

C6636117

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®
REG. U.S. PAT. & TM. OFF.

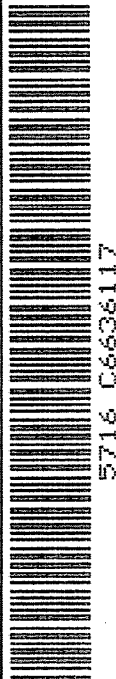
MODEL 700™ M24

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

SERIAL NO.
C6636117

ORDER NO.
5716

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



5716 C6636117

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636117

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		GS.
617	Drill and Tap Sight Holes	5 15 9 1		1-6
618	Polish Barrel	5 15 9 1		603
620	Apply Coatings (Barrel Action)		5-31-91	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	JH

op. #	BARBER M24 0037901	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JH
	G) Safety Off Force	4	4	4			6-7-91	JH
	H) Trigger Pull Test & Retainability						6-7-91	JH
	I) Firing Pin Indent	1022	1022	1022			6-7-91	JH
	J) Assemble Stock						6-7-91	KS
	K) Assemble Swivel Studs						6-12-91	
	L) Attach Front and Rear Sight Assemblies						6-7-91	KS
	M) Iron Sight Alignment						6-7-91	CS
	N) Detach Front & Rear Sights & place in numbered container						6-7-91	KS
	O) Attach Scope to Rifle						6-7-91	CS
	P) Detach & Attach Scope 20 Times						6-7-91	CS
640	Gallery Target & Test						6-11-91	KS
	A) Time						6-11-91	KS
	B) Malfunctions						6-11-91	KS
	C) Pierced Primers						6-11-91	KS
	D) Optical Clarity of Scope						6-11-91	KS
645	Inspect for Live Ammo						6-11-91	KS
655	Final Inspection							
	A) Headspace						6-12-91	KS
	B) Trigger Pull	2.25	2.19	2.28	2.27	2.18	6-12-91	JH
	C) Function						6-12-91	KS
660	Pack						6-20-91	KS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636117

DATE 6-7-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.34	2.48	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.36	2.50	2.19	
PULL #3	2.41	2.45	2.44	2.28	
PULL #4	2.31	2.38	2.39	2.27	
PULL #5	2.25	2.46	2.39	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.69	3.55		
PULL #2	3.55	3.60		
PULL #3	3.68	3.66		
PULL #4	3.60	3.58		
PULL #5	3.57	3.70		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.63		4.46
PULL #2	4.71	4.55		4.36
PULL #3	4.26	4.66		4.56
PULL #4	4.20	4.70		4.45
PULL #5	4.20	4.70		4.70
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636117

11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0639531
1 TO	2	.124964
1 TO	3	.142225
1 TO	4	.086209
1 TO	5	.0909065

←——POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0274
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.0478
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0550963

THE AMR FOR THIS RIFLE IS: .8562

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636117

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 1.980

VS= 2.662

GS= 3.097

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.311

1.419

1.357

MINIMUM X

:

-.659

-.561

-.623

MAXIMUM Y

:

1.295

1.281

1.128

MINIMUM Y

:

-1.367

-1.223

-1.253

CENTROID X

:

-.057

-.165

-.102

CENTROID Y

:

.029

-.115

.038

POA TO CENTROID in.

:

.064

.201

.109

MIN RADIUS

:

.645

.467

.613

MEAN RADIUS

:

1.077

1.001

.951

MAX RADIUS

:

1.620

1.420

1.360

HORIZONTAL SPREAD

:

1.980

1.980

1.980

VERTICAL SPREAD

:

2.662

2.584

2.381

EXTREME SPREAD

:

3.097

2.603

2.603

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636117

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

CENTROID *

HS= 2.306

VS= 3.407

GS= 3.449

PATTERN #

2

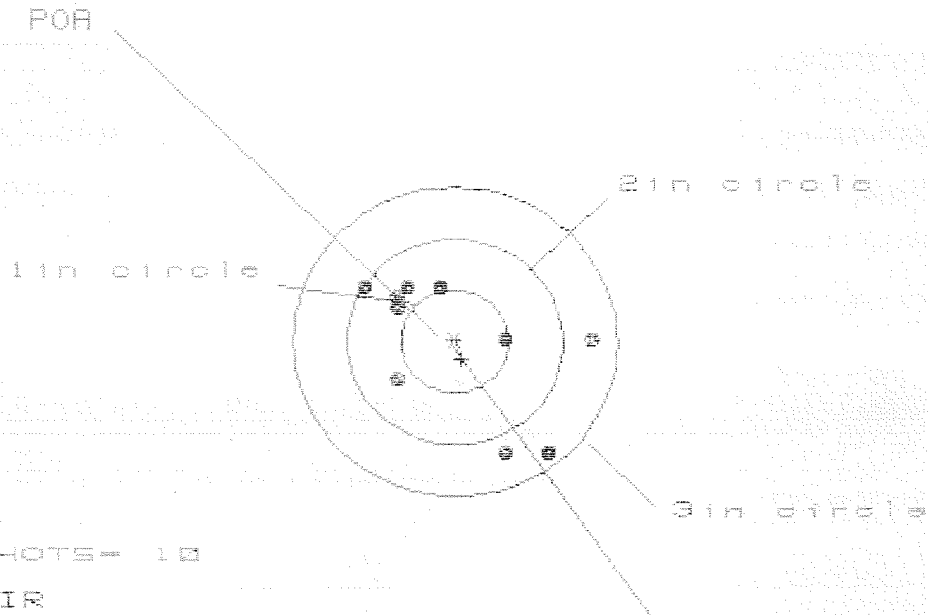
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	1.252	1.219
MINIMUM X	:	-1.081	-1.054	-1.087
MAXIMUM Y	:	1.796	.454	.277
MINIMUM Y	:	-1.611	-1.411	-.227
CENTROID X	:	.023	-.004	.029
CENTROID Y	:	.125	-.075	.102
POA TO CENTROID inv:	:	.127	.075	.106
MIN RADIUS	:	.129	.204	.115
MEAN RADIUS	:	.837	.736	.614
MAX RADIUS	:	1.813	1.436	1.222
HORIZONTAL SPREAD	:	2.306	2.306	2.306
VERTICAL SPREAD	:	3.407	1.865	.504
EXTREME SPREAD	:	3.449	2.327	2.327
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636117

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.104

VS= 1.651

GS= 2.351

CENTROID #

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.238	1.334	.744
MINIMUM X	-.866	-.770	-.603
MAXIMUM Y	.565	.446	.438
MINIMUM Y	-1.086	-1.205	-1.213
CENTROID X	-.065	-.161	-.328
CENTROID Y	.171	.290	.298
POA TO CENTROID in.	.183	.331	.443
MIN RADIUS	.484	.447	.355
MEAN RADIUS	.857	.758	.644
MAX RADIUS	1.377	1.336	1.404
HORIZONTAL SPREAD	2.104	2.104	1.347
VERTICAL SPREAD	1.651	1.651	1.651
EXTREME SPREAD	2.351	2.156	2.072
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636117

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 1.202

VS = 2.623

GS = 2.657

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.684

.632

.621

MINIMUM X

-.518

-.570

-.581

MAXIMUM Y

1.003

.823

.658

MINIMUM Y

-1.620

-.828

-.725

CENTROID X

-.051

.001

.012

CENTROID Y

-.057

.123

.020

POR TO CENTROID in:

.076

.123

.023

MIN RADIUS

.073

.042

.050

MEAN RADIUS

.652

.519

.468

MAX RADIUS

1.684

1.042

.955

HORIZONTAL SPREAD

1.202

1.202

1.202

VERTICAL SPREAD

2.623

1.651

1.383

EXTREME SPREAD

2.657

1.802

1.603

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

18 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6636117

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.642

VS= 2.795

GS= 2.997

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.963	1.009	.932
MINIMUM X	-.679	-.633	-.710
MAXIMUM Y	1.159	.978	.624
MINIMUM Y	-1.635	-.965	-.843
CENTROID X	.013	-.933	.044
CENTROID Y	-.029	.152	.030
POB TO CENTROID in.	.032	.156	.053
MIN RADIUS	.342	.410	.395
MEAN RADIUS	.858	.752	.692
MAX RADIUS	1.688	1.157	1.071
HORIZONTAL SPREAD	1.642	1.642	1.642
VERTICAL SPREAD	2.795	1.943	1.467
EXTREME SPREAD	2.997	1.943	1.915
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		