

C6611417

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington[®]

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

DU PONT

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

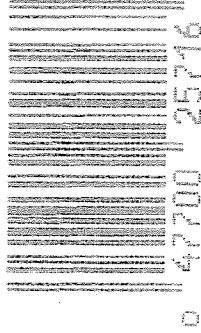
MODEL 700[™] M24

SERIAL NO. C6611417

ORDER NO. 5716

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

UPC



5716 C6611417

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611417

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1 25 91	RW
600	Proof		1 25 91	RW
607	Check Headspace		1 25 91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1 25	KR
	Magnaflux Bolt		1 25	KR
615	Rollmark Caliber		1 25 91	GL
617	Drill and Tap Sight Holes		1 30 91	LB
618	Polish Barrel <i>LB</i>		1 30 91	LB
620	Apply Coatings (Barrel Action)		2-10-91	LB
	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 0076483	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/14/91	JP
	G) Safety Off Force	2	2	2			2/14/91	JP
	H) Trigger Pull Test & Retainability						2/14/91	JP
	I) Firing Pin Indent	.0205	.0205	.0205			2/14/91	JP
	J) Assemble Stock						2/14/91	Rev
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/14/91	Rev
	M) Iron Sight Alignment						2/14/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						2/14/91	Rev
	O) Attach Scope to Rifle						2/14/91	Rev
	P) Detach & Attach Scope 20 Times						2/14/91	Rev
640	Gallery Target & Test						2-15-91	A
	A) Time						2-15-91	A
	B) Malfunctions						2-15-91	A
	C) Pierced Primers						2-15-91	A
	D) Optical Clarity of Scope						2-15-91	A
645	Inspect for Live Ammo						2-15-91	A
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.16	2.15	2.50	2.56	2.54	2/22/91	JP
	C) Function						2-22-91	A
660	Pack						3-18-91	RF

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Safe hits stock	RW
	2nd 2/19/91	File Stock by Safety Arm Bench Check OK	RW
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06611417

DATE 2/14/91

TESTER JRI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.22	2.40	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.44	2.46	2.15	
PULL #3	2.36	2.37	2.39	2.50	
PULL #4	2.22	2.47	2.44	2.56	
PULL #5	2.15	2.35	2.40	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.44		
PULL #2	3.52	3.12		
PULL #3	3.51	3.54		
PULL #4	3.42	3.15		
PULL #5	3.40	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.40		4.15
PULL #2	4.29	4.38		4.29
PULL #3	4.26	4.21		4.32
PULL #4	4.41	4.28		4.33
PULL #5	4.30	4.18		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611417
15 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.483517
1 TO	2	.662785
1 TO	3	.48286
1 TO	4	.284063
1 TO	5	.705071

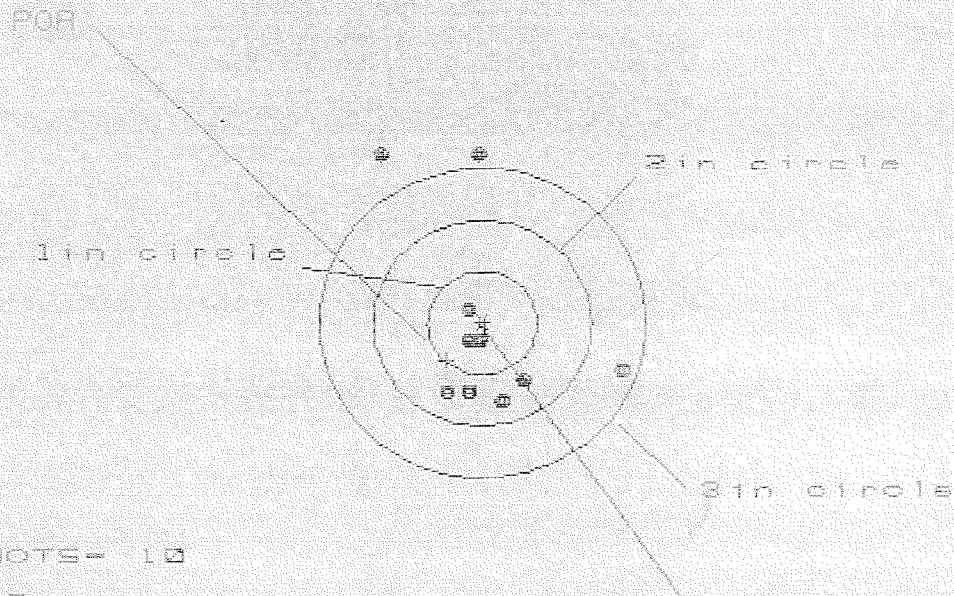
s^2
 t^2 ← POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0512
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .178
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .185217
THE AMR FOR THIS RIFLE IS: .97

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611417

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.352

VS= 2.394

GS= 3.115

PATTERN # 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	1.180	1.164
MINIMUM X	-.965	-.464	-.480
MAXIMUM Y	1.674	1.848	.523
MINIMUM Y	-.720	-.534	-.302
CENTROID X	.325	.432	.448
CENTROID Y	.358	.172	-.060
FOA TO CENTROID in.	.483	.465	.452
MIN RADIUS	.174	.176	.292
MEAN RADIUS	.840	.675	.489
MAX RADIUS	1.933	1.853	1.166
HORIZONTAL SPREAD	2.252	1.644	1.644
VERTICAL SPREAD	2.394	2.382	.825
EXTREME SPREAD	3.115	2.506	1.650
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB11417

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.597

VS = 2.333

GS = 2.484

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.658

.553

.529

MINIMUM X

-.939

-.784

-.808

MAXIMUM Y

1.181

1.053

.833

MINIMUM Y

-1.152

-1.062

-.931

CENTROID X

.142

.247

.271

CENTROID Y

-.279

-.151

-.282

POA TO CENTROID in

.313

.289

.391

MIN RADIUS

.198

.144

.136

MEAN RADIUS

.757

.654

.596

MAX RADIUS

1.487

1.138

1.007

HORIZONTAL SPREAD

1.597

1.337

1.337

VERTICAL SPREAD

2.333

2.115

1.763

EXTREME SPREAD

2.484

2.198

1.799

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

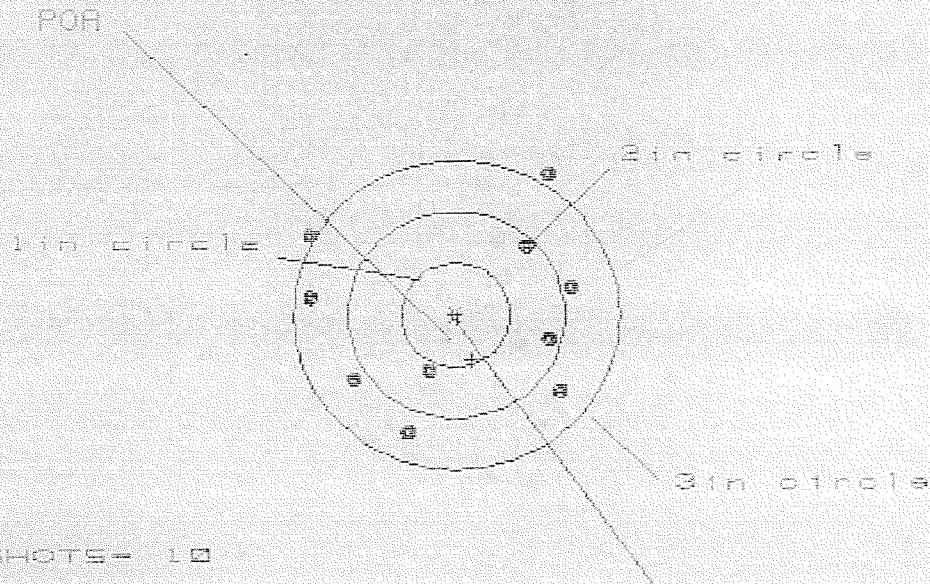
NUMBER IN THREE INCH CIRCLE =

10

15 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C9611417

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 10

2in = 3

3in = 8

HS= 2.433

VS= 2.428

GS= 2.748

PATTERN #

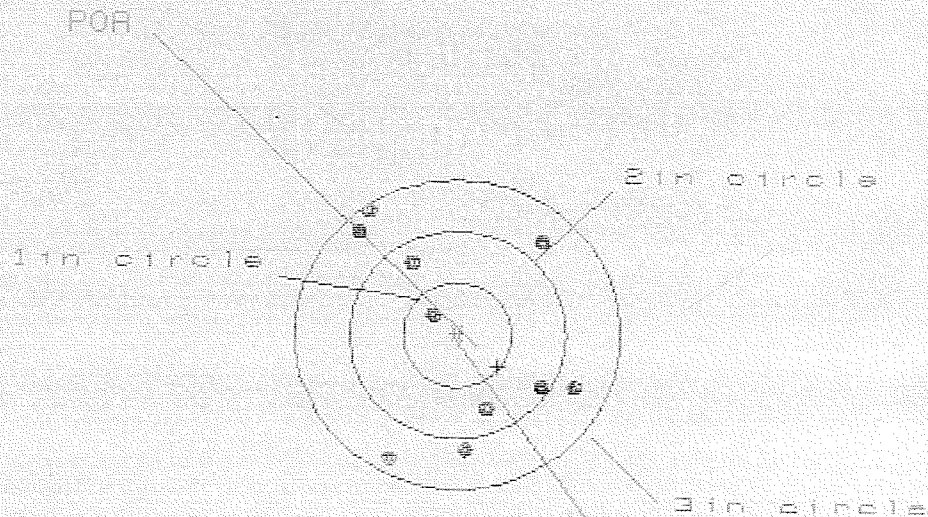
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.079	1.175	1.018
MINIMUM X	-1.355	-1.258	-1.400
MAXIMUM Y	1.328	.911	.915
MINIMUM Y	-1.100	-.952	-.839
CENTROID X	-.152	-.249	-.092
CENTROID Y	.433	.285	.171
POA TO CENTROID in.	.459	.379	.195
MIN RADIUS	.687	.435	.420
MEAN RADIUS	1.144	1.073	.985
MAX RADIUS	1.588	1.553	1.469
HORIZONTAL SPREAD	2.433	2.433	2.418
VERTICAL SPREAD	2.428	1.863	1.754
EXTREME SPREAD	2.748	2.702	2.422
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

15 Feb 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS- 2.003

VS- 2.427

GS- 2.562

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.078	.987	.900
MINIMUM X	-.925	-1.016	-1.103
MAXIMUM Y	1.193	1.112	.974
MINIMUM Y	-1.234	-1.101	-1.121
CENTROID X	-.378	-.287	-.200
CENTROID Y	.304	.171	.309
POA TO CENTROID in.	.405	.334	.368
MIN RADIUS	.342	.498	.491
MEAN RADIUS	1.048	.990	.947
MAX RADIUS	1.447	1.506	1.472
HORIZONTAL SPREAD	2.003	2.003	2.003
VERTICAL SPREAD	2.427	2.213	2.095
EXTREME SPREAD	2.562	2.562	2.482
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 10		