

C6636068

MODEL 700™ M24

Model **SMS**™

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.
C6636068

ORDER NO.
5716

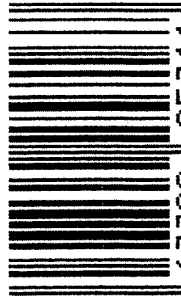
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636068

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636068

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	SS.
615	Rollmark Caliber		4/10/91	11
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5-22-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5-22-91	KS
	C) Inspect Ejector Hole for Chamfer		5-22-91	KS
	D) Oil Firing Pin Ass'y		5-22-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-23-91	TH

op. BARBER - M24 0037322		READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5	5	5	5-23-91	PH
	G) Safety Off Force	3	3	3	3	3	5-23-91	PH
	H) Trigger Pull Test & Retainability						5-23-91	PH
	I) Firing Pin Indent	1.020	2.021	1.020			5-23-91	PH
	J) Assemble Stock						5/23/91	KS
	K) Assemble Swivel Studs						6-1-91	PH
	L) Attach Front and Rear Sight Assemblies						5/23/91	KS
	M) Iron Sight Alignment						5/23/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	KS
	O) Attach Scope to Rifle						5/23/91	KS
	P) Detach & Attach Scope 20 Times						5/23/91	KS
640	Gallery Target & Test						5-25-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-25-91	AF
655	Final Inspection							
	A) Headspace						6-1-91	PH
	B) Trigger Pull	2.49	2.46	2.38	2.46	2.46	6-1-91	PH
	C) Function						6-1-91	PH
660	Pack						6-20-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636068

DATE 5-23-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.37	2.59	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.28	2.62	2.46	
PULL #3	2.30	2.37	2.65	2.38	
PULL #4	2.44	2.36	2.63	2.46	
PULL #5	2.48	2.38	2.55	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.62		
PULL #2	3.60	3.45		
PULL #3	3.58	3.62		
PULL #4	3.59	3.72		
PULL #5	3.51	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.29		4.21
PULL #2	4.35	4.35		4.14
PULL #3	4.33	4.32		4.13
PULL #4	4.34	4.38		4.15
PULL #5	4.34	4.35		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636068
25 May 1991

CENTROIDAL DISTANCES

0 TO	1	.276682
1 TO	2	.837225
1 TO	3	.687922
1 TO	4	.244761
1 TO	5	.395548

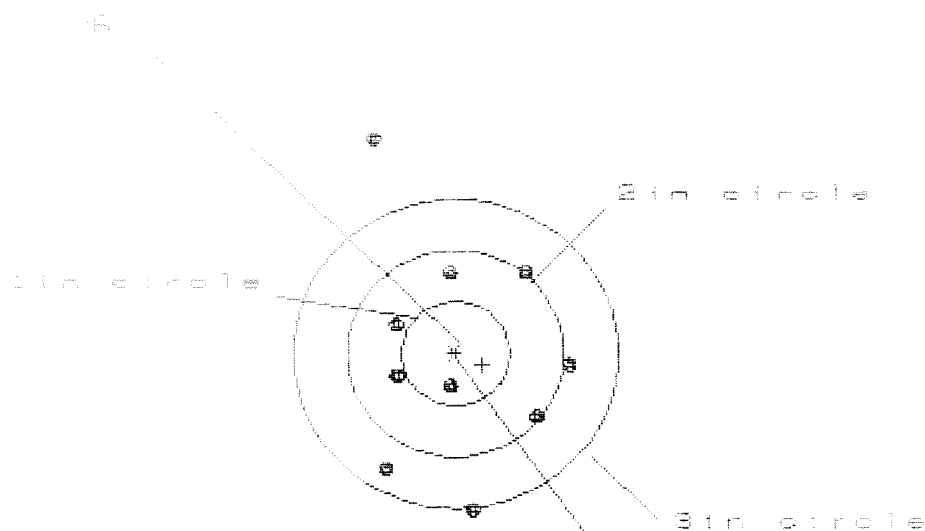
14_3^2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1552
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155867
THE AMR FOR THIS RIFLE IS: 1.091

25 MAR 1961

FILE:/PATTERNING/CENTERFIRE_PATT/08036088

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.788

VS= 3.568

GS= 3.688

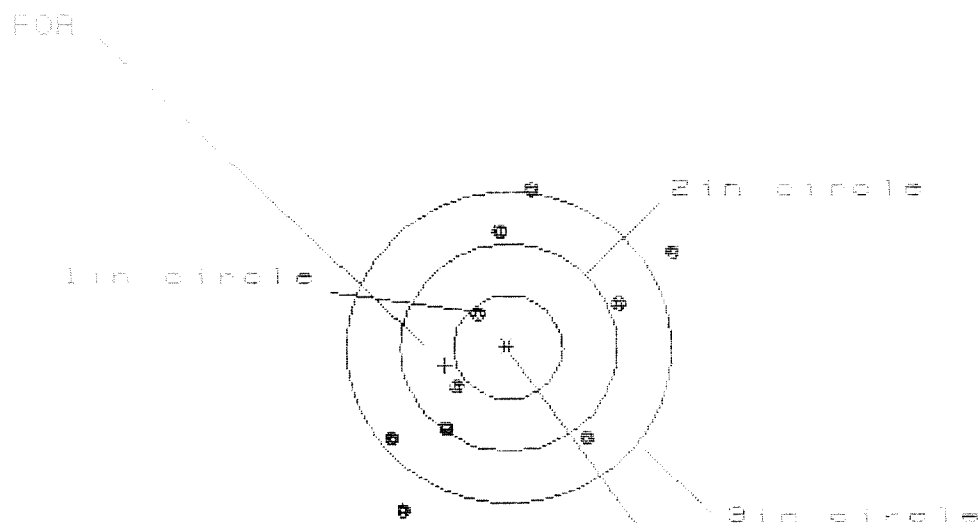
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	.923	.932
MINIMUM X	-.778	-.764	-.755
MAXIMUM Y	2.038	1.057	.894
MINIMUM Y	-1.530	-1.303	-1.053
CENTROID X	-.253	-.166	-.175
CENTROID Y	.112	-.114	.049
POA TO CENTROID in.	.277	.201	.182
MIN RADIUS	.322	.138	.274
MEAN RADIUS	1.047	.895	.841
MAX RADIUS	2.182	1.305	1.328
HORIZONTAL SPREAD	1.788	1.687	1.687
VERTICAL SPREAD	3.568	2.360	1.987
EXTREME SPREAD	3.688	2.369	2.046
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

25 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 2.558

VS = 3.378

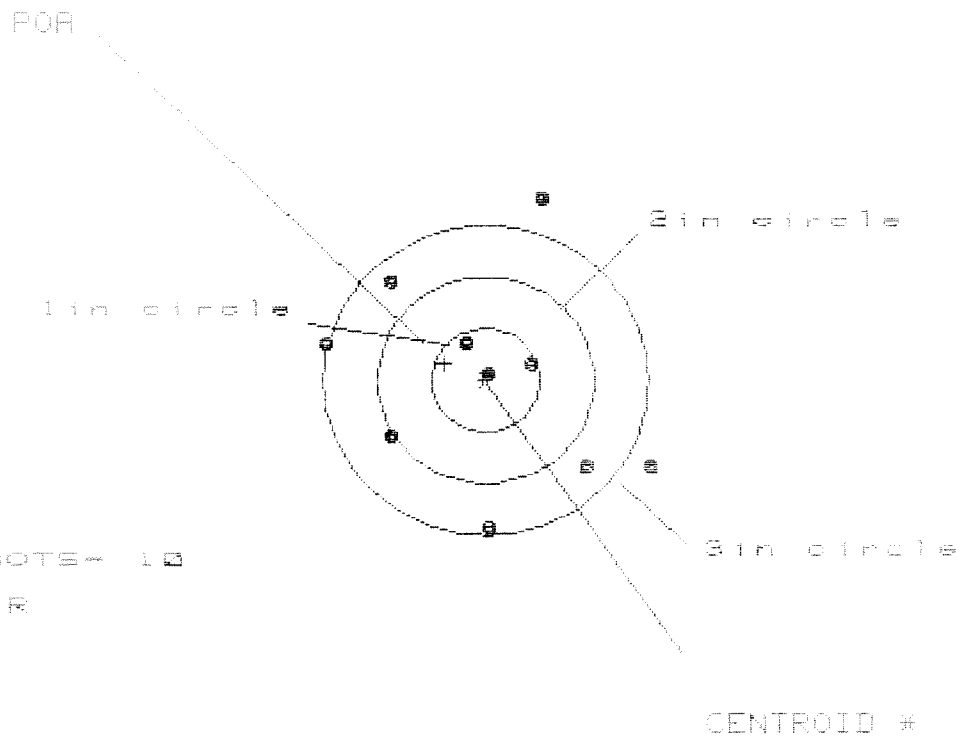
GS = 3.511

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.489	1.378	1.077
MINIMUM X	-1.069	-1.180	-1.008
MAXIMUM Y	1.533	1.362	1.458
MINIMUM Y	-1.537	-1.010	-0.913
CENTROID X	.582	.693	.521
CENTROID Y	.173	.344	.247
FOR TO CENTROID in.	.607	.774	.577
MIN RADIUS	.429	.446	.343
MEAN RADIUS	1.184	1.111	1.023
MAX RADIUS	1.834	1.578	1.493
HORIZONTAL SPREAD	2.558	2.558	2.085
VERTICAL SPREAD	3.078	2.372	2.372
EXTREME SPREAD	3.511	3.115	2.719
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

25 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 8

HS= 3.862

VS= 3.154

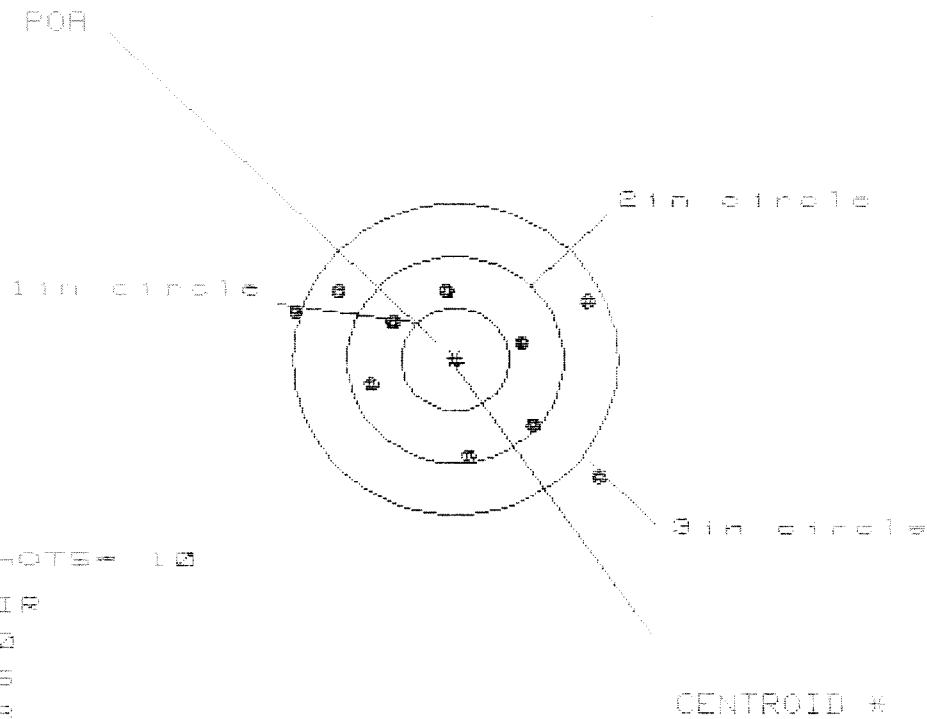
GS= 3.206

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.528	1.583	1.182
MINIMUM X	-1.434	-1.379	-1.181
MAXIMUM Y	1.747	1.127	1.046
MINIMUM Y	-1.407	-1.212	-1.293
CENTROID X	.378	.323	.125
CENTROID Y	-.162	-.357	-.276
POA TO CENTROID in.	.412	.481	.303
MIN RADIUS	.043	.242	.294
MEAN RADIUS	1.102	1.045	.948
MAX RADIUS	1.817	1.709	1.407
HORIZONTAL SPREAD	2.962	2.962	2.363
VERTICAL SPREAD	3.154	2.339	2.339
EXTREME SPREAD	3.206	3.206	2.680
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

25 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 8

HS = 2.748

VS = 1.840

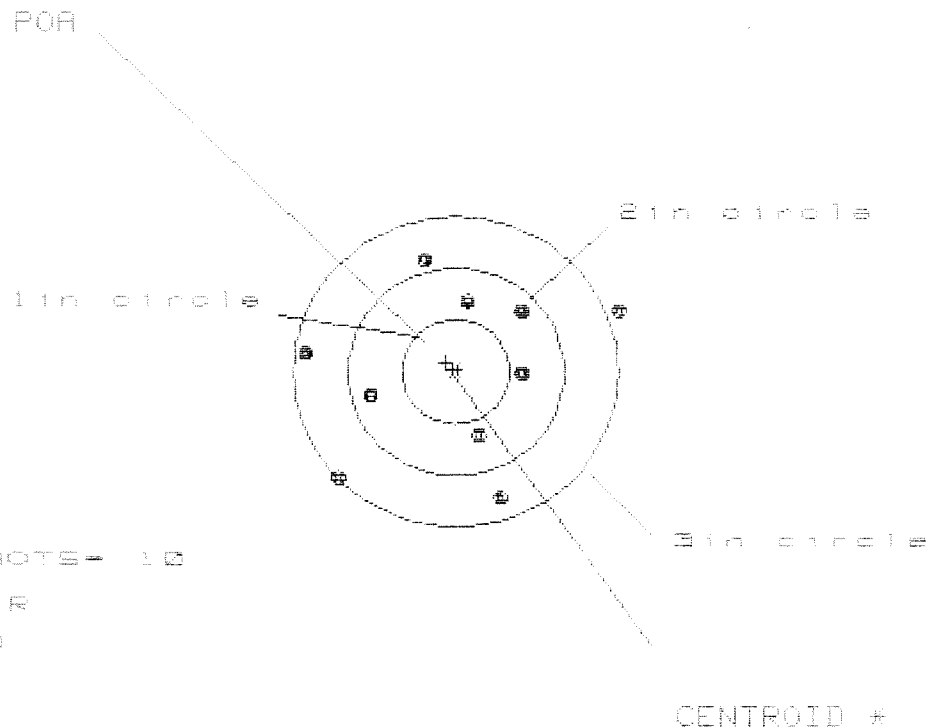
GS = 2.178

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.325	1.164
MINIMUM X	:	-1.439	-1.294	-1.090
MAXIMUM Y	:	.706	.580	.623
MINIMUM Y	:	-1.134	-1.018	-.976
CENTROID X	:	-.021	-.166	-.085
CENTROID Y	:	.034	.160	.117
POR TO CENTROID in.	:	.040	.231	.118
MIN RADIUS	:	.648	.518	.616
MEAN RADIUS	:	1.056	.960	.910
MAX RADIUS	:	1.730	1.395	1.258
HORIZONTAL SPREAD	:	2.746	2.619	2.254
VERTICAL SPREAD	:	1.840	1.598	1.596
EXTREME SPREAD	:	3.178	2.621	2.259
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

25 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 5

HS= 2.846

VS= 2.322

GS= 3.072

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.543	.824	.713
MINIMUM X	-1.403	-1.231	-1.342
MAXIMUM Y	1.104	1.168	1.044
MINIMUM Y	-1.218	-1.154	-1.277
CENTROID X	.090	-.082	.029
CENTROID Y	-.085	-.149	-.026
POA TO CENTROID in.	.124	.170	.039
MIN RADIUS	.683	.596	.672
MEAN RADIUS	1.066	1.000	.940
MAX RADIUS	1.647	1.330	1.357
HORIZONTAL SPREAD	2.946	2.055	2.055
VERTICAL SPREAD	2.322	2.322	2.322
EXTREME SPREAD	3.072	2.428	2.428
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	5		