

C6636131

MODEL 700™ M24

Model **SMS**™

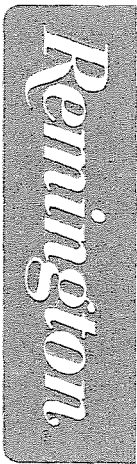
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

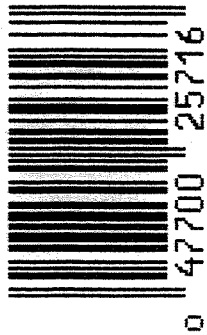
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

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

SERIAL NO. C6636131	20
ORDER NO. 5716	

UPC



5716 C6636131

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636131

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	KR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	GS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 9 1991	WB
620	Apply Coatings (Barrel Action)		5/10/91	JA
	Apply Coating (Bolt)		5/10/91	JA
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		5/30/91	JA

BARBER - M24 0038083

BARBER - M24 0038083								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6/30/91	DL
	G) Safety Off Force	4	4	4			6/30/91	DL
	H) Trigger Pull Test & Retainability						6-8-91	DL
	I) Firing Pin Indent	.025-.020	.022-.020	.022	.020		6/30/91	DL
	J) Assemble Stock						5/30/91	KS
	K) Assemble Swivel Studs						6/8/91	DL
	L) Attach Front and Rear Sight Assemblies						5/30/91	KS
	M) Iron Sight Alignment						5/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/30/91	KS
	O) Attach Scope to Rifle						5/30/91	KS
	P) Detach & Attach Scope 20 Times						5/30/91	KS
640	Gallery Target & Test						6/3/91	DL
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/3/91	KT
655	Final Inspection							
	A) Headspace						6-8-91	DL
	B) Trigger Pull	2.26	2.25	2.25	2.30	2.30	6-8-91	DL
	C) Function						6-8-91	DL
660	Pack						6-20-91	DL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 26636131

DATE 5/30/91

TESTER JLI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.45	2.50	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.48	2.53	2.25	
PULL #3	2.29	2.52	2.49	2.25	
PULL #4	2.49	2.46	2.44	2.30	
PULL #5	2.45	2.52	2.48	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.43		
PULL #2	3.41	3.43		
PULL #3	3.34	3.30		
PULL #4	3.42	3.45		
PULL #5	3.26	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	4.27	4.20		4.36
PULL #2	4.21	4.40		4.32
PULL #3	4.22	4.43		4.42
PULL #4	4.30	4.35		4.44
PULL #5	4.29	4.42		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636131
5 JUN 1991

CENTROIDAL DISTANCES

0 TO	1	.123944
1 TO	2	.11044
1 TO	3	.131643
1 TO	4	.322332
1 TO	5	.162003

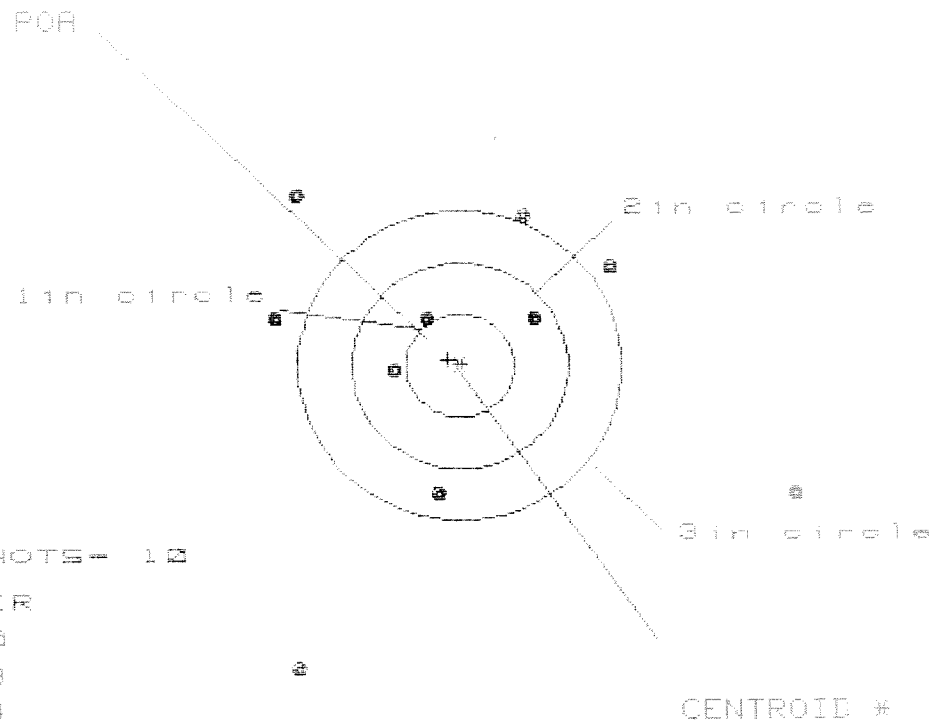
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:
THE AOP FOR THIS RIFLE IS: 1.041

2 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636131

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 4

HS = 4.843

VS = 4.561

GS = 5.466

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

3.121

1.758

1.611

MINIMUM X

-1.722

-1.375

-1.521

MAXIMUM Y

1.633

1.497

1.114

MINIMUM Y

-2.929

-3.064

-1.740

CENTROID X

.109

-.238

-.051

CENTROID Y

-.059

.077

.024

POA TO CENTROID in.

.123

.250

.403

MIN RADIUS

.580

.312

.111

MEAN RADIUS

1.718

1.477

1.204

MAX RADIUS

3.350

3.282

3.260

HORIZONTAL SPREAD

4.843

3.133

2.131

VERTICAL SPREAD

4.561

4.561

2.854

EXTREME SPREAD

5.466

4.866

3.171

NUMBER IN ONE

INCH CIRCLE

=

0

NUMBER IN TWO

INCH CIRCLE

=

3

NUMBER IN THREE

INCH CIRCLE

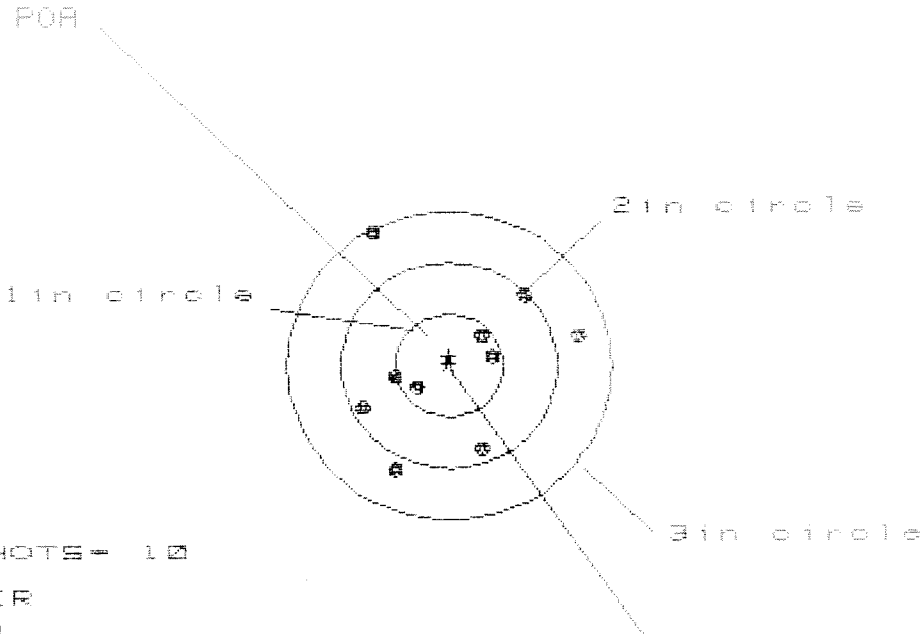
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2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG636131

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 10

HS = 2.022

VS = 2.260

GS = 2.285

CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.097	.791
MINIMUM X	-.850	-.925	-.788
MAXIMUM Y	1.250	.842	.894
MINIMUM Y	-1.010	-.872	-.820
CENTROID X	.003	.078	-.059
CENTROID Y	-.090	-.228	-.230
POA TO CENTROID in.	.090	.242	.285
MIN RADIUS	.370	.348	.291
MEAN RADIUS	.825	.751	.690
MAX RADIUS	1.422	1.171	1.191
HORIZONTAL SPREAD	2.022	2.022	1.579
VERTICAL SPREAD	2.260	1.714	1.714
EXTREME SPREAD	2.285	2.132	2.084
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08638131

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 10

HS = 2.213

VS = 2.351

GS = 2.391

CENTROID #

PATTERN #

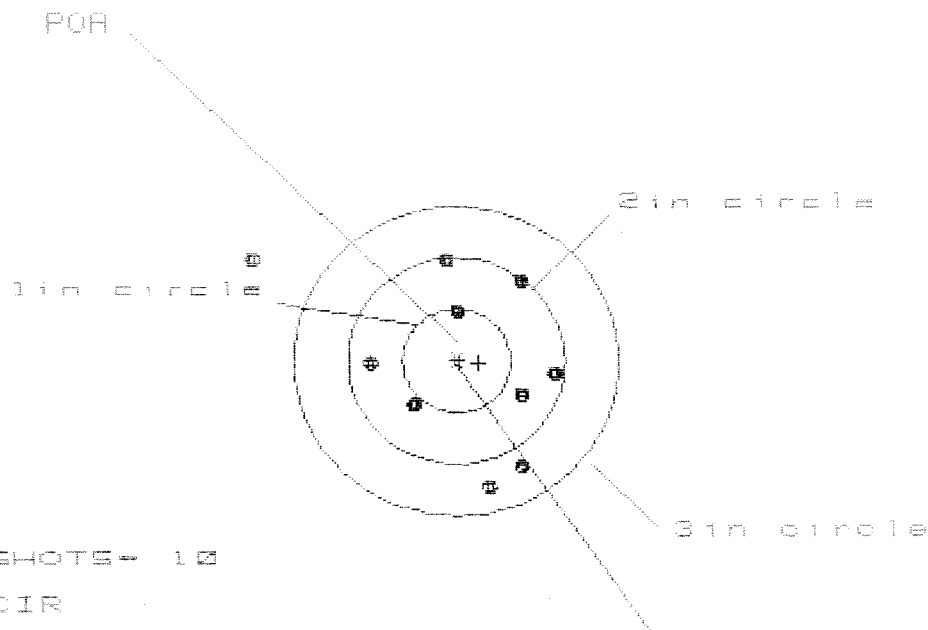
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	1.128	1.200
MINIMUM X	-1.100	-1.085	-1.013
MAXIMUM Y	1.326	.655	.545
MINIMUM Y	-1.025	-.870	-.723
CENTROID X	.020	.005	-.067
CENTROID Y	-.156	-.303	-.193
POA TO CENTROID in.	.157	.300	.205
MIN RADIUS	.146	.248	.119
MEAN RADIUS	.783	.724	.671
MAX RADIUS	1.332	1.154	1.208
HORIZONTAL SPREAD	2.213	2.213	2.213
VERTICAL SPREAD	2.351	1.533	1.268
EXTREME SPREAD	2.391	2.231	2.231
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06638131

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.738

VS = 2.187

GS = 3.168

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.683	.696
MINIMUM X	-1.849	-.958	-.945
MAXIMUM Y	.952	1.055	.914
MINIMUM Y	-1.235	-1.132	-1.060
CENTROID X	-.204	.002	-.011
CENTROID Y	.018	-.085	.056
POA TO CENTROID in.	.205	.085	.037
MIN RADIUS	.460	.491	.450
MEAN RADIUS	.989	.847	.799
MAX RADIUS	2.071	1.136	1.152
HORIZONTAL SPREAD	2.738	1.641	1.641
VERTICAL SPREAD	2.187	2.187	1.974
EXTREME SPREAD	3.168	2.231	2.123
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836131

CENTERFIRE PATTERNS # 5

POA

2 in circle

1 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.575

VS = 2.422

GS = 2.750

CENTROID #

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.295

.816

.878

MINIMUM X

:

-1.290

-1.148

-1.094

MAXIMUM Y

:

1.140

.821

.676

MINIMUM Y

:

-1.282

-1.155

-.988

CENTROID X

:

-.020

-.162

-.216

CENTROID Y

:

.039

-.088

.057

POA TO CENTROID in.:

.044

.104

.224

MIN RADIUS

:

.407

.347

.282

MEAN RADIUS

:

.892

.791

.715

MAX RADIUS

:

1.717

1.233

1.258

HORIZONTAL SPREAD

:

2.575

1.964

1.954

VERTICAL SPREAD

:

2.422

1.976

1.584

EXTREME SPREAD

:

2.750

2.234

2.234

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9