

C6611412

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6611412

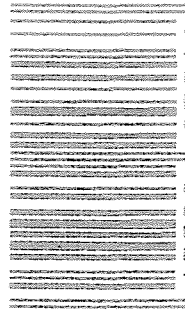
ORDER NO.
5716

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



5716 C6611412

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611412

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		91	RW
600	Proof	1 25	91	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	LS
617	Drill and Tap Sight Holes	1 30	91	LB
618	Polish Barrel <i>ABB</i>	1 30	91	LB
620	Apply Coatings (Barrel Action)		2-10-91	TH
	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		2/13/91	JH

Op. #	BARBER M24 0076409	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/13/91	WLB
	G) Safety Off Force	2	2 1/4	2 1/4			2/13/91	WLB
	H) Trigger Pull Test & Retainability						2/13/91	SP
	I) Firing Pin Indent	.022	.0225	.0222			2/13/91	WLB
	J) Assemble Stock						2/13/91	RW
	K) Assemble Swivel Studs						2-22-91	AC
	L) Attach Front and Rear Sight Assemblies						2/13/91	RW
	M) Iron Sight Alignment						2/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	RW
	O) Attach Scope to Rifle						2/13/91	RW
	P) Detach & Attach Scope 20 Times						2/13/91	RW
640	Gallery Target & Test						2-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-13-91	NF
655	Final Inspection							
	A) Headspace						2-22-91	AC
	B) Trigger Pull	2.75	2.76	2.65	2.60	2.58	2/19/91	WLB
	C) Function						2-22-91	AC
660	Pack						3/14/91	WLB

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

SERIAL NO. C6611412DATE 2/13/91TESTER SA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.39	2.30	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.23	2.33	2.76	
PULL #3	2.41	2.35	2.38	2.65	
PULL #4	2.22	2.36	2.40	2.60	
PULL #5	2.33	2.34	2.32	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.31		
PULL #2	3.38	3.12		
PULL #3	3.28	3.22		
PULL #4	3.21	3.40		
PULL #5	3.19	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.23		4.19
PULL #2	4.27	4.28		4.26
PULL #3	4.18	4.30		4.24
PULL #4	4.29	4.18		4.26
PULL #5	4.28	4.20		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611412
14 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.353617
1 TO 2	.581393
1 TO 3	.484663
1 TO 4	.600664
1 TO 5	.21496

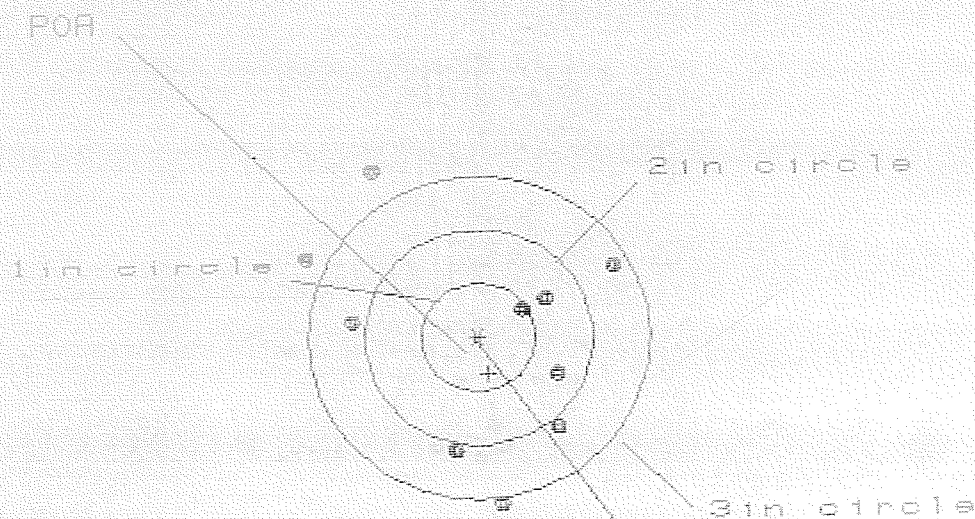
←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .109
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112199
THE AMR FOR THIS RIFLE IS: 1.054

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611412.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.728

VS= 3.127

GS= 3.311

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.284	1.185	.982
MINIMUM X	-1.524	-1.623	-1.422
MAXIMUM Y	1.588	.963	.990
MINIMUM Y	-1.539	-1.362	-1.242
CENTROID X	-.086	.013	.216
CENTROID Y	.343	.166	.046
POA TO CENTROID in.	.354	.167	.221
MIN RADIUS	.421	.482	.430
MEAN RADIUS	1.158	1.052	.898
MAX RADIUS	1.824	1.887	1.480
HORIZONTAL SPREAD	2.728	2.728	2.324
VERTICAL SPREAD	3.127	2.325	2.232
EXTREME SPREAD	3.311	2.888	2.452
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 7		

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.204

VS= 1.540

GS= 1.590

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.588

.594

.663

MINIMUM X

-.616

-.610

-.541

MAXIMUM Y

.445

.323

.360

MINIMUM Y

-1.095

-.381

-.344

CENTROID X

.111

.105

.036

CENTROID Y

-.204

-.082

-.119

POA TO CENTROID in.

.232

.133

.124

MIN RADIUS

.161

.221

.150

MEAN RADIUS

.526

.455

.421

MAX RADIUS

1.097

.710

.674

HORIZONTAL SPREAD

1.204

1.204

1.204

VERTICAL SPREAD

1.540

.704

.704

EXTREME SPREAD

1.590

1.336

1.284

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

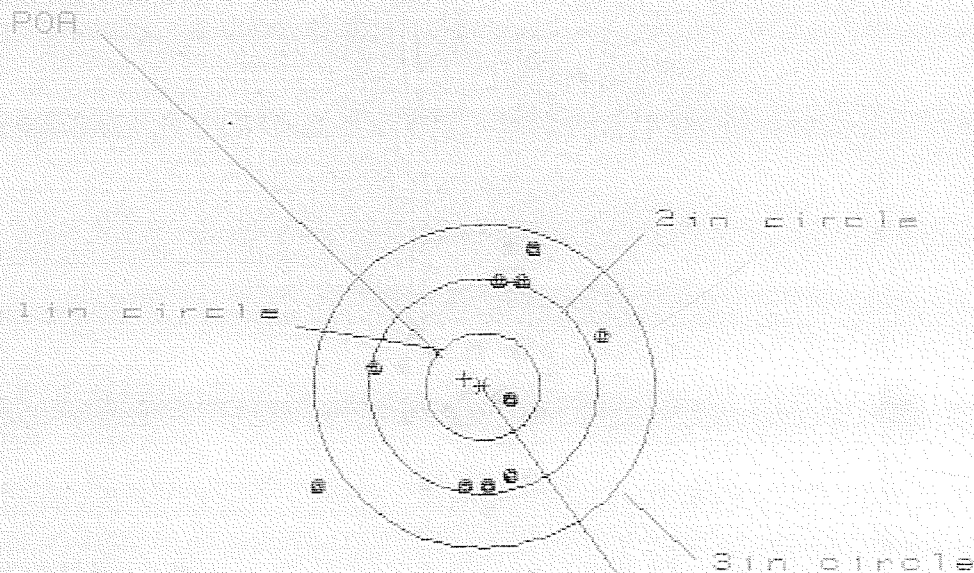
NUMBER IN THREE INCH CIRCLE =

10

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.548

VS= 2.227

GS= 2.896

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.085	.923	.960
MINIMUM X	-1.463	-1.125	-1.088
MAXIMUM Y	1.280	1.182	1.003
MINIMUM Y	-.947	-1.045	-.897
CENTROID X	.161	.323	.286
CENTROID Y	-.074	.024	-.124
POA TO CENTROID in.	.177	.324	.311
MIN RADIUS	.256	.243	.127
MEAN RADIUS	1.024	.933	.874
MAX RADIUS	1.708	1.220	1.106
HORIZONTAL SPREAD	2.548	2.048	2.048
VERTICAL SPREAD	2.227	2.227	1.900
EXTREME SPREAD	2.896	2.304	2.069
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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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 = 6

3 in = 9

HS = 2.589

VS = 2.301

GS = 2.958

PATTERN #

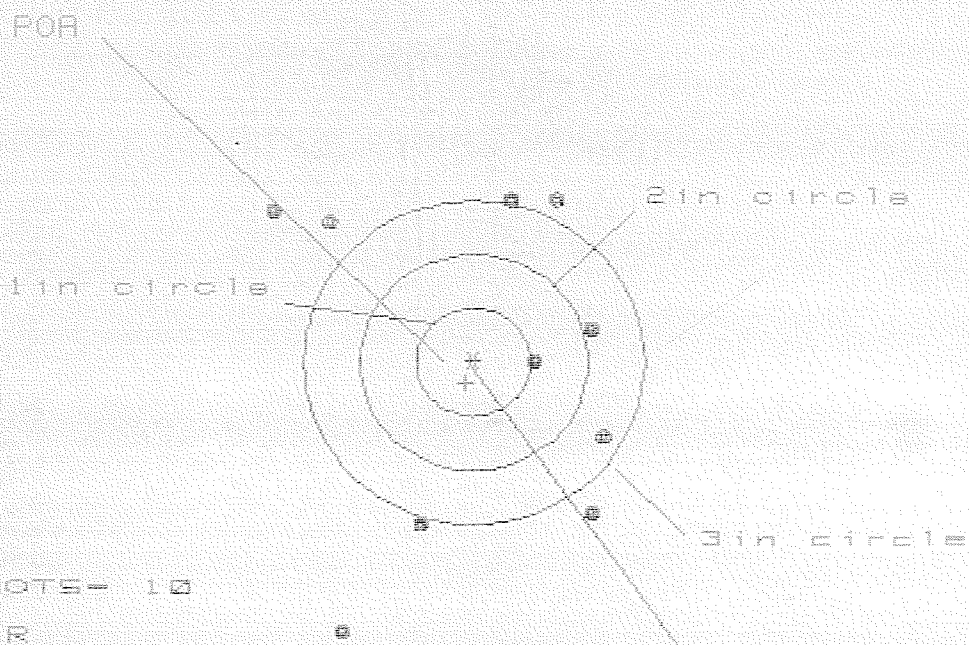
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.741	.868	.892
MINIMUM X	-.848	-.655	-.631
MAXIMUM Y	1.282	1.169	1.098
MINIMUM Y	-1.018	-1.031	-.885
CENTROID X	.293	.100	.076
CENTROID Y	-.123	-.009	-.155
POA TO CENTROID in.	.318	.100	.173
MIN RADIUS	.077	.195	.149
MEAN RADIUS	.919	.785	.706
MAX RADIUS	2.017	1.282	1.408
HORIZONTAL SPREAD	2.589	1.523	1.523
VERTICAL SPREAD	2.301	2.200	1.974
EXTREME SPREAD	2.958	2.402	2.402
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 1

3in = 3

HS= 2.934

VS= 4.057

GS= 4.470

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.163	1.030	.792
MINIMUM X	-1.771	-1.904	-1.613
MAXIMUM Y	1.529	1.248	1.393
MINIMUM Y	-2.528	-1.817	-1.672
CENTROID X	.066	.199	.437
CENTROID Y	.191	.472	.327
POA TO CENTROID in.	.202	.513	.546
MIN RADIUS	.530	.496	.220
MEAN RADIUS	1.641	1.464	1.299
MAX RADIUS	2.797	2.232	2.000
HORIZONTAL SPREAD	2.934	2.934	2.405
VERTICAL SPREAD	4.057	3.065	3.065
EXTREME SPREAD	4.470	3.975	3.527
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	3		