

C6611515

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6611515

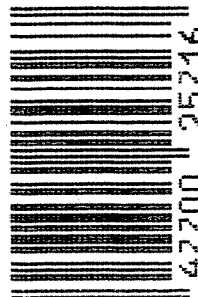
ORDER NO.
5715

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



5715 C6611515

UPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611515

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		4	KR
615	Rollmark Caliber		3/27/91	SL
617	Drill and Tap Sight Holes	APR	3 1991	EB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		3/27/91	SL
	Apply Coating (Bolt)			SL
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		5/2/91	SL

op. #	NAME BARBER M24 0078084	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-9-91	K
	G) Safety Off Force	4	4	4			5-9-91	K
	H) Trigger Pull Test & Retainability						5-9-91	DH
	I) Firing Pin Indent	.022	.023	.023			5-9-91	AC
	J) Assemble Stock						5/9/91	ICS
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/9/91	ICS
	M) Iron Sight Alignment						5/9/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	KS
	O) Attach Scope to Rifle						5/9/91	KS
	P) Detach & Attach Scope 20 Times						5/9/91	KS
640	Gallery Target & Test						5/13/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/13/91	KT
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.26	2.20	2.26	2.24	2.19	5/20/91	JP
	C) Function						5-21-91	DH
660	Pack						6-10-91	NF

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

SERIAL NO. C0011515DATE 5-9-91TESTER P.H.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.68	2.77	2.26	MIN. SETTING
PULL #2	2.67	2.59	2.77	2.20	NO AVG. OF 5
PULL #3	2.57	3.02	2.86	2.26	READINGS ACCEPT-
PULL #4	2.77	2.83	2.86	2.24	ABLE LESS THAN 2#
PULL #5	2.70	3.00	2.88	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.33	3.06			
PULL #2	3.32	3.07			
PULL #3	3.19	3.22			
PULL #4	3.03	3.05			
PULL #5	3.31	3.24			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.00		4.58
PULL #2	3.99	4.03		4.60
PULL #3	3.96	4.22		4.60
PULL #4	4.33	4.40		4.61
PULL #5	4.24	4.01		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611515
13 May 1991

CENTROIDAL DISTANCES

0 TO	1	.112894
1 TO	2	.221508
1 TO	3	.344397
1 TO	4	1.3041
1 TO	5	.353362

4
15 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2448
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .141
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.000
THE AMR FOR THIS RIFLE IS: 1.127

13 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11515

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.362

VS= 1.089

GS= 2.416

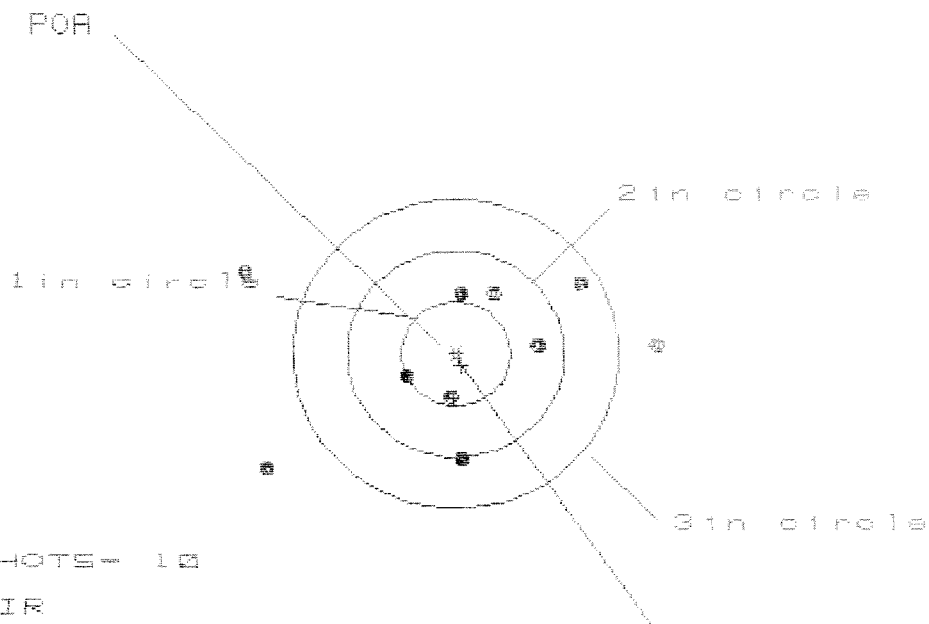
CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.126	1.017
MINIMUM X	:	-1.020	-.871	-.909
MAXIMUM Y	:	.688	.722	.700
MINIMUM Y	:	-.401	-.367	-.389
CENTROID X	:	-.036	-.185	-.076
CENTROID Y	:	-.107	-.141	-.119
POA TO CENTROID in.	:	.113	.232	.141
MIN RADIUS	:	.205	.102	.171
MEAN RADIUS	:	.729	.640	.606
MAX RADIUS	:	1.375	1.133	1.028
HORIZONTAL SPREAD	:	2.362	1.997	1.926
VERTICAL SPREAD	:	1.089	1.089	1.089
EXTREME SPREAD	:	2.416	1.997	1.931
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611515

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.815

VS= 1.818

GS= 3.873

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.829	1.689	1.366
MINIMUM X	-1.986	-1.943	-.951
MAXIMUM Y	.743	.727	.603
MINIMUM Y	-1.075	-.993	-1.049
CENTROID X	-.051	.169	.412
CENTROID Y	.114	.032	.156
POA TO CENTROID in.	.125	.172	.441
MIN RADIUS	.409	.425	.316
MEAN RADIUS	1.134	1.005	.833
MAX RADIUS	2.120	2.182	1.366
HORIZONTAL SPREAD	3.815	3.552	2.317
VERTICAL SPREAD	1.818	1.720	1.652
EXTREME SPREAD	3.873	3.733	2.337
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811515

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.706

VS = 2.201

GS = 2.715

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.298
MINIMUM X	-1.408
MAXIMUM Y	.999
MINIMUM Y	-1.202
CENTROID X	.069
CENTROID Y	.221
POA TO CENTROID in.	.231
MIN RADIUS	.149
MEAN RADIUS	.940
MAX RADIUS	1.410
HORIZONTAL SPREAD	2.706
VERTICAL SPREAD	2.201
EXTREME SPREAD	2.715
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11515

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 1

3 in = 7

HS= 3.193

VS= 2.905

GS= 3.194

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.874	1.728	1.700
MINIMUM X	:	-1.319	-1.111	-1.139
MAXIMUM Y	:	1.695	1.649	1.513
MINIMUM Y	:	-1.210	-1.256	-1.050
CENTROID X	:	.959	.751	.780
CENTROID Y	:	.736	.782	.576
POA TO CENTROID in.	:	1.209	1.054	.969
MIN RADIUS	:	.721	.901	.763
MEAN RADIUS	:	1.376	1.303	1.230
MAX RADIUS	:	1.919	1.750	1.701
HORIZONTAL SPREAD	:	3.193	2.839	2.839
VERTICAL SPREAD	:	2.905	2.905	2.563
EXTREME SPREAD	:	3.194	2.934	2.653
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		7	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611515

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 5

HS = 3.334

VS = 5.260

GS = 5.296

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	1.044	.758
MINIMUM X	-2.285	-2.290	-.971
MAXIMUM Y	1.729	1.337	1.196
MINIMUM Y	-3.531	-1.128	-1.069
CENTROID X	.283	.288	.574
CENTROID Y	-.258	.133	.274
POA TO CENTROID in.	.384	.317	.636
MIN RADIUS	.328	.344	.396
MEAN RADIUS	1.456	1.175	.900
MAX RADIUS	3.531	2.553	1.445
HORIZONTAL SPREAD	3.334	3.334	1.729
VERTICAL SPREAD	5.260	2.465	2.265
EXTREME SPREAD	5.296	4.024	2.684
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	5		