

C6611444

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington



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

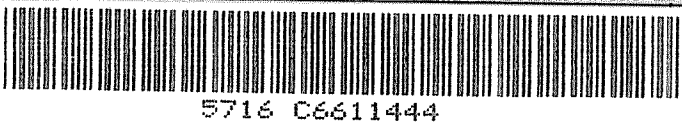
MODEL 700™ H24

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

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

SERIAL NO.
C6611444

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611444

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	JS
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	HA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/2/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	KS
	C) Inspect Ejector Hole for Chamfer		5/2/91	KS
	D) Oil Firing Pin Ass'y		5/2/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-17-91	PH

op. #	BARBER - M24 0076971	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-17-91	AC
	G) Safety Off Force	4	4	3			5-17-91	AC
	H) Trigger Pull Test & Retainability						5-17-91	DH
	I) Firing Pin Indent	.023	.023	.021			5-17-91	AC
	J) Assemble Stock						5/17/91	KS
	K) Assemble Swivel Studs						5-20-91	AC
	L) Attach Front and Rear Sight Assemblies						5/17/91	KS
	M) Iron Sight Alignment						5/17/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/17/91	KS
	O) Attach Scope to Rifle						5/17/91	KS
	P) Detach & Attach Scope 20 Times						5/17/91	KS
640	Gallery Target & Test						5/18/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/18/91	KT
655	Final Inspection							
	A) Headspace						5-20-91	AC
	B) Trigger Pull	2.46	2.43	2.41	2.41	2.51	5/20/91	JCP
	C) Function						5-20-91	AC
660	Pack						6-18-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611444

DATE 5-17-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.49	2.46	2.46	MIN. SETTING, NO. AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.60	2.52	2.43	
PULL #3	2.53	2.39	2.38	2.41	
PULL #4	2.52	2.35	2.41	2.41	
PULL #5	2.47	2.35	2.42	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.22		
PULL #2	3.19	3.20		
PULL #3	3.15	3.19		
PULL #4	3.14	3.19		
PULL #5	3.04	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.17		4.30
PULL #2	4.21	4.21		4.18
PULL #3	4.18	4.20		4.29
PULL #4	4.15	4.13		4.28
PULL #5	4.16	4.17		4.11
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611444
18 May 1991

CENTROIDAL DISTANCES

0 TO	1	.247245
1 TO	2	.247588
1 TO	3	.293471
1 TO	4	.243417
1 TO	5	.161443

34 5
-----POA

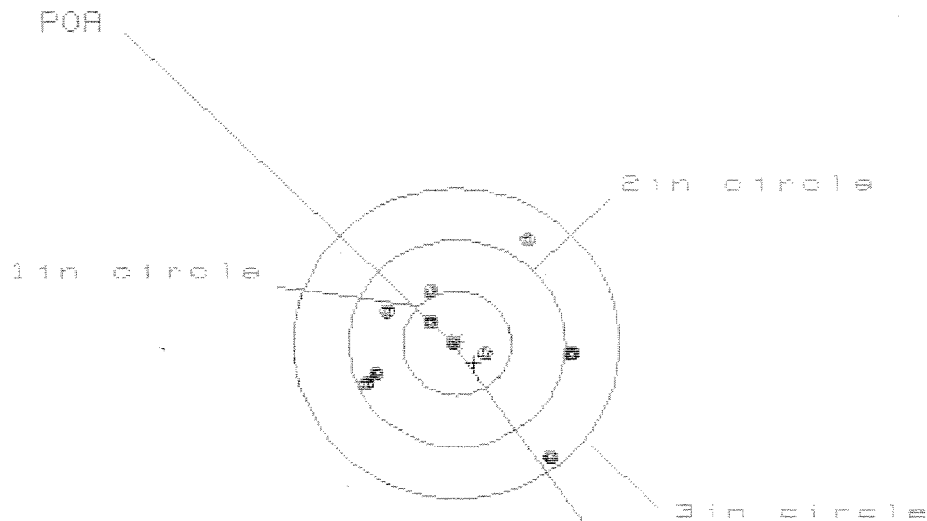
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1154
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0900
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146839

THE AMR FOR THIS RIFLE IS: .8684

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611444

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.966

VS= 2.103

GS= 2.121

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	1.182	1.272
MINIMUM X	-.883	-.784	-.695
MAXIMUM Y	1.029	.909	.505
MINIMUM Y	-1.074	-.550	-.436
CENTROID X	-.157	-.256	-.345
CENTROID Y	.191	.311	.197
POA TO CENTROID in.	.248	.403	.398
MIN RADIUS	.049	.172	.164
MEAN RADIUS	.747	.658	.583
MAX RADIUS	1.394	1.202	1.276
HORIZONTAL SPREAD	1.966	1.966	1.966
VERTICAL SPREAD	2.103	1.459	.941
EXTREME SPREAD	2.121	2.092	1.994
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611444

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.051

VS= 1.923

GS= 2.725

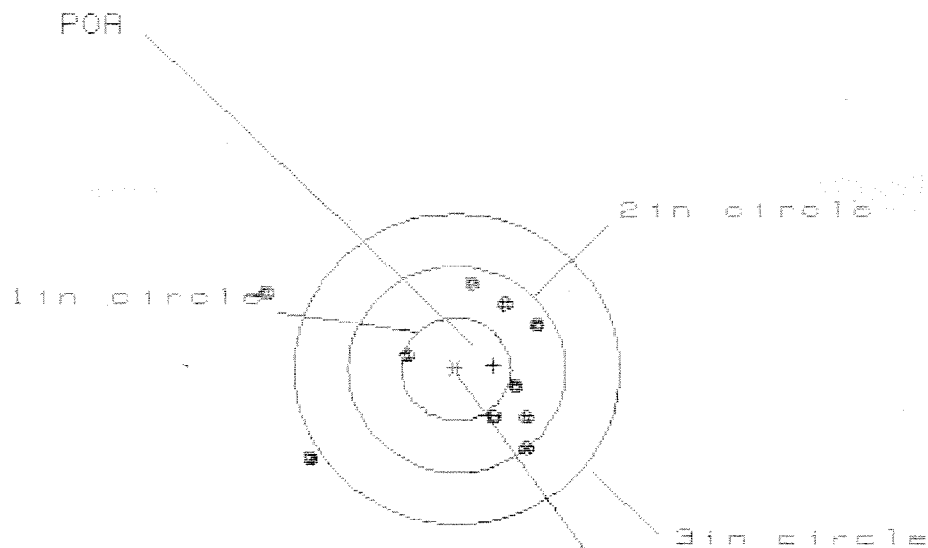
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.230	.973	.899
MINIMUM X	-.821	-.685	-.759
MAXIMUM Y	.793	.878	.747
MINIMUM Y	-1.130	-1.045	-.780
CENTROID X	.013	-.123	-.049
CENTROID Y	.011	-.074	.057
POA TO CENTROID in.	.017	.144	.075
MIN RADIUS	.252	.141	.269
MEAN RADIUS	.769	.659	.610
MAX RADIUS	1.447	1.311	1.169
HORIZONTAL SPREAD	2.051	1.658	1.658
VERTICAL SPREAD	1.923	1.923	1.527
EXTREME SPREAD	2.725	2.481	1.956
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611444

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 2.540

VS= 1.649

GS= 2.876

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.767
MINIMUM X	-1.773
MAXIMUM Y	.816
MINIMUM Y	-.833
CENTROID X	-.343
CENTROID Y	-.036
POA TO CENTROID in.	.345
MIN RADIUS	.445
MEAN RADIUS	.929
MAX RADIUS	1.936
HORIZONTAL SPREAD	2.540
VERTICAL SPREAD	1.649
EXTREME SPREAD	2.876
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	8

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611444

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 2.702

VS = 2.267

QS = 2.235

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.770	.555	.611
MINIMUM X	:	-1.932	-.867	-.811
MAXIMUM Y	:	1.077	1.159	1.021
MINIMUM Y	:	-1.190	-1.108	-.838
CENTROID X	:	-.041	.174	.118
CENTROID Y	:	-.023	-.105	.033
POA TO CENTROID in.	:	.047	.203	.122
MIN RADIUS	:	.331	.176	.168
MEAN RADIUS	:	.858	.697	.618
MAX RADIUS	:	2.069	1.195	1.037
HORIZONTAL SPREAD	:	2.702	1.422	1.422
VERTICAL SPREAD	:	2.267	2.267	1.859
EXTREME SPREAD	:	3.235	2.321	1.955
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611444

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.250

VS= 2.719

GS= 2.720

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.328
MINIMUM X	-.922
MAXIMUM Y	1.221
MINIMUM Y	-1.498
CENTROID X	-.049
CENTROID Y	.311
POA TO CENTROID in.	.315
MIN RADIUS	.566
MEAN RADIUS	1.039
MAX RADIUS	1.555
HORIZONTAL SPREAD	2.250
VERTICAL SPREAD	2.719
EXTREME SPREAD	2.720
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9