

C6636177

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington[®]

MODEL 700[™] M24

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

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

REG. U.S. PAT. & T.M. OFF.

DUPONT

SERIAL NO.
C6626177

ORDER NO.
5716

20

5716 C6626177

LPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636177

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	EB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8/10/91	AA
	Apply Coating (Bolt)		8/10/91	AA
625	Final Assembly A) Clean inside of Bolt Assembly		8/19/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	KA
	C) Inspect Ejector Hole for Chamfer		8/19/91	KA
	D) Oil Firing Pin Ass'y		8/19/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	KA

op. #	BARBER - M24 0038597	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/20/91	QH
	G) Safety Off Force	3	3	3			8/20/91	QH
	H) Trigger Pull Test & Retainability						8/20/91	QH
	I) Firing Pin Indent	.021	.021	.021			8/20/91	QH
	J) Assemble Stock						8/20/91	QH
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/20/91	QH
	M) Iron Sight Alignment						8/20/91	QH
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	QH
	O) Attach Scope to Rifle						8/20/91	QH
	P) Detach & Attach Scope 20 Times						8/20/91	QH
640	Gallery Target & Test						8-21-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-21-91	AF
655	Final Inspection							
	A) Headspace						8/22/91	QH
	B) Trigger Pull	2.54	2.43	2.40	2.48	2.48	8-22-91	QH
	C) Function						8/22/91	QH
660	Pack						7-17-91	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636177
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.105342
1 TO 2	.149201
1 TO 3	.228127
1 TO 4	.306341
1 TO 5	.153056



<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0388
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.043
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0579175
THE AMR FOR THIS RIFLE IS: 1.055

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636177

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.608

VS = 2.349

GS = 2.943

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.478	1.618	1.014
MINIMUM X	-1.130	-.990	-.788
MAXIMUM Y	1.053	.915	.973
MINIMUM Y	-1.296	-1.434	-1.376
CENTROID X	-.036	-.176	-.378
CENTROID Y	.099	.237	.179
POA TO CENTROID in.	.105	.295	.418
MIN RADIUS	.322	.127	.212
MEAN RADIUS	1.103	.995	.889
MAX RADIUS	1.767	1.684	1.405
HORIZONTAL SPREAD	2.608	2.608	1.802
VERTICAL SPREAD	2.349	2.349	2.349
EXTREME SPREAD	2.943	2.836	2.672
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

23 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8636177

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 1

3in = 8

HS = 2.337

VS = 3.104

GS = 3.399

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.195	1.069	.978
MINIMUM X	:	-1.142	-.721	-.696
MAXIMUM Y	:	1.451	1.267	1.060
MINIMUM Y	:	-1.653	-1.659	-1.719
CENTROID X	:	-.155	-.029	.062
CENTROID Y	:	.009	.193	.400
POA TO CENTROID in.	:	.156	.195	.405
MIN RADIUS	:	.280	.469	.636
MEAN RADIUS	:	1.252	1.147	1.030
MAX RADIUS	:	2.009	1.809	1.722
HORIZONTAL SPREAD	:	2.337	1.790	1.674
VERTICAL SPREAD	:	3.104	2.926	2.779
EXTREME SPREAD	:	3.399	2.986	2.782
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06636177

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.477

VS = 2.080

GS = 2.822

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.347	.960	.838
MINIMUM X	-1.130	-.981	-.830
MAXIMUM Y	1.038	1.109	1.029
MINIMUM Y	-1.042	-.971	-1.051
CENTROID X	.115	-.034	.088
CENTROID Y	-.072	-.143	-.063
POA TO CENTROID in.	.136	.147	.108
MIN RADIUS	.281	.243	.253
MEAN RADIUS	.856	.773	.714
MAX RADIUS	1.491	1.365	1.344
HORIZONTAL SPREAD	2.477	1.941	1.668
VERTICAL SPREAD	2.080	2.080	2.080
EXTREME SPREAD	2.822	2.195	2.170
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

23 Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS = 1.629

VS = 2.644

GS = 2.649

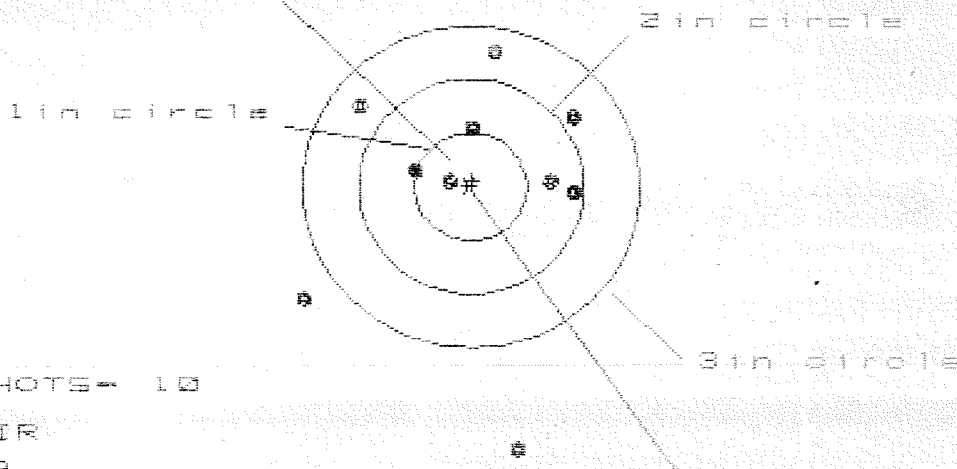
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.583	.588	.573
MINIMUM X	:	-1.046	-1.041	-1.056
MAXIMUM Y	:	1.360	1.138	.997
MINIMUM Y	:	-1.284	-1.133	-1.237
CENTROID X	:	-.107	-.112	-.097
CENTROID Y	:	-.199	-.350	-.289
POA TO CENTROID in.	:	.226	.368	.230
MIN RADIUS	:	.687	.545	.594
MEAN RADIUS	:	.977	.928	.889
MAX RADIUS	:	1.361	1.221	1.238
HORIZONTAL SPREAD	:	1.629	1.629	1.629
VERTICAL SPREAD	:	2.644	2.271	2.234
EXTREME SPREAD	:	2.649	2.340	2.285
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636177

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIRCLE

1 in = 2

2 in = 5

3 in = 3

HS= 2.485

VS= 3.660

GS= 3.660

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.949	1.994	1.808
MINIMUM X	-1.536	-1.491	-1.098
MAXIMUM Y	1.238	1.969	1.803
MINIMUM Y	-2.422	-1.328	-1.525
CENTROID X	-0.011	-0.056	0.130
CENTROID Y	-0.052	0.217	0.383
POA TO CENTROID in.	0.053	0.224	0.405
MIN RADIUS	0.163	0.241	0.231
MEAN RADIUS	1.087	0.882	0.726
MAX RADIUS	2.456	1.996	1.152
HORIZONTAL SPREAD	2.485	2.485	1.906
VERTICAL SPREAD	3.660	2.297	1.328
EXTREME SPREAD	3.668	3.016	2.097
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06636177

DATE 8/20/91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.45	2.44	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.49	2.50	2.43	
PULL #3	2.36	2.43	2.48	2.40	
PULL #4	2.47	2.35	2.45	2.48	
PULL #5	2.46	2.51	2.50	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.35		
PULL #2	3.60	3.34		
PULL #3	3.57	3.39		
PULL #4	3.59	3.45		
PULL #5	3.60	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.36		4.47
PULL #2	4.39	4.48		4.56
PULL #3	4.49	4.42		4.50
PULL #4	4.45	4.38		4.60
PULL #5	4.36	4.52		4.63
TOTAL				
AVG.				