

C6611508

MODEL 700™ M24

Model **SMS**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

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

MODEL 700TM H24

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

SERIAL NO.
C6611508

ORDER NO.
5716

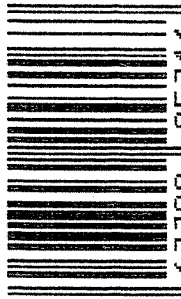
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611508

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611508**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes	ADD	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/19/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	KS
	C) Inspect Ejector Hole for Chamfer		5/1/91	KS
	D) Oil Firing Pin Ass'y		5/1/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-15-91	JK

op. #	BARBER - M24 0077973	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-15-91	JH
	G) Safety Off Force	4	4	4			5-15-91	JH
	H) Trigger Pull Test & Retainability						5/15-91	JH
	I) Firing Pin Indent	.0215	.021	.021			5-15-91	JH
	J) Assemble Stock						5/14/91	KS
	K) Assemble Swivel Studs						5-20-91	AC
	L) Attach Front and Rear Sight Assemblies						5/16/91	KS
	M) Iron Sight Alignment						5/16/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/16/91	KS
	O) Attach Scope to Rifle						5/16/91	KS
	P) Detach & Attach Scope 20 Times						5/16/91	KS
640	Gallery Target & Test						5-18-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-18-91	NF
655	Final Inspection							
	A) Headspace						5-20-91	AC
	B) Trigger Pull	2.53	2.40	2.47	2.51	2.56	5/20/91	JH
	C) Function						5-20-91	AC
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611508DATE 5-15-91TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.40	2.42	2.53	MIN. SETTING,
PULL #2	2.25	2.41	2.38	2.40	NO AVG. OF 5
PULL #3	2.40	2.44	2.40	2.47	READINGS ACCEPT-
PULL #4	2.38	2.44	2.43	2.51	ABLE LESS THAN 2#
PULL #5	2.43	2.42	2.40	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.22	3.54			
PULL #2	3.23	3.55			
PULL #3	3.27	3.53			
PULL #4	3.50	3.56			
PULL #5	3.57	3.58			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO (4#) FOR TARGET & ACCURACY
PULL #1	4.46	4.52		4.48
PULL #2	4.38	4.50		4.53
PULL #3	4.55	4.51		4.50
PULL #4	4.50	4.52		4.50
PULL #5	4.51	4.50		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611508
18 May 1991

CENTROIDAL DISTANCES

0 TO	1	.958818
1 TO	2	1.12857
1 TO	3	1.00676
1 TO	4	.927863
1 TO	5	1.53868

5
(----POB
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0389
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .045705
THE AMR FOR THIS RIFLE IS: .9376

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811508

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 8

HS = 2.885

VS = 2.814

GS = 3.132

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.039	.834	.713
MINIMUM X	-1.845	-.970	-.682
MAXIMUM Y	1.379	1.321	1.190
MINIMUM Y	-1.435	-1.493	-1.328
CENTROID X	-.096	.109	.230
CENTROID Y	-.954	-.896	-1.061
POA TO CENTROID in.	.959	.903	1.086
MIN RADIUS	.487	.275	.300
MEAN RADIUS	1.172	1.046	.935
MAX RADIUS	1.917	1.639	1.376
HORIZONTAL SPREAD	2.885	1.804	1.595
VERTICAL SPREAD	2.814	2.814	2.518
EXTREME SPREAD	3.132	3.016	2.557
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =			8

16 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811586

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.712

VS= 2.246

GS= 2.273

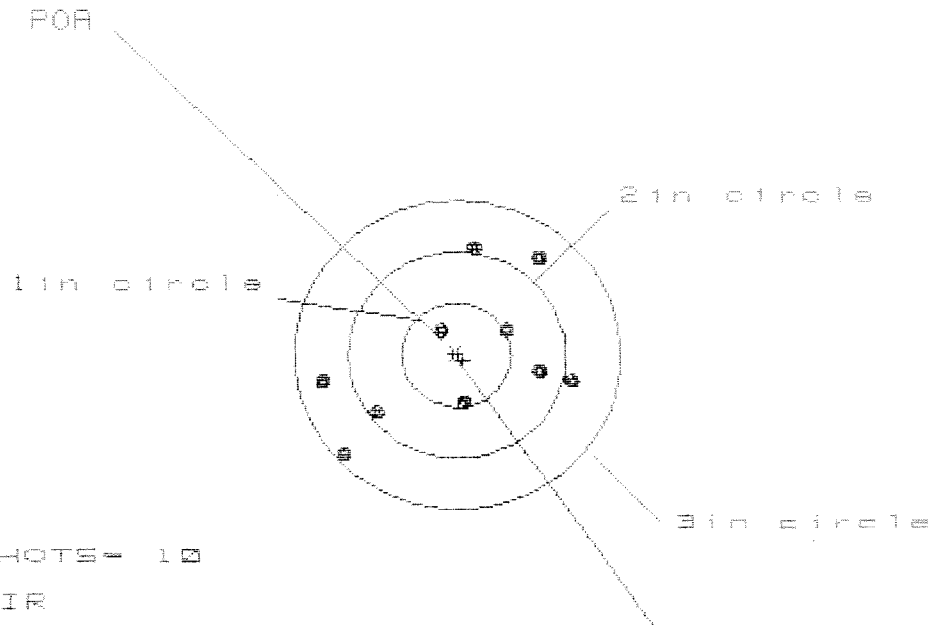
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.585	.551	.418
MINIMUM X	-1.127	-1.062	-.616
MAXIMUM Y	.975	.834	.721
MINIMUM Y	-1.271	-1.054	-1.167
CENTROID X	.016	-.049	.084
CENTROID Y	.169	.310	.423
POA TO CENTROID in.	.170	.314	.432
MIN RADIUS	.088	.129	.169
MEAN RADIUS	.781	.685	.583
MAX RADIUS	1.399	1.396	1.182
HORIZONTAL SPREAD	1.712	1.613	1.034
VERTICAL SPREAD	2.246	1.888	1.888
EXTREME SPREAD	2.273	2.273	1.890
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611588

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.236

VS = 1.976

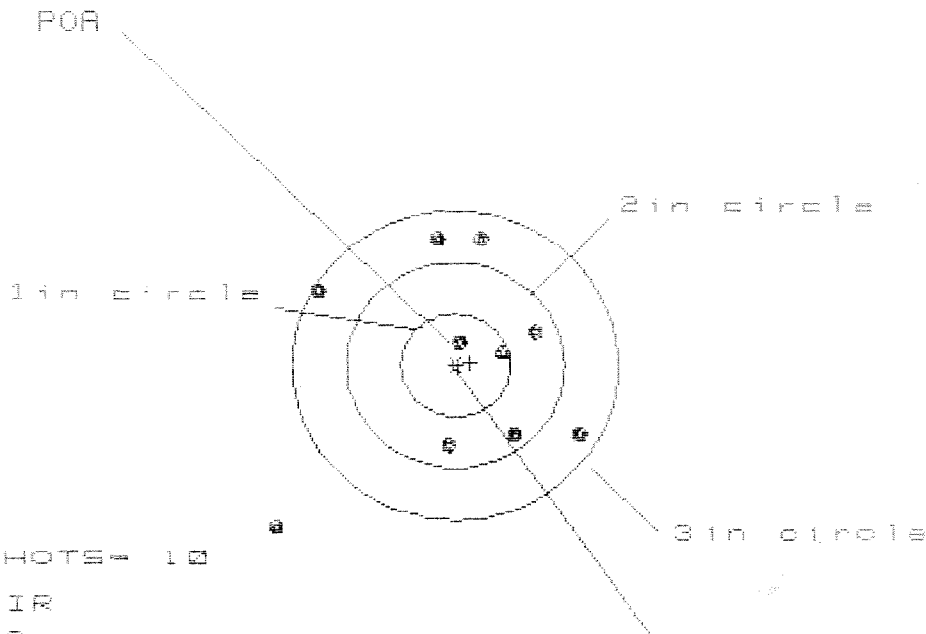
CS = 2.679

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	.893	.073
MINIMUM X	-1.222	-1.343	-1.263
MAXIMUM Y	1.019	.912	1.022
MINIMUM Y	-.957	-.671	-.561
CENTROID X	-.057	.064	-.016
CENTROID Y	.052	.159	.049
POA TO CENTROID in.	.077	.171	.051
MIN RADIUS	.324	.341	.351
MEAN RADIUS	.911	.831	.799
MAX RADIUS	1.447	1.380	1.280
HORIZONTAL SPREAD	2.236	2.236	2.236
VERTICAL SPREAD	1.976	1.583	1.583
EXTREME SPREAD	2.679	2.315	2.236
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.805

VS = 2.859

GS = 3.417

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.120	.933	.754
MINIMUM X	-1.684	-1.431	-.535
MAXIMUM Y	1.241	1.061	1.129
MINIMUM Y	-1.618	-.938	-.870
CENTROID X	-.136	.051	.230
CENTROID Y	-.027	.153	.085
POA TO CENTROID in.	.139	.161	.245
MIN RADIUS	.235	.121	.048
MEAN RADIUS	1.076	.876	.764
MAX RADIUS	2.336	1.531	1.247
HORIZONTAL SPREAD	2.805	2.364	1.290
VERTICAL SPREAD	2.859	1.999	1.999
EXTREME SPREAD	3.417	2.771	2.345
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611508

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS = 2.541

VS = 2.111

GS = 2.879

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.595	.820	.724
MINIMUM X	-.946	-.769	-.387
MAXIMUM Y	1.247	.699	.741
MINIMUM Y	-.864	-.726	-.684
CENTROID X	.143	-.034	.062
CENTROID Y	.566	.428	.386
POA TO CENTROID in.	.584	.429	.391
MIN RADIUS	.150	.080	.118
MEAN RADIUS	.748	.542	.502
MAX RADIUS	2.024	1.078	1.036
HORIZONTAL SPREAD	2.541	1.589	1.111
VERTICAL SPREAD	2.111	1.425	1.425
EXTREME SPREAD	2.879	1.734	1.734
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	9	