

C6636195

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

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

MODEL 700TM M24

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

SERIAL NO.
C6636195

ORDER NO.
5716


5716 C6636195

UPC


0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636195

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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	LI
615	Rollmark Caliber		4/10/91	YJ
617	Drill and Tap Sight Holes		APR 19 1991	EB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
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	D/H

op. #	BARBER - M24 0038781 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	6			5-30-91	DH
	G) Safety Off Force	3	3	3			5-30-91	DH
	H) Trigger Pull Test & Retainability						5-30-91	DH
	I) Firing Pin Indent	.023	.022	.023			5-30-91	DH
	J) Assemble Stock						5/30/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	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	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-3-91	AF
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.64	2.66	2.58	2.60	2.39	6-8-91	02/
	C) Function						6-8-91	DH
660	Pack						6-20-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636195

DATE 7-30-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.44	2.32	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.29	2.80	2.66	
PULL #3	2.94	2.04	2.82	2.58	
PULL #4	2.88	2.03	2.86	2.60	
PULL #5	2.79	2.00	2.65	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	2.86		
PULL #2	3.25	3.12		
PULL #3	3.45	3.09		
PULL #4	3.50	2.94		
PULL #5	3.04	3.02		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.18		4.61
PULL #2	4.36	4.21		4.56
PULL #3	4.34	4.38		4.63
PULL #4	4.31	4.36		4.54
PULL #5	4.22	4.19		4.84
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636195
JUN 1991

CENTROIDAL DISTANCES

0 TO	1	.135
1 TO	2	.232215
1 TO	3	.281656
1 TO	4	.29598
1 TO	5	.156541

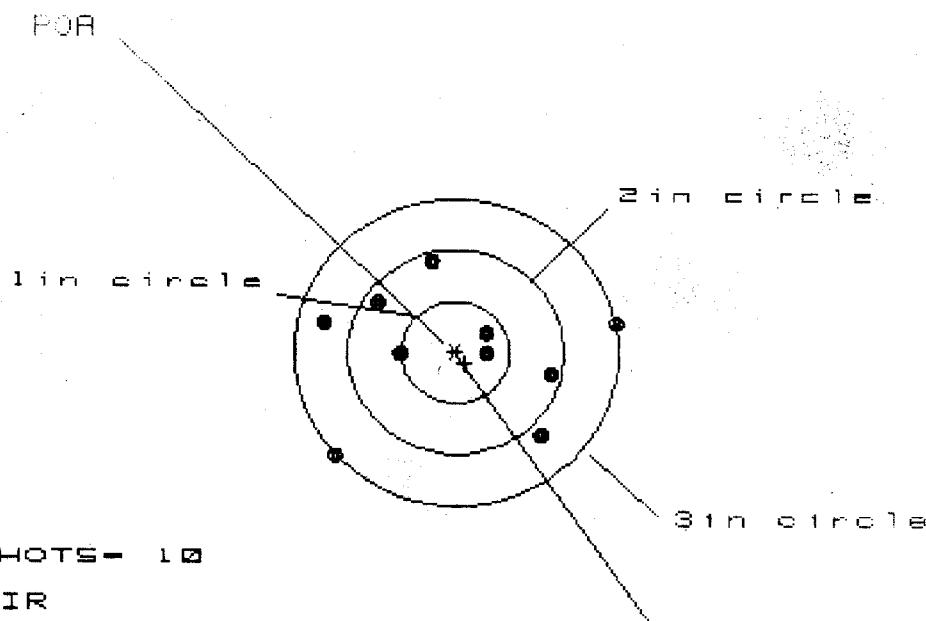
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0308
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .033359
THE AMR FOR THIS RIFLE IS: 1.019

3 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636195

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.664

VS= 1.858

GS= 2.857

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.473	1.051	.937
MINIMUM X	:	-1.191	-1.027	-1.141
MAXIMUM Y	:	.898	.934	.819
MINIMUM Y	:	-.960	-.924	-.933
CENTROID X	:	-.081	-.245	-.131
CENTROID Y	:	.108	.072	.187
POA TO CENTROID in.	:	.135	.255	.228
MIN RADIUS	:	.244	.320	.307
MEAN RADIUS	:	.907	.842	.762
MAX RADIUS	:	1.509	1.300	1.251
HORIZONTAL SPREAD	:	2.664	2.078	2.078
VERTICAL SPREAD	:	1.858	1.858	1.752
EXTREME SPREAD	:	2.857	2.278	2.278
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636195

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

CENTROID *

HS= 3.633

VS= 4.600

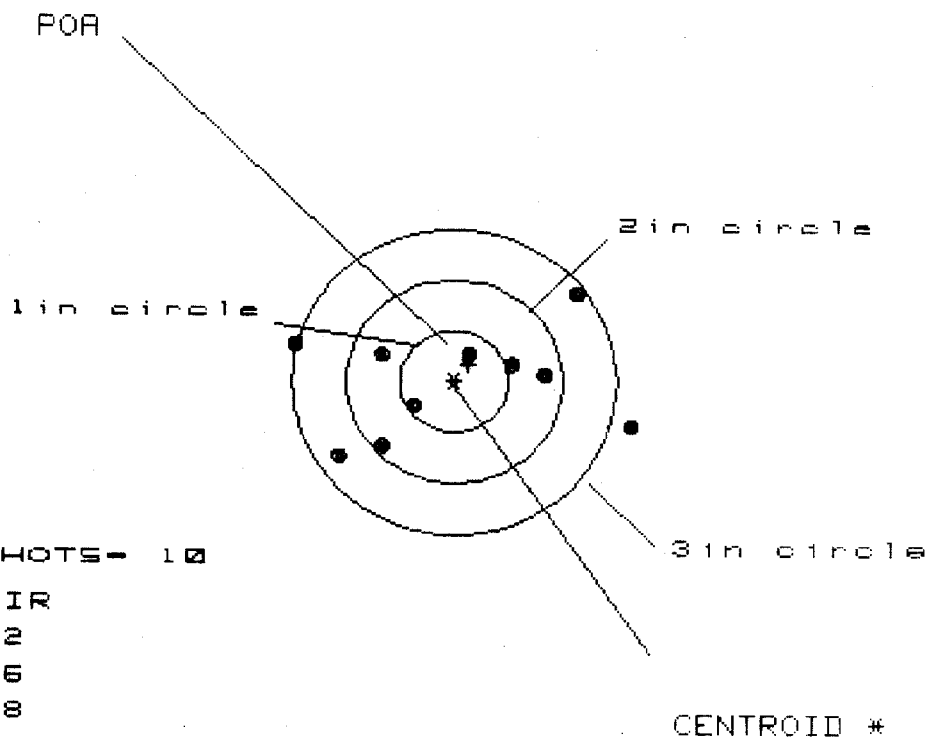
GS= 4.813

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.958	2.009	1.897
MINIMUM X	:	-1.675	-1.624	-1.736
MAXIMUM Y	:	2.124	1.848	1.498
MINIMUM Y	:	-2.476	-1.588	-1.357
CENTROID X	:	.137	.086	.198
CENTROID Y	:	.028	.304	.072
POA TO CENTROID in.	:	.140	.315	.211
MIN RADIUS	:	.194	.366	.267
MEAN RADIUS	:	1.443	1.292	1.205
MAX RADIUS	:	2.520	2.148	1.969
HORIZONTAL SPREAD	:	3.633	3.633	3.633
VERTICAL SPREAD	:	4.600	3.436	2.855
EXTREME SPREAD	:	4.813	3.906	3.694
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	5		

3 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.185

VS = 1.528

GS = 3.306

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.681	1.361	1.196
MINIMUM X	-1.504	-1.317	-1.090
MAXIMUM Y	.841	.788	.833
MINIMUM Y	-.687	-.740	-.695
CENTROID X	-.132	-.319	-.154
CENTROID Y	-.169	-.116	-.161
POA TO CENTROID in.	.214	.339	.223
MIN RADIUS	.272	.329	.276
MEAN RADIUS	.972	.872	.801
MAX RADIUS	1.746	1.573	1.458
HORIZONTAL SPREAD	3.185	2.678	2.286
VERTICAL SPREAD	1.528	1.528	1.528
EXTREME SPREAD	3.306	2.750	2.750
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636195

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.427

VS= 1.542

GS= 2.453

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	.868	.741
MINIMUM X	:	-1.403	-1.013	-1.015
MAXIMUM Y	:	.731	.768	.845
MINIMUM Y	:	-.811	-.774	-.697
CENTROID X	:	.117	.272	.399
CENTROID Y	:	-.112	-.149	-.226
POA TO CENTROID in.	:	.162	.311	.459
MIN RADIUS	:	.284	.148	.155
MEAN RADIUS	:	.832	.730	.645
MAX RADIUS	:	1.442	1.185	1.025
HORIZONTAL SPREAD	:	2.427	1.881	1.756
VERTICAL SPREAD	:	1.542	1.542	1.542
EXTREME SPREAD	:	2.453	1.975	1.771
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636195

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.960

VS= 1.531

GS= 3.150

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.676	1.300	1.163
MINIMUM X	:	-1.284	-1.098	-.564
MAXIMUM Y	:	.733	.674	.735
MINIMUM Y	:	-.798	-.857	-.796
CENTROID X	:	.023	-.163	-.026
CENTROID Y	:	-.009	.050	-.011
POA TO CENTROID in.	:	.025	.171	.028
MIN RADIUS	:	.490	.299	.448
MEAN RADIUS	:	.943	.814	.777
MAX RADIUS	:	1.758	1.303	1.173
HORIZONTAL SPREAD	:	2.960	2.398	1.727
VERTICAL SPREAD	:	1.531	1.531	1.531
EXTREME SPREAD	:	3.150	2.430	1.860
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	