

C6636193

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		SERIAL NO. C6636193
20		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636193

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		WB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-25-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	84

op. #	BARBER M24 0038759	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-4-91	DH
	G) Safety Off Force	2 1/2	2 3/4	3			6-4-91	DH
	H) Trigger Pull Test & Retainability						6-4-91	RL
	I) Firing Pin Indent	.022	.021	.021			6-4-91	DH
	J) Assemble Stock						6-15-91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6-5-91	RW
	M) Iron Sight Alignment						6-5-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-5-91	RW
	O) Attach Scope to Rifle						6-5-91	RW
	P) Detach & Attach Scope 20 Times						6-5-91	RW
640	Gallery Target & Test						6-5-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6-5-91	KT
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.17	2.35	2.25	2.44	2.46	6-8-91	RL
	C) Function						6-8-91	DH
660	Pack						6-20-91	RV

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636193

DATE 6-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.19	2.31	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.38	2.35	2.35	
PULL #3	2.47	2.38	2.23	2.25	
PULL #4	2.19	2.35	2.38	2.44	
PULL #5	2.43	2.27	2.34	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.45		
PULL #2	3.20	3.39		
PULL #3	3.39	3.37		
PULL #4	3.37	3.31		
PULL #5	3.29	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.56		4.58
PULL #2	4.39	4.56		4.58
PULL #3	4.53	4.57		4.48
PULL #4	4.58	4.53		4.48
PULL #5	4.50	4.51		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636193
5 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.139979
1 TO	2	.230274
1 TO	3	.190979
1 TO	4	.2986
1 TO	5	.143544

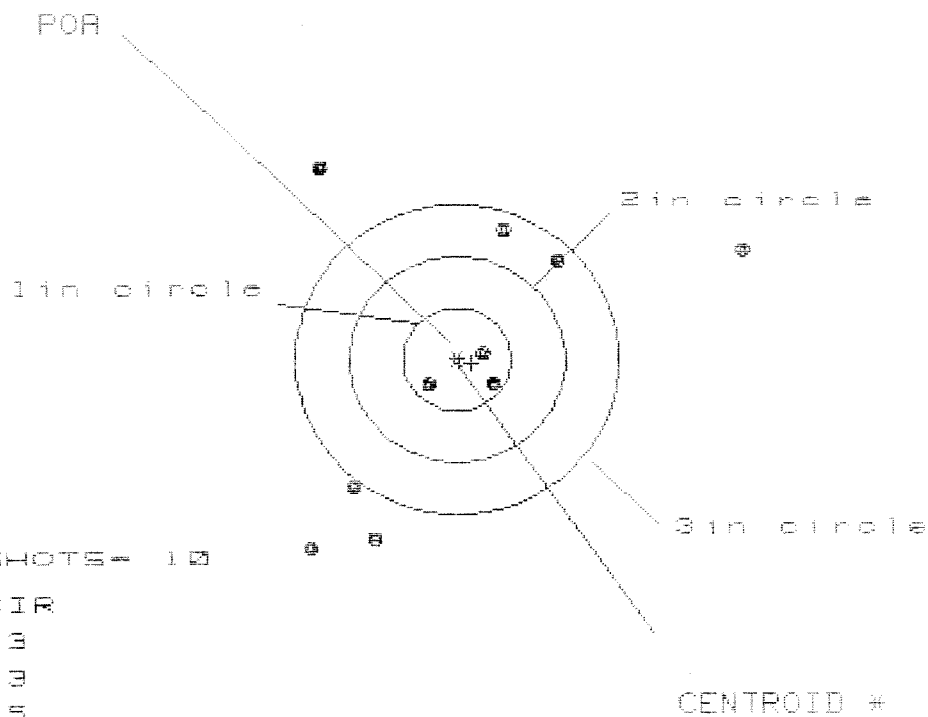
24
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0504
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0892
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102454
THE AMR FOR THIS RIFLE IS: 1.06

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636193

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 3

3in = 5

HS = 4.032

VS = 3.724

GS = 4.984

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.647	1.208	1.071
MINIMUM X	-1.385	-1.091	-1.129
MAXIMUM Y	1.876	1.996	1.780
MINIMUM Y	-1.848	-1.728	-1.860
CENTROID X	-.135	-.429	-.292
CENTROID Y	.037	-.083	.133
FOR TO CENTROID in.	.140	.437	.321
MIN RADIUS	.243	.103	.290
MEAN RADIUS	1.453	1.309	1.198
MAX RADIUS	2.859	2.229	2.108
HORIZONTAL SPREAD	4.032	2.299	2.200
VERTICAL SPREAD	3.724	3.724	3.648
EXTREME SPREAD	4.984	3.725	3.688
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.165

VS= 2.883

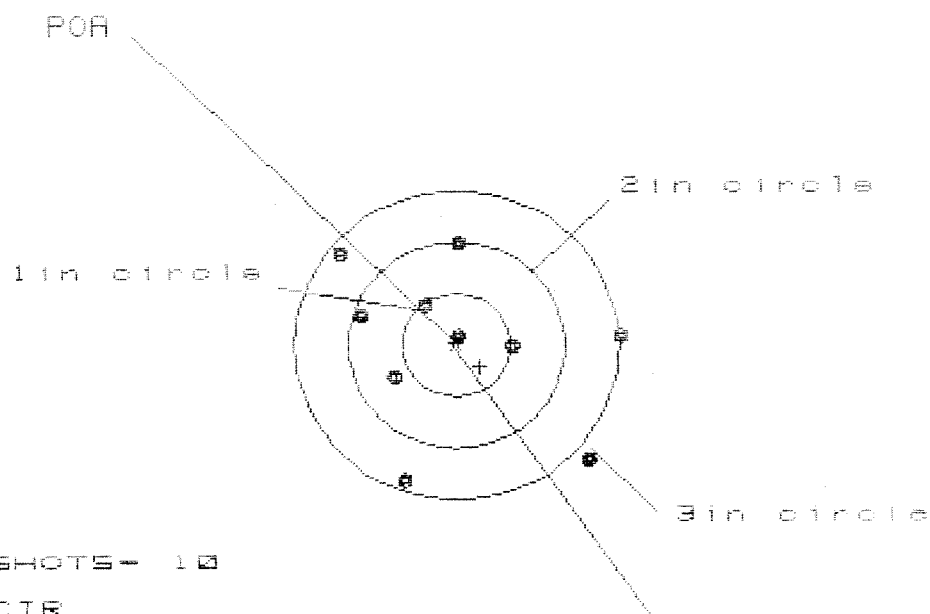
GS= 2.897

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.185	1.199	1.181
MINIMUM X	:	-.980	-.966	-.984
MAXIMUM Y	:	1.416	1.253	.933
MINIMUM Y	:	-1.467	-.823	-.667
CENTROID X	:	.090	.076	.094
CENTROID Y	:	-.012	.151	-.005
POA TO CENTROID in.	:	.091	.169	.094
MIN RADIUS	:	.254	.107	.247
MEAN RADIUS	:	.947	.865	.821
MAX RADIUS	:	1.473	1.261	1.186
HORIZONTAL SPREAD	:	2.165	2.165	2.165
VERTICAL SPREAD	:	2.883	2.076	1.600
EXTREME SPREAD	:	2.897	2.298	2.298
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636193

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.617

VS = 2.270

GS = 3.033

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.561
MINIMUM X	-1.056
MAXIMUM Y	.982
MINIMUM Y	-1.288
CENTROID X	-.218
CENTROID Y	.209
POA TO CENTROID in.	.302
MIN RADIUS	.093
MEAN RADIUS	.957
MAX RADIUS	1.645
HORIZONTAL SPREAD	2.617
VERTICAL SPREAD	2.270
EXTREME SPREAD	3.033
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

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FILE:/PATTERNING/CENTERFIRE_PATT/08636193

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.582

VS= 1.752

GS= 2.583

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.898	.549
MINIMUM X	:	-1.516	-.942	-.830
MAXIMUM Y	:	.776	.667	.542
MINIMUM Y	:	-.976	-1.002	-.756
CENTROID X	:	.044	.212	.100
CENTROID Y	:	.276	.385	.510
POA TO CENTROID in.	:	.280	.439	.520
MIN RADIUS	:	.388	.426	.285
MEAN RADIUS	:	.839	.703	.597
MAX RADIUS	:	1.803	1.345	.934
HORIZONTAL SPREAD	:	2.582	1.840	1.379
VERTICAL SPREAD	:	1.752	1.669	1.298
EXTREME SPREAD	:	2.583	2.343	1.752
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.897

VS= 2.159

GS= 3.144

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.445	1.579	1.414
MINIMUM X	:	-1.452	-1.318	-1.476
MAXIMUM Y	:	1.107	.990	.896
MINIMUM Y	:	-1.052	-.750	-.794
CENTROID X	:	-.033	-.167	-.002
CENTROID Y	:	-.064	.053	.147
POR TO CENTROID in.	:	.072	.175	.147
MIN RADIUS	:	.265	.272	.082
MEAN RADIUS	:	1.104	1.050	.952
MAX RADIUS	:	1.600	1.647	1.483
HORIZONTAL SPREAD	:	2.897	2.897	2.890
VERTICAL SPREAD	:	2.159	1.740	1.690
EXTREME SPREAD	:	3.144	3.144	2.899
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	