

C6636154

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



Remington ®		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6636164	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			

20



5716 C6636164

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636164

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KL
	C) Inspect Ejector Hole for Chamfer		8/15/91	KL
	D) Oil Firing Pin Ass'y		8/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	BARBER - M24 0038454	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2	8/16/91	WB		
	G) Safety Off Force	2 1/4	2 1/4	2 1/4	8/16/91	WB		
	H) Trigger Pull Test & Retainability				8/16/91	WB		
	I) Firing Pin Indent	.020	.020	.020	8/16/91	WB		
	J) Assemble Stock				8/16/91	KL		
	K) Assemble Swivel Studs				8/22/91	JU		
	L) Attach Front and Rear Sight Assemblies				8/16/91	KL		
	M) Iron Sight Alignment				8/16/91	KL		
	N) Detach Front & Rear Sights & place in numbered container				8/16/91	KL		
	O) Attach Scope to Rifle				8/16/91	KL		
	P) Detach & Attach Scope 20 Times				8/16/91	KL		
640	Gallery Target & Test				8/19/91	KT		
	A) Time					KT		
	B) Malfunctions					KT		
	C) Pierced Primers					KT		
	D) Optical Clarity of Scope					KT		
645	Inspect for Live Ammo				8/19/91	KT		
655	Final Inspection							
	A) Headspace				8/22/91	JU		
	B) Trigger Pull	2.76	2.64	2.68	2.69	2.61	8-22-91	D/H
	C) Function						8/22/91	JU
660	Pack						9-19-91	W

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636164
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.1317
1 TO	2	.17912
1 TO	3	.17328
1 TO	4	.185173
1 TO	5	.150904

4 -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0358
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0520623
THE AMR FOR THIS RIFLE IS: .05

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836184

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.043

VS = 2.219

GS = 2.871

CENTROID #

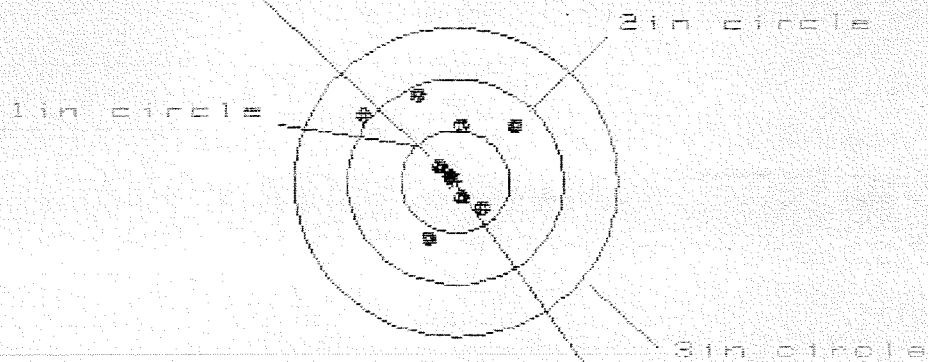
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	.951	.857	.709
MINIMUM X	-1.092	-1.186	-1.203
MAXIMUM Y	1.354	1.303	.698
MINIMUM Y	-.865	-.714	-.551
CENTROID X	-.128	-.034	.114
CENTROID Y	-.031	-.182	-.345
POA TO CENTROID in.	.132	.185	.363
MIN RADIUS	.288	.293	.157
MEAN RADIUS	.918	.800	.611
MAX RADIUS	1.596	1.761	1.237
HORIZONTAL SPREAD	2.043	2.043	1.912
VERTICAL SPREAD	2.219	2.017	1.249
EXTREME SPREAD	2.871	2.871	2.089
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636164

CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 1.635

VS = 2.700

GS = 3.019

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.604	.511
MINIMUM X	:	-.834	-.745	-.343
MAXIMUM Y	:	.851	.646	.706
MINIMUM Y	:	-1.849	-.718	-.658
CENTROID X	:	.050	-.039	.054
CENTROID Y	:	-.051	.154	.094
POA TO CENTROID in.	:	.071	.159	.108
MIN RADIUS	:	.083	.115	.160
MEAN RADIUS	:	.665	.509	.449
MAX RADIUS	:	2.015	.888	.785
HORIZONTAL SPREAD	:	1.635	1.349	.854
VERTICAL SPREAD	:	2.700	1.364	1.364
EXTREME SPREAD	:	3.019	1.438	1.368
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8636164

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.699

VS = 1.689

GS = 2.765

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.223	1.050	.881
MINIMUM X	-1.476	-1.173	-1.040
MAXIMUM Y	.816	.498	.536
MINIMUM Y	-.873	-.782	-.744
CENTROID X	.023	.187	.054
CENTROID Y	.054	-.037	-.075
POA TO CENTROID in.	.058	.190	.093
MIN RADIUS	.350	.367	.475
MEAN RADIUS	.881	.754	.720
MAX RADIUS	1.687	1.274	1.170
HORIZONTAL SPREAD	2.699	2.231	1.921
VERTICAL SPREAD	1.689	1.280	1.280
EXTREME SPREAD	2.765	2.239	2.019
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/066961B4

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 10

HS = 2.299

VS = 1.668

GS = 2.395

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.097	.954	.895
MINIMUM X	-1.202	-.910	-.790
MAXIMUM Y	.921	.885	.922
MINIMUM Y	-.747	-.783	-.745
CENTROID X	-.120	.013	-.107
CENTROID Y	-.216	-.180	-.217
POA TO CENTROID in.	.247	.180	.242
MIN RADIUS	.534	.435	.522
MEAN RADIUS	.884	.832	.805
MAX RADIUS	1.247	1.129	1.065
HORIZONTAL SPREAD	2.299	1.874	1.685
VERTICAL SPREAD	1.668	1.668	1.668
EXTREME SPREAD	2.395	2.041	2.041
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3B164

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.579

VS= 2.174

GS= 2.686

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.310
MINIMUM X	-1.269
MAXIMUM Y	.995
MINIMUM Y	-1.179
CENTROID X	-.004
CENTROID Y	.055
POA TO CENTROID in.	.055
MIN RADIUS	.264
MEAN RADIUS	.902
MAX RADIUS	1.558
HORIZONTAL SPREAD	2.579
VERTICAL SPREAD	2.174
EXTREME SPREAD	2.686
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6636164DATE 8/16/91TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	^{2.3} 2.45	² 2.41	¹ 2.38	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.35	2.20	2.64	
PULL #3	2.27	2.35	2.40	2.68	
PULL #4	2.46	2.42	2.31	2.69	
PULL #5	2.36	2.39	2.42	2.61	
TOTAL	12.00	11.92	11.71		
AVG.	2.40	2.38	2.34		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	² 3.82	² 3.76		
PULL #2	3.26	3.15		
PULL #3	2.95	3.17		
PULL #4	3.24	3.13		
PULL #5	3.17	3.26		
TOTAL	15.74	15.87		
AVG.	3.15	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	¹ 4.12	4.02		² 4.26
PULL #2	4.11	4.11		4.40
PULL #3	4.00	4.10		4.35
PULL #4	4.08	4.10		4.36
PULL #5	4.16	4.13		4.34
TOTAL	20.47	20.46		21.71
AVG.	4.09	4.09		4.34