

C6611798

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™ M24		SERIAL NO. C6611798
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611798



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26611798

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes	2 2 91		LB
618	Polish Barrel <i>PBB</i>	2 2 91		WB
620	Apply Coatings (Barrel Action)		2-11-91	TH
	Apply Coating (Bolt)			
625	Final Assembly		2/18/91	Kd
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	Kd
	C) Inspect Ejector Hole for Chamfer		2/18/91	Kd
	D) Oil Firing Pin Ass'y		2/18/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		2-21-91	DH

op. #	BARBER - M24 0036141 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	2-21-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	2-21-91	DH
	H) Trigger Pull Test & Retainability						2-21-91	DH
	I) Firing Pin Indent	.021	.020	.0205			2-21-91	DH
	J) Assemble Stock						2/25/91	KS
	K) Assemble Swivel Studs						2/27/91	KS
	L) Attach Front and Rear Sight Assemblies						2/27/91	KS
	M) Iron Sight Alignment						2/27/91	KS
	N) Detach Front & Rear Sights & place in numbered container						2/27/91	KS
	O) Attach Scope to Rifle						2/25/91	KS
	P) Detach & Attach Scope 20 Times						2/25/91	KS
640	Gallery Target & Test						2/24/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						2/26/91	KS
655	Final Inspection							
	A) Headspace						3-1-91	DH
	B) Trigger Pull	2.35	2.33	2.33	2.35	2.41	2-27-91	DH
	C) Function						3-1-91	DH
660	Pack						3-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611798DATE 2-21-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.42	2.43	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.45	2.62	2.33	
PULL #3	2.56	2.42	2.50	2.33	
PULL #4	2.57	2.45	2.64	2.35	
PULL #5	2.37	2.45	2.60	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.06		
PULL #2	3.20	3.10		
PULL #3	3.15	3.01		
PULL #4	3.14	3.06		
PULL #5	3.11	3.08		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.00		4.11
PULL #2	4.15	4.01		4.05
PULL #3	4.13	4.03		4.03
PULL #4	4.16	3.96		4.00
PULL #5	4.14	3.91		4.10
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611798
27 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.240071
1 TO	2	.454714
1 TO	3	.316166
1 TO	4	.22454
1 TO	5	.0915915

$\frac{4}{5}$
2.1 <----POA

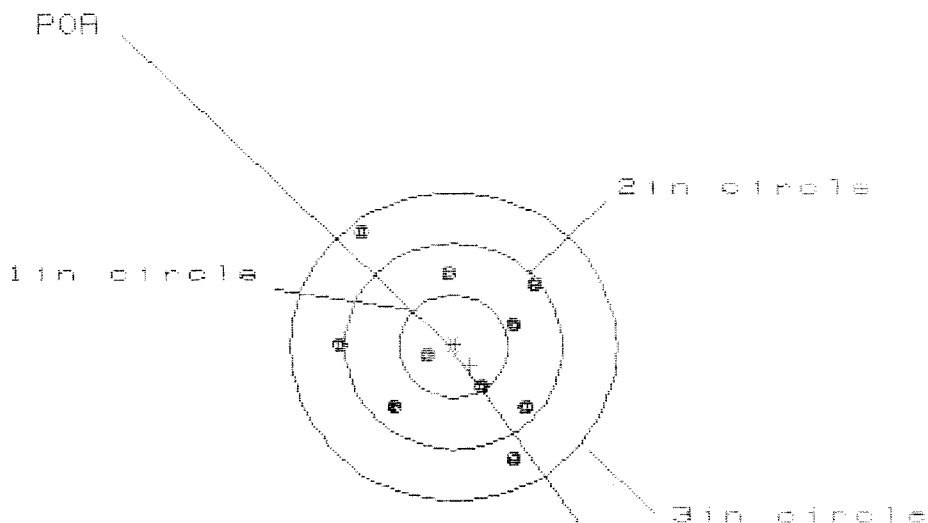
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0044
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148513

THE AMP FOR THIS RIFLE IS: .9218

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FILE:/PATTERNING/CENTERFIRE_PATT/C8811798

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.801

VS= 2.242

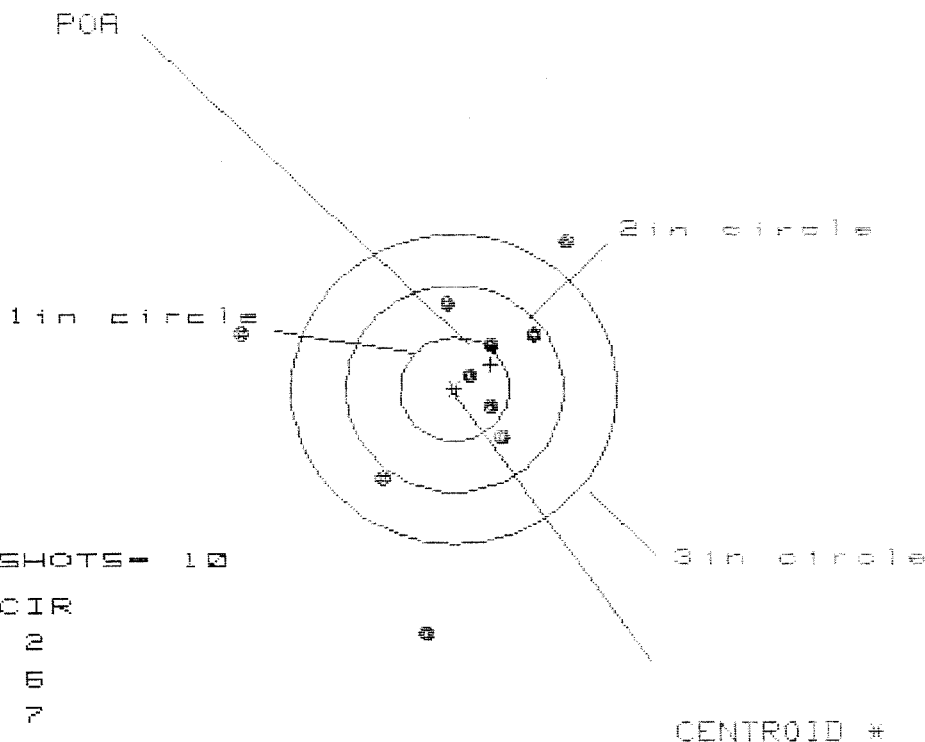
GS= 2.617

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.728	.636	.691
MINIMUM X	-1.073	-1.165	-1.110
MAXIMUM Y	1.133	.799	.677
MINIMUM Y	-1.109	-.983	-.595
CENTROID X	-.153	-.061	-.116
CENTROID Y	.185	.060	.182
POA TO CENTROID in.	.240	.085	.216
MIN RADIUS	.297	.280	.333
MEAN RADIUS	.839	.761	.720
MAX RADIUS	1.400	1.180	1.112
HORIZONTAL SPREAD	1.801	1.801	1.801
VERTICAL SPREAD	2.242	1.782	1.272
EXTREME SPREAD	2.617	1.983	1.888
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.028

VS = 3.761

GS = 3.970

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	1.022	.772
MINIMUM X	:	-1.981	-2.006	-.930
MAXIMUM Y	:	1.420	1.160	1.195
MINIMUM Y	:	-2.341	-1.127	-1.092
CENTROID X	:	-.332	-.307	-.057
CENTROID Y	:	-.233	.027	-.008
POA TO CENTROID in.	:	.406	.309	.057
MIN RADIUS	:	.172	.124	.198
MEAN RADIUS	:	1.072	.895	.703
MAX RADIUS	:	2.352	2.026	1.434
HORIZONTAL SPREAD	:	3.028	3.028	1.702
VERTICAL SPREAD	:	3.761	2.287	2.287
EXTREME SPREAD	:	3.970	3.152	2.851
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 1.803

VS = 2.997

GS = 3.205

CENTROID #

PATTERN #

-3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.915

.816

.834

MINIMUM X

-.888

-.964

-.946

MAXIMUM Y

1.329

1.144

.460

MINIMUM Y

-1.668

-.759

-.616

CENTROID X

.003

.102

.084

CENTROID Y

-.090

.095

-.040

POA TO CENTROID in.

.090

.140

.096

MIN RADIUS

.193

.167

.111

MEAN RADIUS

.830

.683

.616

MAX RADIUS

1.890

1.153

.946

HORIZONTAL SPREAD

1.803

1.780

1.780

VERTICAL SPREAD

2.997

1.903

1.876

EXTREME SPREAD

3.205

2.051

1.810

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

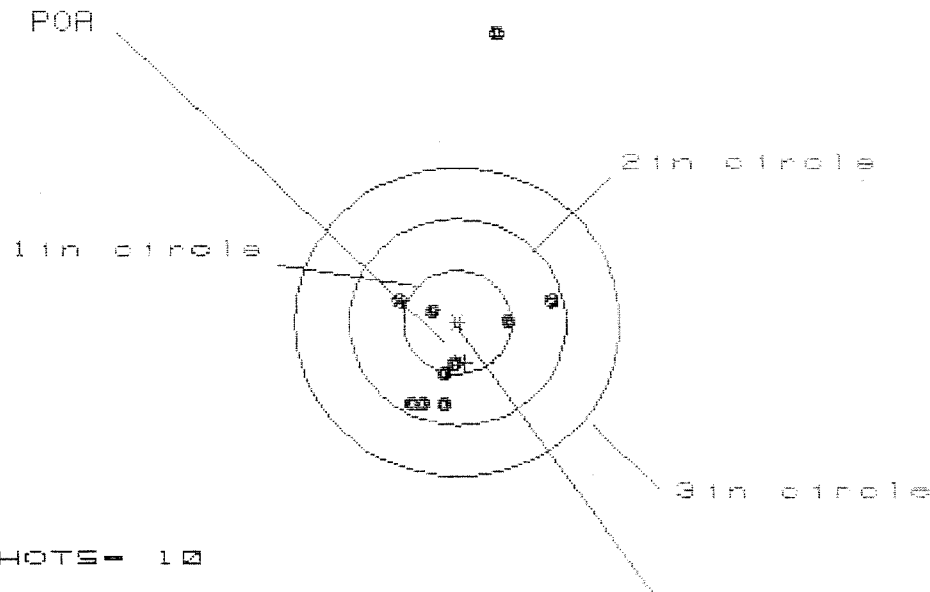
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 9

3 in - 9

HS - 1.386

VS - 3.641

GS - 3.739

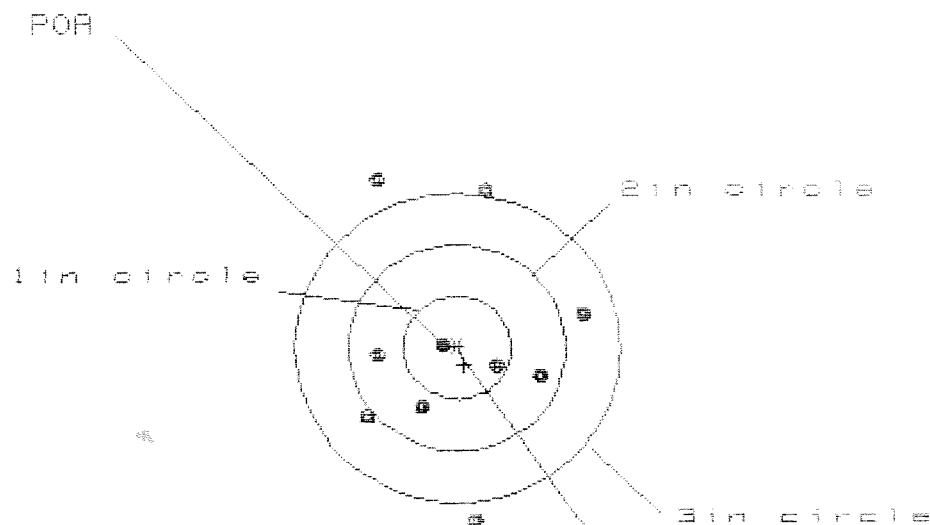
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.893	.938	.887
MINIMUM X	:	-.493	-.448	-.499
MAXIMUM Y	:	2.801	.548	.481
MINIMUM Y	:	-.840	-.528	-.553
CENTROID X	:	-.066	-.111	-.060
CENTROID Y	:	.392	.080	.147
POA TO CENTROID in.	:	.397	.137	.158
MIN RADIUS	:	.229	.106	.187
MEAN RADIUS	:	.851	.532	.531
MAX RADIUS	:	2.830	1.086	1.009
HORIZONTAL SPREAD	:	1.386	1.386	1.386
VERTICAL SPREAD	:	3.641	1.076	1.035
EXTREME SPREAD	:	3.739	1.722	1.579
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 5

3 in - 7

HS - 2.058

VS - 3.247

GS - 3.373

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	1.114	1.125
MINIMUM X	-0.862	-0.944	-0.933
MAXIMUM Y	1.591	1.668	1.483
MINIMUM Y	-1.656	-1.480	-1.686
CENTROID X	-0.063	.019	.008
CENTROID Y	.168	-.008	.177
POA TO CENTROID in.	.180	.021	.177
MIN RADIUS	.164	.314	.233
MEAN RADIUS	1.017	.917	.847
MAX RADIUS	1.754	1.678	1.496
HORIZONTAL SPREAD	2.058	2.058	2.058
VERTICAL SPREAD	3.247	3.148	2.169
EXTREME SPREAD	3.373	3.149	2.445
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	