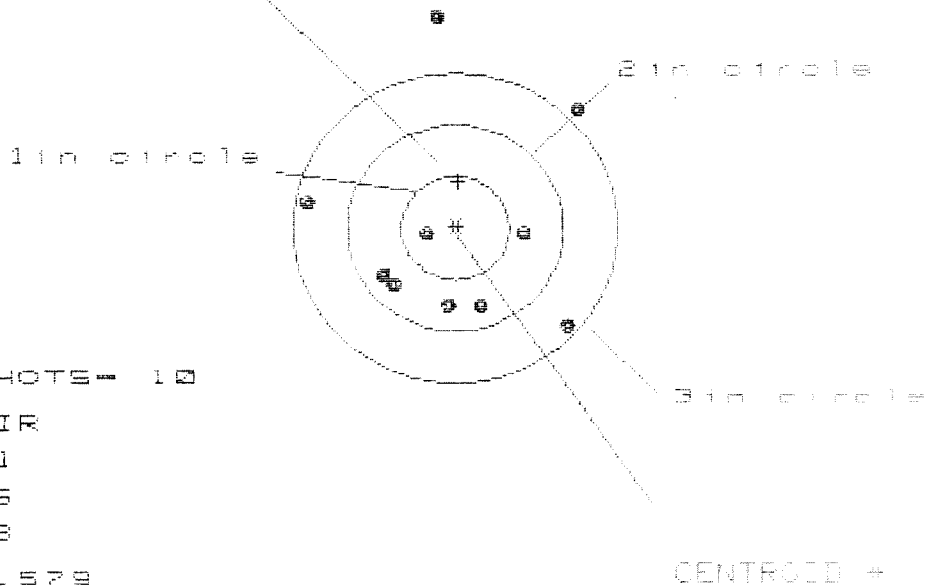
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.388	1.366	.535
MINIMUM X	-1.043	-1.065	-.895
MAXIMUM Y	1.618	1.379	1.507
MINIMUM Y	-2.158	-1.560	-1.432
CENTROID X	-.140	-.118	-.288
CENTROID Y	.005	.244	.116
POA TO CENTROID in.	.140	.271	.311
MIN RADIUS	.334	.410	.506
MEAN RADIUS	1.127	1.039	.939
MAX RADIUS	2.167	1.707	1.523
HORIZONTAL SPREAD	2.431	2.431	1.400
VERTICAL SPREAD	3.776	2.939	2.939
EXTREME SPREAD	3.786	3.200	2.994
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			7

2 May 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.579

VS = 3.017

GS = 3.252

CENTROID +

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.170
MINIMUM X	:	-1.409
MAXIMUM Y	:	2.026
MINIMUM Y	:	-0.991
CENTROID X	:	-0.029
CENTROID Y	:	-0.451
POA TO CENTROID in.	:	.452
MIN RADIUS	:	.243
MEAN RADIUS	:	1.053
MAX RADIUS	:	2.031
HORIZONTAL SPREAD	:	2.579
VERTICAL SPREAD	:	3.017
EXTREME SPREAD	:	3.252
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	8

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 3.691

VS = 2.790

GS = 3.938

CENTROID #

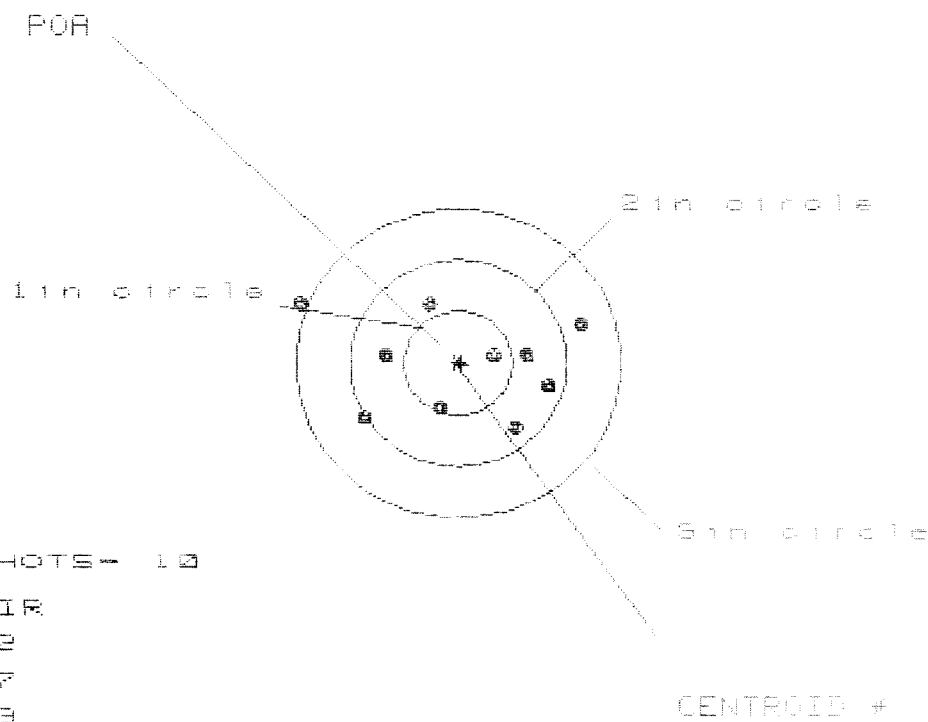
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.624
MINIMUM X	-2.067
MAXIMUM Y	1.584
MINIMUM Y	-1.206
CENTROID X	.011
CENTROID Y	-.127
POA TO CENTROID in.	.127
MIN RADIUS	.684
MEAN RADIUS	1.310
MAX RADIUS	2.073
HORIZONTAL SPREAD	3.691
VERTICAL SPREAD	2.790
EXTREME SPREAD	3.938
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.526

VS= 1.187

GS= 2.536

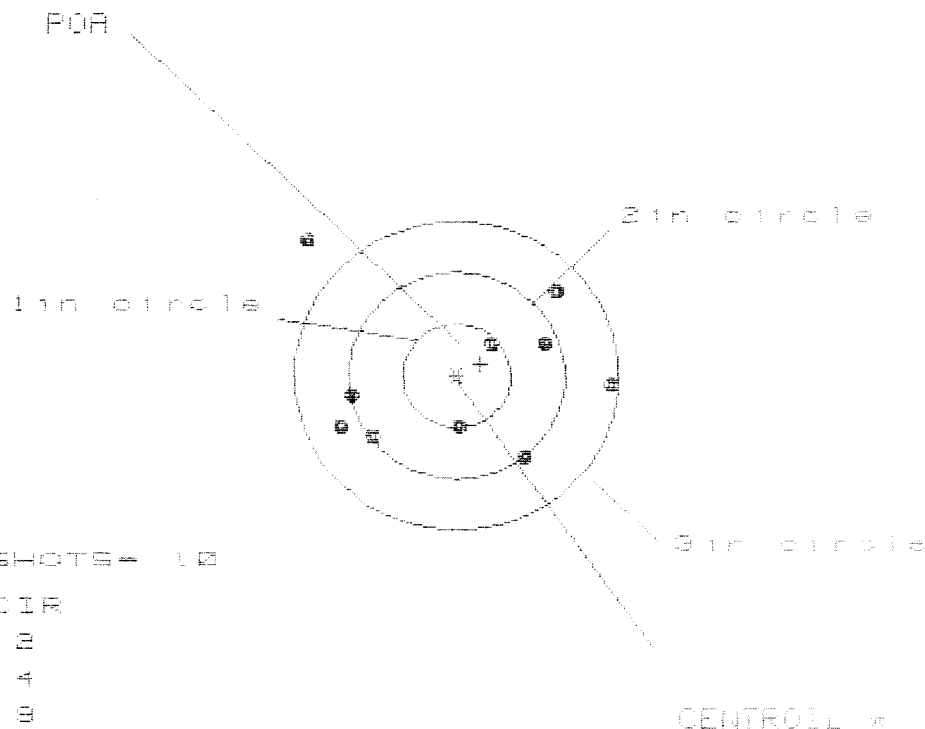
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.093	.933	.747
MINIMUM X	-1.433	-1.012	-.895
MAXIMUM Y	.589	.648	.704
MINIMUM Y	-.598	-.539	-.483
CENTROID X	-.001	.129	.012
CENTROID Y	.023	-.036	-.092
POA TO CENTROID in.	.038	.133	.093
MIN RADIUS	.297	.195	.317
MEAN RADIUS	.909	.703	.666
MAX RADIUS	1.528	1.127	.997
HORIZONTAL SPREAD	2.526	1.945	1.642
VERTICAL SPREAD	1.187	1.187	1.187
EXTREME SPREAD	2.536	2.165	1.682
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.790

VS = 2.103

GS = 3.124

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.452	1.303	1.899
MINIMUM X	-1.338	-1.226	-1.063
MAXIMUM Y	1.278	1.978	1.980
MINIMUM Y	-1.825	-1.583	-1.681
CENTROID X	-1.223	-1.074	-1.237
CENTROID Y	-1.114	-1.256	-1.258
POA TO CENTROID in.	1.250	1.267	1.350
MIN RADIUS	1.454	1.332	1.312
MEAN RADIUS	1.062	1.049	1.098
MAX RADIUS	1.850	1.303	1.330
HORIZONTAL SPREAD	2.790	2.529	1.962
VERTICAL SPREAD	2.103	1.561	1.661
EXTREME SPREAD	3.124	2.581	2.392
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	