

C6611537

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.
C6611537

ORDER NO.
5716

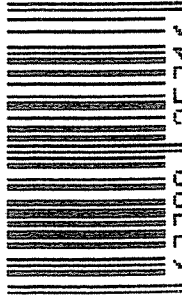
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MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611537

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611537

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	U
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	TA
	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		5-13-91	JS

op. #	BARBER - M24 0078434 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			5-13-91	DH
	G) Safety Off Force	3	3	3			5-13-91	DH
	H) Trigger Pull Test & Retainability						5/13/91	ff
	I) Firing Pin Indent	.021	.021	.021			5-13-91	✓
	J) Assemble Stock						5/13/91	RW
	K) Assemble Swivel Studs						5-20-91	DH
	L) Attach Front and Rear Sight Assemblies						5/13/91	RW
	M) Iron Sight Alignment						5/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/13/91	RW
	O) Attach Scope to Rifle						5/13/91	RW
	P) Detach & Attach Scope 20 Times						5/13/91	RW
640	Gallery Target & Test						5-14-91	AC
	A) Time						5-14-91	AC
	B) Malfunctions						5-14-91	AC
	C) Pierced Primers						5-14-91	AC
	D) Optical Clarity of Scope						5-14-91	AC
645	Inspect for Live Ammo						5-14-91	AC
655	Final Inspection							
	A) Headspace						5-20-91	DH
	B) Trigger Pull	2.23	2.51	2.25	2.33	2.30	5/20/91	ff
	C) Function						5-20-91	DH
660	Pack						6-14-91	NF

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

SERIAL NO. C-6611537DATE 5-13-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.27	2.25	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.28	2.22	2.51	
PULL #3	2.35	2.16	2.20	2.25	
PULL #4	2.36	2.29	2.31	2.33	
PULL #5	2.35	2.18	2.22	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.39	3.28		
PULL #3	3.41	3.21		
PULL #4	3.31	3.32		
PULL #5	3.40	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.33		4.17
PULL #2	4.41	4.27		4.33
PULL #3	4.38	4.20		4.30
PULL #4	4.39	4.30		4.28
PULL #5	4.36	4.33		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611537
14 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0726911
1 TO	2	.1111198
1 TO	3	.567325
1 TO	4	.262488
1 TO	5	.292957

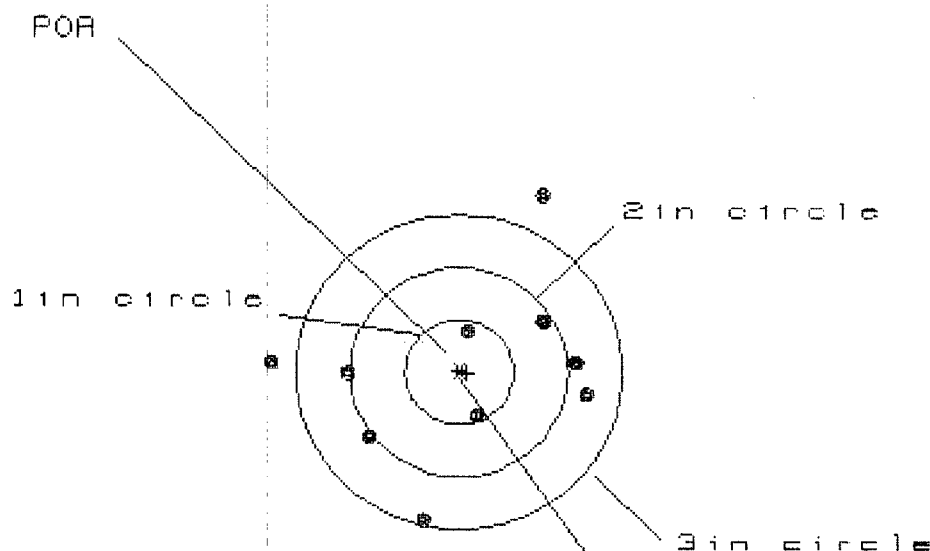
54³ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0278
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0632
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .069044
THE AMR FOR THIS RIFLE IS: .927

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11537

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.924

VS= 3.099

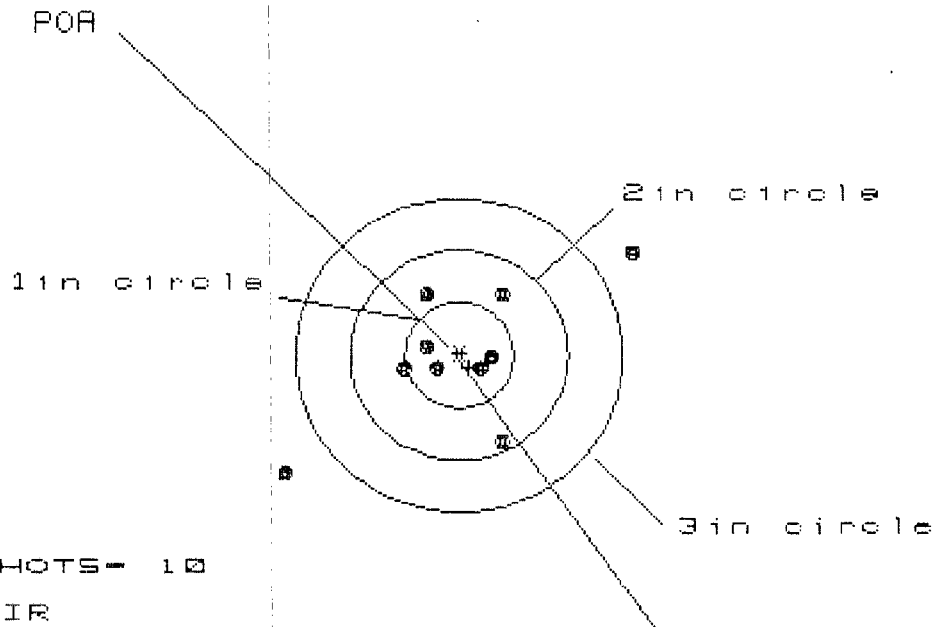
GS= 3.269

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.195	1.278	1.072
MINIMUM X	-1.729	-1.646	-1.199
MAXIMUM Y	1.675	.642	.671
MINIMUM Y	-1.424	-1.238	-1.209
CENTROID X	-.072	-.155	.051
CENTROID Y	.010	-.176	-.205
POA TO CENTROID in.	.072	.234	.211
MIN RADIUS	.400	.328	.214
MEAN RADIUS	1.115	1.027	.919
MAX RADIUS	1.834	1.663	1.278
HORIZONTAL SPREAD	2.924	2.924	2.271
VERTICAL SPREAD	3.099	1.880	1.880
EXTREME SPREAD	3.269	2.938	2.281
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

14 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 8

HS= 3.218

VS= 2.131

GS= 3.860

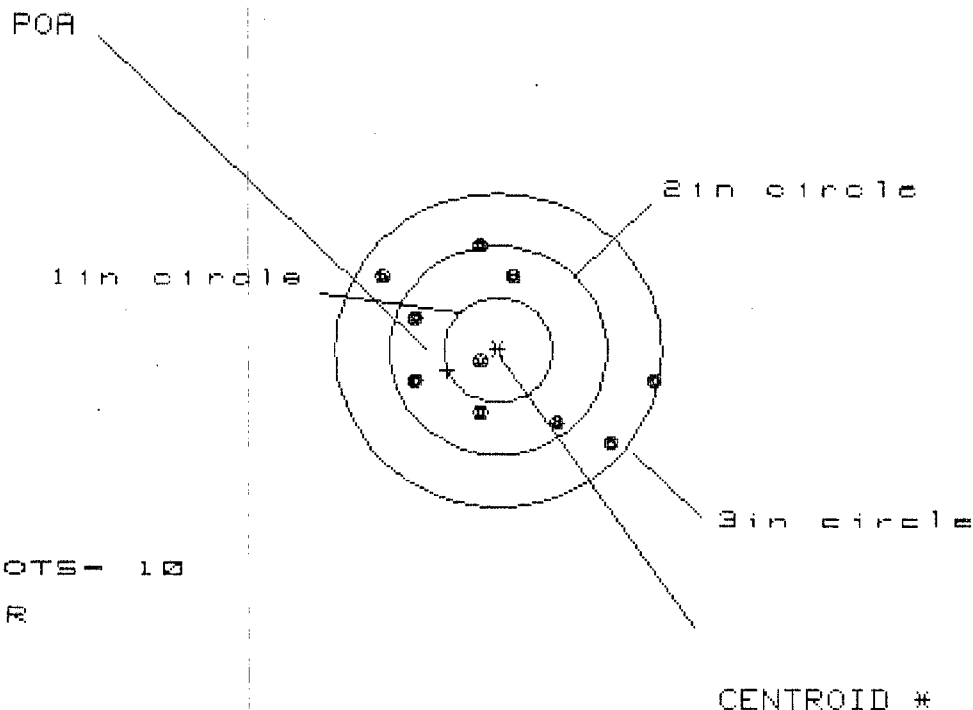
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.430	.407
MINIMUM X	:	-1.609	-.644	-.465
MAXIMUM Y	:	1.028	.906	.616
MINIMUM Y	:	-1.103	-.973	-.860
CENTROID X	:	-.094	.085	-.094
CENTROID Y	:	.119	.241	.128
POA TO CENTROID in.	:	.151	.256	.159
MIN RADIUS	:	.186	.214	.190
MEAN RADIUS	:	.777	.666	.489
MAX RADIUS	:	1.950	1.693	.930
HORIZONTAL SPREAD	:	3.218	2.074	.872
VERTICAL SPREAD	:	2.131	1.879	1.476
EXTREME SPREAD	:	3.860	2.368	1.581
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611537

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.547

VS= 1.904

GS= 2.706

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.464	1.182	.828
MINIMUM X	-1.083	-.921	-.773
MAXIMUM Y	1.048	1.021	.910
MINIMUM Y	-.856	-.883	-.783
CENTROID X	.465	.303	.155
CENTROID Y	.193	.220	.331
POA TO CENTROID in.	.504	.374	.365
MIN RADIUS	.210	.100	.232
MEAN RADIUS	.914	.818	.723
MAX RADIUS	1.485	1.476	1.140
HORIZONTAL SPREAD	2.547	2.103	1.601
VERTICAL SPREAD	1.904	1.904	1.693
EXTREME SPREAD	2.706	2.596	2.069
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

14 May 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.187

VS= 2.316

GS= 2.527

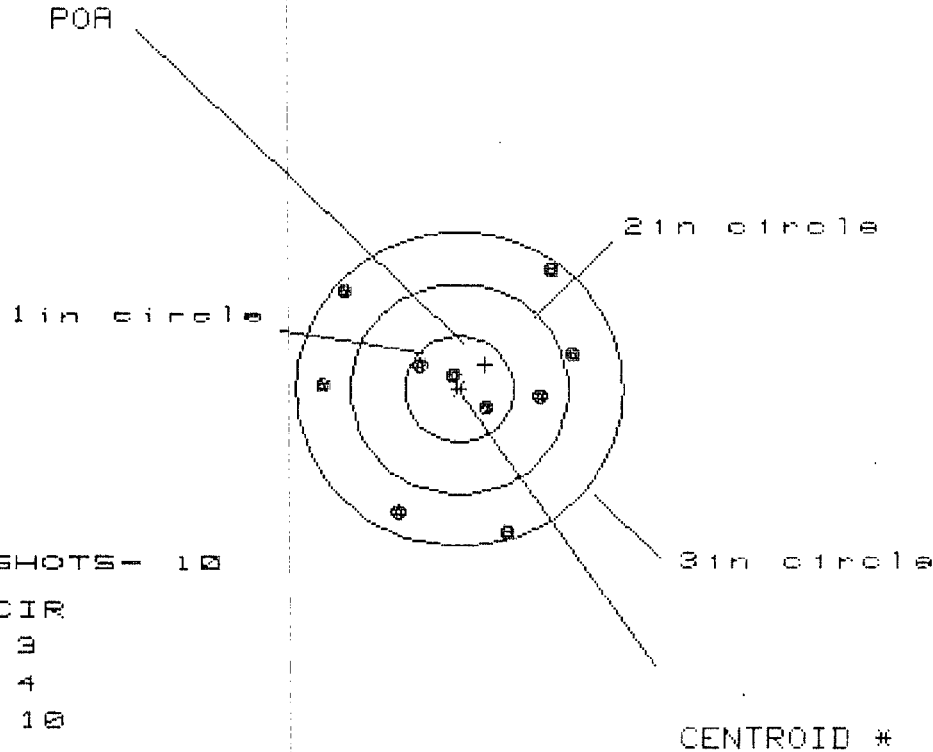
CENTROID *

PATTERN #	1	4	9	8
SHOTS (BEST OF)	10			
MAXIMUM X	1.089	.564	.589	
MINIMUM X	-1.098	-.977	-.952	
MAXIMUM Y	1.286	1.171	.968	
MINIMUM Y	-1.030	-.918	-.771	
CENTROID X	.080	-.041	-.066	
CENTROID Y	.224	.339	.192	
POA TO CENTROID in.	.238	.341	.203	
MIN RADIUS	.199	.364	.318	
MEAN RADIUS	.862	.797	.730	
MAX RADIUS	1.499	1.188	1.133	
HORIZONTAL SPREAD	2.187	1.541	1.541	
VERTICAL SPREAD	2.316	2.089	1.739	
EXTREME SPREAD	2.527	2.089	1.844	
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

14 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS= 2.349

VS= 2.550

GS= 2.807

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.053	1.105	.975
MINIMUM X	-1.296	-1.244	-1.374
MAXIMUM Y	1.171	1.018	1.118
MINIMUM Y	-1.379	-1.365	-1.265
CENTROID X	-.240	-.292	-.162
CENTROID Y	-.230	-.077	-.177
POA TO CENTROID in.	.333	.302	.240
MIN RADIUS	.111	.055	.138
MEAN RADIUS	.967	.901	.838
MAX RADIUS	1.457	1.465	1.428
HORIZONTAL SPREAD	2.349	2.349	2.349
VERTICAL SPREAD	2.550	2.383	2.383
EXTREME SPREAD	2.807	2.753	2.753
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 10		