

C6611473

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ H24

SERIAL NO. C6611473

ORDER NO. 5716

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

20



5716 C6611473

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611473

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	Rw
600	Proof	3 25	91	Rw
607	Check Headspace	3 25	91	Rw
610	Dis-assemble Gun	3 25	91	Rw
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	"
615	Rollmark Caliber	3 28	91	JS
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	LB
620	Apply Coatings (Barrel Action)		4-11-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	JS

BARBER - M24 0077525								
op. #	OP. NAME	READINGS				DATE	INIT	
625 cont.	F) Safety On Force	6	6	6		5/3/91	QH	
	G) Safety Off Force	4	4	4		5/3/91	QH	
	H) Trigger Pull Test & Retainability					5/3/91	QH	
	I) Firing Pin Indent	1023	10225	10225		5/3/91	QH	
	J) Assemble Stock					5/4/91	RW	
	K) Assemble Swivel Studs					5-21-91	D/H	
	L) Attach Front and Rear Sight Assemblies					5/4/91	RW	
	M) Iron Sight Alignment					5/4/91	RW	
	N) Detach Front & Rear Sights & place in numbered container					5/4/91	RW	
	O) Attach Scope to Rifle					5/4/91	RW	
	P) Detach & Attach Scope 20 Times					5/4/91	RW	
640	Gallery Target & Test					5/4/91	KT	
	A) Time						KT	
	B) Malfunctions						KT	
	C) Pierced Primers						KT	
	D) Optical Clarity of Scope						KT	
645	Inspect for Live Ammo					5/4/91	KT	
655	Final Inspection							
	A) Headspace					5-21-91	D/H	
	B) Trigger Pull	2.34	2.31	2.43	2.51	2.55	5/9/91	QH
	C) Function						5-21-91	D/H
660	Pack					6-18-91	NF	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611473

DATE 5/3/97

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.43	2.40	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.39	2.38	2.31	
PULL #3	2.41	2.33	2.40	2.43	
PULL #4	2.41	2.38	2.41	2.51	
PULL #5	2.43	2.35	2.41	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.41		
PULL #2	3.51	3.25		
PULL #3	3.46	3.41		
PULL #4	3.29	3.41		
PULL #5	3.55	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	4.21	4.48		4.51
PULL #2	4.48	4.42		4.49
PULL #3	4.55	4.53		4.51
PULL #4	4.50	4.47		4.48
PULL #5	4.45	4.24		4.48
TOTAL				
AVG.				

Change
Stock

Re Target

Cracked Stock

TARGET

5-13-91

OK

DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611473
4 May 1991

CENTROIDAL DISTANCES

0 TO	1	.116914
1 TO	2	.545162
1 TO	3	.104216
1 TO	4	.208432
1 TO	5	.19906

$\frac{2}{5}$ <----FOR

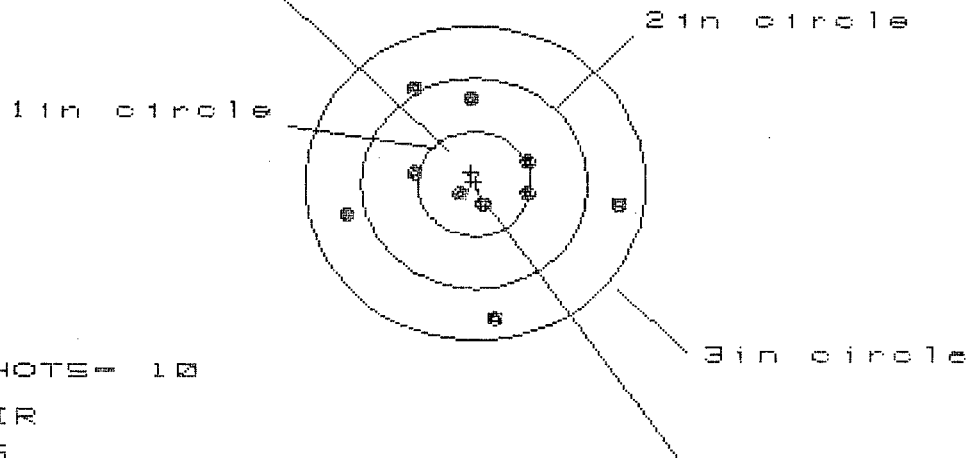
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0288
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0714605
THE AMR FOR THIS RIFLE IS: .963

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 5

2in = 6

3in = 10

HS = 2.462

VS = 2.175

GS = 2.465

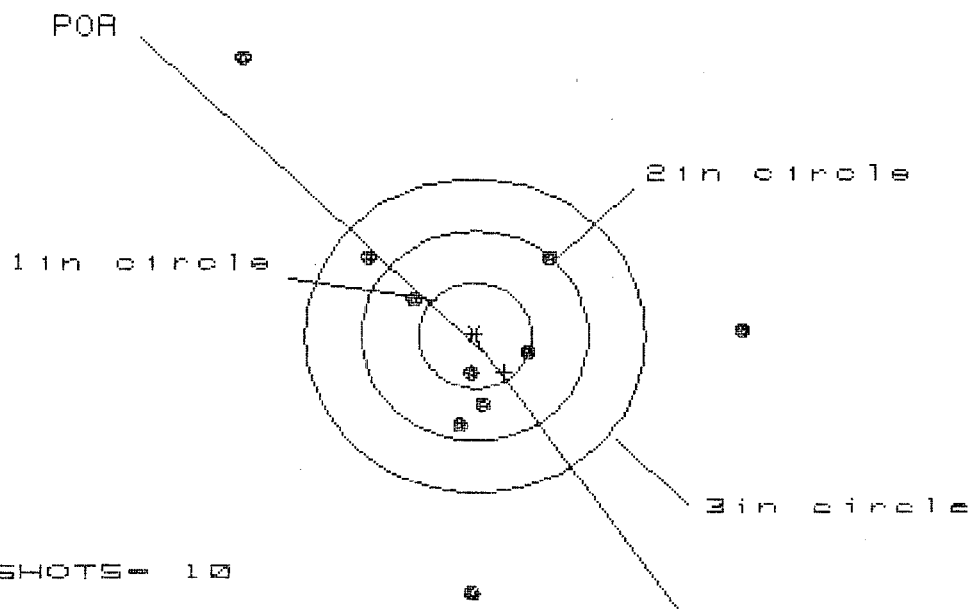
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.285	.569	.606
MINIMUM X	-1.177	-1.034	-.997
MAXIMUM Y	.921	.905	.746
MINIMUM Y	-1.254	-1.270	-.443
CENTROID X	.030	-.113	-.150
CENTROID Y	-.113	-.097	.062
POA TO CENTROID in.	.116	.149	.162
MIN RADIUS	.184	.119	.279
MEAN RADIUS	.748	.686	.616
MAX RADIUS	1.293	1.304	1.091
HORIZONTAL SPREAD	2.462	1.603	1.603
VERTICAL SPREAD	2.175	2.175	1.189
EXTREME SPREAD	2.465	2.286	1.666
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 4.389

VS= 5.159

GS= 5.522

CENTROID #

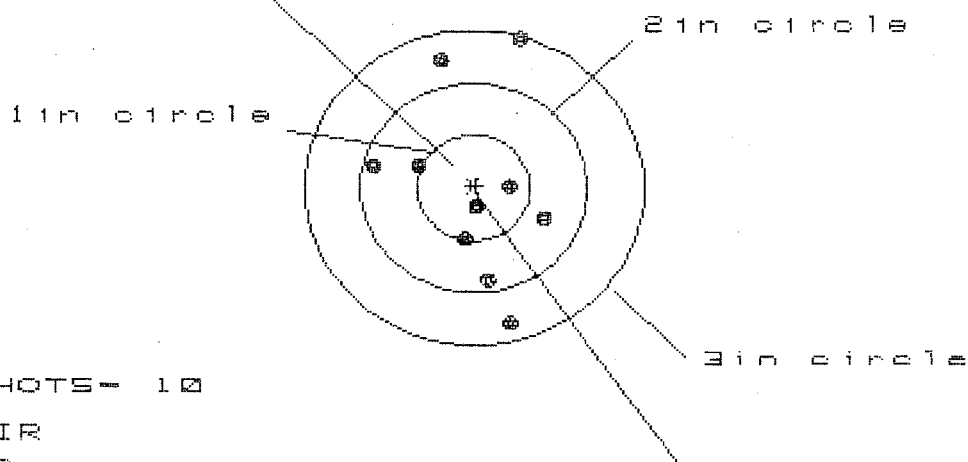
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.392	2.170	2.139
MINIMUM X	:	-1.997	-1.114	-1.145
MAXIMUM Y	:	2.666	1.066	.792
MINIMUM Y	:	-2.493	-2.197	-.855
CENTROID X	:	-.261	-.039	-.008
CENTROID Y	:	.348	.052	.326
POA TO CENTROID in.	:	.435	.065	.326
MIN RADIUS	:	.356	.241	.284
MEAN RADIUS	:	1.345	1.076	.946
MAX RADIUS	:	3.331	2.211	2.140
HORIZONTAL SPREAD	:	4.389	3.284	3.284
VERTICAL SPREAD	:	5.159	3.263	1.647
EXTREME SPREAD	:	5.522	3.516	3.361
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.523

VS= 2.664

GS= 2.665

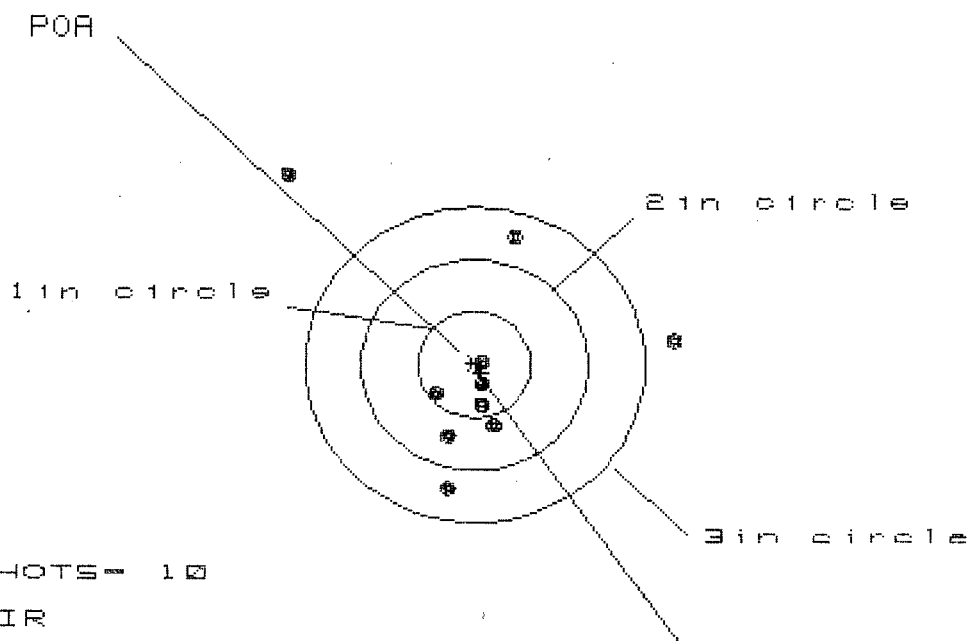
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.589	.636	.686
MINIMUM X	:	-.934	-.887	-.837
MAXIMUM Y	:	1.426	1.379	1.244
MINIMUM Y	:	-1.238	-1.079	-.814
CENTROID X	:	-.015	-.062	-.112
CENTROID Y	:	-.019	-.177	-.042
POA TO CENTROID in.	:	.024	.187	.120
MIN RADIUS	:	.228	.069	.212
MEAN RADIUS	:	.811	.699	.664
MAX RADIUS	:	1.486	1.401	1.260
HORIZONTAL SPREAD	:	1.523	1.523	1.523
VERTICAL SPREAD	:	2.664	2.458	2.058
EXTREME SPREAD	:	2.665	2.543	2.104
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS = 3.411

VS = 3.028

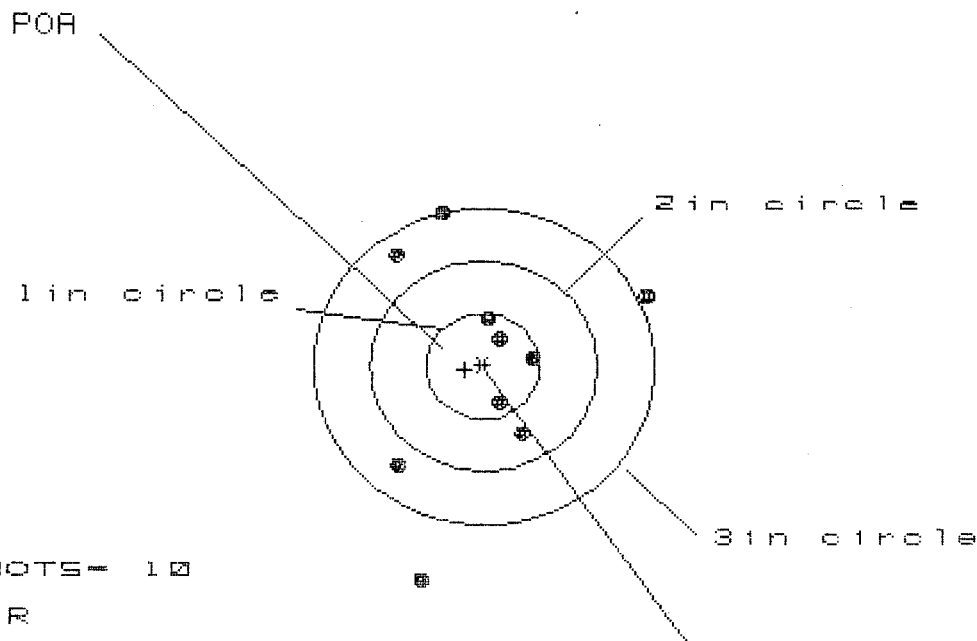
GS = 3.752

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.764	1.581	.355
MINIMUM X	-1.647	-.558	-.361
MAXIMUM Y	1.806	1.430	1.485
MINIMUM Y	-1.222	-1.021	-.966
CENTROID X	-.060	.123	-.074
CENTROID Y	.075	-.126	-.181
POA TO CENTROID in.	.096	.176	.196
MIN RADIUS	.033	.102	.105
MEAN RADIUS	.913	.703	.527
MAX RADIUS	2.445	1.642	1.527
HORIZONTAL SPREAD	3.411	2.139	.716
VERTICAL SPREAD	3.028	2.451	2.451
EXTREME SPREAD	3.752	2.513	2.513
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 2.192

VS = 3.473

GS = 3.482

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.389	1.325	.534
MINIMUM X	-.803	-.867	-.701
MAXIMUM Y	1.470	1.247	1.298
MINIMUM Y	-2.003	-1.118	-1.067
CENTROID X	.162	.226	.060
CENTROID Y	.036	.259	.208
POA TO CENTROID in.	.166	.344	.217
MIN RADIUS	.267	.086	.256
MEAN RADIUS	.998	.842	.801
MAX RADIUS	2.083	1.401	1.316
HORIZONTAL SPREAD	2.192	2.192	1.235
VERTICAL SPREAD	3.473	2.365	2.365
EXTREME SPREAD	3.482	2.652	2.410
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611473
13 May 1991

CENTROIDAL DISTANCES

0 TO	1	.202193
1 TO	2	.0742159
1 TO	3	.234917
1 TO	4	.338423
1 TO	5	.197314

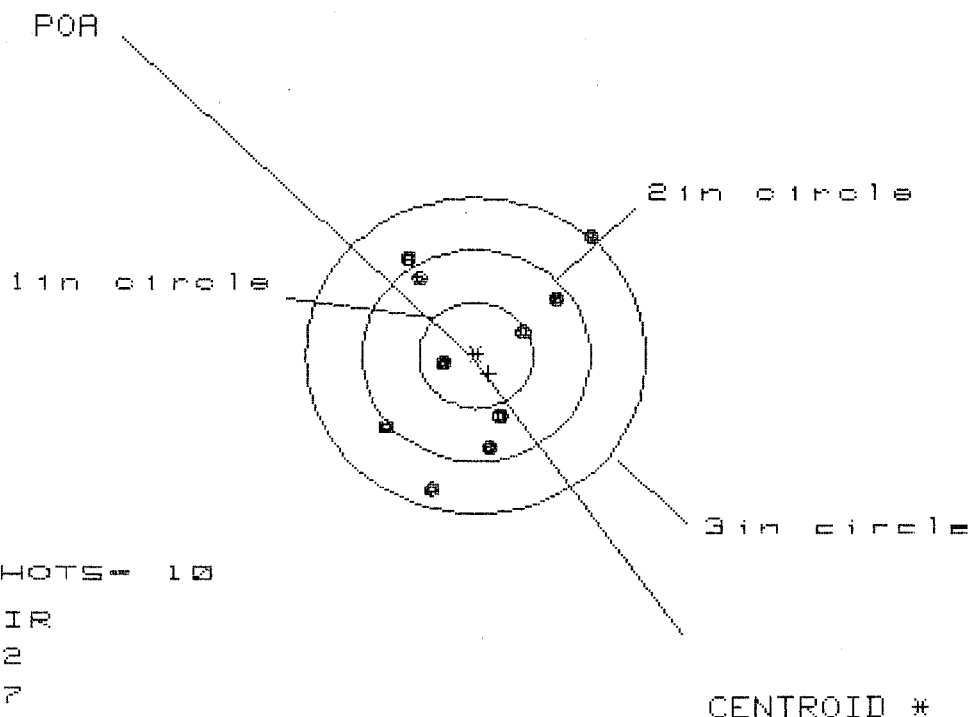
3.4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0926
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140751
THE AMR FOR THIS RIFLE IS: .8802

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611473.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.702

VS= 2.360

GS= 2.714

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	.858	.824
MINIMUM X	-.740	-.633	-.667
MAXIMUM Y	1.090	1.003	.860
MINIMUM Y	-1.270	-1.149	-.925
CENTROID X	-.111	-.218	-.184
CENTROID Y	.169	.048	.191
POA TO CENTROID in.	.202	.223	.265
MIN RADIUS	.276	.167	.215
MEAN RADIUS	.888	.809	.760
MAX RADIUS	1.454	1.181	1.011
HORIZONTAL SPREAD	1.702	1.491	1.491
VERTICAL SPREAD	2.360	2.152	1.785
EXTREME SPREAD	2.714	2.164	1.941
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611473.1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.684

VS= 2.105

GS= 2.742

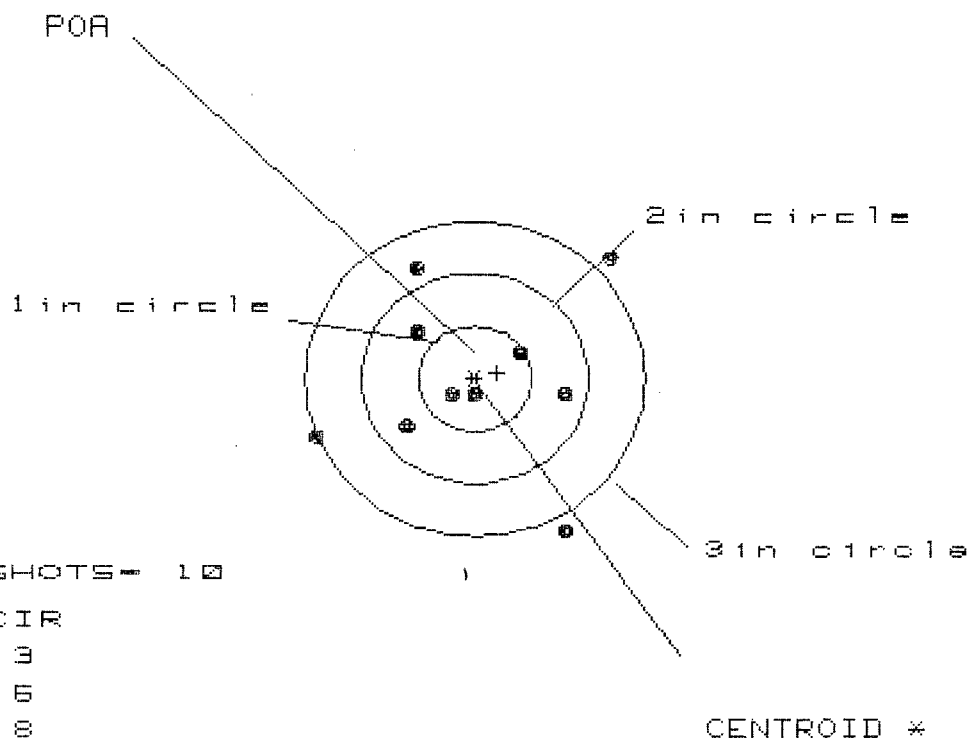
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.516	1.390
MINIMUM X	:	-1.294	-1.168	-.978
MAXIMUM Y	:	1.151	.722	.794
MINIMUM Y	:	-.954	-.826	-.753
CENTROID X	:	-.129	-.255	-.445
CENTROID Y	:	.241	.113	.041
POA TO CENTROID in.	:	.273	.279	.447
MIN RADIUS	:	.224	.072	.150
MEAN RADIUS	:	1.004	.902	.804
MAX RADIUS	:	1.617	1.624	1.405
HORIZONTAL SPREAD	:	2.684	2.684	2.368
VERTICAL SPREAD	:	2.105	1.548	1.548
EXTREME SPREAD	:	2.742	2.742	2.387
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.576

VS= 2.597

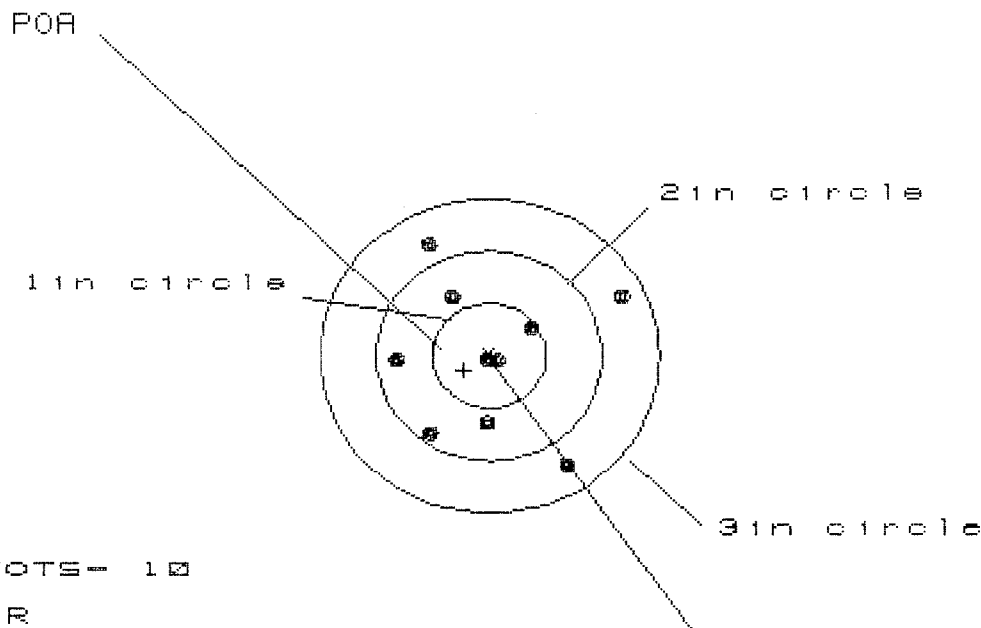
GS= 3.123

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	.937	1.052
MINIMUM X	:	-1.372	-1.238	-1.123
MAXIMUM Y	:	1.175	1.135	.973
MINIMUM Y	:	-1.422	-1.291	-.621
CENTROID X	:	-.196	-.330	-.446
CENTROID Y	:	-.050	-.181	-.019
POA TO CENTROID in.	:	.202	.376	.446
MIN RADIUS	:	.193	.088	.163
MEAN RADIUS	:	.907	.801	.701
MAX RADIUS	:	1.682	1.590	1.283
HORIZONTAL SPREAD	:	2.576	2.175	2.175
VERTICAL SPREAD	:	2.597	2.426	1.594
EXTREME SPREAD	:	3.123	2.743	2.215
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611473.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.029

VS= 2.114

GS= 2.428

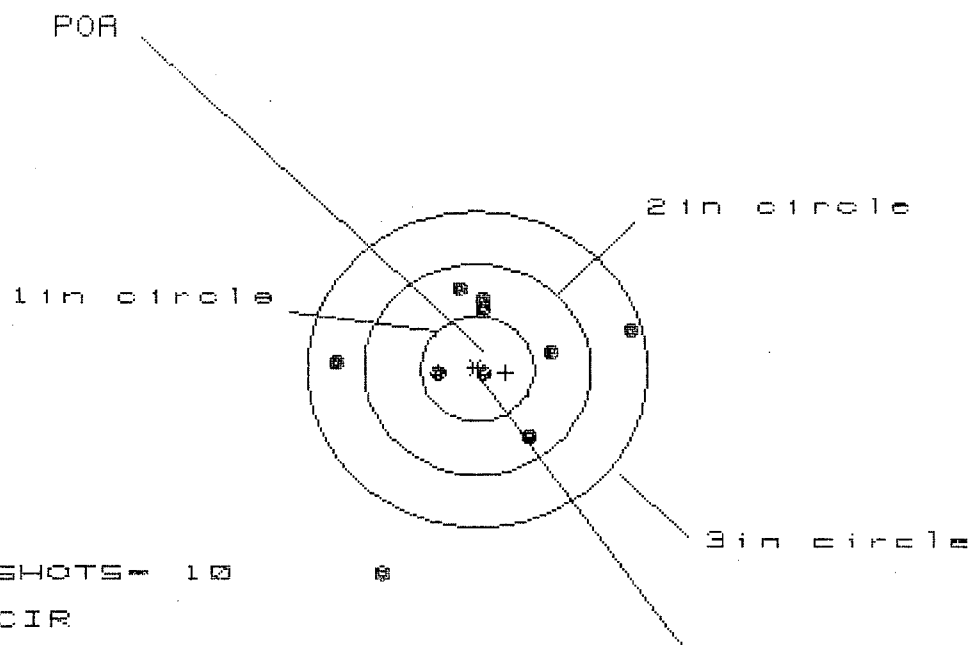
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	.785	.734
MINIMUM X	:	-.831	-.698	-.749
MAXIMUM Y	:	1.089	1.154	.731
MINIMUM Y	:	-1.025	-.960	-.816
CENTROID X	:	.226	.093	.144
CENTROID Y	:	.138	.073	-.072
POA TO CENTROID in.	:	.264	.118	.161
MIN RADIUS	:	.026	.131	.199
MEAN RADIUS	:	.735	.679	.610
MAX RADIUS	:	1.334	1.240	1.097
HORIZONTAL SPREAD	:	2.029	1.483	1.483
VERTICAL SPREAD	:	2.114	2.114	1.546
EXTREME SPREAD	:	2.428	2.428	1.839
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611473.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.604

VS = 2.693

GS = 3.183

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.356	1.258	.754
MINIMUM X	-1.248	-1.346	-1.188
MAXIMUM Y	.788	.576	.594
MINIMUM Y	-1.905	-.865	-.847
CENTROID X	-.253	-.155	-.313
CENTROID Y	.032	.244	.226
POA TO CENTROID in.	.255	.289	.386
MIN RADIUS	.067	.241	.251
MEAN RADIUS	.867	.703	.625
MAX RADIUS	2.100	1.353	1.194
HORIZONTAL SPREAD	2.604	2.604	1.942
VERTICAL SPREAD	2.693	1.441	1.441
EXTREME SPREAD	3.183	2.619	1.943
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		