

C6649260

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700[™] M24

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

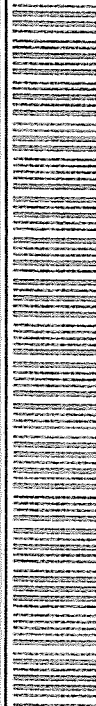
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

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

SERIAL NO. C6649260

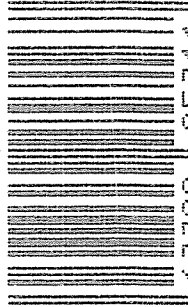
ORDER NO. 5716

20



5716 C6649260

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649260

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	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	JA
	Apply Coating (Bolt)			JA
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		9/4/91	JH

op.	BARBER - M24 0067049	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/91	SH
	G) Safety Off Force	3	3	3			9/4/91	SH
	H) Trigger Pull Test & Retainability						9/4/91	SH
	I) Firing Pin Indent	.021	.0215	.0215			9/4/91	SH
	J) Assemble Stock						9/4/91	RW
	K) Assemble Swivel Studs						9-9-91	AC
	L) Attach Front and Rear Sight Assemblies						9/4/91	RW
	M) Iron Sight Alignment						9/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	RW
	O) Attach Scope to Rifle						9/4/91	RW
	P) Detach & Attach Scope 20 Times						9/4/91	RW
640	Gallery Target & Test						9-4-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-4-91	AF
655	Final Inspection							
	A) Headspace						9-9-91	AC
	B) Trigger Pull	2.63	2.56	2.64	2.58	2.62	9-6-91	SH
	C) Function						9-9-91	AC
660	Pack						9-12-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO

C-6649260

DATE

9/4/91

TESTER

JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.52	2.45	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.56	2.48	2.56	
PULL #3	2.57	2.48	2.50	2.64	
PULL #4	2.57	2.46	2.44	2.58	
PULL #5	2.63	2.46	2.40	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.22		
PULL #2	3.32	3.23		
PULL #3	3.29	3.24		
PULL #4	3.26	3.25		
PULL #5	3.26	3.22		
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	4.40		4.41
PULL #2	4.28	4.41		4.35
PULL #3	4.35	4.39		4.33
PULL #4	4.37	4.32		4.36
PULL #5	4.38	4.34		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649260
4 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.04245
1 TO	2	.200232
1 TO	3	.329074
1 TO	4	.0606383
1 TO	5	.427874

s_f^2 <----POA

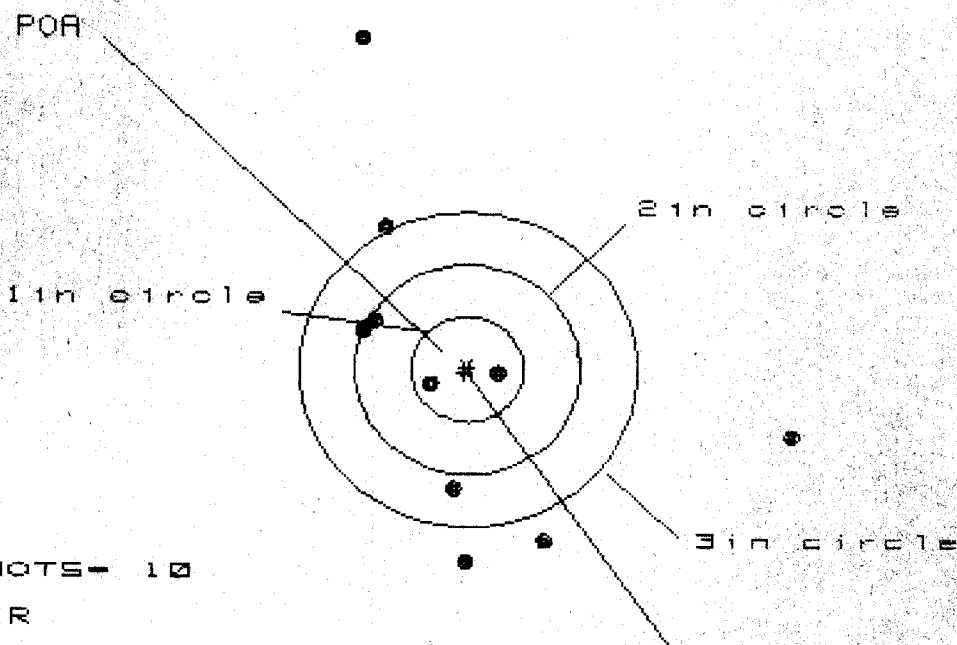
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0358
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.023
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0425516
THE POI FOR THIS RIFLE IS: 1.17

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649260

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in - 2

2in - 4

3in = 5

HS- 3.805

VS= 4.944

GS= 5.375

CENTROID *

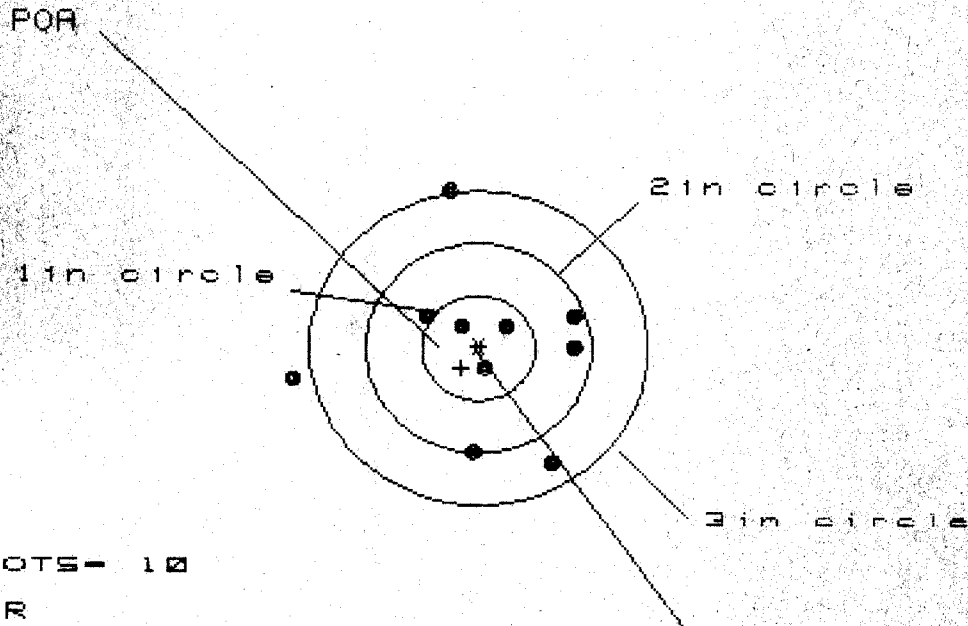
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.860	2.755	.942
MINIMUM X	:	-.945	-1.016	-.672
MAXIMUM Y	:	3.145	1.767	1.729
MINIMUM Y	:	-1.799	-1.449	-1.487
CENTROID X	:	.029	.134	-.210
CENTROID Y	:	.031	-.319	-.281
POA TO CENTROID in.	:	.043	.346	.351
MIN RADIUS	:	.288	.403	.153
MEAN RADIUS	:	1.504	1.298	1.048
MAX RADIUS	:	3.284	2.771	1.785
HORIZONTAL SPREAD	:	3.805	3.771	1.614
VERTICAL SPREAD	:	4.944	3.216	3.216
EXTREME SPREAD	:	5.375	4.104	3.332
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

4 Sep 1991

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CENTERFIRE PATTERNS

2



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 2.553

VS = 2.618

GS = 2.770

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.879	.693	.633
MINIMUM X	:	-1.674	-.640	-.700
MAXIMUM Y	:	1.488	1.457	.493
MINIMUM Y	:	-1.130	-1.161	-.979
CENTROID X	:	.152	.338	.398
CENTROID Y	:	.189	.220	.038
POA TO CENTROID in.	:	.243	.403	.400
MIN RADIUS	:	.232	.227	.258
MEAN RADIUS	:	.873	.768	.680
MAX RADIUS	:	1.697	1.534	1.045
HORIZONTAL SPREAD	:	2.553	1.333	1.333
VERTICAL SPREAD	:	2.618	2.618	1.472
EXTREME SPREAD	:	2.770	2.770	1.766
NUMBER IN ONE INCH CIRCLE =	:	3	6	8
NUMBER IN TWO INCH CIRCLE =	:	6	6	8
NUMBER IN THREE INCH CIRCLE =	:	8	6	8

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649260

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.976

VS= 3.072

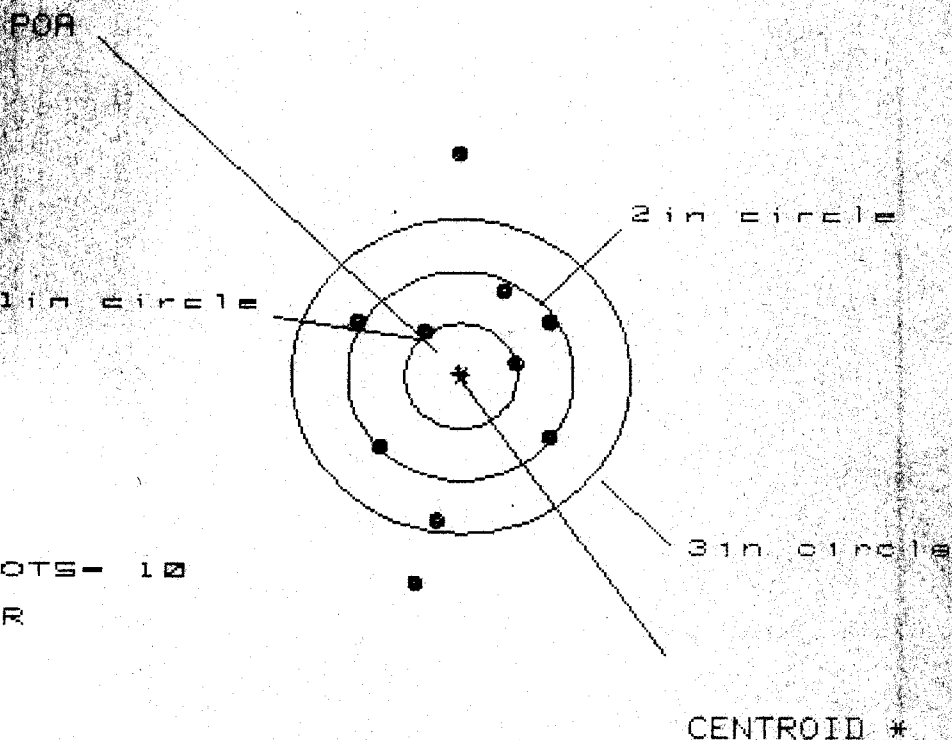
GS= 3.082

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.991	.957	.617
MINIMUM X	:	-.985	-1.019	-.899
MAXIMUM Y	:	1.850	1.232	1.102
MINIMUM Y	:	-1.222	-1.016	-.862
CENTROID X	:	.022	.056	-.064
CENTROID Y	:	-.298	-.504	-.658
POA TO CENTROID in.	:	.299	.507	.661
MIN RADIUS	:	.540	.440	.406
MEAN RADIUS	:	1.049	.912	.812
MAX RADIUS	:	1.875	1.560	1.422
HORIZONTAL SPREAD	:	1.976	1.976	1.516
VERTICAL SPREAD	:	3.072	2.248	1.964
EXTREME SPREAD	:	3.082	2.729	2.102
NUMBER IN ONE INCH CIRCLE	=	0	5	9
NUMBER IN TWO INCH CIRCLE	=			
NUMBER IN THREE INCH CIRCLE	=			

4 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 8

HS- 1.732

VS= 4.068

GS= 4.088

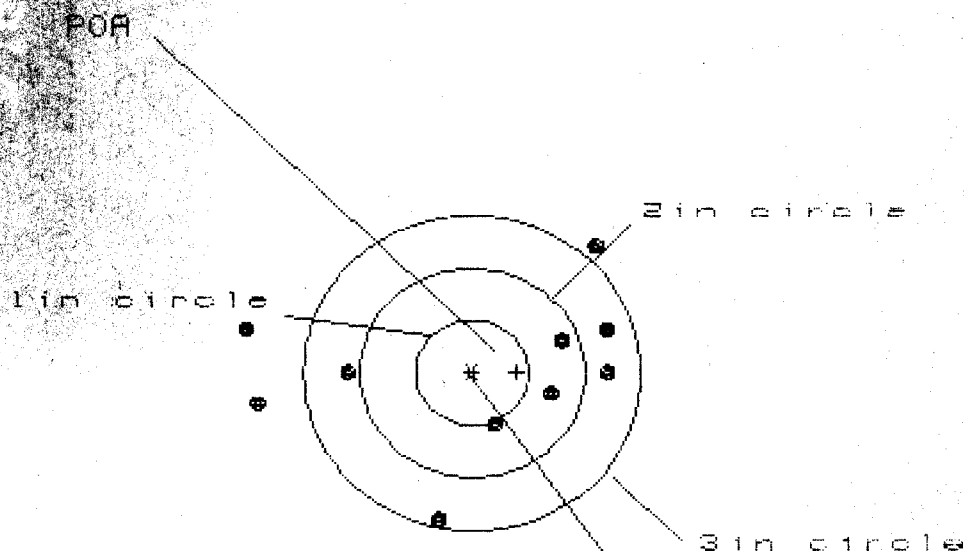
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.818	.820	.771
MINIMUM X	-.914	-.912	-.961
MAXIMUM Y	2.120	1.053	.839
MINIMUM Y	-1.948	-1.713	-1.363
CENTROID X	.015	.013	.062
CENTROID Y	-.028	-.263	-.049
POA TO CENTROID in.	.032	.264	.079
MIN RADIUS	.531	.658	.514
MEAN RADIUS	1.143	1.045	.915
MAX RADIUS	2.120	1.757	1.386
HORIZONTAL SPREAD	1.732	1.732	1.732
VERTICAL SPREAD	4.068	2.766	2.202
EXTREME SPREAD	4.088	2.876	2.283
NUMBER IN ONE INCH CIRCLE =	0	5	8
NUMBER IN TWO INCH CIRCLE =	5	8	
NUMBER IN THREE INCH CIRCLE =	8		

1 Sep 1991

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CENTERFIRE PATTERNS

5



+ OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

CS = 3.246

VS = 2.670

GS = 3.354

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.217	.991	.729
MINIMUM X	:	-2.029	-2.100	-1.560
MAXIMUM Y	:	1.237	1.279	1.250
MINIMUM Y	:	-1.433	-1.391	-1.419
CENTROID X	:	-.397	-.171	.091
CENTROID Y	:	-.009	-.051	-.022
OFF TO CENTROID IN.	:	.397	.179	.094
1 in RADIUS	:	.558	.483	.289
2 in RADIUS	:	1.279	1.131	.931
3 in RADIUS	:	2.064	2.112	1.605
HORIZONTAL OFFSET	:	3.246	3.091	2.289
VERTICAL OFFSET	:	2.670	2.670	2.670
SPHERE OFFSET	:	3.354	3.354	3.007
NUMBER OF SHOTS IN 1 INCH CIRCLE	=	0		
NUMBER OF SHOTS IN 2 INCH CIRCLE	=	3		
NUMBER OF SHOTS IN 3 INCH CIRCLE	=	7		