

C6649291

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

DUPONT

SERIAL NO.
C6649291

ORDER NO.
5716

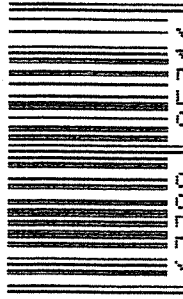
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



5716 C6649291

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649291

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
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	LB
618	Polish Barrel		1 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		8-8-91	RL

op. #	BARBER - M24 0067394		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5	5	5			8-8-91	JH
	G) Safety Off Force		3	3	3			8-8-91	JH
	H) Trigger Pull Test & Retainability							8-8-91	JH
	I) Firing Pin Indent		.0205	.0205	.0205			8-8-91	JH
	J) Assemble Stock							8/8/91	RW
	K) Assemble Swivel Studs							8-10-91	DH
	L) Attach Front and Rear Sight Assemblies							8/8/91	RW
	M) Iron Sight Alignment							8/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container							8/8/91	RW
	O) Attach Scope to Rifle							8/8/91	RW
	P) Detach & Attach Scope 20 Times							8/8/91	RW
640	Gallery Target & Test							8/8/91	KT
	A) Time							"	KT
	B) Malfunctions							"	KT
	C) Pierced Primers							"	KT
	D) Optical Clarity of Scope							"	KT
645	Inspect for Live Ammo							8/8/91	KT
655	Final Inspection								
	A) Headspace							8-10-91	DH
	B) Trigger Pull		2.69	2.59	2.60	2.62	2.65	8-9-91	JH
	C) Function							8-10-91	DH
660	Pack							9-19-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649291

DATE 8-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.46	2.49	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.46	2.50	2.59	
PULL #3	2.39	2.50	2.55	2.60	
PULL #4	2.66	2.51	2.48	2.62	
PULL #5	2.64	2.50	2.44	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.24		
PULL #2	3.25	3.37		
PULL #3	3.20	3.33		
PULL #4	3.58	3.31		
PULL #5	3.54	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	4.60	4.41		4.54
PULL #2	4.47	4.42		4.47
PULL #3	4.52	4.44		4.45
PULL #4	4.47	4.15		4.57
PULL #5	4.38	4.43		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6291
8 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0410488
1 TO	2	.151855
1 TO	3	.254621
1 TO	4	.28092
1 TO	5	.172308



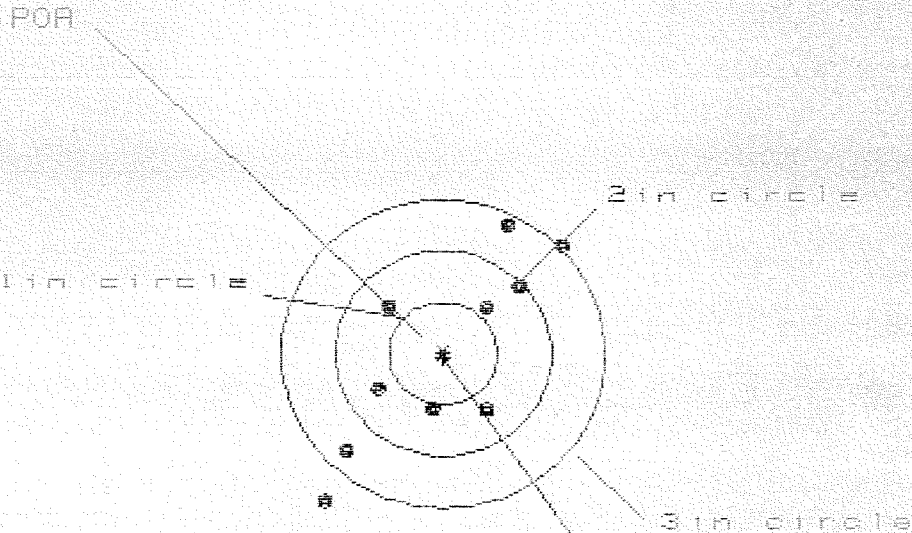
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0182
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118605
THE AMR FOR THIS RIFLE IS: 1.027

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649291

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

CENTROID *

HS= 2.161

VS= 2.704

GS= 3.243

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.085	.966	.676
MINIMUM X	-1.076	-.971	-.850
MAXIMUM Y	1.302	1.146	1.254
MINIMUM Y	-1.402	-1.103	-.995
CENTROID X	-.002	.117	-.004
CENTROID Y	.041	.197	.089
POA TO CENTROID in.	.041	.229	.089
MIN RADIUS	.585	.388	.548
MEAN RADIUS	1.024	.928	.874
MAX RADIUS	1.767	1.469	1.404
HORIZONTAL SPREAD	2.161	1.937	1.526
VERTICAL SPREAD	2.704	2.249	2.249
EXTREME SPREAD	3.243	2.758	2.693
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

8 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/06649291

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS = 1.8882

VS = 1.646

GS = 1.988

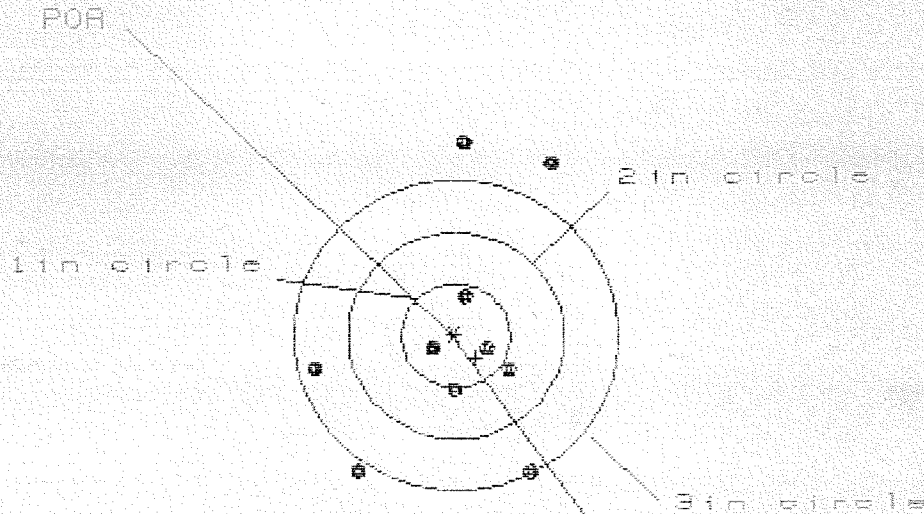
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	.865	.755
MINIMUM X	:	-.979	-.879	-.569
MAXIMUM Y	:	.851	.801	.815
MINIMUM Y	:	-.795	-.845	-.831
CENTROID X	:	.114	.014	.124
CENTROID Y	:	-.057	-.007	-.021
POR TO CENTROID in.	:	.128	.015	.125
MIN RADIUS	:	.300	.370	.273
MEAN RADIUS	:	.746	.712	.681
MAX RADIUS	:	1.011	1.002	.917
HORIZONTAL SPREAD	:	1.882	1.744	1.324
VERTICAL SPREAD	:	1.646	1.646	1.646
EXTREME SPREAD	:	1.988	1.788	1.706
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.139

VS= 3.270

GS= 3.527

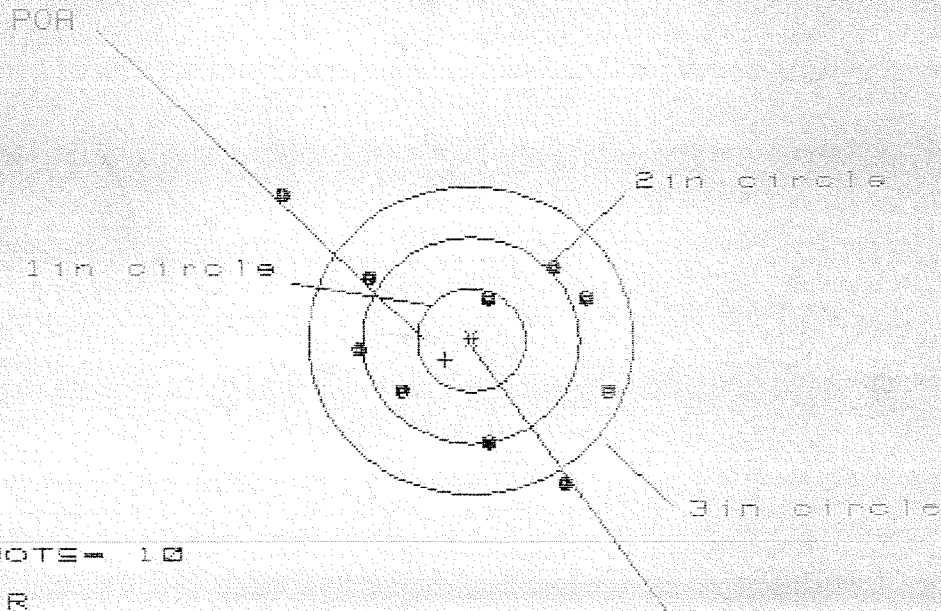
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.855	.863	.754
MINIMUM X	-1.284	-1.276	-1.168
MAXIMUM Y	1.914	1.924	.832
MINIMUM Y	-1.356	-1.143	-.903
CENTROID X	-.186	-.194	-.302
CENTROID Y	.217	.004	-.236
POA TO CENTROID in.	.286	.194	.384
MIN RADIUS	.227	.249	.111
MEAN RADIUS	1.027	.903	.758
MAX RADIUS	1.916	2.109	1.186
HORIZONTAL SPREAD	2.139	2.139	1.922
VERTICAL SPREAD	3.270	3.067	1.735
EXTREME SPREAD	3.527	3.527	2.190
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 3.021

VS= 2.776

GS= 3.823

CENTROID #

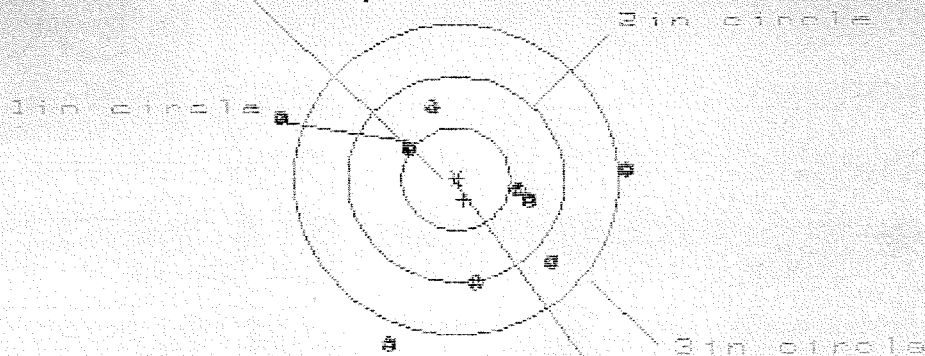
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.252	1.055	1.138
MINIMUM X	:	-1.769	-1.201	-1.118
MAXIMUM Y	:	1.397	.821	.668
MINIMUM Y	:	-1.379	-1.224	-.954
CENTROID X	:	.238	.435	.352
CENTROID Y	:	.187	.032	.185
POA TO CENTROID in.	:	.303	.436	.397
MIN RADIUS	:	.411	.525	.378
MEAN RADIUS	:	1.173	1.039	.976
MAX RADIUS	:	2.254	1.392	1.248
HORIZONTAL SPREAD	:	3.021	2.256	2.256
VERTICAL SPREAD	:	2.776	2.045	1.622
EXTREME SPREAD	:	3.823	2.660	2.429
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 6

HS = 3.154

VS = 3.395

GS = 3.401

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.539
MINIMUM X	-1.615
MAXIMUM Y	1.841
MINIMUM Y	-1.554
CENTROID X	-1.073
CENTROID Y	.198
POB TO CENTROID in.	.211
MIN RADIUS	.543
MEAN RADIUS	1.165
MAX RADIUS	2.029
HORIZONTAL SPREAD	3.154
VERTICAL SPREAD	3.395
EXTREME SPREAD	3.401
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	6