

C6611381

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

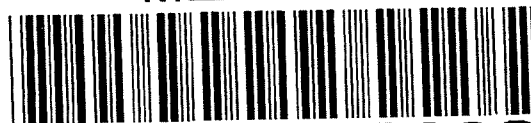
Order No. **5716**

*Includes 1 in chamber.

Remington

Serial Number: C66 1 1 38 1

Model: M24 SWS



RE00093003

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

Remington®
REG. U.S. PAT. & TM. OFF.

DUPONT

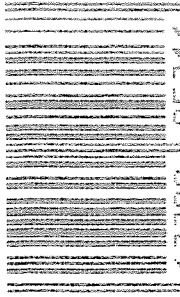
MODEL 700™ M24

SERIAL NO.
C6611381

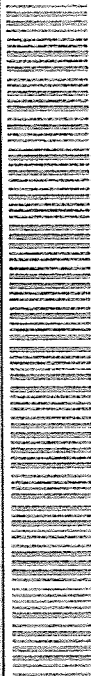
ORDER NO.
5716

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

UPC



0 47700 25716 2



5716 C6611381

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611381

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof			RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GL
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel RBB	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TJH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/14/91	GL

op. #	BARBER - M24 0075879 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/19/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/19/91	WB
	H) Trigger Pull Test & Retainability						2/19/91	JLL
	I) Firing Pin Indent	.0235	.023	.023			2/19/91	WB
	J) Assemble Stock						2/19/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/19/91	RW
	M) Iron Sight Alignment						2/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	RW
	O) Attach Scope to Rifle						2/19/91	RW
	P) Detach & Attach Scope 20 Times						2/19/91	RW
640	Gallery Target & Test						2-20-91	DH
	A) Time						2-20-91	DH
	B) Malfunctions						2-20-91	DH
	C) Pierced Primers						2-20-91	DH
	D) Optical Clarity of Scope						2-20-91	DH
645	Inspect for Live Ammo						2-20-91	DH
655	Final Inspection						2-22-91	A
	A) Headspace							
	B) Trigger Pull	2.31	2.37	2.27	2.39	2.35	2/21/91	JLL
	C) Function						2-22-91	R
660	Pack						3-18-91	N

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

SERIAL NO. C6611381DATE 2/19/91TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.45	2.40	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.45	2.43	2.37	
PULL #3	2.49	2.40	2.40	2.27	
PULL #4	2.42	2.42	2.48	2.39	
PULL #5	2.41	2.49	2.41	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.40		
PULL #2	3.23	3.49		
PULL #3	3.16	3.43		
PULL #4	3.28	3.42		
PULL #5	3.26	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.16		4.29
PULL #2	4.34	4.23		4.29
PULL #3	4.31	4.27		4.30
PULL #4	4.29	4.36		4.22
PULL #5	4.29	4.25		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611381
30 Feb 1991

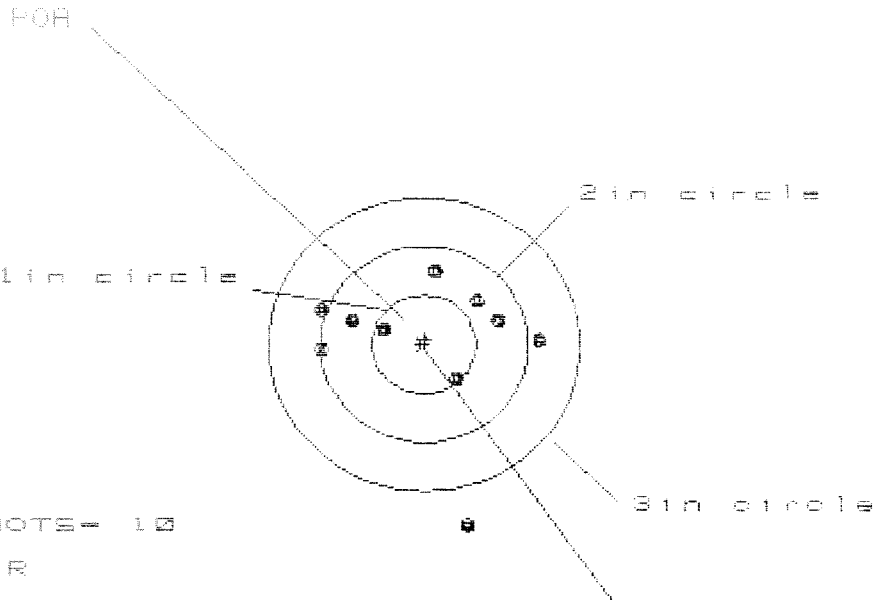
CENTROIDAL DISTANCES

0 TO	1	.0511957
1 TO	2	.0801561
1 TO	3	.164402
1 TO	4	.178393
1 TO	5	.035

←----POB

THE X-COORDINATE FOR THIS RIFLE IS: .0198
THE Y-COORDINATE FOR THIS RIFLE IS: -.0272
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .0336434
THE POI RADIUS FOR THIS RIFLE IS: .0346

CENTERFIRE PATTERNS # 1



OF SHOTS = 10
IN CIR
1in = 2
2in = 7
3in = 8
HS = 2.131
VS = 2.549
CS = 2.581

CENTROID #

CENTER #	1		
# OF SHOTS	10	9	8
EXTREME X	1.135	1.184	.908
MINIMUM X	-.996	-.947	-.799
MAXIMUM Y	.727	.524	.500
MINIMUM Y	-1.822	-.567	-.591
CENTROID X	-.011	-.060	-.208
CENTROID Y	-.050	.153	.177
POI TO CENTROID IN.	.051	.164	.273
MIN RADIUS	.450	.388	.244
MAX RADIUS	.889	.747	.670
AVG RADIUS	1.876	1.200	.908
HORIZONTAL SPREAD	2.131	2.131	1.787
VERTICAL SPREAD	2.549	1.091	1.091

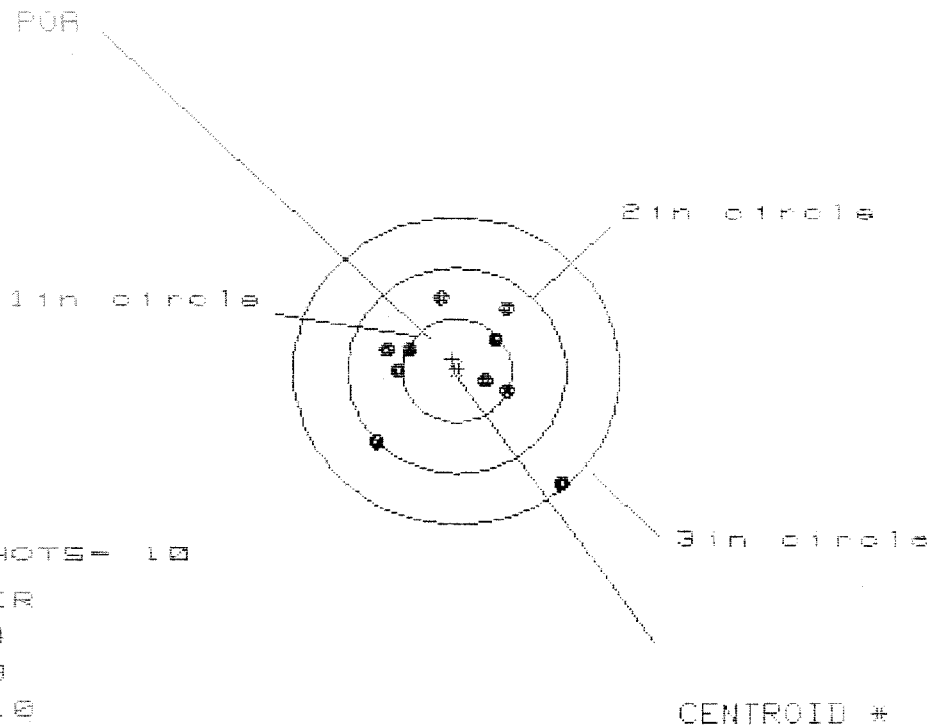
EXTREME SPREAD	2.581	2.134	1.727
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611361

CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.686

VS= 1.791

GS= 2.091

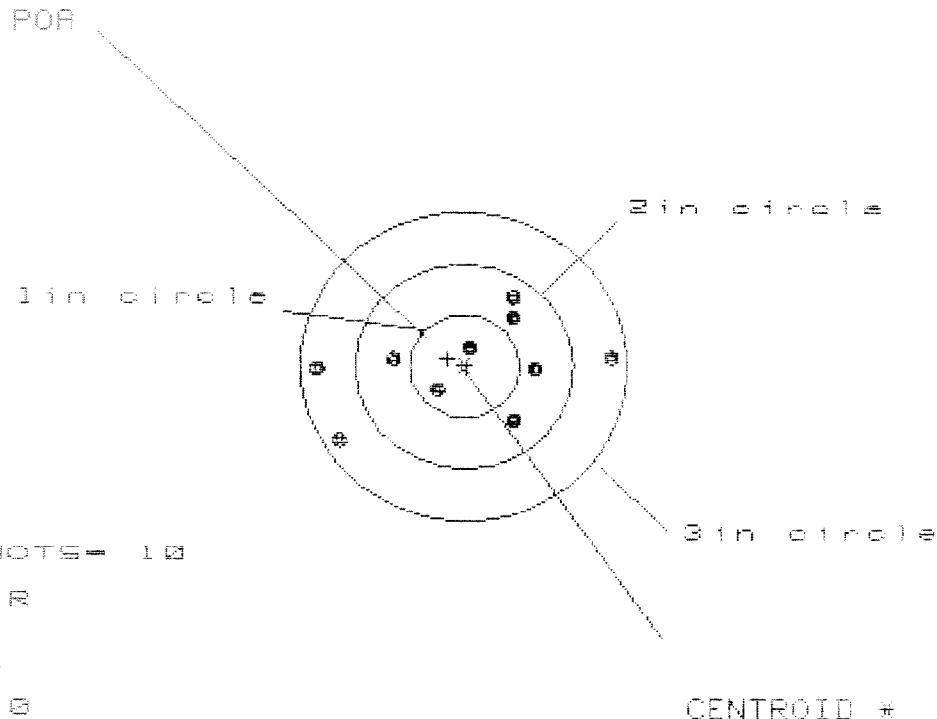
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.980	.590	.516
MINIMUM X	-.706	-.598	-.653
MAXIMUM Y	.735	.618	.516
MINIMUM Y	-1.056	-.811	-.405
CENTROID X	.041	-.067	.007
CENTROID Y	-.111	.006	.108
POR TO CENTROID in.	.119	.068	.108
MIN RADIUS	.240	.327	.376
MEAN RADIUS	.678	.575	.510
MAX RADIUS	1.440	1.007	.656
HORIZONTAL SPREAD	1.686	1.188	1.169
VERTICAL SPREAD	1.791	1.429	.922
EXTREME SPREAD	2.091	1.687	1.225
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

28 Feb 1991

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CENTERFIRE PATTERNS # 3



HS= 2.752

VS= 1.417

GS= 2.753

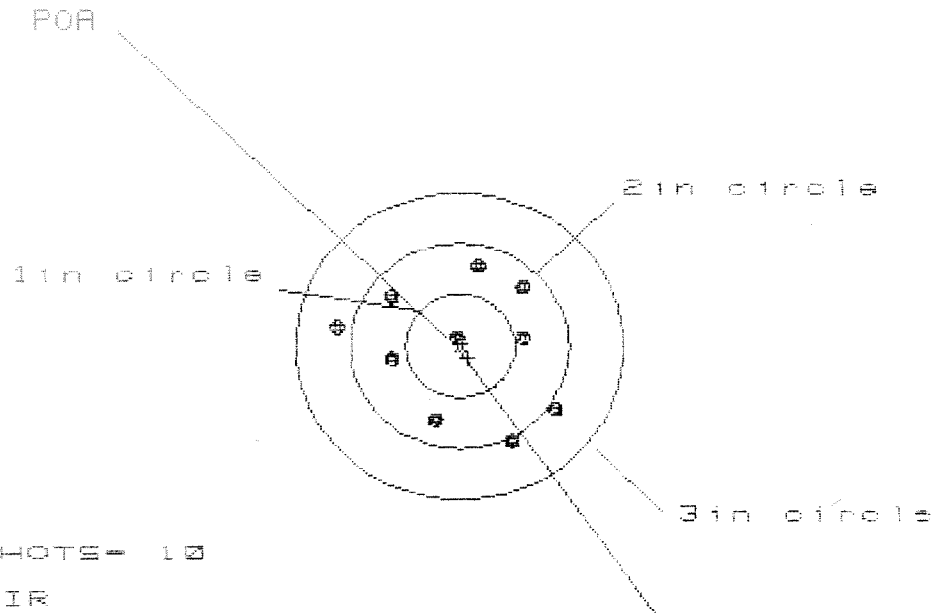
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.205	.694
MINIMUM X	-1.392	-1.298	-1.147
MAXIMUM Y	.726	.723	.727
MINIMUM Y	-.691	-.694	-.690
CENTROID X	.151	.306	.155
CENTROID Y	-.078	-.075	-.079
POA TO CENTROID in.	.170	.315	.174
MIN RADIUS	.146	.211	.147
MEAN RADIUS	.815	.742	.674
MAX RADIUS	1.392	1.472	1.339
HORIZONTAL SPREAD	2.752	2.503	1.841
VERTICAL SPREAD	1.417	1.417	1.417
EXTREME SPREAD	2.753	2.606	2.107
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

20 Feb 1991

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 1.955

VS = 1.728

GS = 2.123

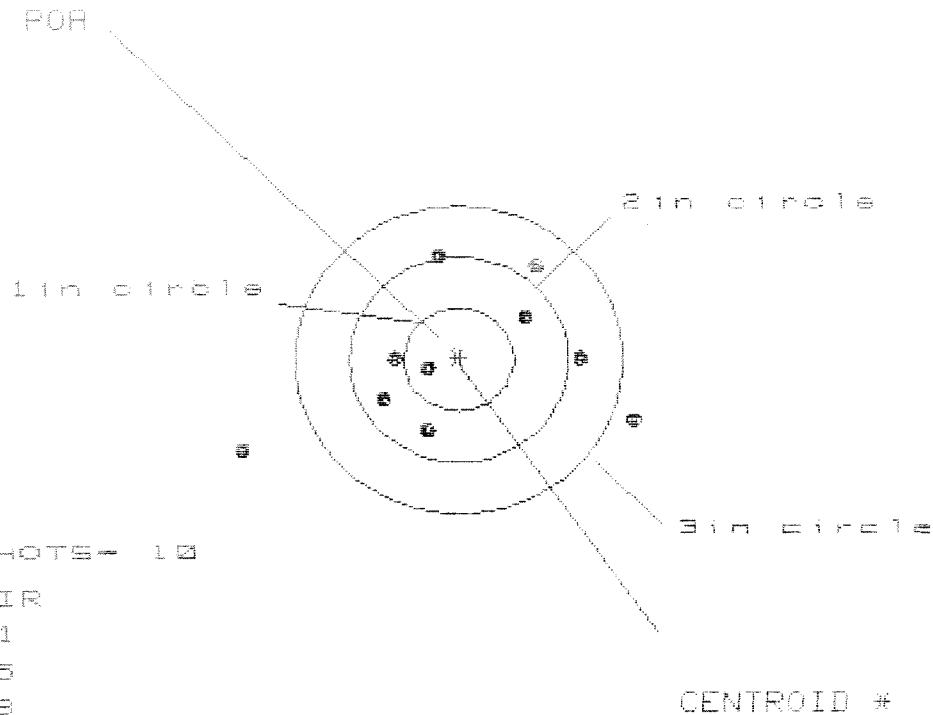
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.873	.752	.507
MINIMUM X	:	-1.083	-.738	-.644
MAXIMUM Y	:	.827	.849	.773
MINIMUM Y	:	-.961	-.879	-.955
CENTROID X	:	-.071	.049	-.045
CENTROID Y	:	.118	.096	.172
POA TO CENTROID in.	:	.138	.108	.178
MIN RADIUS	:	.098	.202	.084
MEAN RADIUS	:	.760	.724	.672
MAX RADIUS	:	1.100	.968	1.075
HORIZONTAL SPREAD	:	1.955	1.490	1.151
VERTICAL SPREAD	:	1.728	1.728	1.728
EXTREME SPREAD	:	2.123	1.865	1.797
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Feb 1991

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.585

VS= 1.893

GS= 3.599

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.562	1.338	1.051
MINIMUM X	-2.023	-.885	-.718
MAXIMUM Y	1.039	.944	.865
MINIMUM Y	-.854	-.737	-.816
CENTROID X	-.011	.213	.046
CENTROID Y	-.015	.080	.159
POA TO CENTROID in.	.019	.228	.165
MIN RADIUS	.239	.532	.412
MEAN RADIUS	1.031	.906	.808
MAX RADIUS	2.196	1.479	1.058
HORIZONTAL SPREAD	3.585	2.223	1.769
VERTICAL SPREAD	1.893	1.681	1.681
EXTREME SPREAD	3.599	2.347	1.929
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		