

C6611795

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington





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

MODEL 700™ H24	SERIAL NO. C6611795
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.	ORDER NO. 5716

20



5716 C6611795

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611795**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	SL
617	Drill and Tap Sight Holes	2 2	91	FS
618	Polish Barrel <i>RBB</i>	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	KL
	C) Inspect Ejector Hole for Chamfer		2/18/91	KL
	D) Oil Firing Pin Ass'y		2/18/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		2-21-91	DH

op. #	BARBER M24 0036102	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 3/4			2-21-91	DH
	G) Safety Off Force	2 1/4	2 1/2	2 1/2			2-21-91	DH
	H) Trigger Pull Test & Retainability						2-21-91	DH
	I) Firing Pin Indent	.021 3/4	.021	.022			2-21-91	DH
	J) Assemble Stock						2/25/91	KS
	K) Assemble Swivel Studs						3/2/91	WB
	L) Attach Front and Rear Sight Assemblies						2/25/91	KS
	M) Iron Sight Alignment						2/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						2/25/91	KS
	O) Attach Scope to Rifle						2/25/91	KS
	P) Detach & Attach Scope 20 Times						2/25/91	KS
640	Gallery Target & Test						3/1/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						3/1/91	KS
655	Final Inspection						3/2/91	WB
	A) Headspace						3/2/91	WB
	B) Trigger Pull	2.65	2.60	2.55	2.51	2.32	3/2/91	KS
	C) Function						3/2/91	WB
660	Pack						3-18-91	KS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611795

DATE 2-27-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.38	2.48	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.38	2.47	2.60	
PULL #3	2.57	2.39	2.60	2.55	
PULL #4	2.54	2.41	2.58	2.51	
PULL #5	2.51	2.38	2.57	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.29		
PULL #2	3.16	3.08		
PULL #3	3.21	3.00		
PULL #4	3.19	2.97		
PULL #5	3.22	2.94		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.10		4.21
PULL #2	4.16	4.19		4.21
PULL #3	4.17	4.12		4.16
PULL #4	4.15	4.19		4.02
PULL #5	4.07	4.21		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611735
1 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.636756
1 TO	2	.519762
1 TO	3	.601791
1 TO	4	.820366
1 TO	5	.775761

$\frac{1}{5}$ <----POB

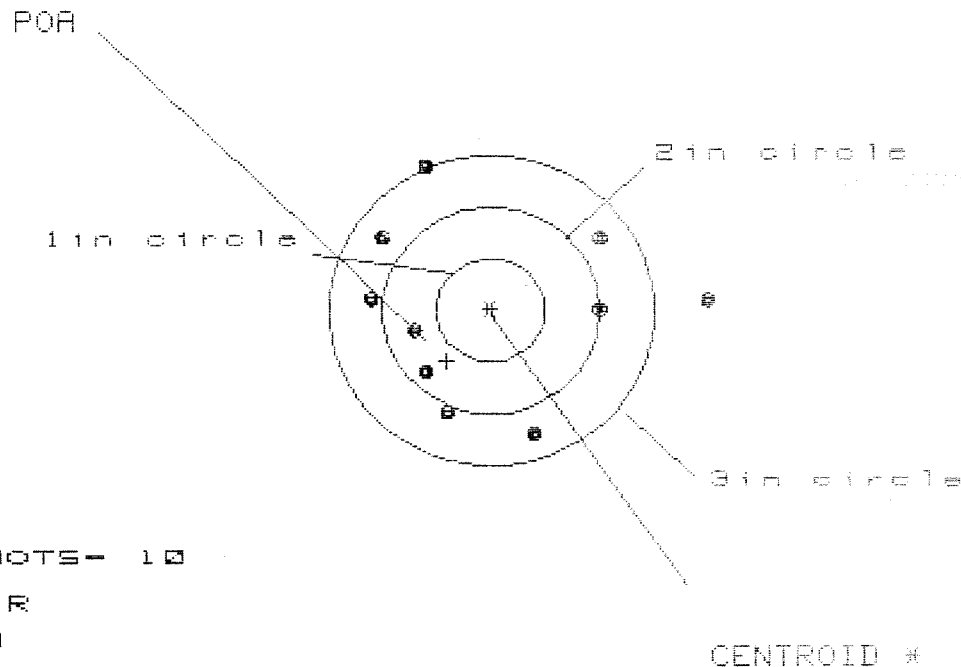
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0944
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0634
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113714
THE AMR FOR THIS RIFLE IS: 1.114

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11795

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS = 3.021

VS = 2.592

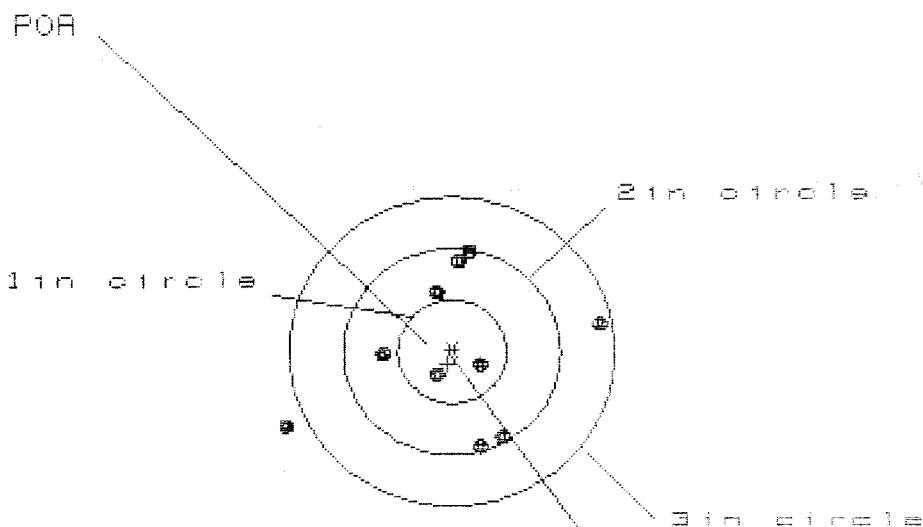
GS = 3.021

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.952	1.240	1.190
MINIMUM X	-1.069	-.852	-.982
MAXIMUM Y	1.393	1.402	.862
MINIMUM Y	-1.199	-1.190	-1.014
CENTROID X	.403	.186	.236
CENTROID Y	.493	.484	.388
POA TO CENTROID in.	.637	.518	.389
MIN RADIUS	.780	.570	.558
MEAN RADIUS	1.181	1.052	.981
MAX RADIUS	1.954	1.459	1.438
HORIZONTAL SPREAD	3.021	2.092	2.092
VERTICAL SPREAD	2.592	2.592	1.876
EXTREME SPREAD	3.021	2.787	2.368
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

1 Mar 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 8

3 in - 9

HS= 2.907

VS= 1.883

GS= 3.082

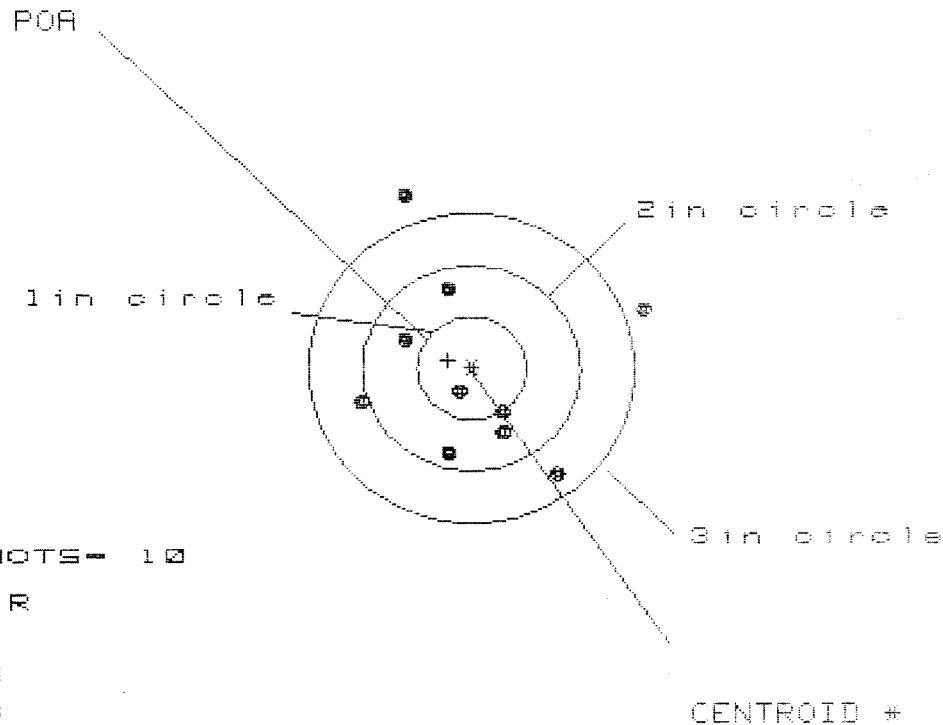
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.349	1.176	.446
MINIMUM X	:	-1.558	-.850	-.703
MAXIMUM Y	:	.931	.853	.884
MINIMUM Y	:	-.952	-1.030	-.999
CENTROID X	:	.040	.213	.066
CENTROID Y	:	.121	.199	.168
POA TO CENTROID in.	:	.128	.291	.180
MIN RADIUS	:	.238	.215	.267
MEAN RADIUS	:	.861	.766	.691
MAX RADIUS	:	1.706	1.203	1.018
HORIZONTAL SPREAD	:	2.907	2.026	1.148
VERTICAL SPREAD	:	1.883	1.883	1.883
EXTREME SPREAD	:	3.082	2.049	1.886
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.628

VS = 2.687

GS = 3.022

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.564
MINIMUM X	-1.064
MAXIMUM Y	1.714
MINIMUM Y	-.973
CENTROID X	.216
CENTROID Y	-.079
POA TO CENTROID in.	.230
MIN RADIUS	.297
MEAN RADIUS	.969
MAX RADIUS	1.816
HORIZONTAL SPREAD	2.628
VERTICAL SPREAD	2.687
EXTREME SPREAD	3.022
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8

1 Mar 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.726

VS= 3.934

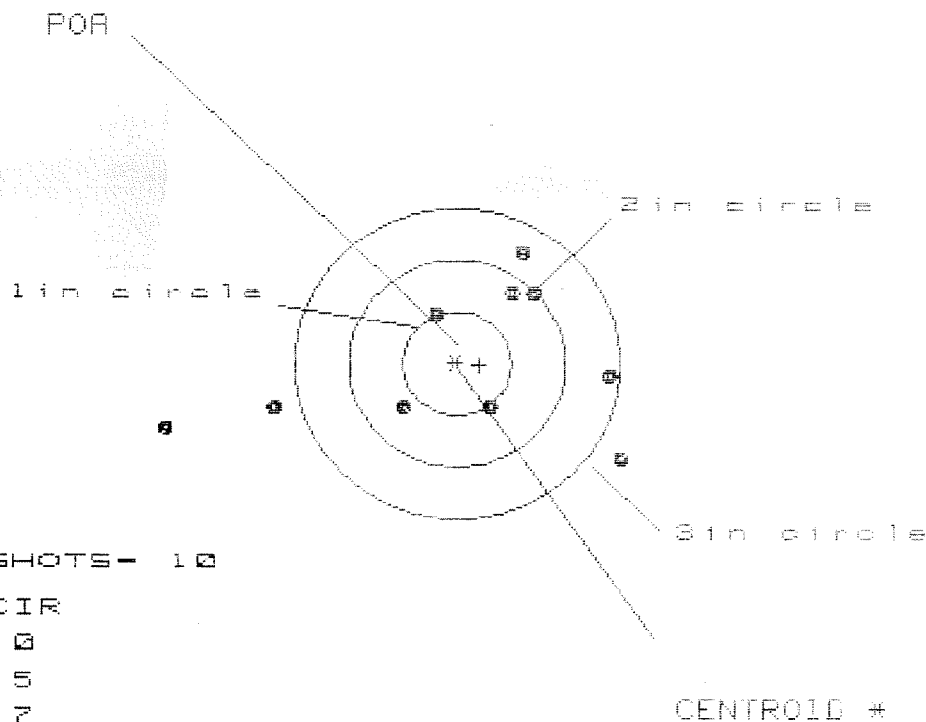
GS= 3.989

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	1.480	.912
MINIMUM X	:	-1.250	-1.086	-.981
MAXIMUM Y	:	1.812	1.576	1.191
MINIMUM Y	:	-2.122	-1.637	-1.440
CENTROID X	:	.021	-.143	-.329
CENTROID Y	:	-.233	.003	-.194
POA TO CENTROID in.	:	.234	.143	.382
MIN RADIUS	:	.523	.249	.467
MEAN RADIUS	:	1.305	1.110	.965
MAX RADIUS	:	2.585	2.163	1.545
HORIZONTAL SPREAD	:	2.726	2.566	1.813
VERTICAL SPREAD	:	3.934	3.213	2.631
EXTREME SPREAD	:	3.989	3.398	2.779
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS= 4.233

VS= 1.993

GS= 4.242

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.524
MINIMUM X	-2.709
MAXIMUM Y	1.075
MINIMUM Y	-1.917
CENTROID X	-1.208
CENTROID Y	.015
POA TO CENTROID in.	.209
MIN RADIUS	.533
MEAN RADIUS	1.255
MAX RADIUS	2.784
HORIZONTAL SPREAD	4.233
VERTICAL SPREAD	1.993
EXTREME SPREAD	4.242
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 7