

C6649223

MODEL 780™ M24

Model **SMS**™

Action

Barrel Length

Capacity

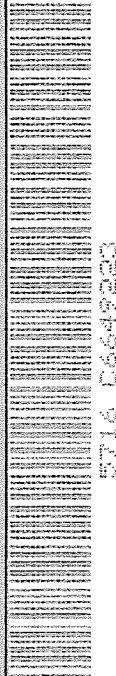
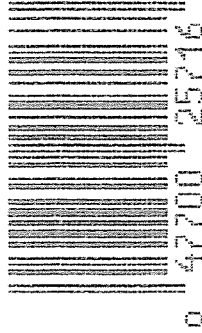
Order No. **5715**

*Includes 1 in chamber.



Remington  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6649223
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649223

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		RW
600	Proof	6 27 91		RW
607	Check Headspace	6 27 91		RW
610	Dis-assemble Gun	6 27 91		RW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	SS
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL 1 7 1991		WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-29-91	M

op. #	BARBER - M24 0066636 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5½	5¾			7-29-91	DH
	G) Safety Off Force	3	2½	3			7-29-91	DA
	H) Trigger Pull Test & Retainability						7-29-91	JK
	I) Firing Pin Indent	.022	.022	.021			7-29-91	DH
	J) Assemble Stock						8/1/91	RW
	K) Assemble Swivel Studs						8-6-91	A
	L) Attach Front and Rear Sight Assemblies						8/1/91	RW
	M) Iron Sight Alignment						8/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	RW
	O) Attach Scope to Rifle						8/1/91	RW
	P) Detach & Attach Scope 20 Times						8/1/91	RW
640	Gallery Target & Test						8/1/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/1/91	KT
655	Final Inspection							
	A) Headspace						8-6-91	A
	B) Trigger Pull	2.60	2.61	2.69	2.57	2.62	8-6-91	JK
	C) Function						8-6-91	A
660	Pack						7-7-91	DH

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

SERIAL NO. C 6649223DATE 7-29-91

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.50	2.60		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.57	2.61		
PULL #3	2.34	2.48	2.69		
PULL #4	2.38	2.38	2.57		
PULL #5	2.40	2.44	2.62		
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.48		
PULL #2	3.50	3.44		
PULL #3	3.57	3.55		
PULL #4	3.48	3.60		
PULL #5	3.30	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.32		4.30
PULL #2	4.30	4.31		4.28
PULL #3	4.32	4.30		4.35
PULL #4	4.29	4.35		4.32
PULL #5	4.30	4.38		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649223
1 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.245638
1 TO	2	.227438
1 TO	3	.28985
1 TO	4	.273788
1 TO	5	.518955

51 <----POA

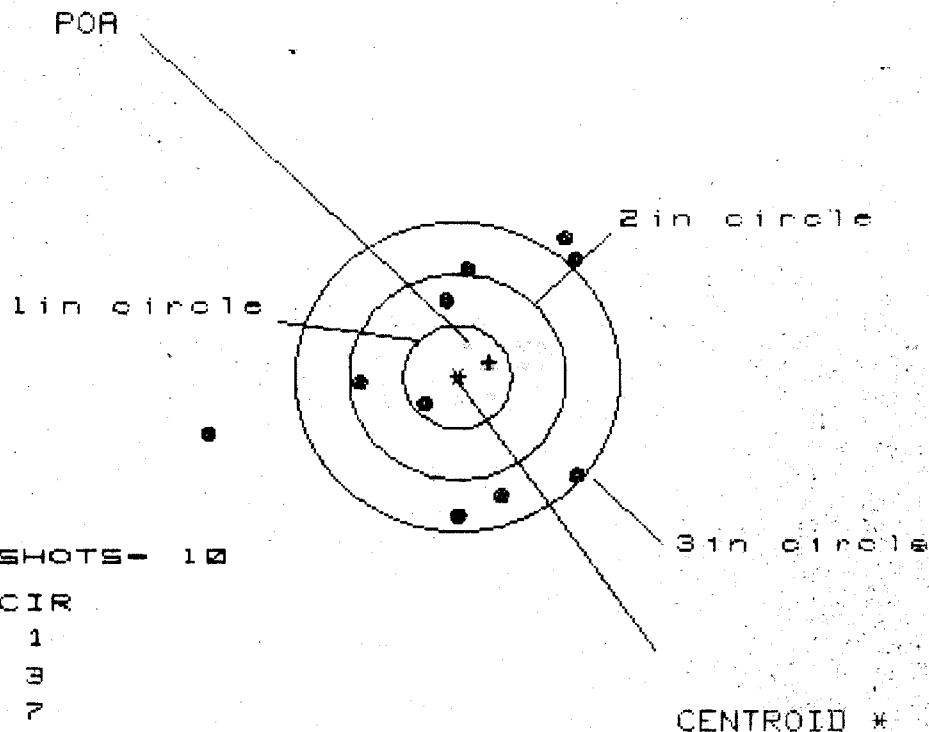
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.057
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0635059

THE AMR FOR THIS RIFLE IS: .8962

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649223

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.361

VS= 2.663

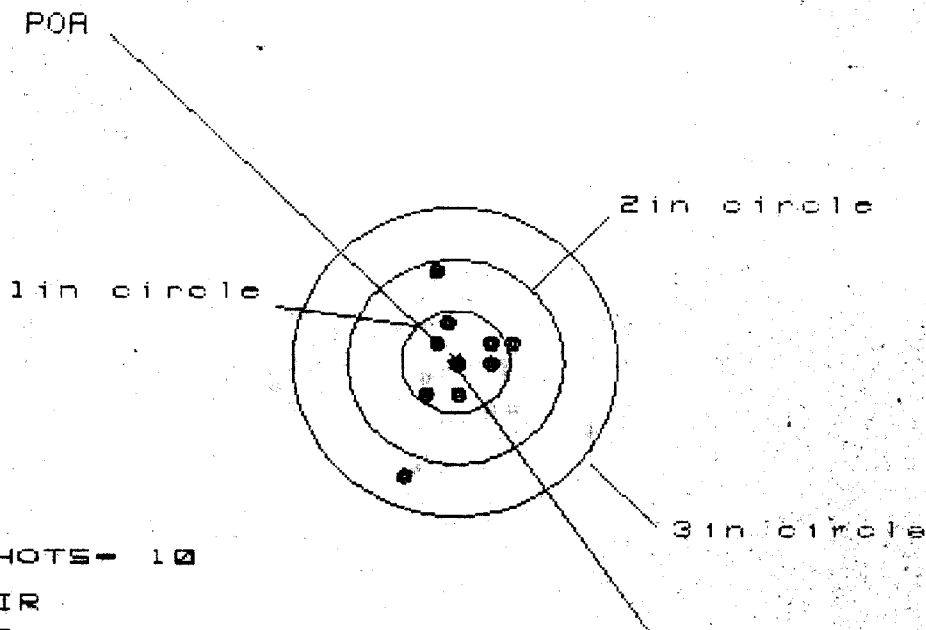
GS= 3.728

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.096	.844	.933
MINIMUM X	-2.265	-1.168	-1.079
MAXIMUM Y	1.311	1.252	1.203
MINIMUM Y	-1.352	-1.411	-1.255
CENTROID X	-.294	-.042	-.131
CENTROID Y	-.148	-.089	-.245
POA TO CENTROID in.	.329	.098	.278
MIN RADIUS	.427	.674	.533
MEAN RADIUS	1.265	1.149	1.094
MAX RADIUS	2.326	1.438	1.516
HORIZONTAL SPREAD	3.361	2.012	2.012
VERTICAL SPREAD	2.663	2.663	2.458
EXTREME SPREAD	3.728	2.817	2.671
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 7

2in = 9

3in = 10

HS= .979

VS= 2.028

GS= 2.039

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.543	.494	.461
MINIMUM X	-.436	-.300	-.334
MAXIMUM Y	.894	.768	.383
MINIMUM Y	-1.134	-.463	-.367
CENTROID X	-.025	.024	.058
CENTROID Y	.013	.139	.043
POA TO CENTROID in.	.028	.141	.072
MIN RADIUS	.042	.177	.121
MEAN RADIUS	.485	.402	.337
MAX RADIUS	1.215	.815	.501
HORIZONTAL SPREAD	.979	.794	.794
VERTICAL SPREAD	2.028	1.231	.750
EXTREME SPREAD	2.039	1.231	.973
NUMBER IN ONE INCH CIRCLE =	7		
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.892

VS= 1.900

GS= 2.816

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.243	1.060	.503
MINIMUM X	:	-1.649	-.499	-.367
MAXIMUM Y	:	.975	.956	.886
MINIMUM Y	:	-.925	-.944	-1.014
CENTROID X	:	-.059	.124	-.008
CENTROID Y	:	-.036	-.017	.053
POA TO CENTROID in.	:	.069	.126	.054
MIN RADIUS	:	.250	.236	.335
MEAN RADIUS	:	.830	.715	.657
MAX RADIUS	:	1.658	1.200	1.079
HORIZONTAL SPREAD	:	2.892	1.559	.870
VERTICAL SPREAD	:	1.900	1.900	1.900
EXTREME SPREAD	:	2.916	2.066	1.907
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.250

VS= 2.868

GS= 3.356

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.624	1.443	.496
MINIMUM X	-1.626	-1.003	-.822
MAXIMUM Y	1.634	1.497	1.430
MINIMUM Y	-1.234	-1.064	-1.131
CENTROID X	.015	.196	.015
CENTROID Y	-.011	.126	.193
POA TO CENTROID in.	.018	.233	.194
MIN RADIUS	.030	.198	.181
MEAN RADIUS	1.032	.928	.835
MAX RADIUS	2.041	1.539	1.430
HORIZONTAL SPREAD	3.250	2.446	1.318
VERTICAL SPREAD	2.868	2.561	2.561
EXTREME SPREAD	3.356	2.603	2.563
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.613

VS= 1.539

GS= 3.655

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.649	.705	.621
MINIMUM X	:	-.964	-.669	-.597
MAXIMUM Y	:	.824	.806	.715
MINIMUM Y	:	-.715	-.733	-.670
CENTROID X	:	.223	-.072	.012
CENTROID Y	:	-.103	-.085	.006
POA TO CENTROID in.	:	.245	.111	.014
MIN RADIUS	:	.183	.289	.310
MEAN RADIUS	:	.869	.643	.599
MAX RADIUS	:	2.654	.993	.931
HORIZONTAL SPREAD	:	3.613	1.374	1.218
VERTICAL SPREAD	:	1.539	1.539	1.385
EXTREME SPREAD	:	3.655	1.847	1.492
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		