

C6348835

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

179



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

MODEL 700™ M24	SERIAL NO. C6348835
	ORDER NO. 5716

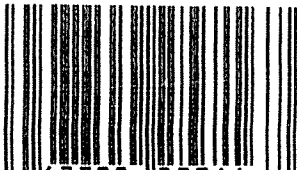
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

01



5716 C6348835

UPC



0 47700 25716 7

[illegible]

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498835

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KOR
	Magnaflux Bolt		5/22/90	KER
615	Rollmark Caliber		5/22/90	G.S.
617	Drill and Tap Sight Holes		5/23/90	KB
618	Polish Barrel RWB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/4/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/90	RW
	C) Inspect Ejector Hole for Chamfer		6/4/90	RW
	D) Oil Firing Pin Ass'y		6/4/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/8/90	GM

BARBER - M24 0039396								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	3	3	3	6/12/90	JH		
	G) Safety Off Force	3	3	3	6/12/90	JH		
	H) Trigger Pull Test & Retainability				6/8/90	JH		
	I) Firing Pin Indent	.023	.023	.023	6/11/90	WB		
	J) Assemble Stock				6/12/90	RW		
	K) Assemble Swivel Studs				6/14/90	JH		
	L) Attach Front and Rear Sight Assemblies				6/12/90	RW		
	M) Iron Sight Alignment				6/12/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				6/12/90	RW		
	O) Attach Scope to Rifle				6/12/90	WB		
	P) Detach & Attach Scope 20 Times				6/12/90	WB		
640	Gallery Target & Test				6-12-90	A		
	A) Time				"	A		
	B) Malfunctions				"	A		
	C) Pierced Primers				"	A		
	D) Optical Clarity of Scope				"	A		
645	Inspect for Live Ammo				6-12-90	A		
655	Final Inspection							
	A) Headspace				6/14/90	JH		
	B) Trigger Pull	2.31	2.32	2.25	2.27	2.26	6-14-90	JH
	C) Function						6/14/90	JH
660	Pack						6-20-90	DH

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

SERIAL NO. 06498835DATE 6/8/98TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.46	2.42	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.44	2.40	2.32	
PULL #3	2.43	2.49	2.43	2.25	
PULL #4	2.46	2.51	2.35	2.27	
PULL #5	2.46	2.48	2.40	2.26	
TOTAL	12.19	12.38	12.00		
AVG.	2.438	2.476	2.4		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.36		
PULL #2	3.31	3.38		
PULL #3	3.34	3.11		
PULL #4	3.16	3.42		
PULL #5	3.30	3.40		
TOTAL	16.31	16.67		
AVG.	3.262			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.33		4.41
PULL #2	4.16	4.26		4.45
PULL #3	4.24	4.38		4.48
PULL #4	4.13	4.39		4.43
PULL #5	4.19	4.39		4.45
TOTAL	21.00	21.75		22.22
AVG.	4.2	4.35		4.444

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498835
13 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.061131
1 TO	2	.331887
1 TO	3	.674756
1 TO	4	.605535
1 TO	5	.643199

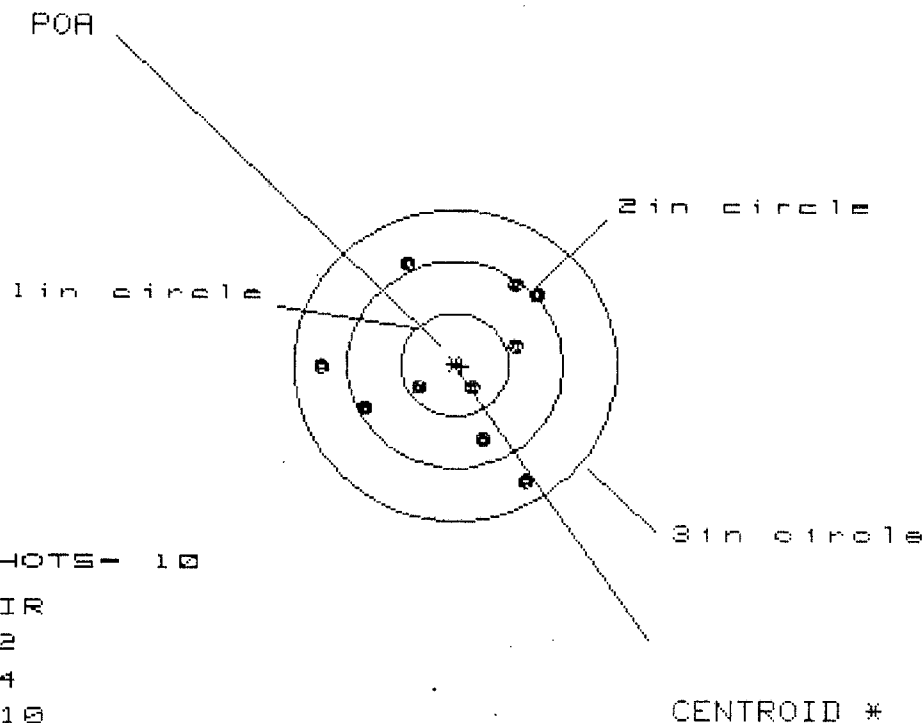
$S_{\frac{2}{4}}^{\#}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4474
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .470187
THE AMR FOR THIS RIFLE IS: .8394

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6496835

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.011

VS= 2.027

GS= 2.328

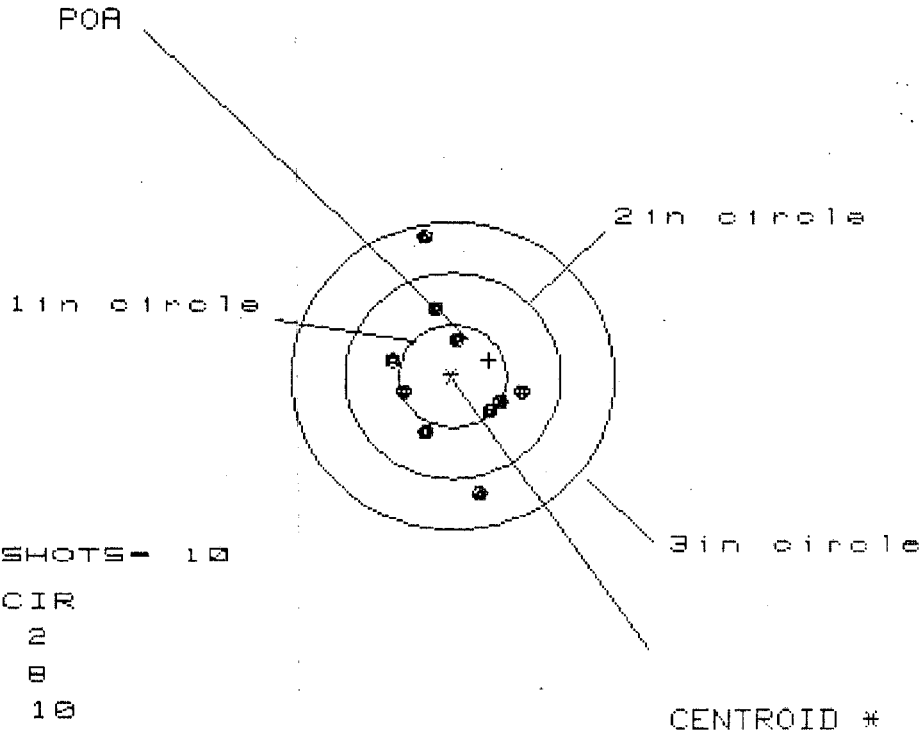
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.769	.844	.698
MINIMUM X	-1.242	-1.167	-.961
MAXIMUM Y	.937	.816	.804
MINIMUM Y	-1.090	-.861	-.873
CENTROID X	-.059	-.134	.012
CENTROID Y	.016	.137	.149
POA TO CENTROID in.	.061	.192	.150
MIN RADIUS	.250	.390	.328
MEAN RADIUS	.857	.816	.752
MAX RADIUS	1.281	1.171	1.128
HORIZONTAL SPREAD	2.011	2.011	1.659
VERTICAL SPREAD	2.027	1.677	1.677
EXTREME SPREAD	2.328	2.105	1.992
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06438835

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.275

VS= 2.507

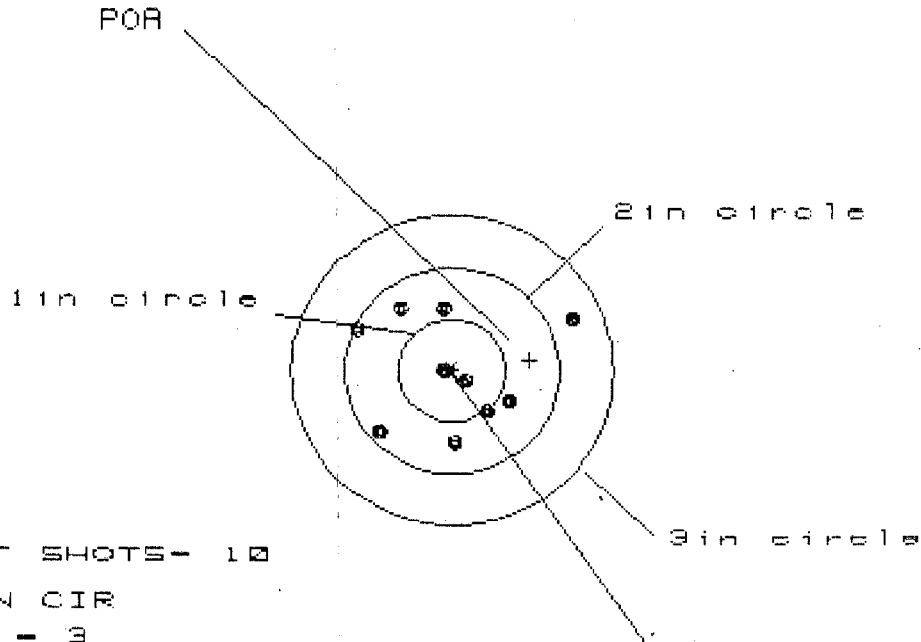
GS= 2.551

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.667	.636	.657
MINIMUM X	:	-.608	-.639	-.618
MAXIMUM Y	:	1.354	.835	.710
MINIMUM Y	:	-1.153	-1.003	-.515
CENTROID X	:	-.341	-.310	-.331
CENTROID Y	:	-.159	-.309	-.184
POA TO CENTROID in.	:	.376	.438	.379
MIN RADIUS	:	.402	.350	.425
MEAN RADIUS	:	.705	.614	.561
MAX RADIUS	:	1.381	1.017	.726
HORIZONTAL SPREAD	:	1.275	1.275	1.275
VERTICAL SPREAD	:	2.507	1.838	1.225
EXTREME SPREAD	:	2.551	1.869	1.320
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Jun 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498835

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 2.034

VS= 1.332

GS= 2.145

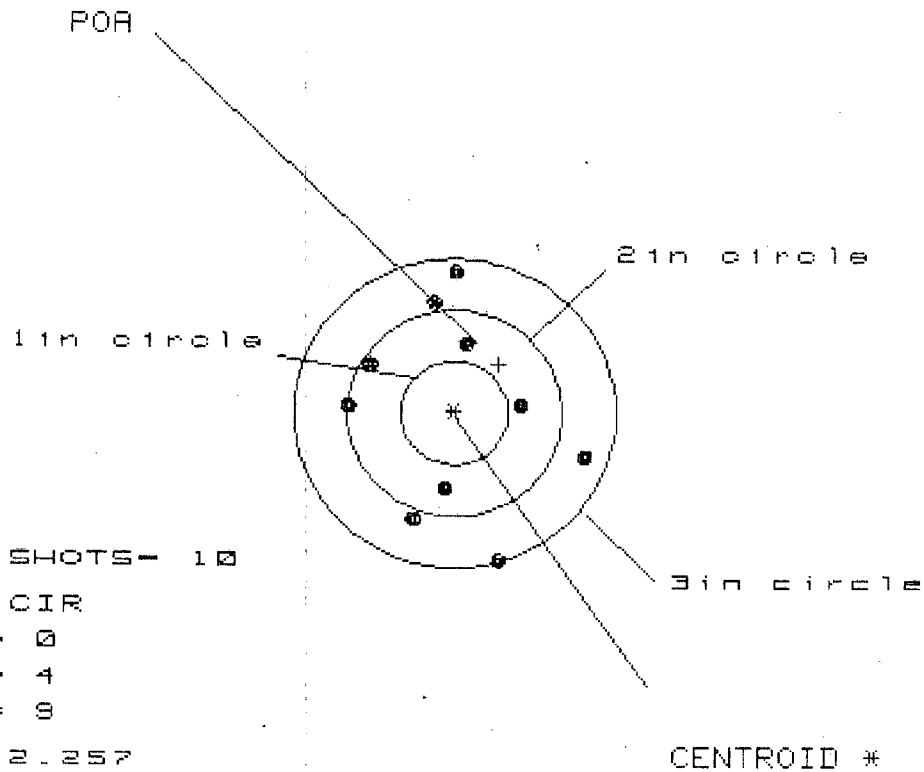
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.169	.697	.605
MINIMUM X	:	-.865	-.735	-.620
MAXIMUM Y	:	.617	.676	.734
MINIMUM Y	:	-.715	-.656	-.598
CENTROID X	:	-.723	-.853	-.761
CENTROID Y	:	-.104	-.163	-.221
POA TO CENTROID in.	:	.731	.869	.793
MIN RADIUS	:	.123	.045	.132
MEAN RADIUS	:	.665	.589	.540
MAX RADIUS	:	1.285	.868	.824
HORIZONTAL SPREAD	:	2.034	1.432	1.225
VERTICAL SPREAD	:	1.332	1.332	1.332
EXTREME SPREAD	:	2.145	1.581	1.396
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B835

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.257

VS= 2.852

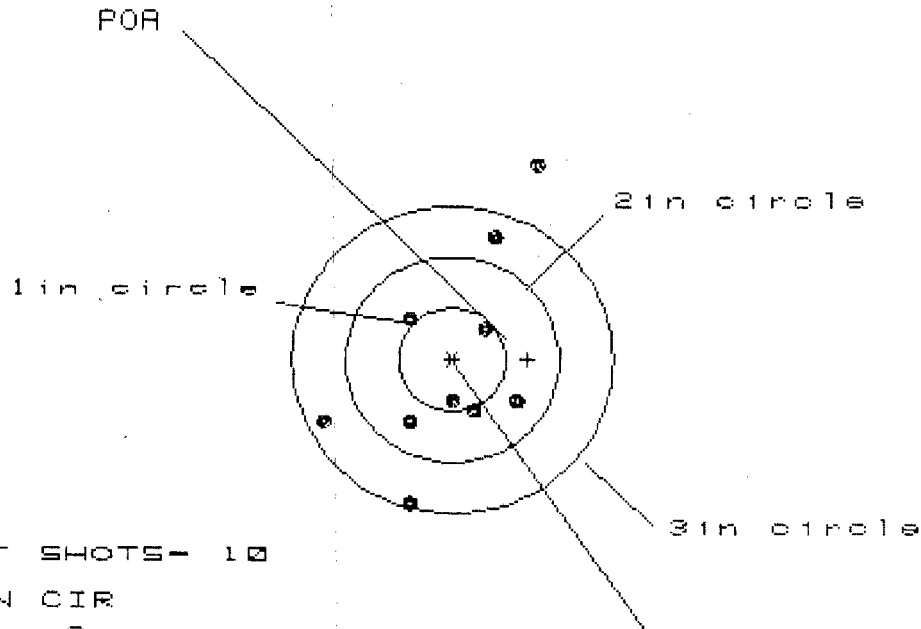
GS= 2.872

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.295	1.306
MINIMUM X	-1.005	-.962	-.951
MAXIMUM Y	1.384	1.221	1.046
MINIMUM Y	-1.468	-1.193	-1.041
CENTROID X	-.412	-.455	-.466
CENTROID Y	-.476	-.313	-.465
POA TO CENTROID in.	.629	.552	.659
MIN RADIUS	.588	.510	.641
MEAN RADIUS	1.024	.950	.916
MAX RADIUS	1.519	1.429	1.382
HORIZONTAL SPREAD	2.257	2.257	2.257
VERTICAL SPREAD	2.852	2.414	2.087
EXTREME SPREAD	2.872	2.452	2.311
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C643B835

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.954

VS= 3.254

GS= 3.473

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.689	.645
MINIMUM X	:	-1.179	-1.093	-1.137
MAXIMUM Y	:	1.886	1.414	1.269
MINIMUM Y	:	-1.368	-1.158	-.554
CENTROID X	:	-.702	-.788	-.744
CENTROID Y	:	-.000	-.210	-.065
POA TO CENTROID in.	:	.702	.816	.747
MIN RADIUS	:	.432	.230	.367
MEAN RADIUS	:	.946	.783	.739
MAX RADIUS	:	2.039	1.509	1.358
HORIZONTAL SPREAD	:	1.954	1.782	1.782
VERTICAL SPREAD	:	3.254	2.572	1.823
EXTREME SPREAD	:	3.473	2.719	2.439
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	