

C6636083

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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.
C6636083

ORDER NO.
5716

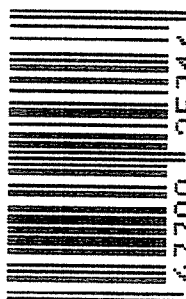
20

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



5716 C6636083

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636083

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof			RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	11
615	Rollmark Caliber		APR 9 1991	GL
617	Drill and Tap Sight Holes		APR 19 1991	FB
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		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	RL

op. #	BARBER - M24 0037503 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	7	7			6-4-91	WB
	G) Safety Off Force	3/2	3/2	3/2			6-4-91	WB
	H) Trigger Pull Test & Retainability						6-4-91	RL
	I) Firing Pin Indent	.021	.0205	.021			6-4-91	WB
	J) Assemble Stock						6-4-91	RL
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6-4-91	RL
	M) Iron Sight Alignment						6-4-91	RL
	N) Detach Front & Rear Sights & place in numbered container						6-4-91	RL
	O) Attach Scope to Rifle						6-4-91	RL
	P) Detach & Attach Scope 20 Times						6-4-91	RL
640	Gallery Target & Test						6-4-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						6-4-91	RF
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.32	2.39	2.46	2.55	2.57	6-8-91	RL
	C) Function						6-8-91	DH
660	Pack						6-19-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636083DATE 6-4-91TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.31	2.20	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.26	2.28	2.39	
PULL #3	2.47	2.34	2.35	2.46	
PULL #4	2.43	2.39	2.38	2.55	
PULL #5	2.36	2.17	2.31	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.39		
PULL #2	3.44	3.47		
PULL #3	3.47	3.57		
PULL #4	3.52	3.50		
PULL #5	3.51	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.29		4.35
PULL #2	4.30	4.18		4.34
PULL #3	4.44	4.29		4.30
PULL #4	4.44	4.43		4.50
PULL #5	4.33	4.45		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636083
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.429684
1 TO	2	.446131
1 TO	3	.587082
1 TO	4	.375446
1 TO	5	.294905

34
1
2
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189768

THE AMR FOR THIS RIFLE IS: 1.112

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C06535083

CENTERFIRE PATTERNS

1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 5

HS= 3.086

VS= 4.172

GS= 4.177

PATTERN

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.117	2.090	1.249
MINIMUM X	-.969	-.996	-.735
MAXIMUM Y	1.649	1.368	1.220
MINIMUM Y	-2.523	-1.890	-2.038
CENTROID X	.428	.455	.194
CENTROID Y	-.038	.242	.390
POR TO CENTROID in.	.429	.515	.435
MIN RADIUS	.193	.446	.568
MEAN RADIUS	1.432	1.279	1.085
MAX RADIUS	2.536	2.401	2.068
HORIZONTAL SPREAD	3.086	3.086	1.984
VERTICAL SPREAD	4.172	3.258	3.258
EXTREME SPREAD	4.177	3.622	3.261
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86350B3

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.387

VS = 2.735

GS = 4.042

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

-1.839

-1.223

-1.055

MINIMUM X

-1.548

-1.344

-1.149

MAXIMUM Y

1.034

.845

.885

MINIMUM Y

-1.701

-1.969

-1.929

CENTROID X

.215

.011

.179

CENTROID Y

-.430

-.241

-.281

POA TO CENTROID in.

.481

.242

.333

MIN RADIUS

.212

.092

.082

MEAN RADIUS

1.117

.957

.876

MAX RADIUS

2.505

1.380

1.411

HORIZONTAL SPREAD

3.387

2.567

2.284

VERTICAL SPREAD

2.735

1.814

1.814

EXTREME SPREAD

4.042

2.585

2.237

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

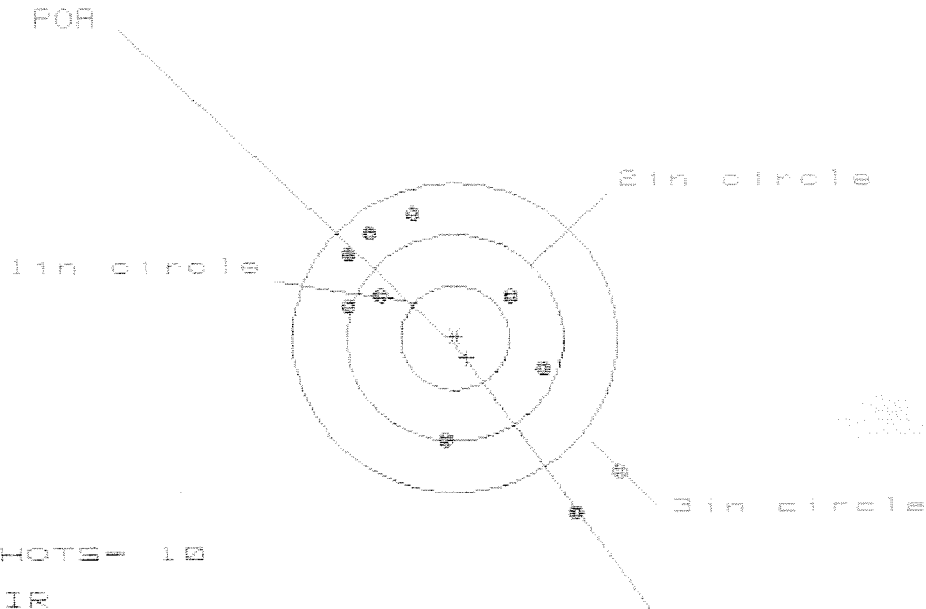
7

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636003

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.547

VS= 2.907

GS= 3.309

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.520
MINIMUM X	-1.026
MAXIMUM Y	1.242
MINIMUM Y	-1.665
CENTROID X	-0.113
CENTROID Y	0.190
POA TO CENTROID in.	0.221
MIN RADIUS	0.628
MEAN RADIUS	1.222
MAX RADIUS	1.981
HORIZONTAL SPREAD	2.547
VERTICAL SPREAD	2.907
EXTREME SPREAD	3.309
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

4 JUN 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B360B3

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.125

VS= 2.000

GS= 2.349

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.050

1.016

.678

MINIMUM X

-1.075

-1.109

-.982

MAXIMUM Y

1.352

.944

.893

MINIMUM Y

-.648

-.498

-.550

CENTROID X

.192

.226

.099

CENTROID Y

.254

.104

.156

POA TO CENTROID in.

.318

.249

.184

MIN RADIUS

.217

.064

.192

MEAN RADIUS

.815

.707

.677

MAX RADIUS

1.386

1.118

1.018

HORIZONTAL SPREAD

2.125

2.125

1.660

VERTICAL SPREAD

2.000

1.442

1.442

EXTREME SPREAD

2.349

2.142

1.831

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66360B3

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.916

VS = 2.311

GS = 2.931

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	1.536	.849	.841
MINIMUM X	-1.380	-1.209	-1.217
MAXIMUM Y	.825	.876	.697
MINIMUM Y	-1.486	-1.435	-.969
CENTROID X	.216	.045	.053
CENTROID Y	.167	.116	.295
POA TO CENTROID in.	.273	.124	.300
MIN RADIUS	.287	.298	.450
MEAN RADIUS	.976	.912	.836
MAX RADIUS	1.603	1.436	1.217
HORIZONTAL SPREAD	2.916	2.058	2.058
VERTICAL SPREAD	2.311	2.311	1.666
EXTREME SPREAD	2.931	2.408	2.063
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	