

C6611547

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

MODEL 700™ M24

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

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

SERIAL NO. C6611547	ORDER NO. 5716
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20



5716 C6611547

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611547

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KH
600	Proof		2/1/91	KH
607	Check Headspace		2/1/91	KH
610	Dis-assemble Gun		2/1/91	KH
612	Magnaflux Barrel Action	2 11 91		Kid
	Magnaflux Bolt	2 11 91		Kid
615	Rollmark Caliber	2 11 91		GB
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel PBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2-12-91	KA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-2-91	PH

op. #	BARBER, M24 0078616 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	4 1/2			4-2-91	DH
	G) Safety Off Force	2	2	2			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	DH
	I) Firing Pin Indent	.021	.020	.021			4-2-91	DH
	J) Assemble Stock						4/8/91	KS
	K) Assemble Swivel Studs						4/10-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/8/91	KS
	M) Iron Sight Alignment						4/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/8/91	KS
	O) Attach Scope to Rifle						4/8/91	KS
	P) Detach & Attach Scope 20 Times						4/8/91	KS
640	Gallery Target & Test						4/9/91	K2
	A) Time						"	K2
	B) Malfunctions						"	K2
	C) Pierced Primers						"	K2
	D) Optical Clarity of Scope						"	K2
645	Inspect for Live Ammo						4/9/91	K2
655	Final Inspection							
	A) Headspace						4-10-91	DH
	B) Trigger Pull	2.34	2.34	2.35	2.31	2.33	4/10/91	GC
	C) Function						4-10-91	DH
660	Pack						4-11-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. CG611547

DATE 4-2-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.74	2.55	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.70	2.54	2.34	
PULL #3	2.69	2.70	2.59	2.35	
PULL #4	2.66	2.70	2.51	2.31	
PULL #5	2.70	2.49	2.60	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.11		
PULL #2	3.10	3.14		
PULL #3	3.00	3.16		
PULL #4	2.99	3.14		
PULL #5	3.11	3.17		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.25		4.14
PULL #2	4.02	4.22		4.08
PULL #3	4.24	4.29		4.18
PULL #4	4.08	4.26		4.04
PULL #5	4.19	4.13		3.98
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS¹
 FOR RIFLE # C6611547
 9 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.242981
1 TO	2	.264821
1 TO	3	.678107
1 TO	4	.56225
1 TO	5	.202299

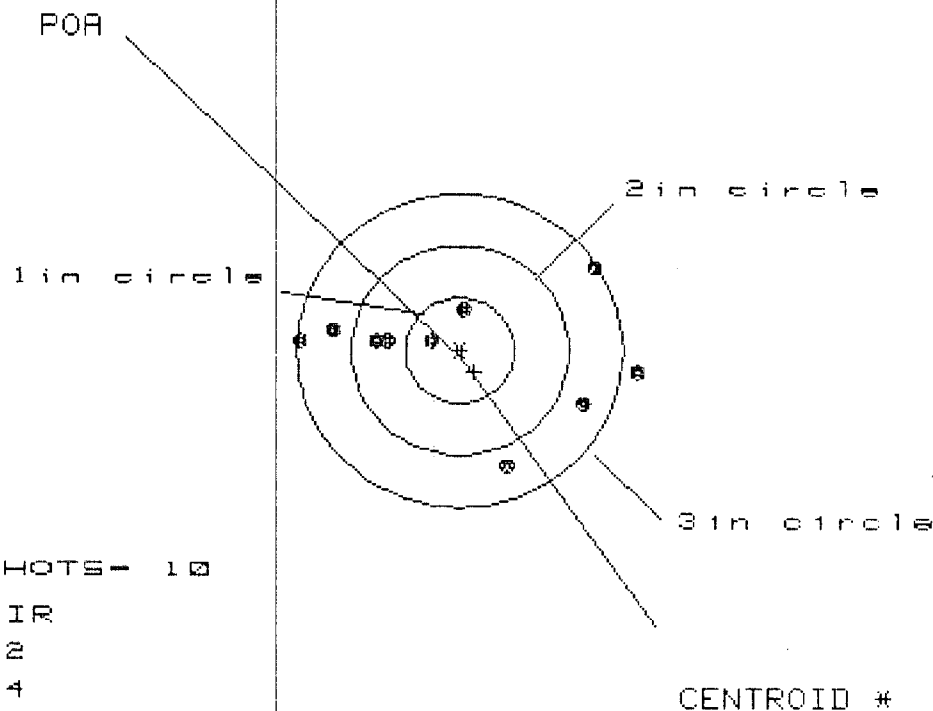
$\frac{4}{43}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0162
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0988
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .100119
 THE AMR FOR THIS RIFLE IS: .8382

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611547

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 3.095

VS= 1.986

GS= 3.114

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.606	1.375	1.211
MINIMUM X	-1.489	-1.311	-1.147
MAXIMUM Y	.841	.818	.831
MINIMUM Y	-1.145	-1.168	-1.155
CENTROID X	-.132	-.310	-.146
CENTROID Y	.204	.227	.214
POA TO CENTROID in.	.243	.385	.259
MIN RADIUS	.259	.094	.242
MEAN RADIUS	1.029	.915	.893
MAX RADIUS	1.619	1.600	1.469
HORIZONTAL SPREAD	3.095	2.686	2.358
VERTICAL SPREAD	1.986	1.986	1.986
EXTREME SPREAD	3.114	2.779	2.432
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 1.384

VS= 3.077

GS= 3.077

CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.641	.621	.590
MINIMUM X	-.743	-.763	-.794
MAXIMUM Y	1.202	.994	.443
MINIMUM Y	-1.875	-.469	-.345
CENTROID X	.001	.021	.052
CENTROID Y	-.025	.183	.059
POA TO CENTROID in.	.025	.184	.078
MIN RADIUS	.124	.219	.126
MEAN RADIUS	.685	.554	.466
MAX RADIUS	1.883	1.025	.909
HORIZONTAL SPREAD	1.384	1.384	1.384
VERTICAL SPREAD	3.077	1.463	.788
EXTREME SPREAD	3.077	1.702	1.593
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611547

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 3.551

VS= 1.557

GS= 3.638

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	1.036	.601
MINIMUM X	-2.264	-1.009	-.880
MAXIMUM Y	.789	.822	.765
MINIMUM Y	-.768	-.735	-.792
CENTROID X	.291	.542	.413
CENTROID Y	-.326	-.359	-.302
POA TO CENTROID in.	.437	.651	.512
MIN RADIUS	.440	.233	.366
MEAN RADIUS	.923	.700	.666
MAX RADIUS	2.284	1.302	1.166
HORIZONTAL SPREAD	3.551	2.045	1.481
VERTICAL SPREAD	1.557	1.557	1.557
EXTREME SPREAD	3.638	2.411	1.780
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.059

VS = 1.660

GS = 3.250

PATTERN #	4	5	6
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.425	1.258	1.033
MINIMUM X	-1.633	-1.801	-1.010
MAXIMUM Y	.534	.409	.455
MINIMUM Y	-1.126	-.905	-.859
CENTROID X	-.063	.105	.330
CENTROID Y	-.354	-.229	-.275
POA TO CENTROID in.	.359	.252	.430
MIN RADIUS	.157	.306	.499
MEAN RADIUS	.992	.908	.815
MAX RADIUS	1.879	1.839	1.074
HORIZONTAL SPREAD	3.059	3.059	2.043
VERTICAL SPREAD	1.660	1.314	1.314
EXTREME SPREAD	3.258	3.073	2.056
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 10

3in = 10

HS= 1.678

VS= .984

GS= 1.707

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.753	.650	.555
MINIMUM X	-.925	-.763	-.521
MAXIMUM Y	.529	.543	.488
MINIMUM Y	-.455	-.441	-.303
CENTROID X	-.178	-.075	.020
CENTROID Y	.007	-.007	.048
POA TO CENTROID in.	.178	.076	.052
MIN RADIUS	.215	.257	.251
MEAN RADIUS	.562	.519	.469
MAX RADIUS	.934	.881	.603
HORIZONTAL SPREAD	1.678	1.413	1.076
VERTICAL SPREAD	.984	.984	.791
EXTREME SPREAD	1.707	1.508	1.125
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 10		
NUMBER IN THREE INCH CIRCLE	= 10		