

C6649143

MODEL 780™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6649143

ORDER NO.
5716

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

20

UPC
0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649143

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-13-91	91

op. #	NAME BARBER - M24 0065299	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-13-91	SH
	G) Safety Off Force	4	4	4			8-13-91	SH
	H) Trigger Pull Test & Retainability						8-13-91	SH
	I) Firing Pin Indent	1020	.0205	.0205			8-13-91	SH
	J) Assemble Stock						8-15-91	RW
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8-15-91	RW
	M) Iron Sight Alignment						8-15-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-15-91	RW
	O) Attach Scope to Rifle						8-15-91	RW
	P) Detach & Attach Scope 20 Times						8-15-91	RW
640	Gallery Target & Test						8-15-91	K+
	A) Time							K+
	B) Malfunctions							K+
	C) Pierced Primers							K+
	D) Optical Clarity of Scope							K+
645	Inspect for Live Ammo						8-15-91	K+
655	Final Inspection							
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.44	2.51	2.58	2.32	2.62	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						8-18-91	N-

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649143

DATE 8-13-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.47	2.50		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.51	2.44		
PULL #3	2.48	2.52	2.55		
PULL #4	2.26	2.49	2.48		
PULL #5	2.54	2.47	2.47		
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.19		
PULL #2	3.36	3.35		
PULL #3	3.31	3.39		
PULL #4	3.19	3.37		
PULL #5	3.26	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.40		4.38
PULL #2	4.34	4.42		4.32
PULL #3	4.38	4.34		4.39
PULL #4	4.40	4.38		4.39
PULL #5	4.37	4.42		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649143
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0891057
1 TO	2	.182923
1 TO	3	.0913893
1 TO	4	.143851
1 TO	5	.134737

-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0216
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0271205

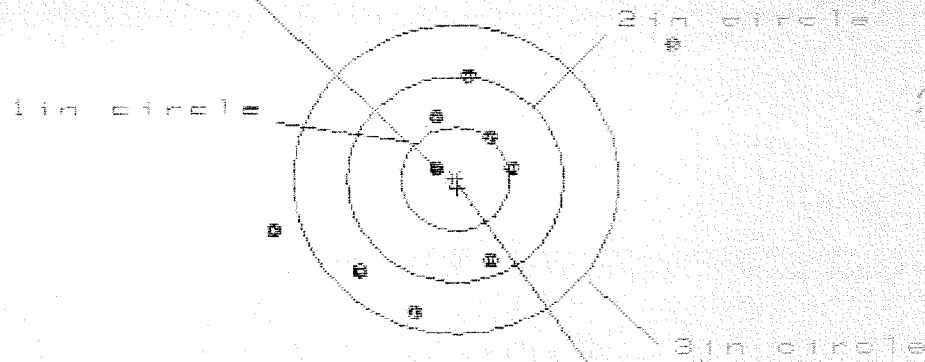
THE AMR FOR THIS RIFLE IS: .8644

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649143

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 3

HS= 3.719

VS= 2.643

GS= 4.137

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.051	.752	.573
MINIMUM X	-1.667	-1.440	-.830
MAXIMUM Y	1.306	1.140	1.095
MINIMUM Y	-1.337	-1.191	-1.236
CENTROID X	-.014	-.242	-.063
CENTROID Y	.038	-.057	-.012
POA TO CENTROID in.	.090	.249	.064
MIN RADIUS	.217	.303	.273
MEAN RADIUS	1.057	.924	.817
MAX RADIUS	2.432	1.484	1.288
HORIZONTAL SPREAD	3.719	2.192	1.402
VERTICAL SPREAD	2.643	2.331	2.331
EXTREME SPREAD	4.137	2.383	2.383
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =			8

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649143

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.951

VS= 2.856

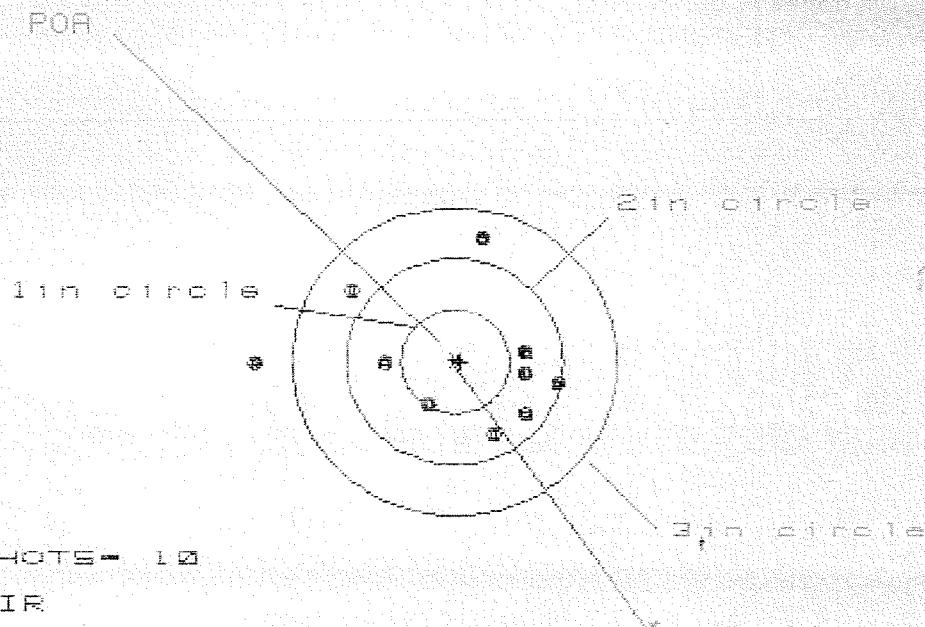
GS= 2.898

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.681	.718	.702
MINIMUM X	-1.270	-1.233	-1.249
MAXIMUM Y	1.518	1.053	.907
MINIMUM Y	-1.338	-1.169	-.600
CENTROID X	-.084	-.121	-.105
CENTROID Y	-.081	-.250	-.104
POA TO CENTROID in.	.117	.278	.148
MIN RADIUS	.145	.143	.116
MEAN RADIUS	.795	.697	.630
MAX RADIUS	1.554	1.293	1.272
HORIZONTAL SPREAD	1.951	1.951	1.951
VERTICAL SPREAD	2.856	2.222	1.507
EXTREME SPREAD	2.898	2.225	2.109
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649143

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.778

VS= 1.907

GS= 2.784

CENTROID #0

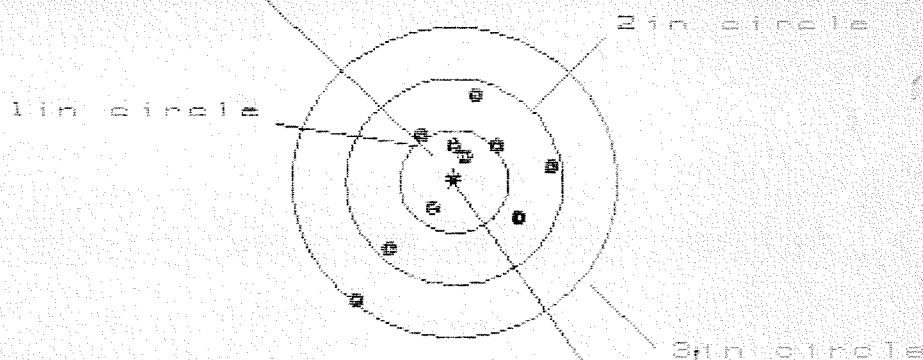
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.755	.766
MINIMUM X	-1.828	-1.162	-1.158
MAXIMUM Y	1.162	1.158	.827
MINIMUM Y	-.745	-.749	-.685
CENTROID X	-.050	.153	.142
CENTROID Y	.084	.088	-.136
POA TO CENTROID in.	.050	.153	.196
MIN RADIUS	.455	.442	.584
MEAN RADIUS	.928	.791	.721
MAX RADIUS	1.821	1.347	1.417
HORIZONTAL SPREAD	2.778	1.917	1.917
VERTICAL SPREAD	1.907	1.907	1.432
EXTREME SPREAD	2.784	2.119	2.119
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649143

CENTERFIRE PATTERNS # 4

POR



OF SHOTS = 10

IN CIR

1in = 3

2in = 3

3in = 10

HS = 1.794

VS = 2.030

GS = 2.332

CENTROID *

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.740	.752
MINIMUM X	-.949	-.681	-.669
MAXIMUM Y	.885	.757	.372
MINIMUM Y	-1.145	-.816	-.721
CENTROID X	.009	.114	.102
CENTROID Y	-.054	.074	-.021
POR TO CENTROID in.	.054	.136	.105
MIN RADIUS	.234	.092	.185
MEAN RADIUS	.681	.554	.542
MAX RADIUS	1.487	1.063	.984
HORIZONTAL SPREAD	1.794	1.421	1.421
VERTICAL SPREAD	2.030	1.573	1.093
EXTREME SPREAD	2.332	1.754	1.677
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

28 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/CBB49143

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.104

VS= 2.871

GS= 3.204

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.806	.661	.659
MINIMUM X	-1.298	-.714	-.716
MAXIMUM Y	1.459	.965	.808
MINIMUM Y	-1.412	-1.250	-.688
CENTROID X	.031	.176	.178
CENTROID Y	-.039	-.201	-.044
POA TO CENTROID in.	.050	.267	.184
MIN RADIUS	.163	.137	.025
MEAN RADIUS	.861	.701	.612
MAX RADIUS	1.953	1.251	1.080
HORIZONTAL SPREAD	2.104	1.375	1.375
VERTICAL SPREAD	2.871	2.215	1.496
EXTREME SPREAD	3.204	2.321	2.032
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		