

C6611433

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ H24

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

20

SERIAL NO. C6611433
ORDER NO. 5716

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



5716 C6611433

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611433

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	8 1	RW
600	Proof	1 25	9 1	RW
607	Check Headspace	1 25	9 1	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	1 2		KR
	Magnaflux Bolt	1 25	8 1	KR
615	Rollmark Caliber	1 25	9 1	GL
617	Drill and Tap Sight Holes	1 30	9 1	LB
618	Polish Barrel R.B.B.	1 30	9 1	LB
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		2/16/91	JA

op. #	BARBER M24 0076784	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/14/91	JH
	I) Firing Pin Indent	.0225	.023	.023			2/16/91	WB
	J) Assemble Stock						2/18/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	RW
	M) Iron Sight Alignment						2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	RW
	O) Attach Scope to Rifle						2/18/91	RW
	P) Detach & Attach Scope 20 Times						2/18/91	RW
640	Gallery Target & Test						2/14/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						2/14/91	KJ
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.40	2.36	2.24	2.35	2.20	2/21/91	JH
	C) Function						2-22-91	A
660	Pack						3-19-91	N

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

SERIAL NO. C6611433DATE 2/16/91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.18	2.48	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.52	2.50	2.36	
PULL #3	2.47	2.23	2.33	2.24	
PULL #4	2.36	2.22	2.41	2.35	
PULL #5	2.35	2.47	2.20	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.27		
PULL #2	3.42	3.29		
PULL #3	3.41	3.25		
PULL #4	3.33	3.27		
PULL #5	3.28	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.45		4.37
PULL #2	4.25	4.34		4.23
PULL #3	4.32	4.34		4.29
PULL #4	4.21	4.31		4.19
PULL #5	4.31	4.27		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611433
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0437379
1 TO	2	.0373363
1 TO	3	.10224
1 TO	4	.151093
1 TO	5	.0512445

4 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0166
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0180942
THE AMR FOR THIS RIFLE IS: .8084

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611433

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.466

VS = 2.124

GS = 2.140

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.635

.673

.574

MINIMUM X

-.831

-.793

-.792

MAXIMUM Y

1.351

1.015

.614

MINIMUM Y

-.773

-.623

-.496

CENTROID X

.043

.005

.104

CENTROID Y

.008

-.142

-.269

POR TO CENTROID in.

.044

.142

.288

MIN RADIUS

.338

.288

.165

MEAN RADIUS

.745

.641

.530

MAX RADIUS

1.393

1.288

.949

HORIZONTAL SPREAD

1.466

1.466

1.366

VERTICAL SPREAD

2.124

1.638

1.110

EXTREME SPREAD

2.140

2.140

1.633

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

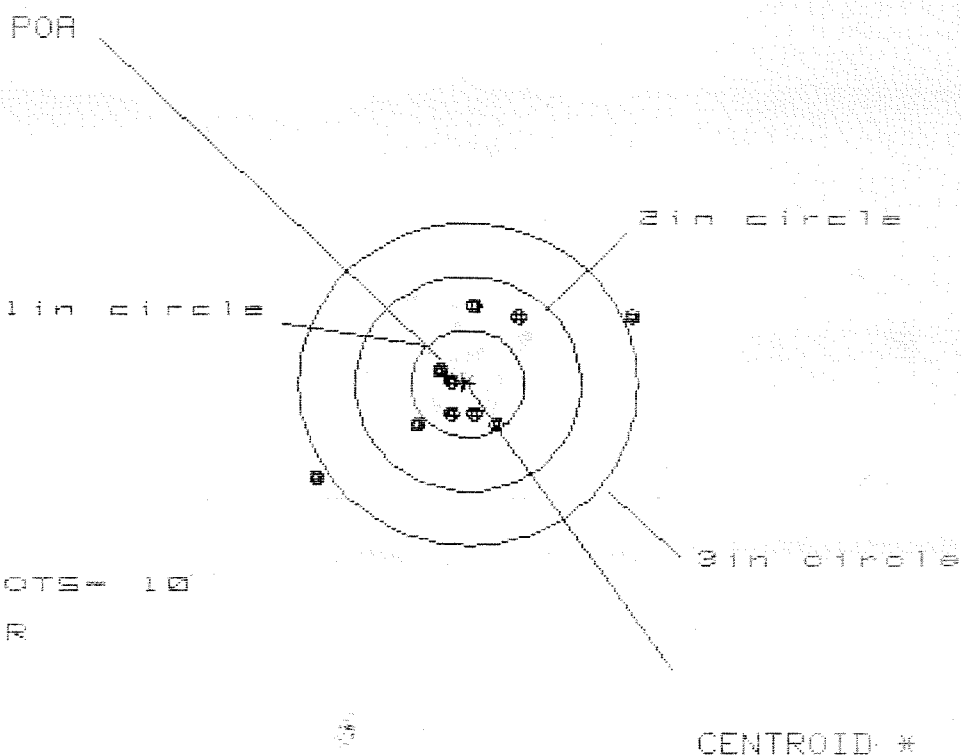
NUMBER IN THREE INCH CIRCLE =

10

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611433

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 8

HS= 2.873

VS= 1.591

GS= 3.237

PATTERN #

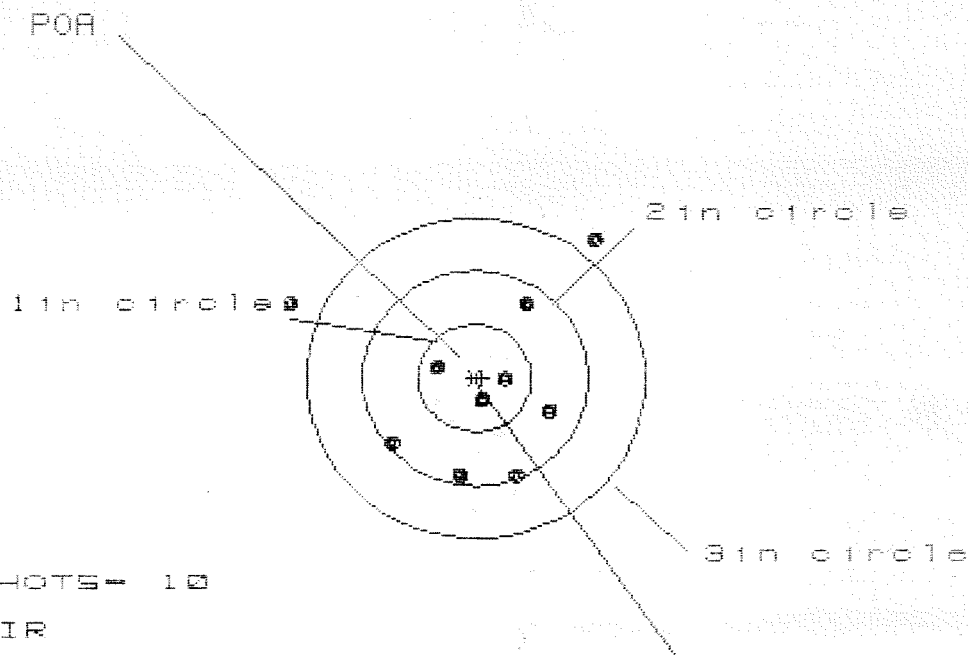
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.494	1.341	.471
MINIMUM X	-1.379	-.557	-.389
MAXIMUM Y	.691	.590	.652
MINIMUM Y	-.901	-.480	-.418
CENTROID X	.048	.201	.033
CENTROID Y	-.029	.072	.010
POA TO CENTROID in.	.056	.213	.035
MIN RADIUS	.131	.278	.107
MEAN RADIUS	.665	.591	.425
MAX RADIUS	1.647	1.428	.749
HORIZONTAL SPREAD	2.873	1.898	.860
VERTICAL SPREAD	1.591	1.070	1.070
EXTREME SPREAD	3.237	2.109	1.281
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/08B11433

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.649

VS= 2.284

GS= 2.720

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.047
MINIMUM X	-1.602
MAXIMUM Y	1.346
MINIMUM Y	-0.938
CENTROID X	-0.059
CENTROID Y	.001
POA TO CENTROID in.	.059
MIN RADIUS	.186
MEAN RADIUS	.870
MAX RADIUS	1.760
HORIZONTAL SPREAD	2.649
VERTICAL SPREAD	2.284
EXTREME SPREAD	2.720
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611433

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.500

VS= 2.044

GS= 2.500

CENTROID #

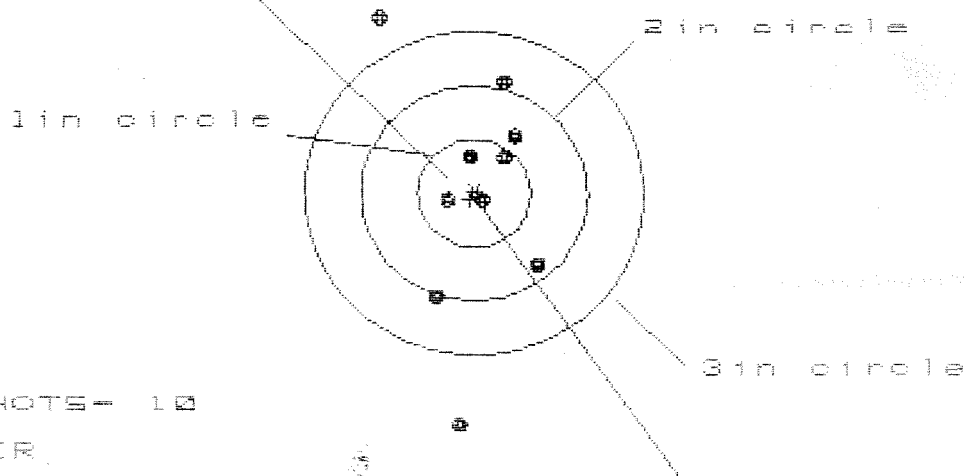
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.286
MINIMUM X	-1.314
MAXIMUM Y	1.146
MINIMUM Y	-.898
CENTROID X	-.034
CENTROID Y	-.122
POA TO CENTROID in.	.127
MIN RADIUS	.276
MEAN RADIUS	.896
MAX RADIUS	1.319
HORIZONTAL SPREAD	2.600
VERTICAL SPREAD	2.044
EXTREME SPREAD	2.600
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10

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FILE:/PATTERNING/CENTERFIRE_PATT/08611433

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 1.419

VS= 3.788.

GS= 3.853

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.589	.575	.470
MINIMUM X	:	-.830	-.844	-.499
MAXIMUM Y	:	1.657	1.420	.939
MINIMUM Y	:	-2.131	-1.160	-.982
CENTROID X	:	.038	.052	.157
CENTROID Y	:	.059	.296	.118
POA TO CENTROID in.	:	.070	.300	.197
MIN RADIUS	:	.137	.113	.160
MEAN RADIUS	:	.866	.696	.571
MAX RADIUS	:	2.135	1.652	1.102
HORIZONTAL SPREAD	:	1.419	1.419	.969
VERTICAL SPREAD	:	3.788	2.580	1.921
EXTREME SPREAD	:	3.853	2.736	2.023
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	