

C6348793

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

BARBER - M24 0064189 **M2400064208**

BARBER - M24 0064170

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C1634879-3DATE 7-16-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.29	2.61		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.52	2.68		
PULL #3	2.33	2.37	2.67		
PULL #4	2.25	2.53	2.79		
PULL #5	2.37	2.48	2.86		
TOTAL	11.65	12.19	13.61		
AVG.	2.33	2.43	2.72		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.27		
PULL #2	3.18	3.01		
PULL #3	3.03	3.00		
PULL #4	3.18	3.25		
PULL #5	3.35	3.34		
TOTAL	15.93	15.87		
AVG.	3.18	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.01		4.06
PULL #2	4.12	3.93		4.00
PULL #3	4.04	3.80		4.06
PULL #4	4.01	3.80		4.04
PULL #5	4.01	3.70		4.00
TOTAL	20.22	19.24		20.18
AVG.	4.04	3.84		4.03

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

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

op. #	BARBER - M24 0064172 OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	5.5	5.5	8/2	SF
	G) Safety Off Force	5	4.5	4.5	8/2	SF
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.0235	.023	.023	8/2	SF
	J) Assemble Stock					
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle					
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test					
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo					
655	Final Inspection A) Headspace					
	B) Trigger Pull	2.70	2.76	2.49	2.49	2.36 8/1/96 SF
	C) Function					
660	Pack					

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348793
12 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	.19799
1 TO	2	.373226
1 TO	3	.202247
1 TO	4	.12881
1 TO	5	.319331

$\frac{34}{26}$ (----)FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1494
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149498

THE AMR FOR THIS RIFLE IS: 1.009

C6348793

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 8

HS = 3.301

VS = 2.342

GS = 3.319

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.657	1.203	1.020
MINIMUM X	-1.644	-1.460	-.985
MAXIMUM Y	1.316	1.374	1.404
MINIMUM Y	-1.026	-.968	-.938
CENTROID X	-.014	-.198	-.015
CENTROID Y	.140	.082	.052
POR TO CENTROID in.	.140	.214	.054
MIN RADIUS	.069	.196	.153
MEAN RADIUS	.937	.841	.743
MAX RADIUS	1.737	1.480	1.415
HORIZONTAL SPREAD	3.301	2.663	2.005
VERTICAL SPREAD	2.342	2.342	2.342
EXTREME SPREAD	3.319	2.792	2.343
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 8		

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

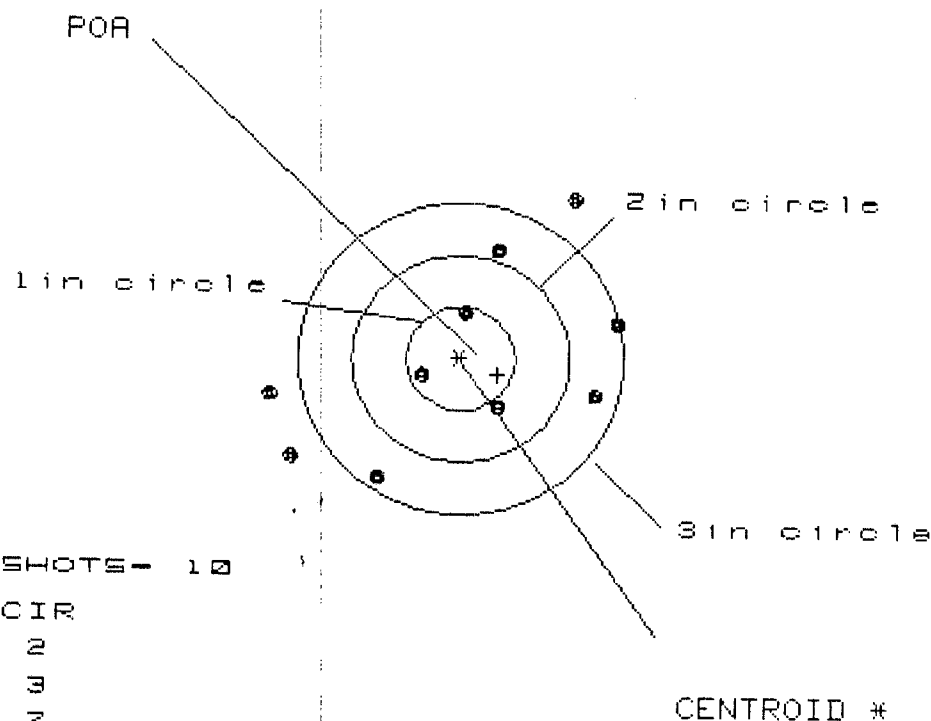
HS = 2.537

VS = 2.753

GS = 2.864

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.366	1.252	1.091
MINIMUM X	:	-1.171	-1.285	-1.374
MAXIMUM Y	:	1.380	1.047	.947
MINIMUM Y	:	-1.373	-1.219	-1.319
CENTROID X	:	-.153	-.039	.122
CENTROID Y	:	-.233	-.387	-.287
POA TO CENTROID in.	:	.279	.388	.312
MIN RADIUS	:	.296	.256	.444
MEAN RADIUS	:	1.089	1.000	.911
MAX RADIUS	:	1.720	1.511	1.442
HORIZONTAL SPREAD	:	2.537	2.537	2.465
VERTICAL SPREAD	:	2.753	2.266	2.266
EXTREME SPREAD	:	2.864	2.807	2.468
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

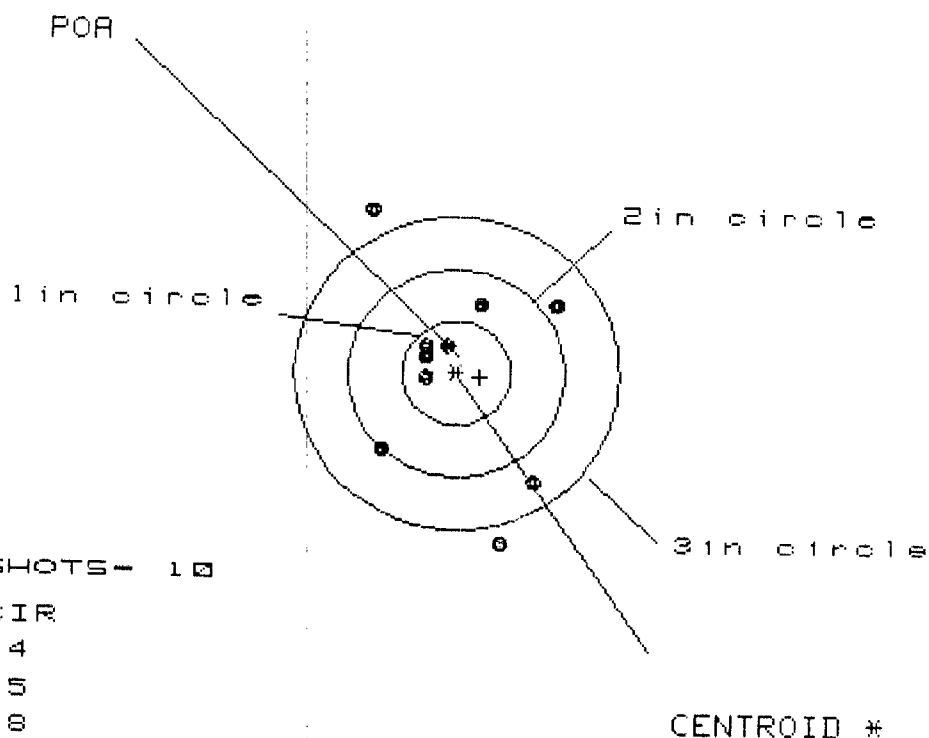
HS= 3.128

VS= 2.675

GS= 3.584

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.397	1.508	1.328
MINIMUM X	-1.731	-1.620	-1.800
MAXIMUM Y	1.549	1.202	1.104
MINIMUM Y	-1.125	-.953	-1.051
CENTROID X	-.342	-.453	-.273
CENTROID Y	.150	-.022	.076
POA TO CENTROID in.	.373	.454	.283
MIN RADIUS	.430	.292	.454
MEAN RADIUS	1.209	1.131	1.049
MAX RADIUS	1.848	1.643	1.826
HORIZONTAL SPREAD	3.128	3.128	3.128
VERTICAL SPREAD	2.675	2.155	2.155
EXTREME SPREAD	3.584	3.240	3.218
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	7	

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS= 1.692

VS= 3.189

GS= 3.397

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.996	.909
MINIMUM X	-.743	-.696	-.739
MAXIMUM Y	1.520	1.335	.658
MINIMUM Y	-1.669	-1.210	-1.043
CENTROID X	-.216	-.263	-.176
CENTROID Y	.036	.221	.054
POA TO CENTROID in.	.219	.344	.185
MIN RADIUS	.283	.094	.274
MEAN RADIUS	.884	.742	.683
MAX RADIUS	1.723	1.505	1.224
HORIZONTAL SPREAD	1.692	1.692	1.648
VERTICAL SPREAD	3.189	2.545	1.701
EXTREME SPREAD	3.397	2.915	2.191
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.906

VS= 2.658

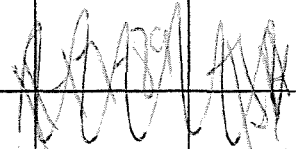
GS= 3.087

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.995	.926	.868
MINIMUM X	-.912	-.801	-.859
MAXIMUM Y	1.300	1.149	1.217
MINIMUM Y	-1.358	-.768	-.624
CENTROID X	.104	-.007	.051
CENTROID Y	-.066	.085	-.059
POA TO CENTROID in.	.123	.085	.078
MIN RADIUS	.222	.386	.233
MEAN RADIUS	.926	.852	.773
MAX RADIUS	1.683	1.240	1.226
HORIZONTAL SPREAD	1.906	1.727	1.727
VERTICAL SPREAD	2.658	1.917	1.841
EXTREME SPREAD	3.087	2.238	2.080
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348793

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10-9 89	RW
600	Proof		10-9 89	AK
607	Check Headspace		10-9 89	RW
610	Dis-assemble Gun		10-9 89	RW
612	Magnaflux Barrel Action	REJECTED	11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test			
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo			
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348793

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	LB
618	Polish Barrel RB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Dec 89	QDS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			4 Dec 89	JS
	G) Safety Off Force	3	3	3			4 Dec 89	JS
	H) Trigger Pull Test & Retainability						4 Dec 89	JS
	I) Firing Pin Indent	.021	.021	.021			4 Dec 89	JS
	J) Assemble Stock						12/5/89	RW
	K) Assemble Swivel Studs						7 Dec 89	JS
	L) Attach Front and Rear Sight Assemblies						12/5/89	RW
	M) Iron Sight Alignment						12/5/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/89	RW
	O) Attach Scope to Rifle						5 Dec 89	JS
	P) Detach & Attach Scope 20 Times						5 Dec 89	JS
640	Gallery Target & Test						12-6-89	K
	A) Time						12-6-89	A
	B) Malfunctions						12-6-89	A
	C) Pierced Primers						12-6-89	A
	D) Optical Clarity of Scope						12-6-89	A
645	Inspect for Live Ammo						12-6-89	A
655	Final Inspection							
	A) Headspace						7 Dec 89	JS
	B) Trigger Pull	2.41	2.59	2.64	2.61	2.61	7 Dec 89	JS
	C) Function						7 Dec 89	JS
660	Pack						15 Dec 89	JS

C6348793

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349067DATE 1 Feb 90TESTER 428

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	269	223	208	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	254	214	244	
PULL #3	259	216	228	
PULL #4	229	211	244	
PULL #5	224	221	227	
TOTAL	1235	1085	1151	
AVG.	247	217	2302	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	301	289	
PULL #2	299	307	
PULL #3	306	303	
PULL #4	302	276	
PULL #5	299	292	
TOTAL	1507	1467	
AVG.	3014	2934	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	394	410		424
PULL #2	398	398		435
PULL #3	401	405		441
PULL #4	402	395		438
PULL #5	403	403		431
TOTAL	1998	2011		2169
AVG.	3996	4022		4338

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348793
5 Dec 1983

CENTROIDAL DISTANCES

0 TO	1	.0444185
1 TO	2	.29671
1 TO	3	1.0706
1 TO	4	.37549
1 TO	5	.320601

7-4-83 7-4-83 FOR

3

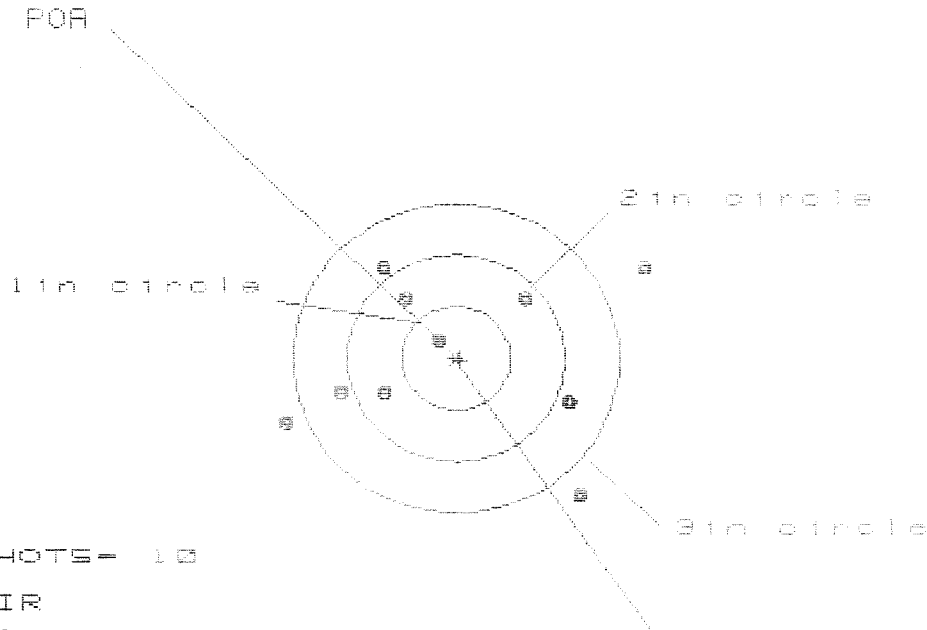
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2682
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .270101
THE AMR FOR THIS RIFLE IS: 1.006

6 Dec 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6346753

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

IS = 3.326

VS = 2.193

GS = 3.630

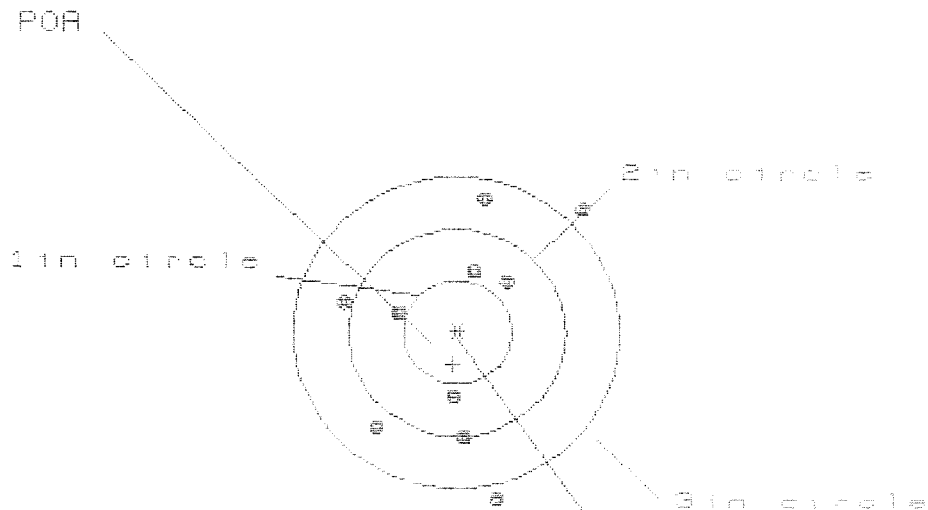
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.778	1.294	1.428
MINIMUM X	-1.548	-1.350	-1.188
MAXIMUM Y	.891	.984	.833
MINIMUM Y	-1.302	-1.209	-1.670
CENTROID X	-.008	-.236	-.398
CENTROID Y	.023	-.070	.081
POA TO CENTROID in.	.045	.246	.406
MIN RADIUS	.282	.309	.235
MEAN RADIUS	1.138	1.021	.878
MAX RADIUS	1.968	1.771	1.520
HORIZONTAL SPREAD	3.326	2.644	2.616
VERTICAL SPREAD	2.193	2.193	1.503
EXTREME SPREAD	3.630	2.809	2.620
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06040753

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

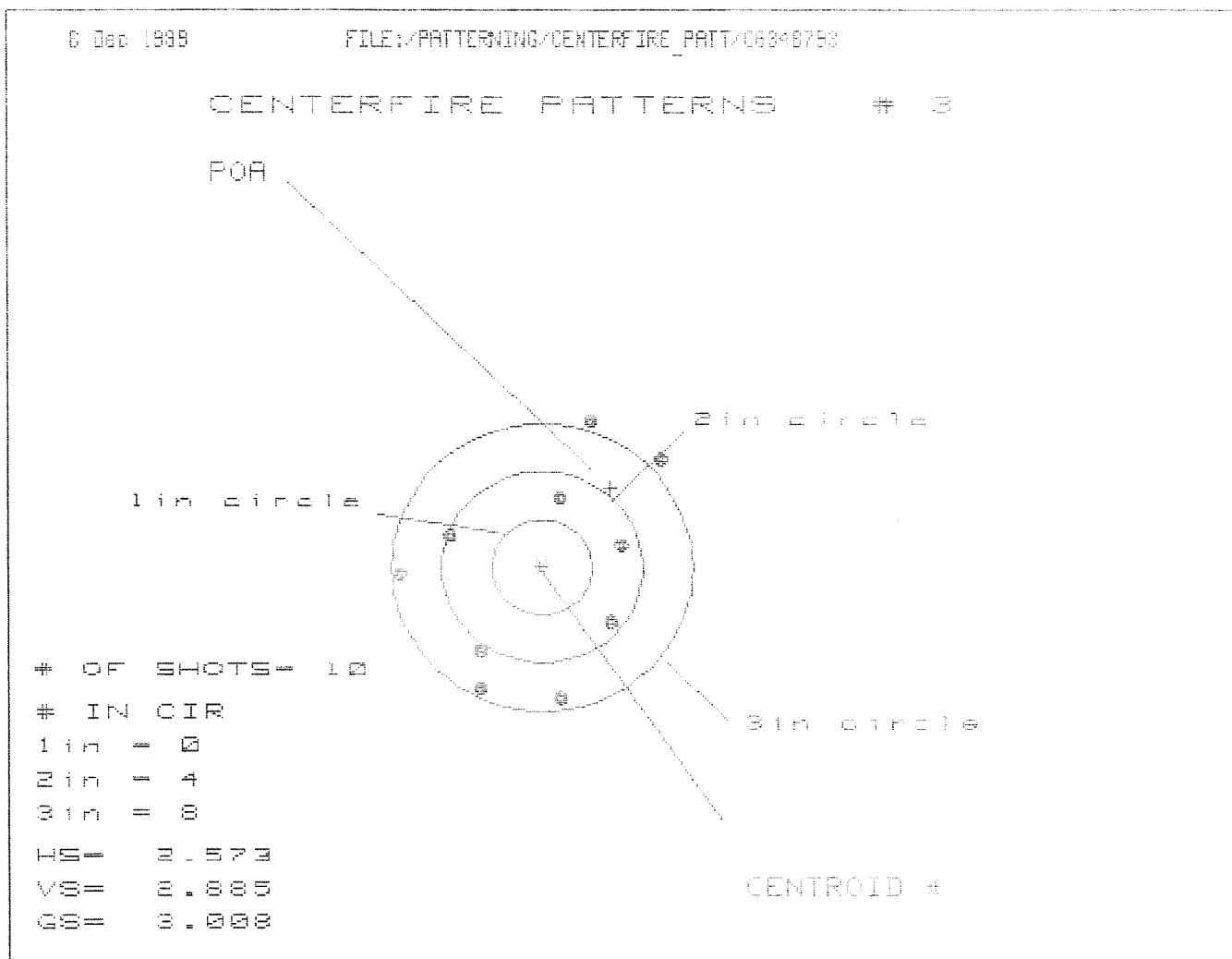
HS = 2.186

VS = 2.889

GS = 2.890

CENTROID %

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	1.153	.664
MINIMUM X	:	-1.075	-1.033	-.889
MAXIMUM Y	:	1.285	1.107	1.232
MINIMUM Y	:	-1.504	-1.165	-1.040
CENTROID X	:	.041	-.001	-.145
CENTROID Y	:	.309	.487	.362
POA TO CENTROID in.	:	.312	.487	.389
MIN RADIUS	:	.601	.470	.409
MEAN RADIUS	:	1.041	.954	.871
MAX RADIUS	:	1.647	1.528	1.328
HORIZONTAL SPREAD	:	2.186	2.186	1.553
VERTICAL SPREAD	:	2.889	2.272	2.272
EXTREME SPREAD	:	2.890	2.798	2.430
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



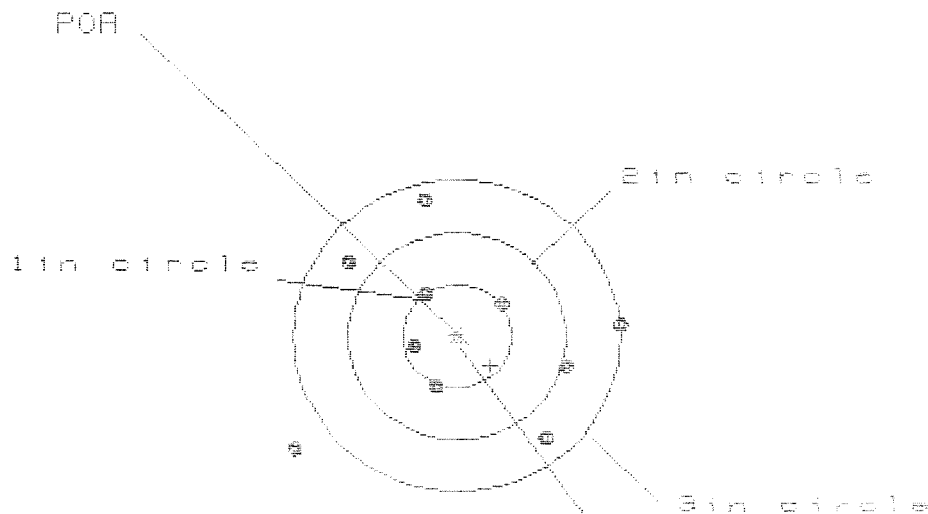
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.142
MINIMUM X	-1.431
MAXIMUM Y	1.560
MINIMUM Y	-1.325
CENTROID X	-0.681
CENTROID Y	-0.833
POA TO CENTROID in.	1.076
MIN RADIUS	.776
MEAN RADIUS	1.199
MAX RADIUS	1.647
HORIZONTAL SPREAD	2.573
VERTICAL SPREAD	2.885
EXTREME SPREAD	3.008
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

6 Dec 1989

FILE: \PATTERNING\CENTERFIRE_PATT\06340753

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.966

VS= 2.418

GS= 3.202

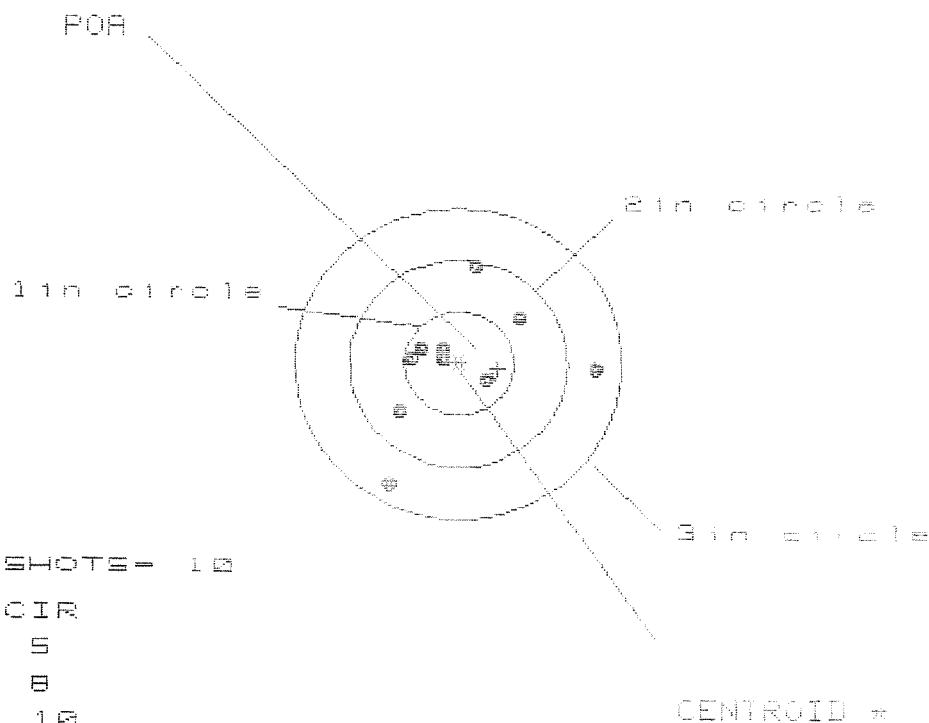
CENTROID +

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.492	1.329	1.029
MINIMUM X	:	-1.474	-1.143	-0.977
MAXIMUM Y	:	1.356	1.238	1.241
MINIMUM Y	:	-1.062	-1.140	-1.137
CENTROID X	:	-1.306	-1.143	-1.309
CENTROID Y	:	.286	.404	.401
POA TO CENTROID in.	:	.419	.428	.505
MIN RADIUS	:	.434	.304	.422
MEAN RADIUS	:	1.020	.926	.854
MAX RADIUS	:	1.816	1.329	1.379
HORIZONTAL SPREAD	:	2.966	2.472	2.606
VERTICAL SPREAD	:	2.418	2.378	2.378
EXTREME SPREAD	:	3.202	2.604	2.604
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06340793

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.913

VS= 2.088

GS= 2.215

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.283
MINIMUM X	-1.698
MAXIMUM Y	.940
MINIMUM Y	-1.148
CENTROID X	-.357
CENTROID Y	.055
POA TO CENTROID in.	.361
MIN RADIUS	.151
MEAN RADIUS	.633
MAX RADIUS	1.310
HORIZONTAL SPREAD	1.913
VERTICAL SPREAD	2.088
EXTREME SPREAD	2.215
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

Remington REG. U.S. PAT. & TM. OFF.		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24			
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada. Marque Deposee.		SERIAL NO. C6348793	ORDER NO. 5716



5716 C6348793

UPC



0 47700 25716 7

