

C6636109

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

Remington®

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

MODEL 700™ M24

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

SERIAL NO.
C6636109

ORDER NO.
5716

20

5716 C6636109

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636109

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCD
	Magnaflux Bolt	5 8 9 1		KCD
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		EB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JL

op. #	BARBER M24 0037813	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-4-91	DH
	G) Safety Off Force	3	3	3			6-4-91	DH
	H) Trigger Pull Test & Retainability						6-4-91	JK
	I) Firing Pin Indent	.020	.021	.020			6-4-91	DH
	J) Assemble Stock						6/5/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/5/91	RW
	M) Iron Sight Alignment						6/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	RW
	O) Attach Scope to Rifle						6/5/91	RW
	P) Detach & Attach Scope 20 Times						6/5/91	RW
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection						6-8-91	DH
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.44	2.37	2.41	2.46	2.45	6-8-91	JK
	C) Function						6-8-91	DH
660	Pack						6-20-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636109DATE 6-4-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.34	2.38	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.43	2.40	2.37	
PULL #3	2.22	2.20	2.36	2.41	
PULL #4	2.45	2.37	2.31	2.46	
PULL #5	2.44	2.31	2.31	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.64		
PULL #2	3.59	3.56		
PULL #3	3.58	3.55		
PULL #4	3.58	3.52		
PULL #5	3.53	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.16		4.26
PULL #2	4.23	4.30		4.39
PULL #3	4.40	4.39		4.44
PULL #4	4.40	4.15		4.41
PULL #5	4.26	4.21		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636109
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.223134
1 TO	2	.045
1 TO	3	.25
1 TO	4	.208125
1 TO	5	.219009

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1256
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .059
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138767

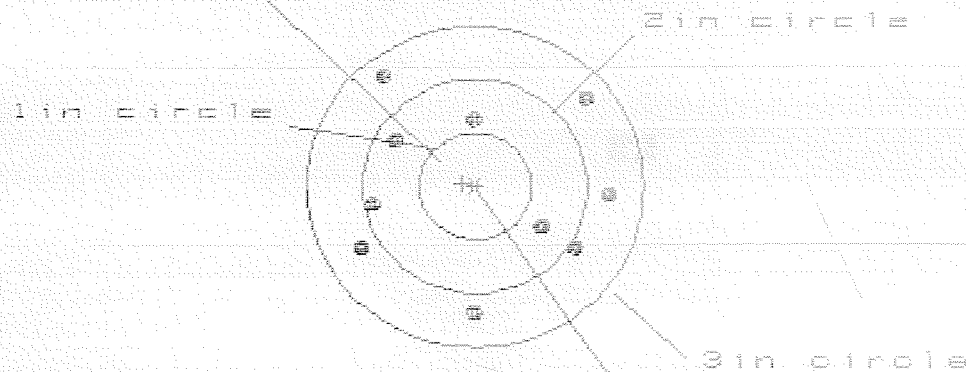
THE AMR FOR THIS RIFLE IS: .8888

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0638109

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.197

VS= 2.199

GS= 2.515

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.145
MINIMUM X	-1.052
MAXIMUM Y	1.016
MINIMUM Y	-1.183
CENTROID X	.115
CENTROID Y	-.029
POA TO CENTROID in.	.118
MIN RADIUS	.645
MEAN RADIUS	1.038
MAX RADIUS	1.322
HORIZONTAL SPREAD	2.197
VERTICAL SPREAD	2.199
EXTREME SPREAD	2.515
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	10

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836189

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.718

VS= 2.123

GS= 2.399

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.877

.784

.806

MINIMUM X

-.841

-.647

-.625

MAXIMUM Y

1.176

1.070

.546

MINIMUM Y

-.947

-.787

-1.653

CENTROID X

.047

.140

.118

CENTROID Y

-.086

.100

-.034

POA TO CENTROID in.

.047

.172

.123

MIN RADIUS

.308

.187

.322

MEAN RADIUS

.733

.677

.614

MAX RADIUS

1.267

1.110

1.037

HORIZONTAL SPREAD

1.718

1.431

1.431

VERTICAL SPREAD

2.123

1.857

1.199

EXTREME SPREAD

2.399

1.952

1.683

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

6 Jun 1991

FILE: PATTERNING/CENTERFIRE_PATT/C066361B3

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.115

VS= 2.808

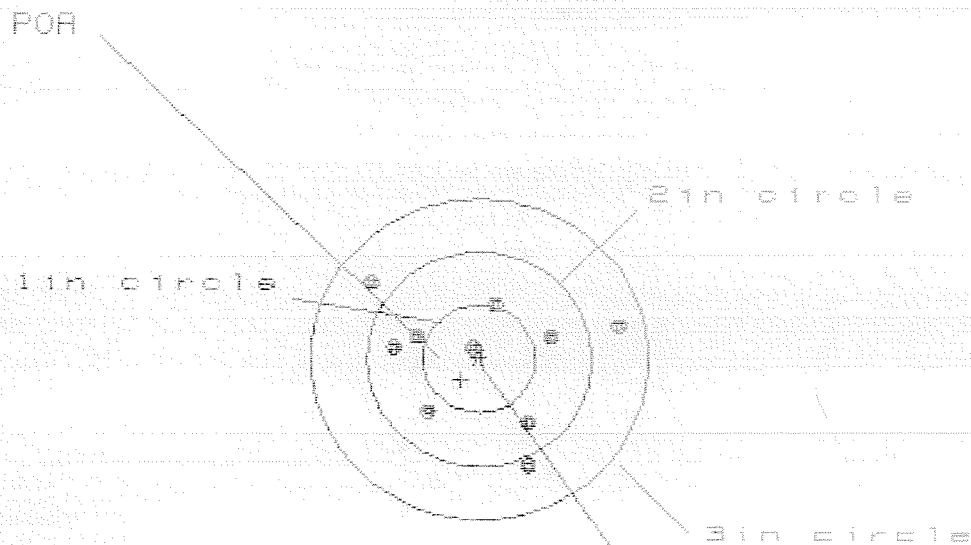
GS= 2.842

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.165	1.213	.617
MINIMUM X	-.950	-.902	-.750
MAXIMUM Y	1.631	1.381	.684
MINIMUM Y	-1.177	-.996	-.824
CENTROID X	.187	.139	-.013
CENTROID Y	-.050	-.231	-.403
POA TO CENTROID in.	.193	.269	.404
MIN RADIUS	.233	.102	.182
MEAN RADIUS	.885	.755	.596
MAX RADIUS	1.686	1.838	.846
HORIZONTAL SPREAD	2.115	2.115	1.367
VERTICAL SPREAD	2.808	2.377	1.508
EXTREME SPREAD	2.842	2.651	1.509
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0636109

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.197

VS = 1.656

GS = 2.219

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.197	.773	.665
MINIMUM X	-1.000	-.867	-.697
MAXIMUM Y	.667	.706	.611
MINIMUM Y	-.989	-.950	-.862
CENTROID X	.162	.029	.137
CENTROID Y	.190	.151	.062
POA TO CENTROID in.	.250	.154	.151
MIN RADIUS	.122	.161	.235
MEAN RADIUS	.759	.694	.650
MAX RADIUS	1.249	1.118	.962
HORIZONTAL SPREAD	2.197	1.640	1.362
VERTICAL SPREAD	1.656	1.656	1.472
EXTREME SPREAD	2.219	2.170	1.575
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8535103

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.175

VS= 3.072

GS= 3.687

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.387	.813	.751
MINIMUM X	-.788	-.633	-.696
MAXIMUM Y	1.662	1.240	1.087
MINIMUM Y	-1.410	-1.225	-.967
CENTROID X	.117	-.038	.024
CENTROID Y	.190	.005	.158
POR TO CENTROID in.	.223	.038	.160
MIN RADIUS	.488	.360	.394
MEAN RADIUS	1.029	.869	.809
MAX RADIUS	2.165	1.387	1.224
HORIZONTAL SPREAD	2.175	1.446	1.446
VERTICAL SPREAD	3.072	2.465	2.053
EXTREME SPREAD	3.687	2.707	2.104
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	