

C6636159

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

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

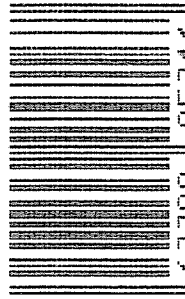
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SERIAL NO.
C6636159

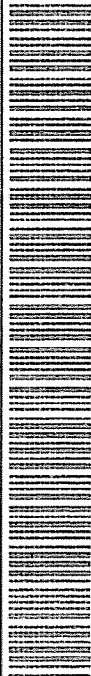
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636159

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636159

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
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		LB
618	Polish Barrel	5 15 9 1		LB
620	Apply Coatings (Barrel Action)		5-31-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/17/91	KS
	C) Inspect Ejector Hole for Chamfer		7/17/91	KS
	D) Oil Firing Pin Ass'y		7/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	97

op. #	BARBER M24 0038389	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-18-91	RL
	G) Safety Off Force	4	4	4			7-18-91	RL
	H) Trigger Pull Test & Retainability						7-18-91	RL
	I) Firing Pin Indent	.0225	.0225	.0225			7-18-91	RL
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/22/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						7/22/91	KT
655	Final Inspection							
	A) Headspace						7-23-91	D/H
	B) Trigger Pull	2.69	2.63	2.25	2.28	2.38	7-23-91	RL
	C) Function						7-23-91	D/H
660	Pack						7-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636159

DATE 7-18-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.48	2.50	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.56	2.46	2.63	
PULL #3	2.46	2.34	2.52	2.25	
PULL #4	2.25	2.48	2.55	2.28	
PULL #5	2.57	2.54	2.50	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.51		
PULL #2	3.43	3.41		
PULL #3	3.41	3.48		
PULL #4	3.40	3.50		
PULL #5	3.48	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.55		4.49
PULL #2	4.53	4.28		4.55
PULL #3	4.48	4.24		4.50
PULL #4	4.50	4.46		4.62
PULL #5	4.36	4.60		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636159
22 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.0813019
1 TO	2	.083006
1 TO	3	.328824
1 TO	4	.336482
1 TO	5	.268927

9/11

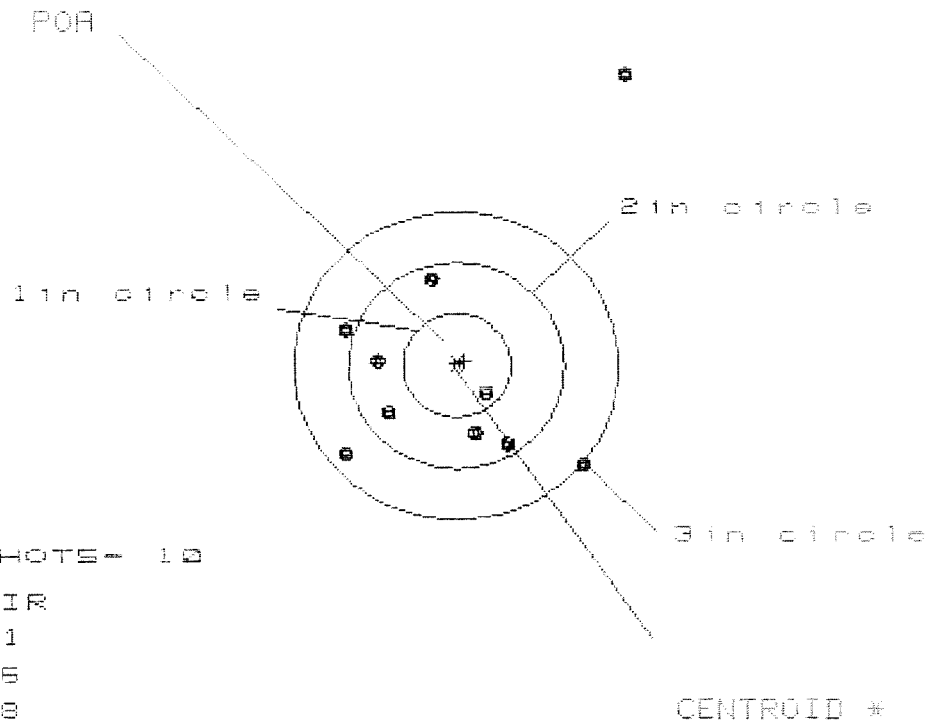
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0546
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .217756
THE AMP FOR THIS RIFLE IS: 1.188

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06635159

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.588

VS = 3.854

GS = 4.492

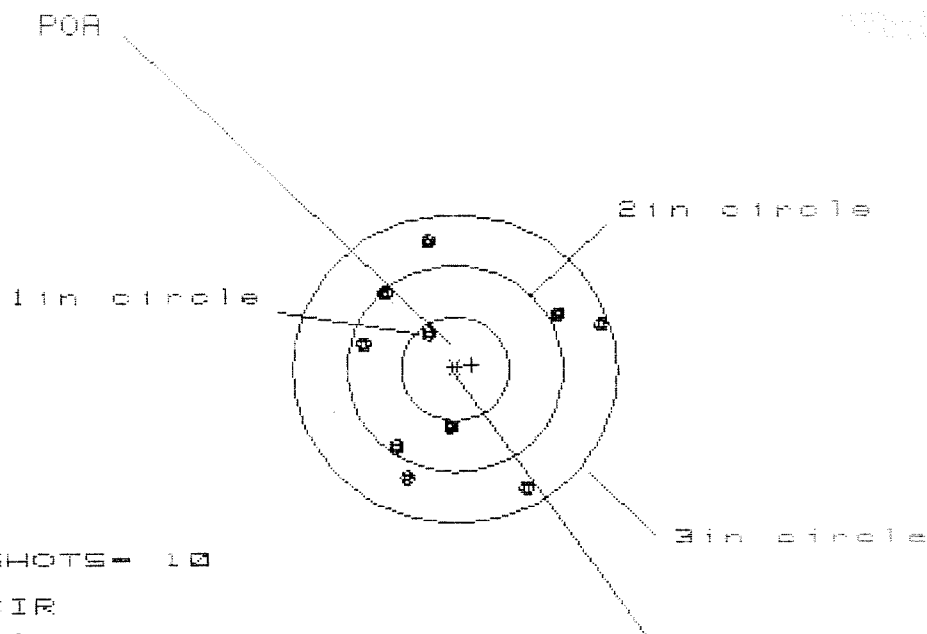
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.528	1.359	.822
MINIMUM X	-1.060	-.890	-.720
MAXIMUM Y	2.852	1.114	1.029
MINIMUM Y	-1.002	-.686	-.589
CENTROID X	-.069	-.239	-.409
CENTROID Y	-.043	-.359	-.274
POA TO CENTROID in.	.081	.432	.492
MIN RADIUS	.397	.445	.387
MEAN RADIUS	1.165	.860	.764
MAX RADIUS	3.235	1.522	1.037
HORIZONTAL SPREAD	2.588	2.249	1.542
VERTICAL SPREAD	3.854	1.800	1.618
EXTREME SPREAD	4.492	2.570	1.872
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

22 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.253

VS = 2.357

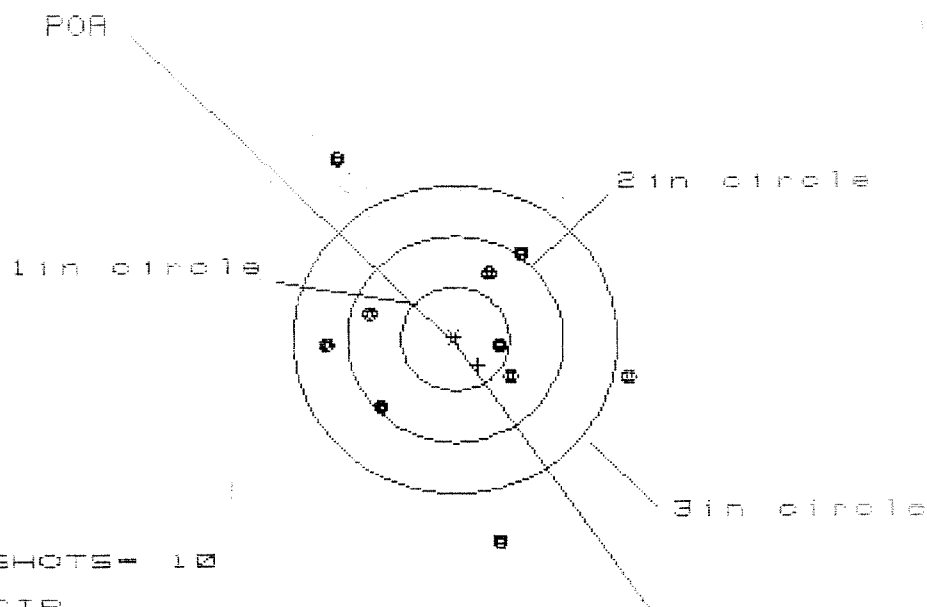
GS = 2.529

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.398	1.156	1.257
MINIMUM X	:	-.855	-.699	-.598
MAXIMUM Y	:	1.219	1.268	1.132
MINIMUM Y	:	-1.138	-1.089	-1.147
CENTROID X	:	-.152	-.308	-.409
CENTROID Y	:	-.042	-.091	.045
POA TO CENTROID in.	:	.158	.321	.411
MIN RADIUS	:	.418	.372	.213
MEAN RADIUS	:	.995	.914	.833
MAX RADIUS	:	1.467	1.358	1.327
HORIZONTAL SPREAD	:	2.253	1.855	1.855
VERTICAL SPREAD	:	2.357	2.357	2.279
EXTREME SPREAD	:	2.529	2.529	2.287
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

22 Jul 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.844

VS = 3.718

GS = 4.030

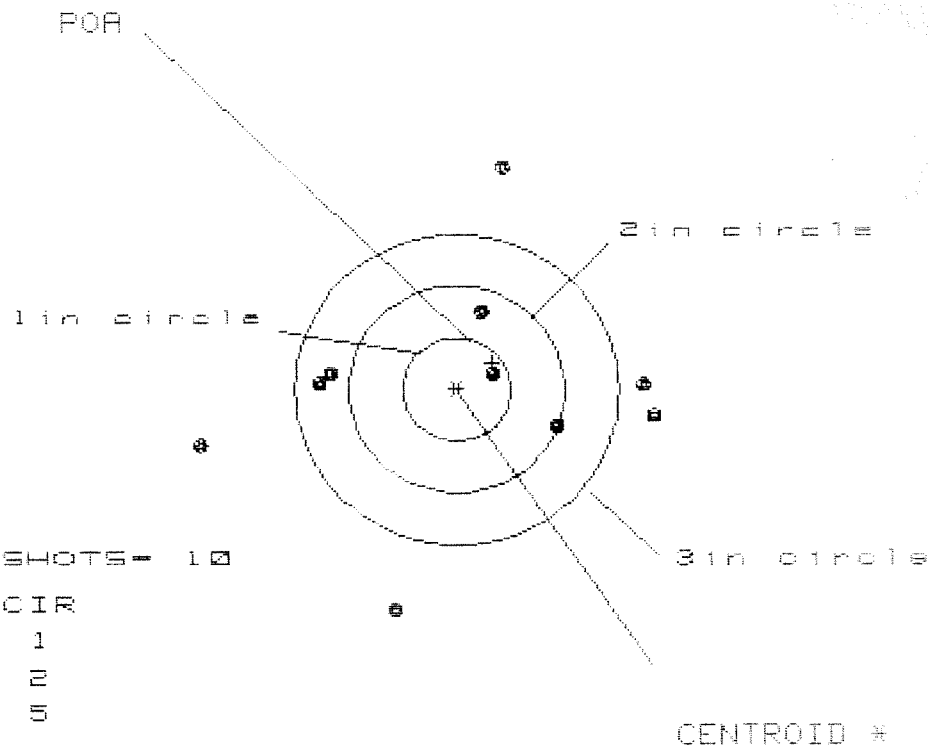
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.648	1.524	1.562
MINIMUM X	:	-1.196	-1.320	-1.282
MAXIMUM Y	:	1.761	1.024	.904
MINIMUM Y	:	-1.957	-1.762	-1.677
CENTROID X	:	-.208	-.084	-.122
CENTROID Y	:	.255	.060	.280
POA TO CENTROID in.	:	.329	.103	.305
MIN RADIUS	:	.418	.315	.339
MEAN RADIUS	:	1.158	1.041	.926
MAX RADIUS	:	2.087	1.789	1.614
HORIZONTAL SPREAD	:	2.844	2.844	2.844
VERTICAL SPREAD	:	3.718	2.786	1.481
EXTREME SPREAD	:	4.030	2.859	2.859
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

22 Jul 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS= 4.139

VS= 4.227

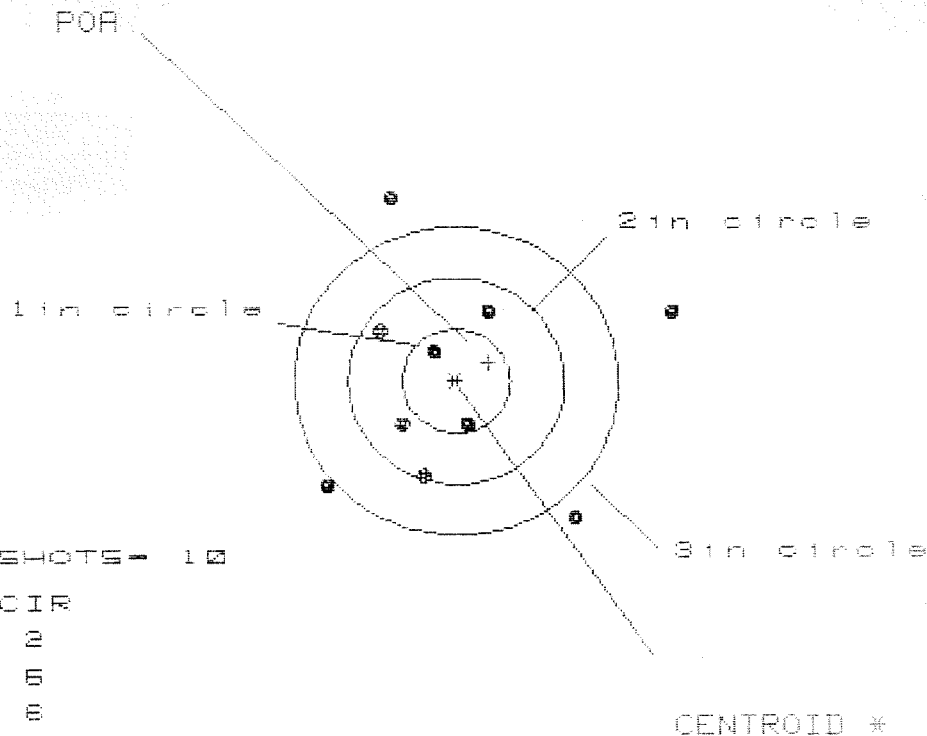
GS= 4.353

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.803	1.543	1.439
MINIMUM X	:	-2.336	-1.559	-1.663
MAXIMUM Y	:	2.126	2.066	1.796
MINIMUM Y	:	-2.101	-2.161	-1.698
CENTROID X	:	-.327	-.067	.037
CENTROID Y	:	-.259	-.199	.071
POA TO CENTROID in.	:	.417	.210	.080
MIN RADIUS	:	.328	.090	.200
MEAN RADIUS	:	1.489	1.332	1.186
MAX RADIUS	:	2.398	2.317	1.799
HORIZONTAL SPREAD	:	4.139	3.102	3.102
VERTICAL SPREAD	:	4.227	4.227	2.494
EXTREME SPREAD	:	4.353	4.353	3.117
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.141

VS= 3.103

GS= 3.558

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.958
MINIMUM X	-1.183
MAXIMUM Y	1.829
MINIMUM Y	-1.274
CENTROID X	-.298
CENTROID Y	-.184
POA TO CENTROID in.	.350
MIN RADIUS	.398
MEAN RADIUS	1.131
MAX RADIUS	2.081
HORIZONTAL SPREAD	3.141
VERTICAL SPREAD	3.103
EXTREME SPREAD	3.558
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8