

C6649282

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

Remington
MODEL 700™ M24

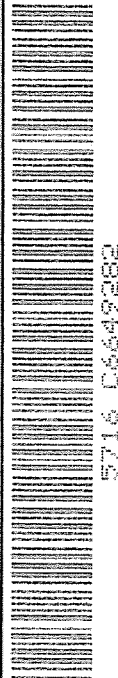
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6649282

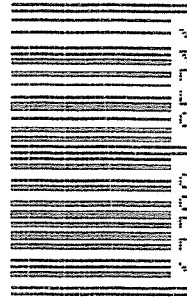
ORDER NO.
5716

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



5716 C6649282

LPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649282

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	dw
600	Proof	6 27	9 1	dw
607	Check Headspace	6 27	9 1	dw
610	Dis-assemble Gun	6 27	9 1	dw
612	Magnaflux Barrel Action	1 JUL	2 1991	KR
	Magnaflux Bolt	1 JUL	2 1991	KR
615	Rollmark Caliber	1 JUL	2 1991	LS
617	Drill and Tap Sight Holes	1 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	dw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	dw
	C) Inspect Ejector Hole for Chamfer		7/23/91	dw
	D) Oil Firing Pin Ass'y		7/23/91	dw
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	94

BARBER - M24 0067292

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			Aug. 5-91	AC
	G) Safety Off Force	4	4	4			Aug. 5-91	AC
	H) Trigger Pull Test & Retainability						8-5-91	JH
	I) Firing Pin Indent	.020	.020	.020			Aug 5-91	AC
	J) Assemble Stock						8/6/91	RW
	K) Assemble Swivel Studs						8-7-91	JH
	L) Attach Front and Rear Sight Assemblies						8/6/91	RW
	M) Iron Sight Alignment						8/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/91	RW
	O) Attach Scope to Rifle						8/6/91	RW
	P) Detach & Attach Scope 20 Times						8/6/91	RW
640	Gallery Target & Test						8/6/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/6/91	KT
655	Final Inspection							
	A) Headspace						8-7-91	JH
	B) Trigger Pull	2.19	2.20	2.20	2.25	2.22	8-7-91	JH
	C) Function						8-7-91	JH
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. C6649282

DATE 8-5-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.25	2.30	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.36	2.34	2.20	
PULL #3	2.17	2.28	2.44	2.20	
PULL #4	2.25	2.27	2.20	2.25	
PULL #5	2.37	2.28	2.22	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.41		
PULL #2	3.35	3.41		
PULL #3	3.52	3.35		
PULL #4	3.25	3.42		
PULL #5	3.45	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.38		4.34
PULL #2	4.44	4.40		4.47
PULL #3	4.36	4.39		4.45
PULL #4	4.36	4.43		4.58
PULL #5	4.40	4.45		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649282
6 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.103586
1 TO	2	.2136
1 TO	3	.319531
1 TO	4	.384187
1 TO	5	.0905207

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0722
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0722044
THE AMR FOR THIS RIFLE IS: 1.004

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649282

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.883

VS= 2.122

GS= 2.908

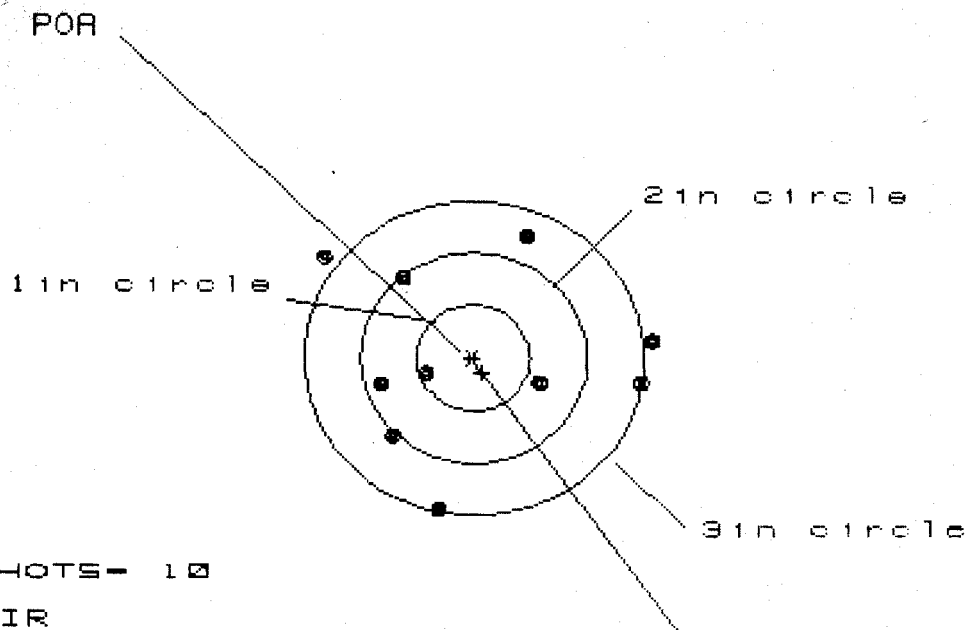
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.485	1.152	.998
MINIMUM X	-1.398	-1.233	-1.148
MAXIMUM Y	1.053	1.097	1.104
MINIMUM Y	-1.069	-1.025	-1.018
CENTROID X	.101	-.064	.090
CENTROID Y	.023	-.021	-.028
POA TO CENTROID in.	.103	.068	.094
MIN RADIUS	.341	.390	.390
MEAN RADIUS	1.035	.979	.929
MAX RADIUS	1.537	1.237	1.283
HORIZONTAL SPREAD	2.883	2.385	2.146
VERTICAL SPREAD	2.122	2.122	2.122
EXTREME SPREAD	2.908	2.439	2.233
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

6 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.862

VS= 2.686

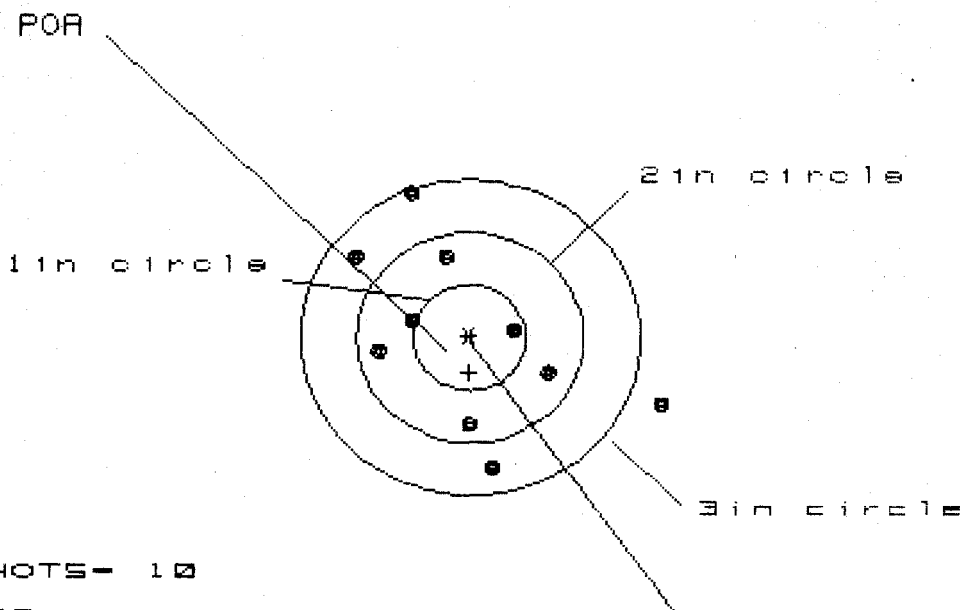
GS= 2.986

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.590	1.448	1.477
MINIMUM X	:	-1.272	-.971	-.790
MAXIMUM Y	:	1.204	1.312	1.340
MINIMUM Y	:	-1.482	-1.374	-1.346
CENTROID X	:	-.079	.063	-.118
CENTROID Y	:	.138	.030	.002
POA TO CENTROID in.	:	.159	.069	.119
MIN RADIUS	:	.426	.487	.349
MEAN RADIUS	:	1.131	1.077	.996
MAX RADIUS	:	1.599	1.466	1.479
HORIZONTAL SPREAD	:	2.862	2.419	2.266
VERTICAL SPREAD	:	2.686	2.686	2.686
EXTREME SPREAD	:	2.986	2.791	2.791
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

6 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.654

VS= 2.541

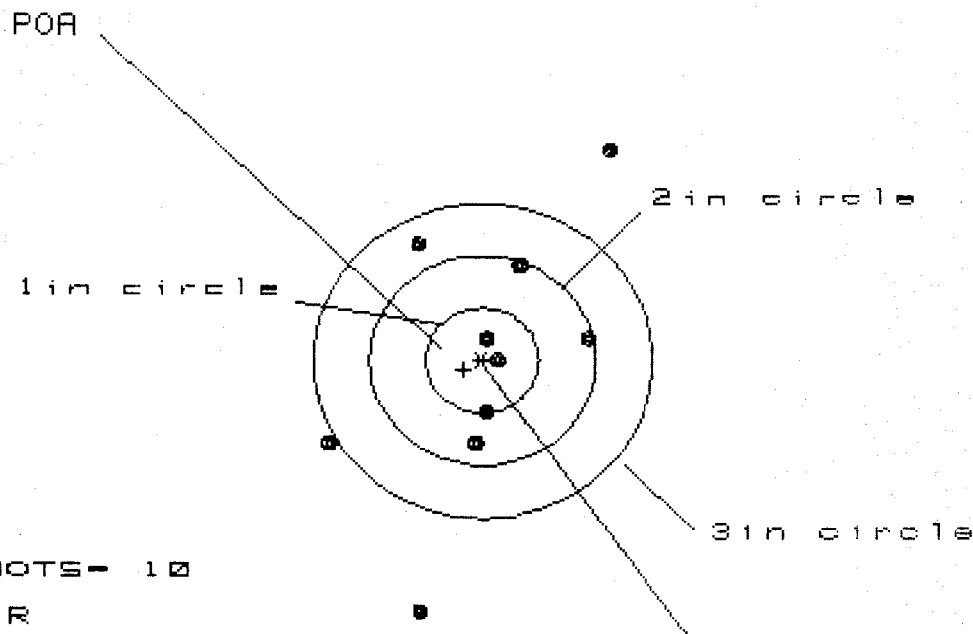
GS= 3.013

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.690	.851	.816
MINIMUM X	:	-.964	-.776	-.811
MAXIMUM Y	:	1.322	1.251	.874
MINIMUM Y	:	-1.219	-1.290	-1.134
CENTROID X	:	.009	-.179	-.144
CENTROID Y	:	.329	.400	.244
POA TO CENTROID in.	:	.329	.438	.283
MIN RADIUS	:	.347	.317	.438
MEAN RADIUS	:	.972	.859	.804
MAX RADIUS	:	1.807	1.354	1.194
HORIZONTAL SPREAD	:	2.654	1.627	1.627
VERTICAL SPREAD	:	2.541	2.541	2.008
EXTREME SPREAD	:	3.013	2.634	2.332
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 2.448

VS = 4.455

GS = 4.756

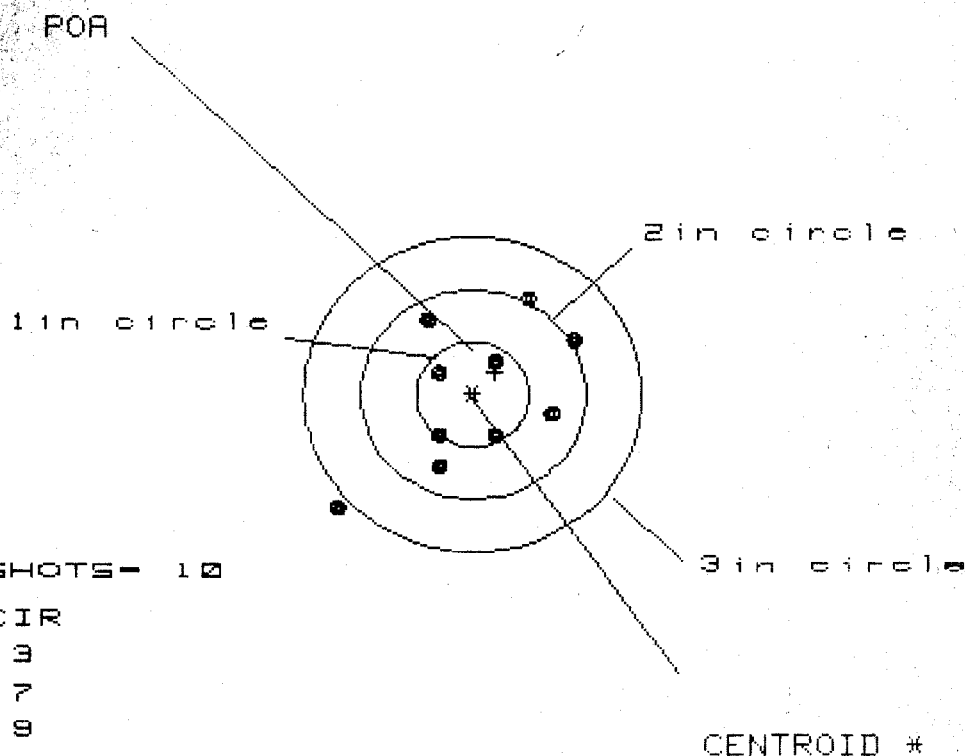
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.124	1.064	1.046
MINIMUM X	:	-1.324	-1.384	-1.251
MAXIMUM Y	:	2.022	1.751	1.054
MINIMUM Y	:	-2.433	-1.098	-.879
CENTROID X	:	.164	.224	.091
CENTROID Y	:	.088	.359	.140
POA TO CENTROID in.	:	.187	.423	.167
MIN RADIUS	:	.097	.037	.178
MEAN RADIUS	:	1.119	.954	.808
MAX RADIUS	:	2.493	2.049	1.529
HORIZONTAL SPREAD	:	2.448	2.448	2.298
VERTICAL SPREAD	:	4.455	2.849	1.933
EXTREME SPREAD	:	4.756	3.756	2.520
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

8 Aug 1981

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 7

3 in - 9

HS - 2.136

VS - 1.970

GS - 2.654

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.904	.768	.819
MINIMUM X	-1.232	-.510	-.459
MAXIMUM Y	.921	.805	.668
MINIMUM Y	-1.049	-.839	-.739
CENTROID X	-.199	-.062	-.113
CENTROID Y	-.217	-.101	-.201
POA TO CENTROID in.	.294	.118	.231
MIN RADIUS	.372	.209	.321
MEAN RADIUS	.761	.651	.612
MAX RADIUS	1.618	.956	.965
HORIZONTAL SPREAD	2.136	1.278	1.278
VERTICAL SPREAD	1.970	1.644	1.407
EXTREME SPREAD	2.654	1.858	1.750
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	