

C6611517

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

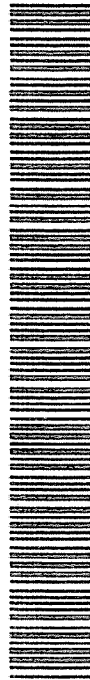
Capacity

Order No. **5716**

*Includes 1 in chamber.

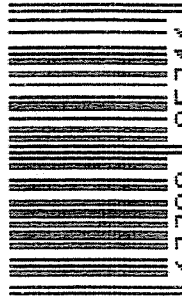
Remington

Remington REG. U.S. PAT. & TM. OFF. 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6611517
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611517

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611517

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		11	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	KS
	C) Inspect Ejector Hole for Chamfer		4/30/91	KS
	D) Oil Firing Pin Ass'y		4/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	961

op. #	BARBER NAME M24 0078122	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/4/91	JK
	G) Safety Off Force	4	4	4			5/4/91	JK
	H) Trigger Pull Test & Retainability						5/4/91	JK
	I) Firing Pin Indent	.022	.022	.022			5/4/91	JK
	J) Assemble Stock						5/4/91	K-S
	K) Assemble Swivel Studs						5-10-91	AC
	L) Attach Front and Rear Sight Assemblies						5/4/91	K-S
	M) Iron Sight Alignment						5/4/91	K-S
	N) Detach Front & Rear Sights & place in numbered container						5/4/91	K-S
	O) Attach Scope to Rifle						5/4/91	K-S
	P) Detach & Attach Scope 20 Times						5/4/91	K-S
640	Gallery Target & Test						5/4/91	Kf
	A) Time							Kf
	B) Malfunctions							Kf
	C) Pierced Primers							Kf
	D) Optical Clarity of Scope							Kf
645	Inspect for Live Ammo						5/4/91	Kf
655	Final Inspection							
	A) Headspace						5-10-91	K
	B) Trigger Pull	2.18	2.16	2.17	2.18	2.19	5/10/91	JK
	C) Function						5-10-91	K
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611617DATE 5/3/91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.33	2.48	2.18	MIN. SETTING, NO. AVG. OF 5 READINGS, ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.55	2.45	2.16	
PULL #3	2.41	2.54	2.40	2.17	
PULL #4	2.49	2.49	2.57	2.18	
PULL #5	2.41	2.54	2.49	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.28		
PULL #2	3.36	3.34		
PULL #3	3.34	3.20		
PULL #4	3.26	3.25		
PULL #5	3.25	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	4.26	4.19		4.22
PULL #2	4.37	4.35		4.31
PULL #3	4.24	4.29		4.33
PULL #4	4.35	4.24		4.30
PULL #5	4.28	4.28		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611517
4 May 1991

CENTROIDAL DISTANCES

0 TO	1	.1
1 TO	2	.211116
1 TO	3	.268198
1 TO	4	.281261
1 TO	5	.154729

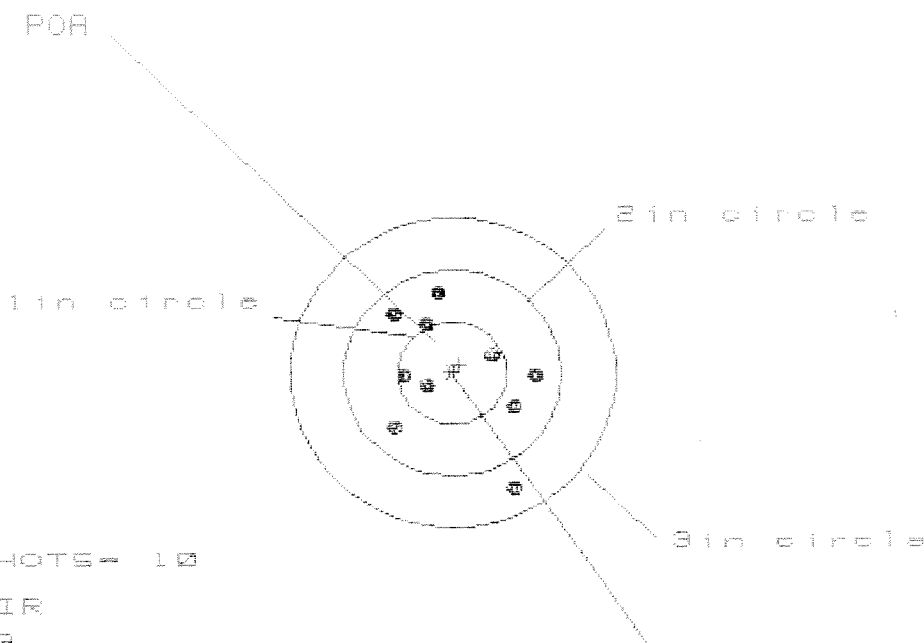
574 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .04
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0006
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0430
THE AMR FOR THIS RIFLE IS: .9038

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611517

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.281

VS = 1.964

GS = 2.063

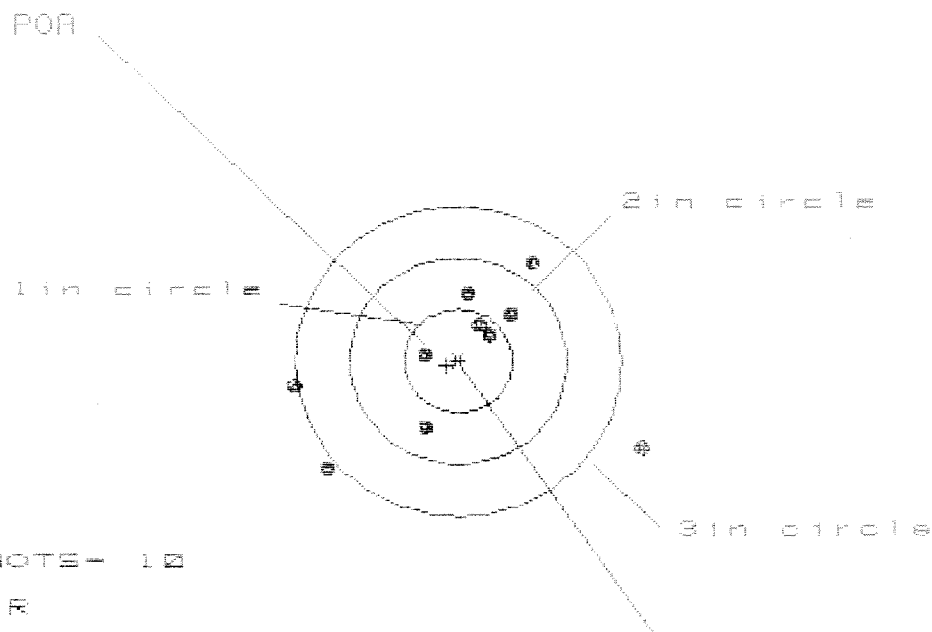
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.722	.779	.772
MINIMUM X	-.559	-.502	-.509
MAXIMUM Y	.809	.680	.528
MINIMUM Y	-1.155	-.659	-.574
CENTROID X	-.080	-.117	-.110
CENTROID Y	-.080	.049	-.036
POA TO CENTROID in.	.100	.127	.115
MIN RADIUS	.241	.263	.213
MEAN RADIUS	.662	.579	.561
MAX RADIUS	1.284	.806	.773
HORIZONTAL SPREAD	1.281	1.281	1.281
VERTICAL SPREAD	1.964	1.339	1.102
EXTREME SPREAD	2.063	1.408	1.408
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.145

VS = 2.013

GS = 3.205

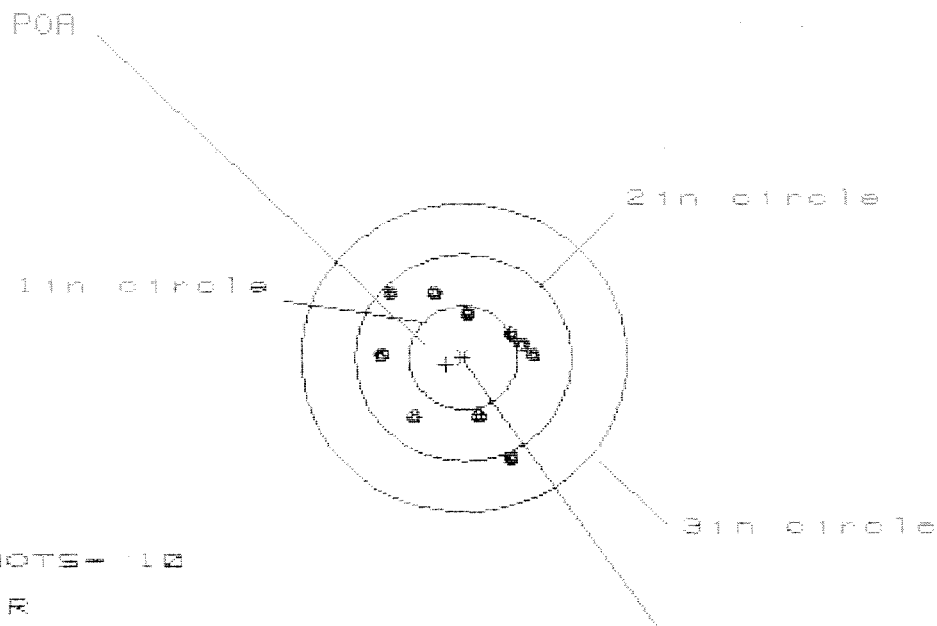
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.680	.920	.789
MINIMUM X	-1.465	-1.278	-1.409
MAXIMUM Y	.947	.852	.707
MINIMUM Y	-1.066	-1.161	-.897
CENTROID X	.113	-.074	.056
CENTROID Y	.041	.136	.281
POR TO CENTROID in.	.120	.155	.287
MIN RADIUS	.363	.179	.248
MEAN RADIUS	.948	.828	.698
MAX RADIUS	1.883	1.562	1.406
HORIZONTAL SPREAD	3.145	2.198	2.198
VERTICAL SPREAD	2.013	2.013	1.604
EXTREME SPREAD	3.205	2.814	2.495
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.363

VS = 1.632

GS = 1.927

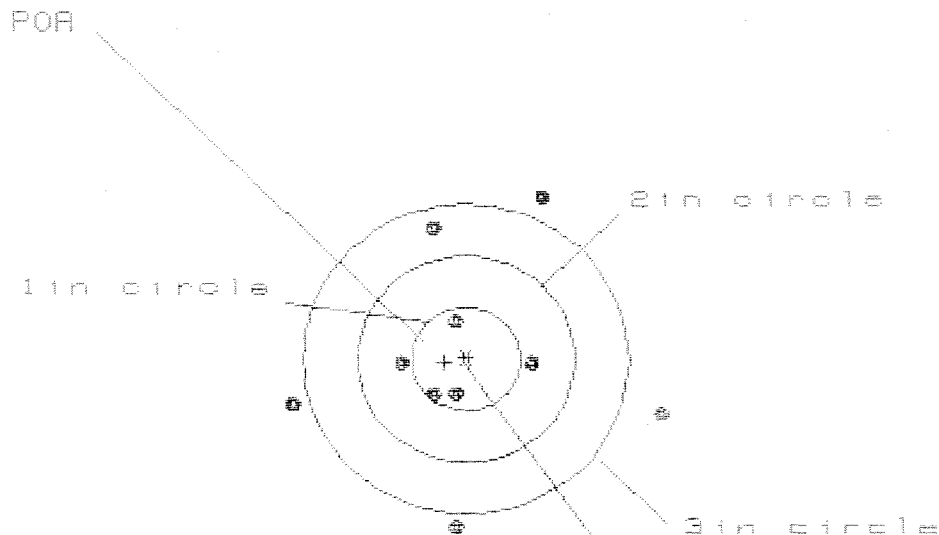
CENTROID #

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.593	.637	.563
MINIMUM X	-.770	-.726	-.800
MAXIMUM Y	.670	.563	.611
MINIMUM Y	-.962	-.701	-.631
CENTROID X	.163	.119	.193
CENTROID Y	.069	.176	.106
POA TO CENTROID in.	.177	.213	.220
MIN RADIUS	.412	.320	.372
MEAN RADIUS	.676	.626	.592
MAX RADIUS	1.039	.836	.823
HORIZONTAL SPREAD	1.363	1.363	1.363
VERTICAL SPREAD	1.632	1.264	1.242
EXTREME SPREAD	1.927	1.434	1.364
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 6

HS = 3.419

VS = 3.190

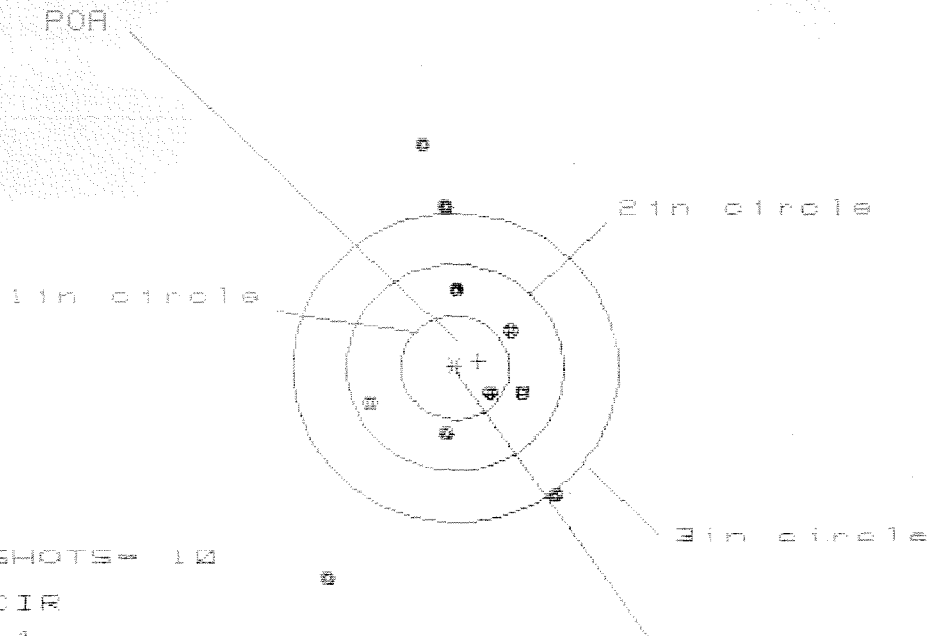
GS = 3.421

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.817
MINIMUM X	-1.602
MAXIMUM Y	1.598
MINIMUM Y	-1.592
CENTROID X	.198
CENTROID Y	.032
POA TO CENTROID in.	.201
MIN RADIUS	.339
MEAN RADIUS	1.060
MAX RADIUS	1.900
HORIZONTAL SPREAD	3.419
VERTICAL SPREAD	3.190
EXTREME SPREAD	3.421
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	6

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 6

HS= 2.087

VS= 4.183

CS= 4.274

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.933
MINIMUM X	-1.154
MAXIMUM Y	2.156
MINIMUM Y	-2.027
CENTROID X	-.214
CENTROID Y	-.065
POA TO CENTROID in.	.224
MIN RADIUS	.428
MEAN RADIUS	1.173
MAX RADIUS	2.333
HORIZONTAL SPREAD	2.087
VERTICAL SPREAD	4.183
EXTREME SPREAD	4.274
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 6
NUMBER IN THREE INCH CIRCLE	= 6