

C6636048

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6636048

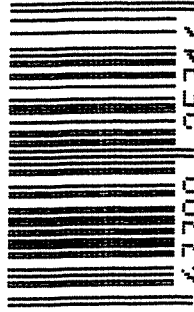
ORDER NO.
5716

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



5716 C6636048

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636048

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		GB.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB.
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)		5-31-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		6/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/10/91	KS
	C) Inspect Ejector Hole for Chamfer		6/10/91	KS
	D) Oil Firing Pin Ass'y		6/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	JA

op.	BARBER - M24 0037085	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-11-91	JH
	G) Safety Off Force	4	4	4			6-11-91	JH
	H) Trigger Pull Test & Retainability						6-11-91	JH
	I) Firing Pin Indent	.0215	.0215	.0215			6-11-91	JH
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6/12/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						6/12/91	KS
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.55	2.47	2.46	2.49	2.38	6-13-91	JH
	C) Function						6-13-91	AC
660	Pack						6-19-91	AC

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

SERIAL NO. 06636048DATE 6-11-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.36	2.39	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.32	2.33	2.47	
PULL #3	2.48	2.40	2.44	2.46	
PULL #4	2.42	2.36	2.35	2.49	
PULL #5	2.30	2.38	2.37	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.60		
PULL #2	3.17	3.69		
PULL #3	3.26	3.70		
PULL #4	3.47	3.70		
PULL #5	3.56	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.52		4.50
PULL #2	4.44	4.48		4.43
PULL #3	4.47	4.50		4.45
PULL #4	4.34	4.38		4.44
PULL #5	4.44	4.42		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636048
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.090377
1 TO	2	.0751665
1 TO	3	.0429535
1 TO	4	.0984124
1 TO	5	.414064

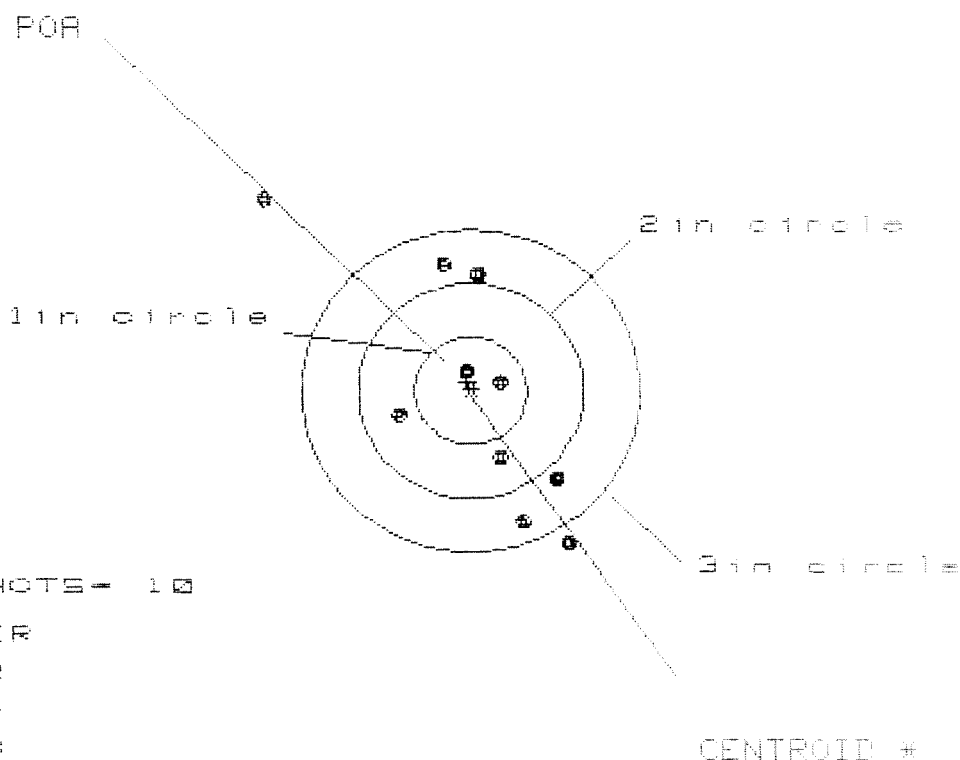
4 <----POA
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0328
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132329
THE AMP FOR THIS RIFLE IS: .8854

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08635848

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.686

VS= 3.211

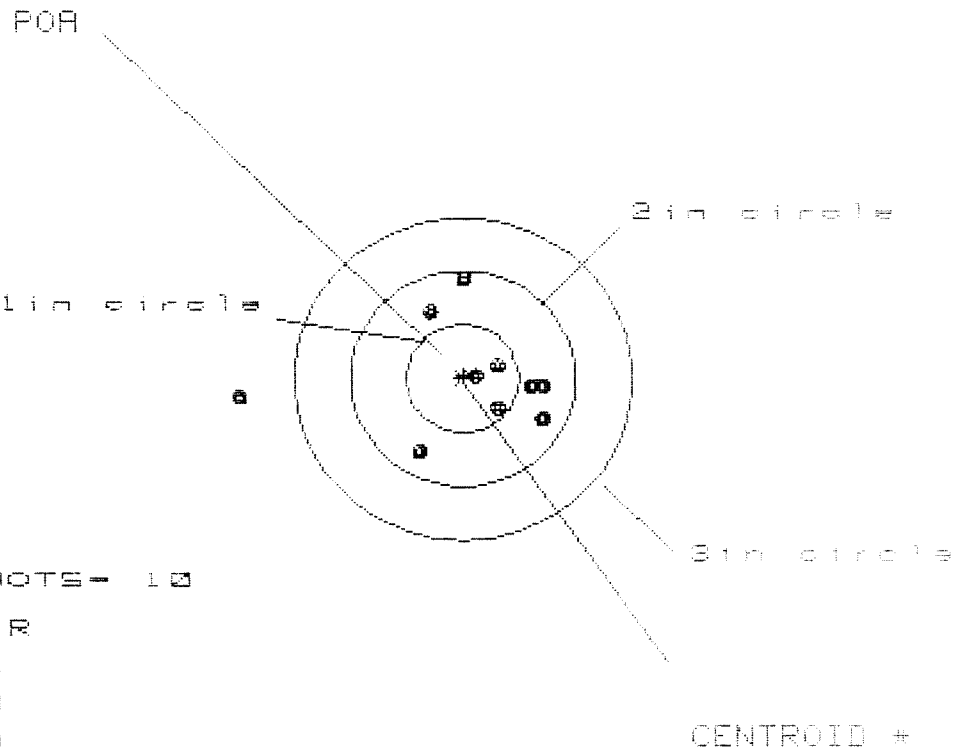
GS= 4.186

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.854	.650	.649
MINIMUM X	:	-1.833	-.796	-.715
MAXIMUM Y	:	1.781	1.370	1.216
MINIMUM Y	:	-1.430	-1.232	-1.260
CENTROID X	:	.038	.241	.160
CENTROID Y	:	-.082	-.280	-.126
POA TO CENTROID in.	:	.090	.370	.204
MIN RADIUS	:	.223	.248	.142
MEAN RADIUS	:	1.076	.892	.808
MAX RADIUS	:	2.556	1.434	1.260
HORIZONTAL SPREAD	:	2.686	1.446	1.364
VERTICAL SPREAD	:	3.211	2.602	2.416
EXTREME SPREAD	:	4.186	2.814	2.520
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

12 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 9

3 in - 9

HS- 2.786

VS- 1.593

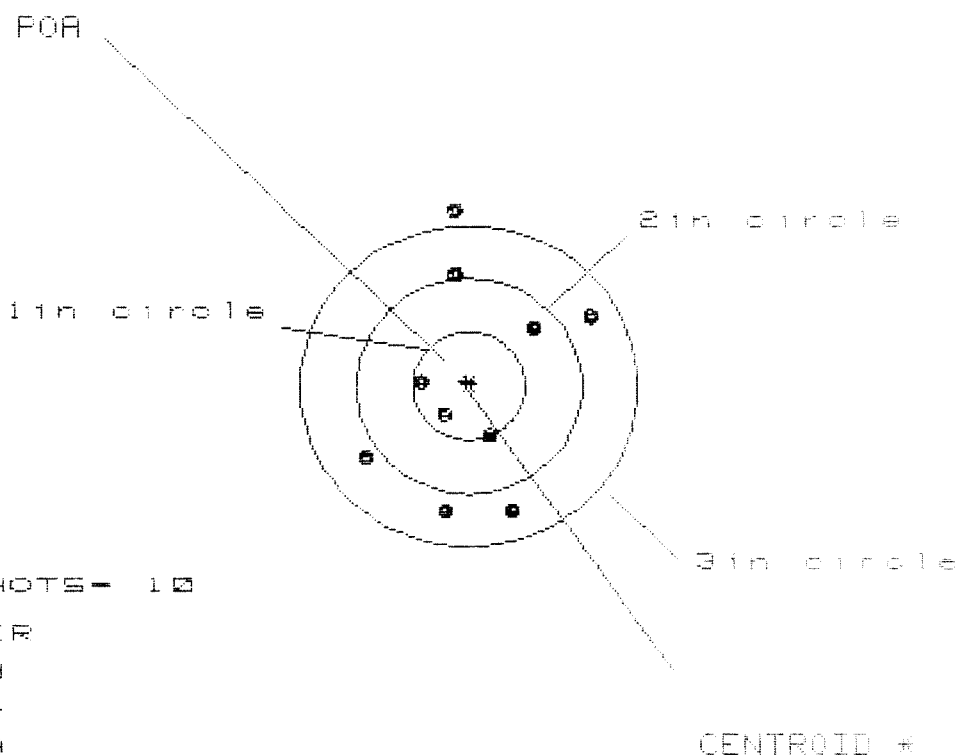
GS- 2.790

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.756	.530	.501
MINIMUM X	:	-2.030	-.664	-.693
MAXIMUM Y	:	.945	.924	.697
MINIMUM Y	:	-.649	-.669	-.553
CENTROID X	:	-.011	.215	.244
CENTROID Y	:	-.025	-.004	-.120
POA TO CENTROID in.	:	.027	.215	.271
MIN RADIUS	:	.084	.106	.109
MEAN RADIUS	:	.742	.533	.470
MAX RADIUS	:	2.039	.952	.887
HORIZONTAL SPREAD	:	2.786	1.194	1.194
VERTICAL SPREAD	:	1.593	1.593	1.250
EXTREME SPREAD	:	2.790	1.651	1.443
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 9

HS = 1.997

VS = 2.816

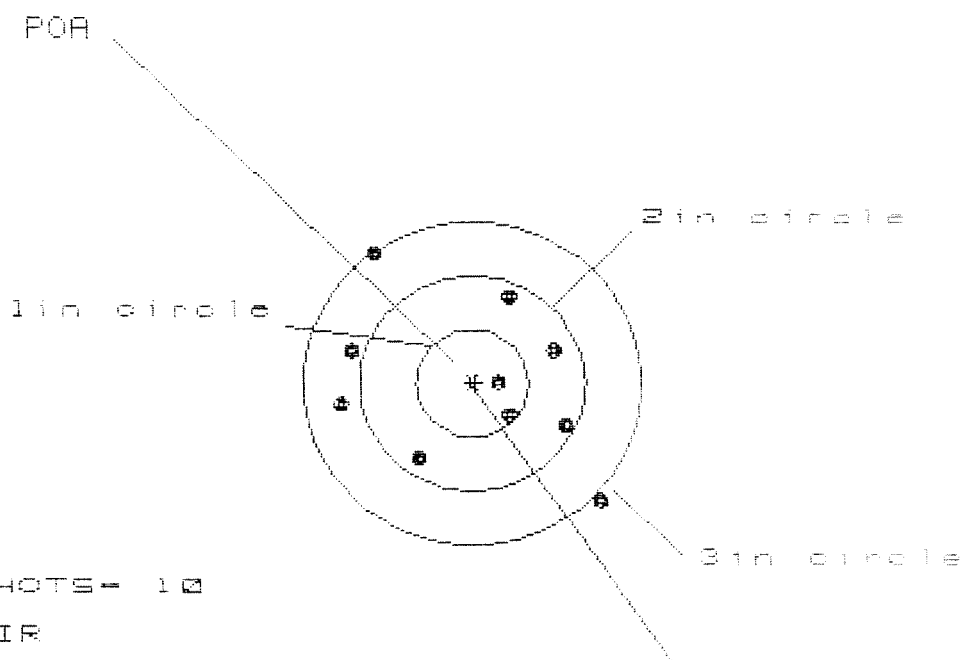
GS = 2.816

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.062	.653
MINIMUM X	:	-.916	-.935	-.802
MAXIMUM Y	:	1.622	1.194	1.293
MINIMUM Y	:	-1.194	-1.014	-.915
CENTROID X	:	.020	.039	-.094
CENTROID Y	:	-.043	-.223	-.322
POA TO CENTROID in.	:	.047	.226	.335
MIN RADIUS	:	.387	.303	.153
MEAN RADIUS	:	.951	.849	.757
MAX RADIUS	:	1.630	1.325	1.293
HORIZONTAL SPREAD	:	1.997	1.997	1.455
VERTICAL SPREAD	:	2.816	2.208	2.208
EXTREME SPREAD	:	2.816	2.370	2.210
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.326

VS= 2.318

GS= 3.083

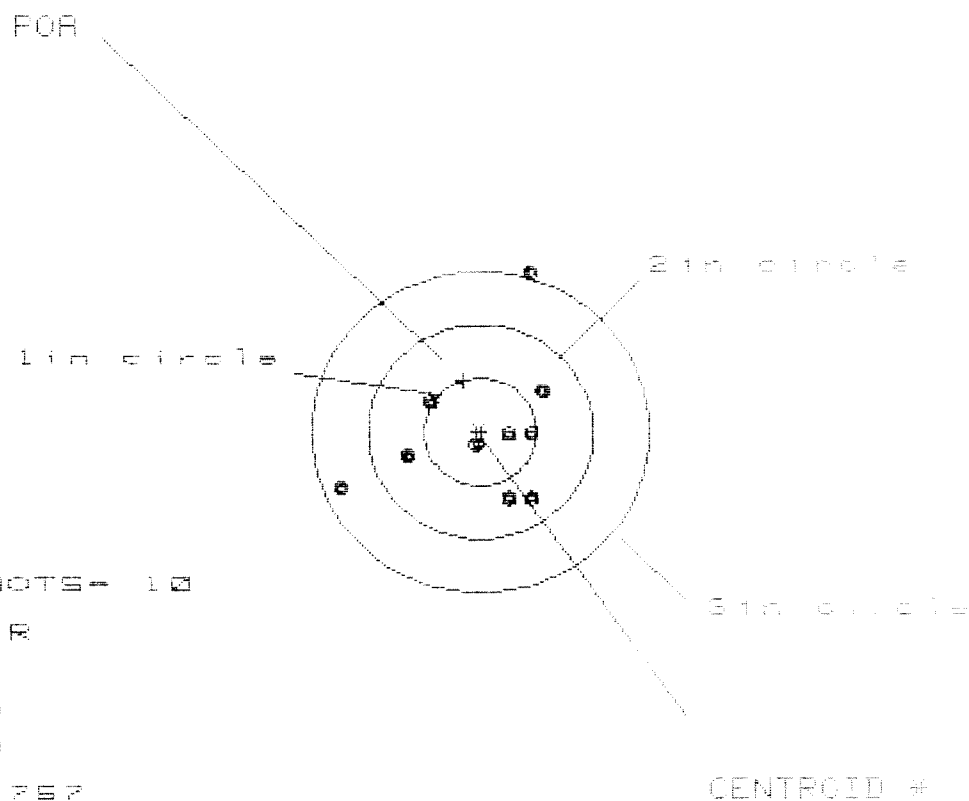
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.158	.913	.820
MINIMUM X	:	-1.178	-1.050	-1.143
MAXIMUM Y	:	1.252	1.134	.783
MINIMUM Y	:	-1.066	-.797	-.656
CENTROID X	:	-.028	-.156	-.063
CENTROID Y	:	-.009	.109	-.032
POA TO CENTROID in.	:	.029	.191	.071
MIN RADIUS	:	.212	.364	.247
MEAN RADIUS	:	.938	.886	.790
MAX RADIUS	:	1.574	1.357	1.149
HORIZONTAL SPREAD	:	2.336	1.963	1.963
VERTICAL SPREAD	:	2.318	1.931	1.439
EXTREME SPREAD	:	3.083	2.345	1.981
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.757

VS= 2.162

GS= 2.626

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.539	.593	.446
MINIMUM X	:	-1.228	-1.174	-1.787
MAXIMUM Y	:	1.496	.584	.542
MINIMUM Y	:	-.686	-.499	-.548
CENTROID X	:	.145	.091	.238
CENTROID Y	:	-.482	-.649	-.607
FOR TO CENTROID in.	:	.504	.655	.652
MIN RADIUS	:	.165	.029	.166
MEAN RADIUS	:	.720	.605	.507
MAX RADIUS	:	1.573	1.219	.795
HORIZONTAL SPREAD	:	1.767	1.767	1.233
VERTICAL SPREAD	:	2.162	1.083	1.083
EXTREME SPREAD	:	2.626	1.989	1.398
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	