

C6649227

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

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

SERIAL NO.
 C6649227

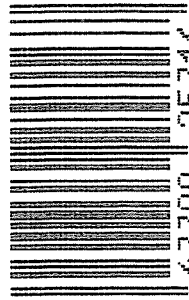
ORDER NO.
 5716

20



5716 C6649227

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649227

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	SS
617	Drill and Tap Sight Holes		JUL 1 1991	KB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		2-27-91	AA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	SL

op. #	BARBER M24 0066688	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/3/91	SH
	G) Safety Off Force	3	3	3			9/3/91	SH
	H) Trigger Pull Test & Retainability						9/3/91	SH
	I) Firing Pin Indent	.0205	.0205	.0205			9/3/91	SH
	J) Assemble Stock						9/3/91	RW
	K) Assemble Swivel Studs						9-4-91	DH
	L) Attach Front and Rear Sight Assemblies						9/3/91	RW
	M) Iron Sight Alignment						9/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	RW
	O) Attach Scope to Rifle						9/3/91	RW
	P) Detach & Attach Scope 20 Times						9/3/91	RW
640	Gallery Target & Test						9-3-91	AC
	A) Time						9-3-91	AC
	B) Malfunctions						9-3-91	AC
	C) Pierced Primers						9-3-91	AC
	D) Optical Clarity of Scope						9-3-91	AC
645	Inspect for Live Ammo						9-3-91	AC
655	Final Inspection							
	A) Headspace						9-4-91	DH
	B) Trigger Pull	2.19	2.29	2.31	2.34	2.33	9-3-91	DH
	C) Function						9-4-91	DH
660	Pack						9-17-91	DH

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

SERIAL NO. C6649227DATE 9-3-91TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.32	2.25	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.33	2.38	2.29	
PULL #3	2.31	2.24	2.30	2.31	
PULL #4	2.31	2.24	2.25	2.34	
PULL #5	2.27	2.29	2.29	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.20		
PULL #2	3.20	3.29		
PULL #3	3.27	3.23		
PULL #4	3.29	3.47		
PULL #5	3.36	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.58		4.36
PULL #2	4.35	4.27		4.58
PULL #3	4.44	4.28		4.30
PULL #4	4.27	4.40		4.44
PULL #5	4.37	4.58		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649227
3 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.132575
1 TO	2	.0631585
1 TO	3	.345352
1 TO	4	.386871
1 TO	5	.249826

4 <----POA

ALB

THE X-COORDINATE FOR THIS RIFLE IS: .0414
THE Y-COORDINATE FOR THIS RIFLE IS: .0156
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .0442416
THE THIS RIFLE IS: .844

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649227

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.397

VS= 1.814

GS= 2.290

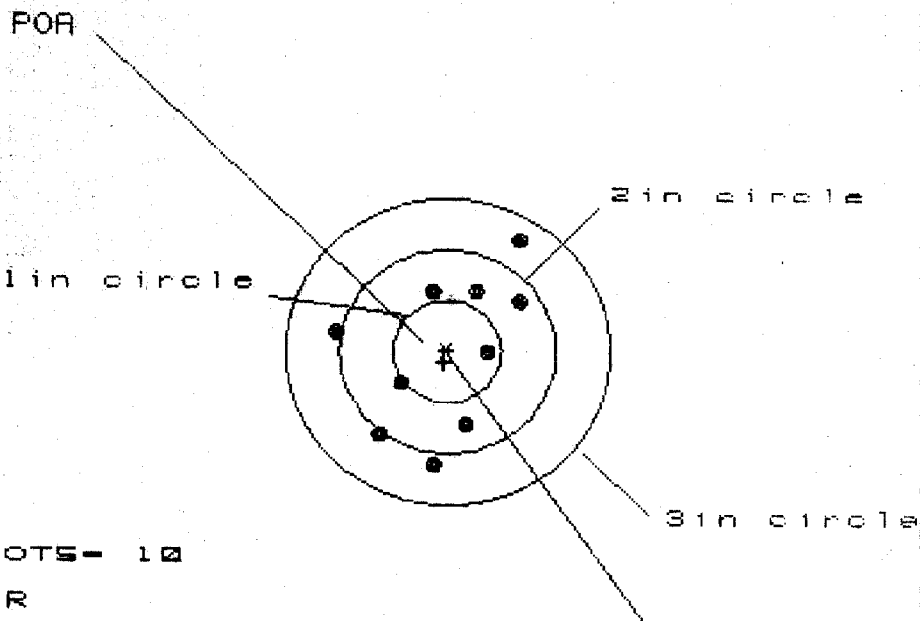
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.610	.523	.536
MINIMUM X	-.787	-.721	-.656
MAXIMUM Y	.848	.659	.550
MINIMUM Y	-.966	-.872	-.685
CENTROID X	-.026	.061	-.004
CENTROID Y	.130	.036	.145
POA TO CENTROID in.	.133	.071	.145
MIN RADIUS	.148	.066	.158
MEAN RADIUS	.662	.591	.540
MAX RADIUS	1.157	1.017	.840
HORIZONTAL SPREAD	1.397	1.244	1.192
VERTICAL SPREAD	1.814	1.531	1.235
EXTREME SPREAD	2.290	1.840	1.542
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

3 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 7

3 in - 10

HS - 1.716

VS - 2.205

GS - 2.346

CENTROID *

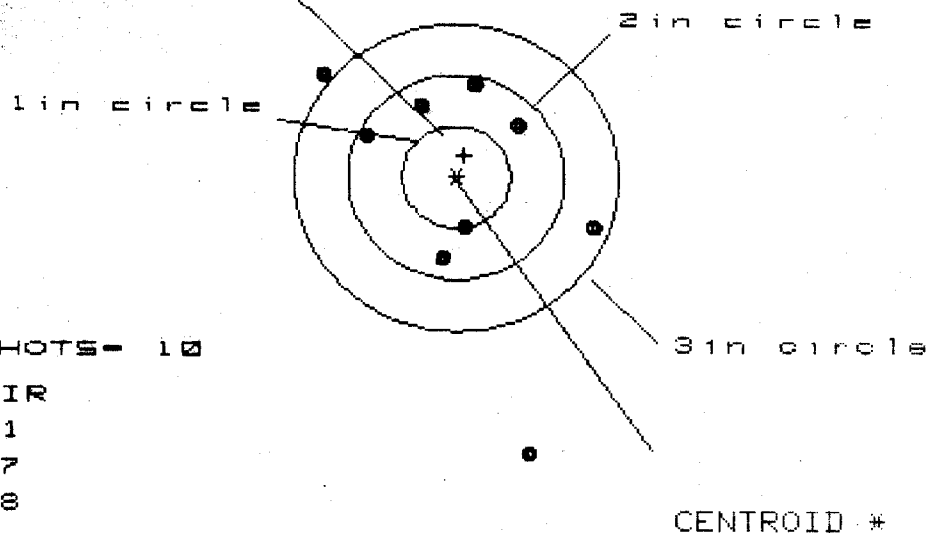
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.692	.704	.700
MINIMUM X	:	-1.024	-.947	-.951
MAXIMUM Y	:	1.071	.757	.630
MINIMUM Y	:	-1.134	-1.015	-.815
CENTROID X	:	.032	-.045	-.041
CENTROID Y	:	.105	-.014	.113
POA TO CENTROID in.	:	.110	.047	.121
MIN RADIUS	:	.416	.369	.446
MEAN RADIUS	:	.818	.762	.723
MAX RADIUS	:	1.275	1.016	.977
HORIZONTAL SPREAD	:	1.716	1.651	1.651
VERTICAL SPREAD	:	2.205	1.772	1.445
EXTREME SPREAD	:	2.346	1.796	1.787
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.502

VS = 3.665

GS = 4.112

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.308	1.383	1.243
MINIMUM X	-1.194	-1.119	-.869
MAXIMUM Y	1.026	.733	.742
MINIMUM Y	-2.639	-1.130	-1.038
CENTROID X	-.074	-.149	-.009
CENTROID Y	-.212	.081	-.011
FOR TO CENTROID in.	.225	.169	.014
MIN RADIUS	.477	.470	.610
MEAN RADIUS	1.122	.877	.832
MAX RADIUS	2.723	1.565	1.399
HORIZONTAL SPREAD	2.502	2.502	2.112
VERTICAL SPREAD	3.665	1.863	1.780
EXTREME SPREAD	4.112	2.900	2.295
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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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 - 3

2 in - 8

3 in - 10

HS- 1.685

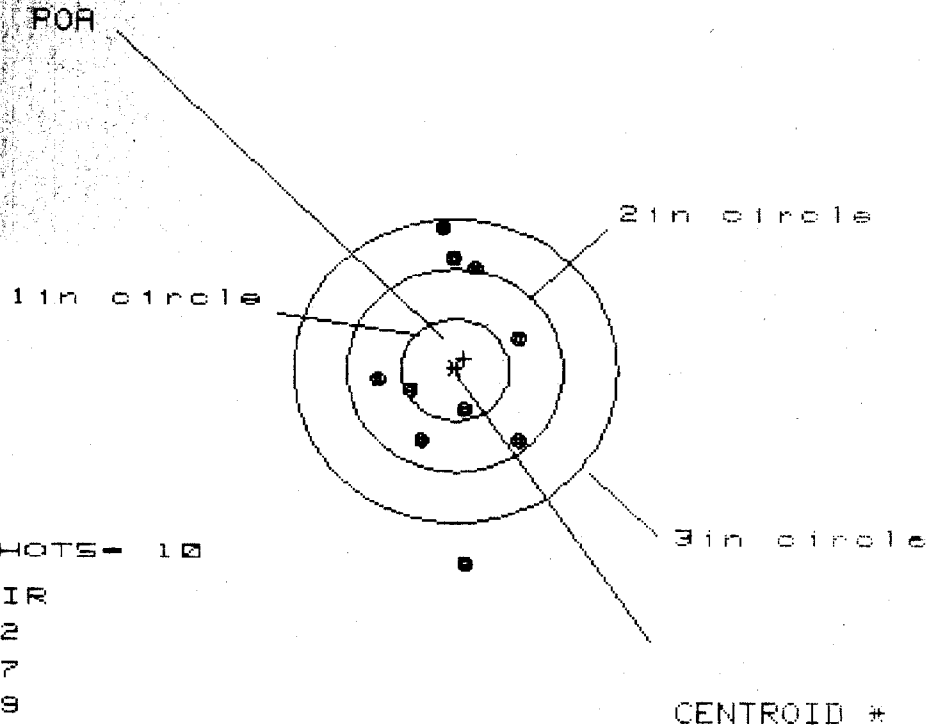
VS- 1.914

GS- 2.150

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.042	.645	.603
MINIMUM X	-.643	-.527	-.569
MAXIMUM Y	.827	.759	.614
MINIMUM Y	-1.087	-1.155	-.879
CENTROID X	.359	.243	.285
CENTROID Y	.168	.236	.381
POA TO CENTROID in.	.396	.339	.476
MIN RADIUS	.210	.313	.238
MEAN RADIUS	.683	.608	.503
MAX RADIUS	1.209	1.203	.883
HORIZONTAL SPREAD	1.685	1.172	1.172
VERTICAL SPREAD	1.914	1.914	1.493
EXTREME SPREAD	2.150	2.150	1.645
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.326

VS = 3.257

GS = 3.264

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.611	.617	.599
MINIMUM X	-.715	-.709	-.727
MAXIMUM Y	1.414	1.209	1.107
MINIMUM Y	-1.843	-.937	-.786
CENTROID X	-.084	-.090	-.072
CENTROID Y	-.113	.092	-.059
POA TO CENTROID in.	.140	.129	.093
MIN RADIUS	.380	.552	.428
MEAN RADIUS	.935	.838	.766
MAX RADIUS	1.844	1.218	1.107
HORIZONTAL SPREAD	1.326	1.326	1.326
VERTICAL SPREAD	3.257	2.146	1.893
EXTREME SPREAD	3.264	2.224	1.928
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		