

C6636105

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

SERIAL NO. C6636105

ORDER NO. 5716

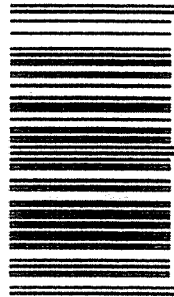
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636105

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636105

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action		APR 9 1991	K.R.
	Magnaflux Bolt		APR 9 1991	U
615	Rollmark Caliber		APR 9 1991	GL
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	LB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)		5-10-91	TH
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		5/23/91	TH

op. #	BARBER M24 0037757	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5-28-91	DH
	G) Safety Off Force	2	2	2			5-28-91	DH
	H) Trigger Pull Test & Retainability						5/28/91	PH
	I) Firing Pin Indent	1020	1020	1020			5-28-91	DH
	J) Assemble Stock						5/29/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	RW
	M) Iron Sight Alignment						5/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	RW
	O) Attach Scope to Rifle						5/29/91	RW
	P) Detach & Attach Scope 20 Times						5/29/91	RW
640	Gallery Target & Test						5-30-91	DH
	A) Time						5-30-91	DH
	B) Malfunctions						5-30-91	DH
	C) Pierced Primers						5-30-91	DH
	D) Optical Clarity of Scope						5-30-91	DH
645	Inspect for Live Ammo						5-30-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.28	2.30	2.35	2.19	2.23	6/1/91	PH
	C) Function						6-1-91	DH
660	Pack						6-20-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06636105

DATE 5/28/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.39	2.39	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.38	2.36	2.30	
PULL #3	2.36	2.41	2.35	2.35	
PULL #4	2.41	2.35	2.30	2.19	
PULL #5	2.27	2.32	2.49	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.56		
PULL #2	3.53	3.29		
PULL #3	3.70	3.15		
PULL #4	3.62	3.22		
PULL #5	3.70	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.33		4.35
PULL #2	4.37	4.35		4.39
PULL #3	4.15	4.30		4.39
PULL #4	4.31	4.35		4.41
PULL #5	4.32	4.35		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06636105
 30 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0523259
1 TO	2	.445588
1 TO	3	.612165
1 TO	4	.133154
1 TO	5	.329515

5
4
2

←----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1158
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0468
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124899

THE AMR FOR THIS RIFLE IS: .9372

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636105

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS = 3.115

VS = 2.033

GS = 3.118

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.593

1.069

.901

MINIMUM X

:

-1.522

-1.345

-1.019

MAXIMUM Y

:

1.072

1.049

1.004

MINIMUM Y

:

-.961

-.984

-1.029

CENTROID X

:

.047

-.130

.038

CENTROID Y

:

-.023

-.000

.045

POA TO CENTROID in.

:

.052

.130

.059

MIN RADIUS

:

.422

.343

.403

MEAN RADIUS

:

1.001

.941

.854

MAX RADIUS

:

1.606

1.393

1.448

HORIZONTAL SPREAD

:

3.115

2.414

1.920

VERTICAL SPREAD

:

2.033

2.033

2.033

EXTREME SPREAD

:

3.118

2.444

2.444

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636105

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.147

VS= 2.982

GS= 3.147

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.827

.760

.792

MINIMUM X

-1.320

-1.117

-1.085

MAXIMUM Y

1.405

1.491

1.305

MINIMUM Y

-1.578

-1.491

-1.410

CENTROID X

.257

.054

.022

CENTROID Y

-.416

-.503

-.317

POA TO CENTROID in.

.489

.506

.317

MIN RADIUS

.562

.556

.453

MEAN RADIUS

1.172

1.064

1.010

MAX RADIUS

1.986

1.536

1.411

HORIZONTAL SPREAD

3.147

1.877

1.877

VERTICAL SPREAD

2.982

2.982

2.715

EXTREME SPREAD

3.147

3.047

2.730

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6

30 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636105

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.137

VS= 2.351

GS= 3.177

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.953

.821

.708

MINIMUM X

-1.184

-1.106

-1.003

MAXIMUM Y

.796

.623

.557

MINIMUM Y

-1.555

-1.214

-1.136

CENTROID X

.292

.424

.321

CENTROID Y

.538

.711

.633

POA TO CENTROID in.

.613

.828

.710

MIN RADIUS

.260

.415

.309

MEAN RADIUS

.943

.795

.770

MAX RADIUS

1.955

1.216

1.147

HORIZONTAL SPREAD

2.137

1.927

1.711

VERTICAL SPREAD

2.351

1.837

1.693

EXTREME SPREAD

3.177

2.043

1.983

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

30 May 1991

FILE:/PATTERNING/CENTERFIRE PATT/C8636105

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.050

VS= 2.428

GS= 3.050

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.103

1.021

.988

MINIMUM X

-.947

-1.029

-.902

MAXIMUM Y

.850

.674

.499

MINIMUM Y

-1.579

-.632

-.548

CENTROID X

.170

.252

.125

CENTROID Y

-.074

.101

.017

POR TO CENTROID in.

.185

.272

.126

MIN RADIUS

.188

.239

.288

MEAN RADIUS

.284

.669

.583

MAX RADIUS

1.745

1.223

.921

HORIZONTAL SPREAD

2.050

2.050

1.810

VERTICAL SPREAD

2.428

1.306

1.047

EXTREME SPREAD

3.050

2.146

1.810

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

30 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8636105

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.650

VS= 2.334

GS= 2.445

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.883	.902	.539
MINIMUM X	-.767	-.748	-.635
MAXIMUM Y	1.343	1.156	1.011
MINIMUM Y	-.991	-.842	-.698
CENTROID X	-.187	-.206	-.319
CENTROID Y	.209	.060	-.084
POB TO CENTROID in.	.281	.215	.330
MIN RADIUS	.266	.130	.180
MEAN RADIUS	.786	.683	.562
MAX RADIUS	1.354	1.466	1.123
HORIZONTAL SPREAD	1.650	1.650	1.174
VERTICAL SPREAD	2.334	1.998	1.709
EXTREME SPREAD	2.445	2.445	1.898
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		