

C6611415

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

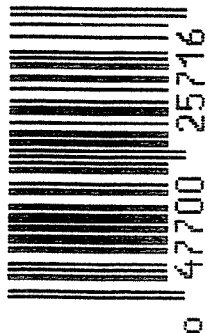
SERIAL NO.
C6611415

ORDER NO.
5716

20

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

UPC



0 47700 25716 7



5716 C6611415

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611415

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25		RW
607	Check Headspace	1 25		RW
610	Dis-assemble Gun	1 25		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	FB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	JA
	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	SL

op. #	BARBER M24 0076451	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/14/91	WB
	G) Safety Off Force	2	2	2			2/14/91	WB
	H) Trigger Pull Test & Retainability						2/14/91	JP
	I) Firing Pin Indent	10215	10213	10245			2/14/91	WB
	J) Assemble Stock						2/15/91	Rw
	K) Assemble Swivel Studs						2-25-91	KC
	L) Attach Front and Rear Sight Assemblies						2/15/91	Rw
	M) Iron Sight Alignment						2/15/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	Rw
	O) Attach Scope to Rifle						2/15/91	Rw
	P) Detach & Attach Scope 20 Times						2/15/91	Rw
640	Gallery Target & Test						2-15-91	DH
	A) Time						2-15-91	DH
	B) Malfunctions						2-15-91	DH
	C) Pierced Primers						2-15-91	DH
	D) Optical Clarity of Scope						2-15-91	DH
645	Inspect for Live Ammo						2-15-91	DH
655	Final Inspection							
	A) Headspace						2-25-91	KC
	B) Trigger Pull	2.68	2.60	2.68	2.58	2.61	2/10/91	WB
	C) Function						2-25-91	KC
660	Pack						3-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± 50#
3.00# ± 75#
4.00# ± 100#

SERIAL NO. C6611415
DATE 2/14/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.44	2.47	2.68	MIN. SETTING,
PULL #2	2.43	2.45	2.45	2.60	NO AVG. OF 5
PULL #3	2.46	2.28	2.26	2.68	READINGS ACCEPT-
PULL #4	2.46	2.42	2.40	2.58	ABLE LESS THAN 2#
PULL #5	2.57	2.47	2.40	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.36		
PULL #2	3.35	3.37		
PULL #3	3.37	3.37		
PULL #4	3.12	3.32		
PULL #5	3.43	3.26		
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	4.31		4.39
PULL #2	4.27	4.35		4.35
PULL #3	4.30	4.33		4.37
PULL #4	4.30	4.35		4.42
PULL #5	4.28	4.32		4.36
TOTAL				
AVG.				

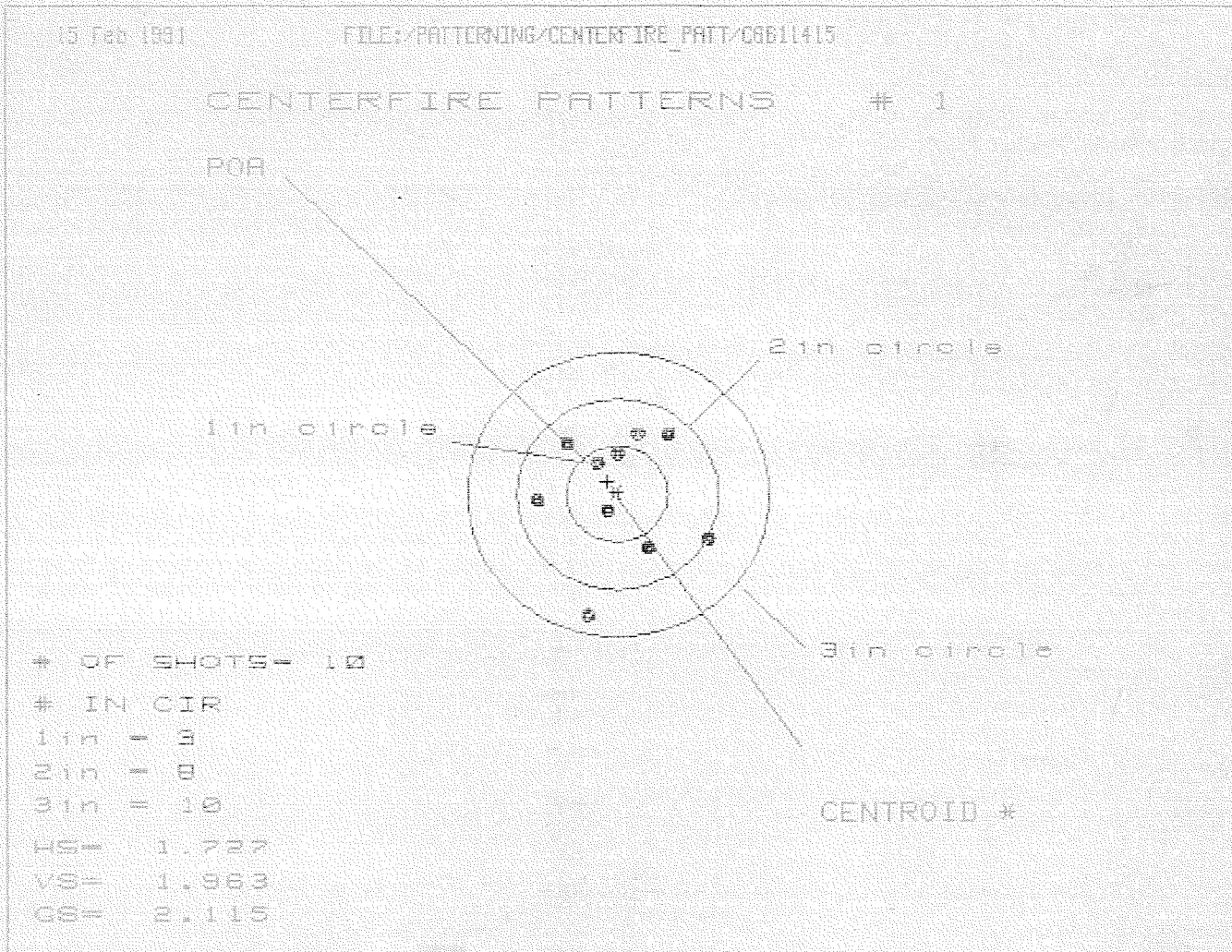
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611415
15 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.165424
1 TO	2	.0630079
1 TO	3	.350297
1 TO	4	.0560446
1 TO	5	.649173

3 1/2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.194
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .197239
THE HQR FOR THIS RIFLE IS: .8574



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.925	.895	.604
MINIMUM X	-.802	-.832	-.720
MAXIMUM Y	.681	.539	.460
MINIMUM Y	-1.282	-.711	-.790
CENTROID X	.097	.127	.015
CENTROID Y	-.134	.008	.087
POA TO CENTROID in.	.166	.127	.088
MIN RADIUS	.154	.245	.158
MEAN RADIUS	.697	.606	.515
MAX RADIUS	1.309	1.096	.865
HORIZONTAL SPREAD	1.727	1.727	1.324
VERTICAL SPREAD	1.963	1.250	1.250
EXTREME SPREAD	2.115	1.781	1.526
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611415

CENTERFIRE PATTERNS

2

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 1.954

VS = 3.335

GS = 3.627

CENTROID *

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.232

.583

.563

MINIMUM X

:

-.722

-.585

-.525

MAXIMUM Y

:

1.635

1.213

1.025

MINIMUM Y

:

-1.701

-1.519

-1.707

CENTROID X

:

.160

.023

-.037

CENTROID Y

:

-.135

-.317

-.129

POB TO CENTROID in.

:

.218

.318

.135

MIN RADIUS

:

.375

.247

.437

MEAN RADIUS

:

1.108

1.003

.905

MAX RADIUS

:

2.047

1.577

1.707

HORIZONTAL SPREAD

:

1.954

1.088

1.088

VERTICAL SPREAD

:

3.335

2.732

2.732

EXTREME SPREAD

:

3.627

2.916

2.782

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611415

CENTERFIRE PATTERNS

3

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.286

VS= 2.127

GS= 2.332

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.582

.657

.656

MINIMUM X

-.704

-.528

-.529

MAXIMUM Y

.890

.858

.690

MINIMUM Y

-1.237

-1.277

-1.323

CENTROID X

.005

-.171

-.170

CENTROID Y

-.472

-.432

-.272

POB TO CENTROID in.

.472

.464

.321

MIN RADIUS

.223

.128

.086

MEAN RADIUS

.835

.719

.617

MAX RADIUS

1.623

1.277

1.366

HORIZONTAL SPREAD

2.286

1.185

1.185

VERTICAL SPREAD

2.127

2.127

2.813

EXTREME SPREAD

2.332

2.161

2.161

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

15 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611415

CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 2.592

VS = 1.793

GS = 2.735

CENTROID *

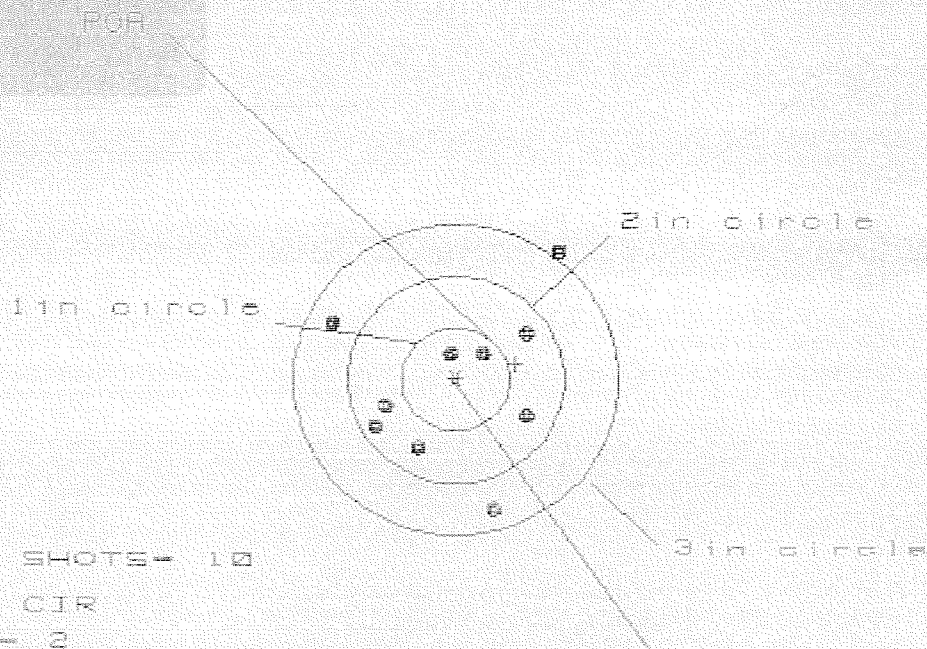
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.242	1.070	.919
MINIMUM X	-1.350	-1.212	-.850
MAXIMUM Y	.795	.684	.655
MINIMUM Y	-.998	-.436	-.465
CENTROID X	.112	-.026	.125
CENTROID Y	-.080	.031	.060
POR TO CENTROID in.	.138	.040	.139
MIN RADIUS	.089	.265	.195
MEAN RADIUS	.792	.703	.615
MAX RADIUS	1.593	1.235	1.030
HORIZONTAL SPREAD	2.592	2.282	1.769
VERTICAL SPREAD	1.793	1.120	1.120
EXTREME SPREAD	2.735	2.291	1.885
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11415

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.027

VS= 2.431

GS= 2.546

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.905

.790

.850

MINIMUM X

-1.122

-1.021

-.961

MAXIMUM Y

1.262

.734

.598

MINIMUM Y

-1.229

-1.089

-.520

CENTROID X

-.552

-.653

-.713

CENTROID Y

-.149

-.289

-.153

POB TO CENTROID in.

.572

.714

.729

MIN RADIUS

.238

.390

.287

MEAN RADIUS

.855

.774

.710

MAX RADIUS

1.553

1.258

1.132

HORIZONTAL SPREAD

2.827

1.811

1.811

VERTICAL SPREAD

2.491

1.823

1.218

EXTREME SPREAD

2.546

2.361

2.025

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9