

C6636078

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

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

MODEL 700TM M24

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

DUPONT

SERIAL NO. C6636078	ORDER NO. 5716
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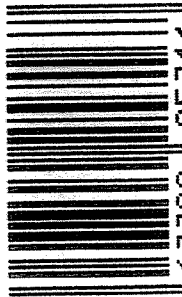
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636078

LPC



0 47700 25716 7

ABILITY

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636078

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	RR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	GS
617	Drill and Tap Sight Holes		APR 10 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	AS

op. #	BARBER M24 0037442	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	5/29/91	JS
	G) Safety Off Force	4	4	4	4	4	5/29/91	JS
	H) Trigger Pull Test & Retainability						6/29/91	JS
	I) Firing Pin Indent	1.0215	1.0225	1.0225	1.0225	1.0225	5/29/91	JS
	J) Assemble Stock						5/29/91	KS
	K) Assemble Swivel Studs						6-3-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	KS
	M) Iron Sight Alignment						5/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	KS
	O) Attach Scope to Rifle						5/29/91	KS
	P) Detach & Attach Scope 20 Times						5/29/91	KS
640	Gallery Target & Test						5/30/91	KS
	A) Time						5/30/91	KS
	B) Malfunctions						5/30/91	KS
	C) Pierced Primers						5/30/91	KS
	D) Optical Clarity of Scope						5/30/91	KS
645	Inspect for Live Ammo						5/30/91	KS
655	Final Inspection							
	A) Headspace						6-3-91	DH
	B) Trigger Pull	2.37	2.18	2.35	2.38	2.35	6/3/91	JS
	C) Function						6-3-91	DH
660	Pack						6-14-91	NE

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

SERIAL NO. C6636078DATE 5/29/91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.42	2.45	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.42	2.35	2.18	
PULL #3	2.28	2.15	2.33	2.35	
PULL #4	2.43	2.38	2.30	2.38	
PULL #5	2.37	2.43	2.39	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.15		
PULL #2	3.24	3.22		
PULL #3	3.52	3.16		
PULL #4	3.41	3.54		
PULL #5	3.42	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.52		4.18
PULL #2	4.40	4.48		4.45
PULL #3	4.36	4.45		4.52
PULL #4	4.53	4.31		4.44
PULL #5	4.61	4.52		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636078
30 May 1991

CENTROIDAL DISTANCES

0 TO	1	1.16503
1 TO	2	1.20812
1 TO	3	1.11881
1 TO	4	.884489
1 TO	5	1.26716

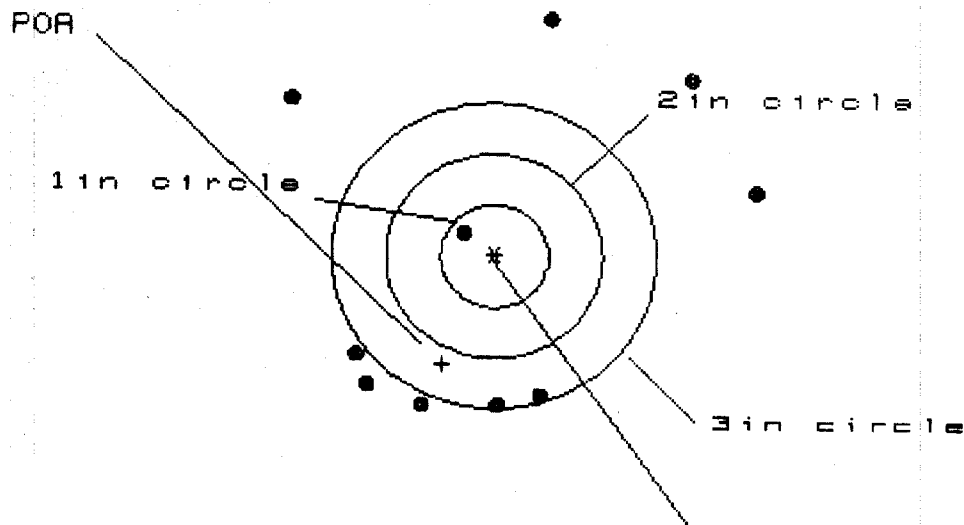
1
2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3166
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1956
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .372149
THE AMR FOR THIS RIFLE IS: 1.299

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636078

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 1

3in = 3

HM = 4.315

VS = 3.845

GS = 4.404

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.465	2.141	1.027
MINIMUM X	:	-1.850	-1.577	-1.309
MAXIMUM Y	:	2.349	2.422	2.643
MINIMUM Y	:	-1.496	-1.423	-1.202
CENTROID X	:	.479	.206	-.062
CENTROID Y	:	1.062	.989	.768
POA TO CENTROID in.	:	1.165	1.010	.770
MIN RADIUS	:	.359	.341	.637
MEAN RADIUS	:	1.806	1.674	1.471
MAX RADIUS	:	2.550	2.780	2.836
HORIZONTAL SPREAD	:	4.315	3.718	2.336
VERTICAL SPREAD	:	3.845	3.845	3.845
EXTREME SPREAD	:	4.404	4.220	4.022
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	3		

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636078

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 3.301

VS= 3.351

GS= 4.355

PATTERN #

24

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.587	1.397	1.437
MINIMUM X	-1.714	-1.282	-1.242
MAXIMUM Y	1.188	1.000	1.706
MINIMUM Y	-2.163	-2.351	-1.686
CENTROID X	.610	.800	.760
CENTROID Y	-.139	.049	.343
POR TO CENTROID in.	.626	.802	.934
MIN RADIUS	.381	.373	.262
MEAN RADIUS	1.304	1.170	.978
MAX RADIUS	2.410	2.373	1.583
HORIZONTAL SPREAD	3.301	2.679	2.679
VERTICAL SPREAD	3.351	3.351	1.392
EXTREME SPREAD	4.355	3.478	2.899
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636078

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.584

VS= 1.894

GS= 2.629

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.454

.698

.577

MINIMUM X

-1.139

-.969

-.498

MAXIMUM Y

.893

.928

.911

MINIMUM Y

-1.001

-.966

-.983

CENTROID X

.169

.068

.129

CENTROID Y

-.013

-.048

-.031

POA TO CENTROID in.

.170

.048

.133

MIN RADIUS

.224

.197

.197

MEAN RADIUS

.814

.732

.688

MAX RADIUS

1.487

1.085

1.022

HORIZONTAL SPREAD

2.584

1.667

1.075

VERTICAL SPREAD

1.894

1.894

1.894

EXTREME SPREAD

2.629

1.962

1.962

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

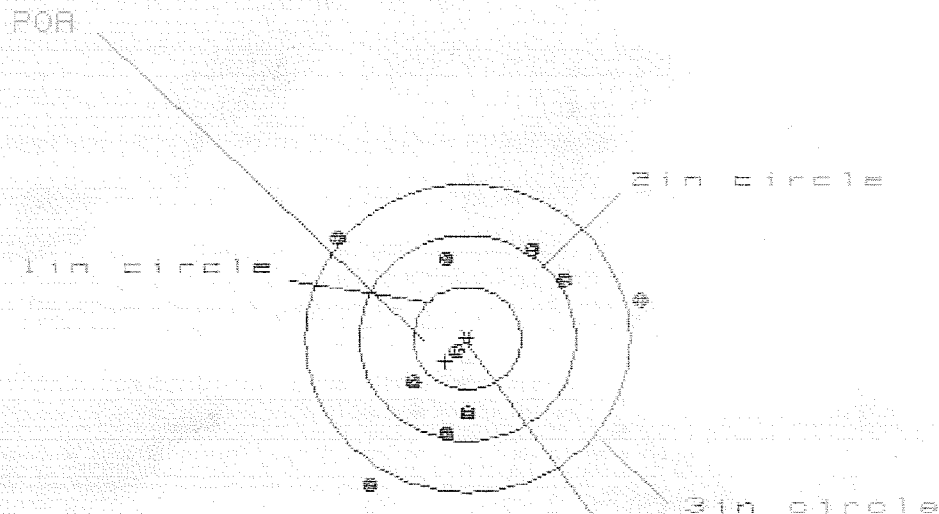
NUMBER IN THREE INCH CIRCLE =

10

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636078

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 2.787

VS= 2.454

GS= 3.032

CENTROID #

PATTERN #

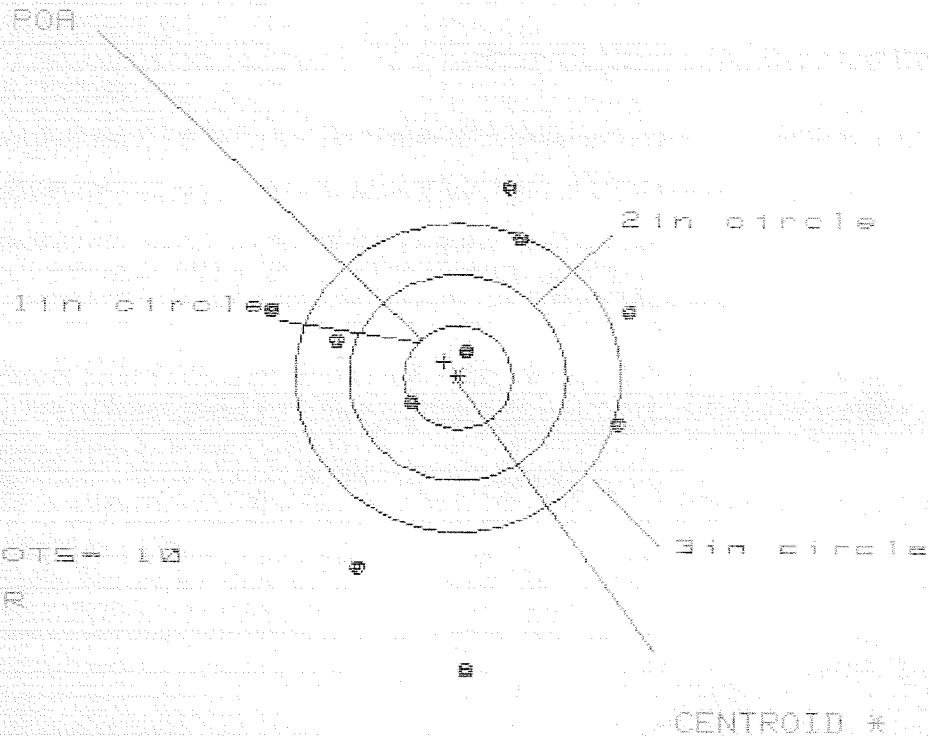
4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.564	1.468	.951
MINIMUM X	-1.223	-1.319	-1.135
MAXIMUM Y	1.006	.845	.872
MINIMUM Y	-1.448	-1.182	-1.075
CENTROID X	.199	.295	.111
CENTROID Y	.223	.384	.357
POB TO CENTROID in.	.299	.484	.374
MIN RADIUS	.115	.301	.238
MEAN RADIUS	1.022	.960	.876
MAX RADIUS	1.683	1.566	1.431
HORIZONTAL SPREAD	2.787	2.787	2.086
VERTICAL SPREAD	2.454	1.947	1.947
EXTREME SPREAD	3.032	2.857	2.210
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

30 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6636078

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 4

HS = 3.261

VS = 4.753

GS = 4.773

PATTERN #

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.541	1.551	1.436
MINIMUM X	-1.720	-1.710	-1.825
MAXIMUM Y	1.895	1.577	1.309
MINIMUM Y	-2.858	-2.143	-1.992
CENTROID X	.126	.116	.231
CENTROID Y	-.155	.163	.431
POA TO CENTROID in.	.200	.200	.489
MIN RADIUS	.300	.042	.297
MEAN RADIUS	1.548	1.345	1.228
MAX RADIUS	2.860	2.338	1.828
HORIZONTAL SPREAD	3.261	3.261	3.261
VERTICAL SPREAD	4.753	3.720	2.301
EXTREME SPREAD	4.773	3.991	3.395
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	2	2	2
NUMBER IN THREE INCH CIRCLE =	4	4	4

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636878
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.458215
1 TO	2	.761936
1 TO	3	.944884
1 TO	4	.839288
1 TO	5	.207212

3+51 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0838
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104242

THE AMR FOR THIS RIFLE IS: .9388

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8336078

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 2.038

VS = 2.155

GS = 2.333

CENTROID *

PATTERN #

1

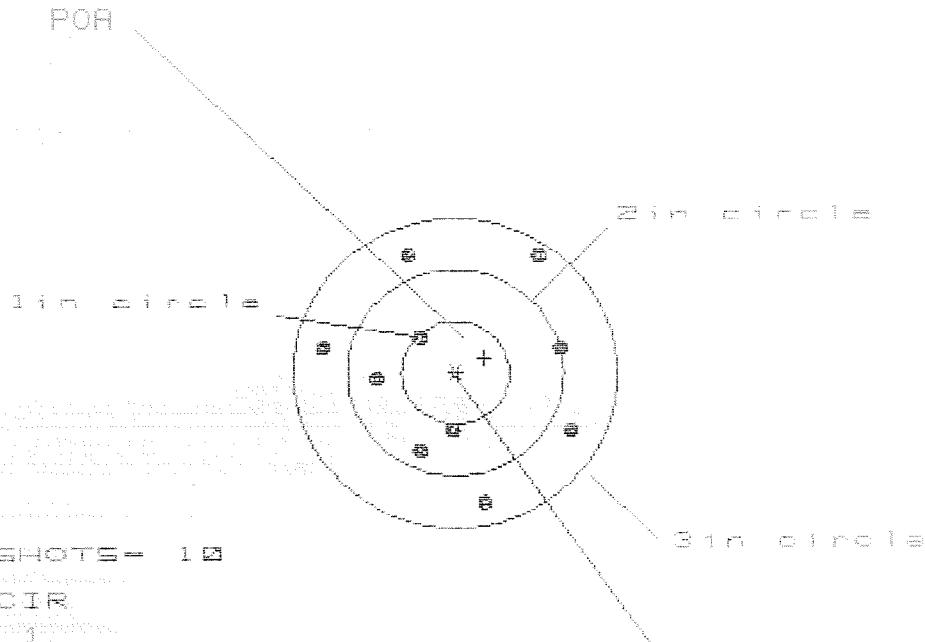
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.840	.592	.454
MINIMUM X	-1.198	-1.105	-.707
MAXIMUM Y	1.171	1.062	1.067
MINIMUM Y	-.984	-.817	-.811
CENTROID X	.435	.342	.480
CENTROID Y	.144	.253	.248
POA TO CENTROID in.	.458	.425	.540
MIN RADIUS	.319	.356	.238
MEAN RADIUS	.760	.700	.628
MAX RADIUS	1.293	1.130	1.096
HORIZONTAL SPREAD	2.038	1.697	1.161
VERTICAL SPREAD	2.155	1.879	1.879
EXTREME SPREAD	2.333	2.107	2.107
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6336078

CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.368

VS = 2.427

GS = 2.486

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.186

1.187

1.039

MINIMUM X

-1.262

-1.181

-.763

MAXIMUM Y

1.188

1.251

1.296

MINIMUM Y

-1.239

-1.107

-1.061

CENTROID X

-.270

-.351

-.203

CENTROID Y

-.145

-.277

-.322

POA TO CENTROID in.

.306

.447

.381

MIN RADIUS

.481

.415

.385

MEAN RADIUS

.995

.928

.889

MAX RADIUS

1.393

1.313

1.407

HORIZONTAL SPREAD

2.368

2.368

1.802

VERTICAL SPREAD

2.427

2.358

2.358

EXTREME SPREAD

2.486

2.486

2.477

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

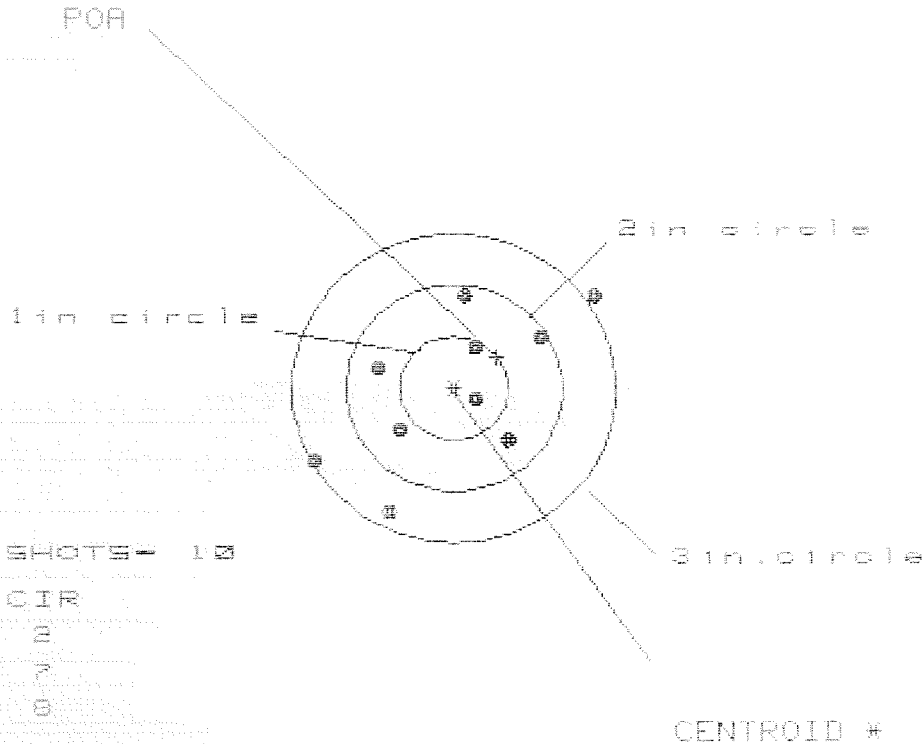
10

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8336078

CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.599

VS = 2.101

GS = 3.072

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.294

.971

.826

MINIMUM X

-1.305

-1.161

-.673

MAXIMUM Y

.922

1.021

.940

MINIMUM Y

-1.179

-1.080

-1.161

CENTROID X

-.398

-.542

-.397

CENTROID Y

-.302

-.401

-.320

POA TO CENTROID in.

.499

.674

.509

MIN RADIUS

.259

.376

.251

MEAN RADIUS

.907

.836

.750

MAX RADIUS

1.571

1.329

1.320

HORIZONTAL SPREAD

2.599

2.132

1.499

VERTICAL SPREAD

2.101

2.101

2.101

EXTREME SPREAD

3.072

2.480

2.236

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

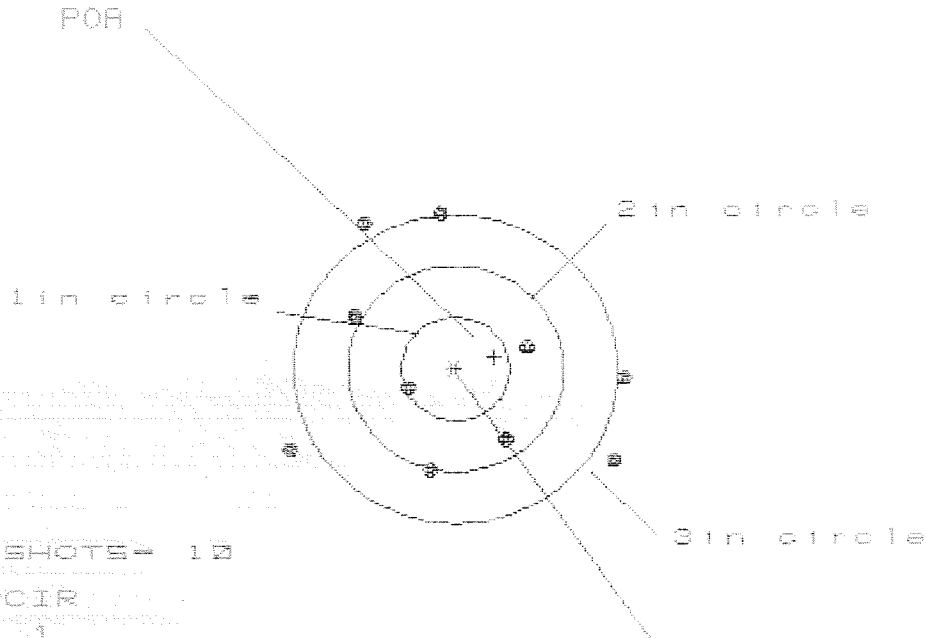
8

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08336070

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 3.174

VS= 2.540

GS= 3.351

CENTROID *

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.607

1.433

1.598

MINIMUM X

-1.567

-1.159

-.994

MAXIMUM Y

1.564

1.472

1.345

MINIMUM Y

-.976

-1.068

-1.195

CENTROID X

-.363

-.189

-.354

CENTROID Y

-.116

-.024

.103

POA TO CENTROID in.

.381

.190

.368

MIN RADIUS

.481

.553

.604

MEAN RADIUS

1.257

1.198

1.135

MAX RADIUS

1.772

1.712

1.633

HORIZONTAL SPREAD

3.174

2.592

2.592

VERTICAL SPREAD

2.540

2.540

2.540

EXTREME SPREAD

3.351

3.351

2.935

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

5

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8336078

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.066

VS= 1.872

GS= 2.293

CENTROID #

PATTERN

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	.678	.730
MINIMUM X	-.814	-.675	-.623
MAXIMUM Y	.795	.843	.715
MINIMUM Y	-1.077	-1.029	-.969
CENTROID X	.286	.147	.095
CENTROID Y	-.080	-.048	.080
POA TO CENTROID in.	.286	.155	.124
MIN RADIUS	.353	.353	.245
MEAN RADIUS	.775	.703	.625
MAX RADIUS	1.324	1.111	.969
HORIZONTAL SPREAD	2.066	1.353	1.353
VERTICAL SPREAD	1.872	1.872	1.684
EXTREME SPREAD	2.293	1.973	1.691
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		