

C6611568

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611568	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			



5716 C6611568

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611568

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 9 1		RW
600	Proof	2 1 9 1		RW
607	Check Headspace	2 1 9 1		RW
610	Dis-assemble Gun	2 1 9 1		RW
612	Magnaflux Barrel Action	2 1 1 9 1		Kcd
	Magnaflux Bolt	2 1 1 9 1		Kcd
615	Rollmark Caliber	2 1 1 9 1		GS
617	Drill and Tap Sight Holes	2 1 3 9 1		LB
618	Polish Barrel RBB	2 1 3 9 1		WB
620	Apply Coatings (Barrel Action)		3/25/91	WB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/4/91	WB

Op. #	BARBER M24 0078954	READINGS				DATE	INIT.
625 cont.	F) Safety On Force	4	4	4		4-4-91	DH
	G) Safety Off Force	2	3	2		4-4-91	DH
	H) Trigger Pull Test & Retainability					4/4/91	JH
	I) Firing Pin Indent	.021	.022	.021		4-4-91	DH
	J) Assemble Stock					4/5/91	RW
	K) Assemble Swivel Studs					4-17-91	J
	L) Attach Front and Rear Sight Assemblies					4/5/91	RW
	M) Iron Sight Alignment					4/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container					4/5/91	RW
	O) Attach Scope to Rifle					4/5/91	RW
	P) Detach & Attach Scope 20 Times					4/5/91	RW
640	Gallery Target & Test					4/8/91	KS
	A) Time						KS
	B) Malfunctions						KS
	C) Pierced Primers						KS
	D) Optical Clarity of Scope						KS
645	Inspect for Live Ammo					4/8/91	KS
655	Final Inspection						
	A) Headspace					4-17-91	J
	B) Trigger Pull	2.25	2.19	2.30	2.21	4/16/91	JH
	C) Function					4-17-91	J
660	Pack					6-19-91	N

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

SERIAL NO. C-6611568DATE 4-4-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.31	2.30	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.14	2.38	2.19	
PULL #3	2.28	2.31	2.24	2.30	
PULL #4	2.24	2.26	2.30	2.21	
PULL #5	2.22	2.37	2.30	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.48		
PULL #2	3.22	3.39		
PULL #3	3.48	3.56		
PULL #4	3.55	3.46		
PULL #5	3.52	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.38		4.26
PULL #2	4.51	4.23		4.41
PULL #3	4.48	4.29		4.12
PULL #4	4.50	4.27		4.37
PULL #5	4.46	4.50		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611568
8 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.299313
1 TO	2	.307586
1 TO	3	.316661
1 TO	4	.3628
1 TO	5	.220581

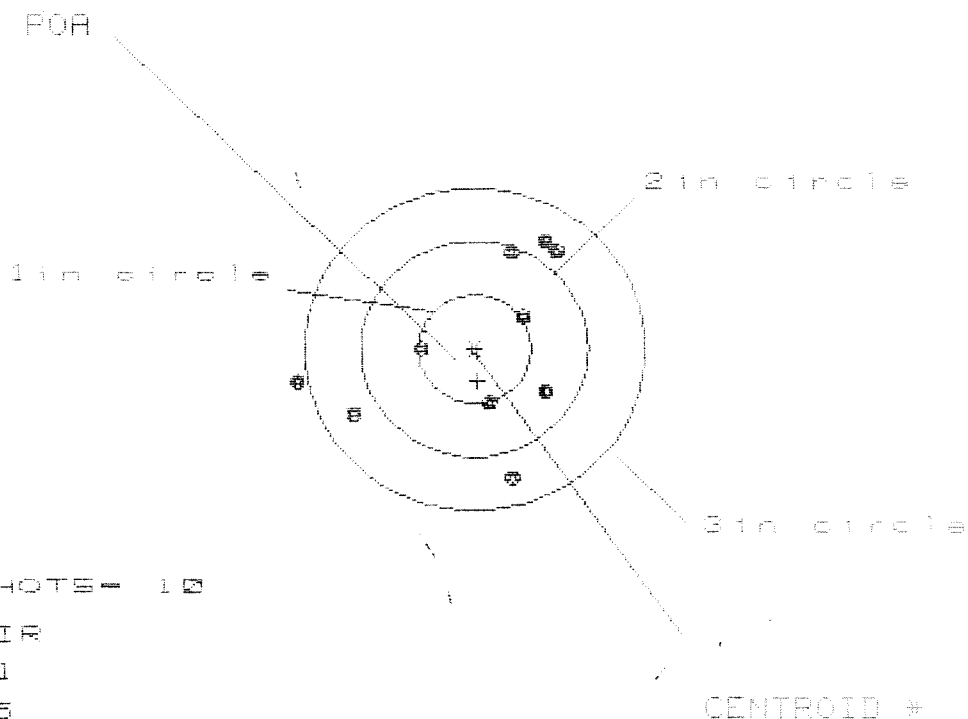
1
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107407
THE AMR FOR THIS RIFLE IS: 1.017

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611568

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 4

HS = 2.378

VS = 2.178

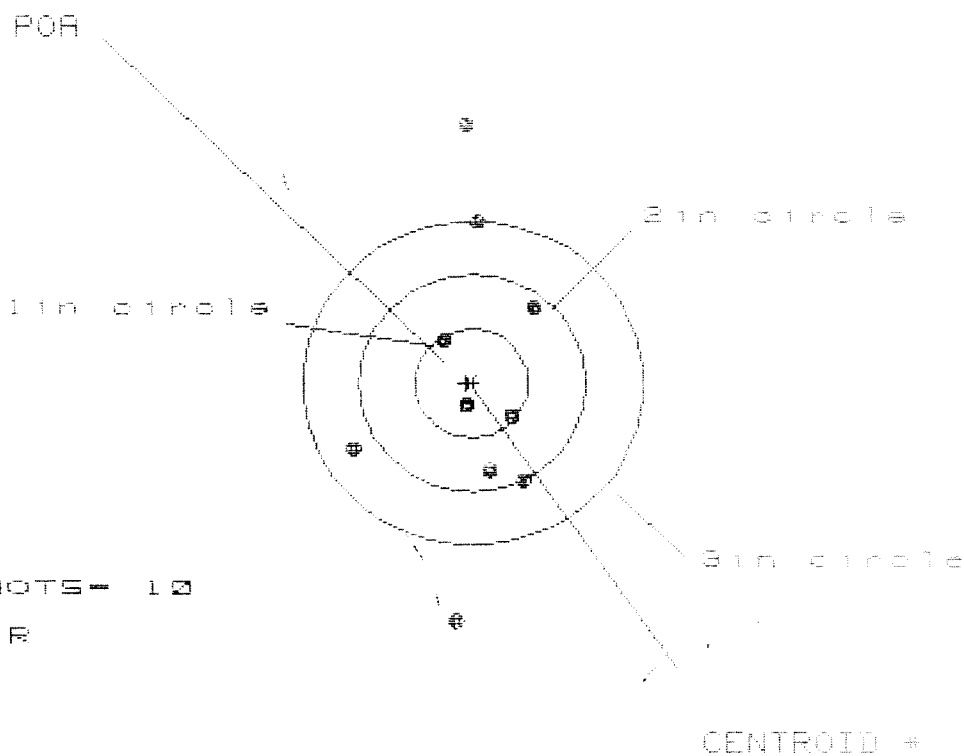
GS = 2.695

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.759	.579	.592
MINIMUM X	-1.619	-1.244	-1.232
MAXIMUM Y	.954	.919	.761
MINIMUM Y	-1.224	-1.259	-1.833
CENTROID X	-.028	.152	.139
CENTROID Y	.298	.333	.491
POA TO CENTROID in.	.299	.366	.510
MIN RADIUS	.444	.361	.285
MEAN RADIUS	.972	.872	.808
MAX RADIUS	1.650	1.415	1.487
HORIZONTAL SPREAD	2.378	1.823	1.823
VERTICAL SPREAD	2.178	2.178	1.594
EXTREME SPREAD	2.695	2.418	2.418
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 1.611

VS = 4.586

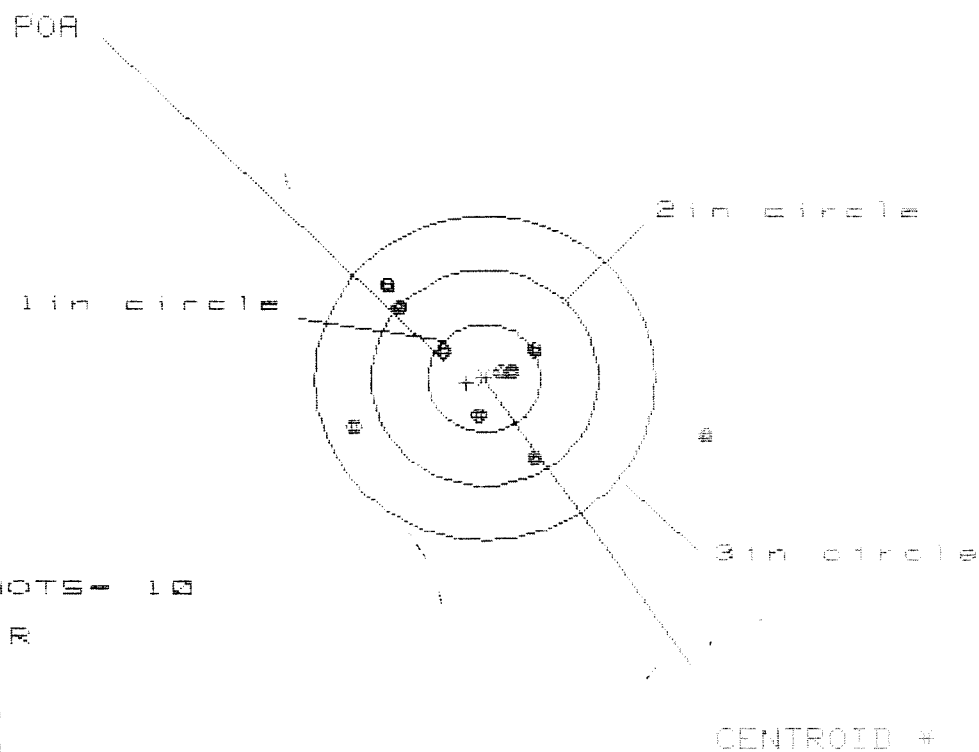
GS = 4.586

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.564	.554	.537
MINIMUM X	:	-1.047	-1.057	-1.074
MAXIMUM Y	:	2.418	1.776	1.539
MINIMUM Y	:	-2.168	-1.900	-1.884
CENTROID X	:	.052	.062	.079
CENTROID Y	:	.001	-.267	-.090
POA TO CENTROID in.	:	.052	.274	.085
MIN RADIUS	:	.203	.068	.176
MEAN RADIUS	:	1.121	.928	.820
MAX RADIUS	:	2.419	1.905	1.540
HORIZONTAL SPREAD	:	1.611	1.611	1.611
VERTICAL SPREAD	:	4.586	3.676	2.423
EXTREME SPREAD	:	4.586	3.683	2.447
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 3.078

VS = 1.593

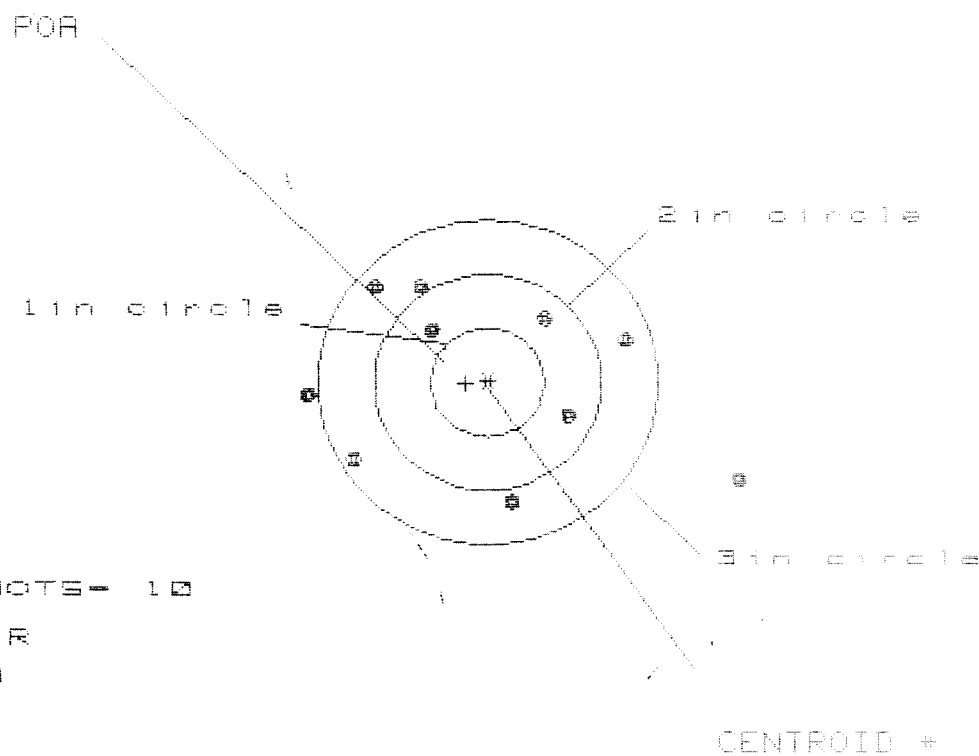
GS = 3.111

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.904
MINIMUM X	-1.173
MAXIMUM Y	.887
MINIMUM Y	-.706
CENTROID X	.157
CENTROID Y	.041
POA TO CENTROID in.	.163
MIN RADIUS	.120
MEAN RADIUS	.797
MAX RADIUS	1.992
HORIZONTAL SPREAD	3.078
VERTICAL SPREAD	1.593
EXTREME SPREAD	3.111
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 4

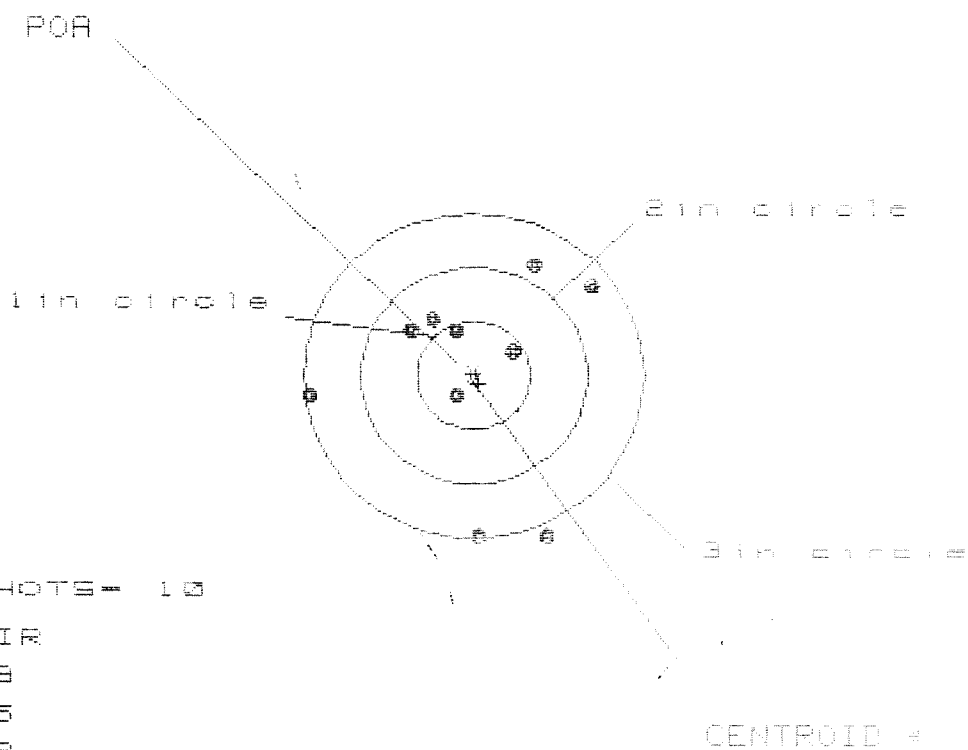


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.229	1.466	1.296
MINIMUM X	:	-1.613	-1.366	-1.065
MAXIMUM Y	:	.891	.788	.761
MINIMUM Y	:	-1.155	-1.258	-1.285
CENTROID X	:	.190	-.057	.113
CENTROID Y	:	.008	.111	.138
POR TO CENTROID in.	:	.190	.125	.179
MIN RADIUS	:	.682	.438	.540
MEAN RADIUS	:	1.243	1.078	1.031
MAX RADIUS	:	2.412	1.499	1.348
HORIZONTAL SPREAD	:	3.842	2.832	2.361
VERTICAL SPREAD	:	2.046	2.046	2.046
EXTREME SPREAD	:	3.925	2.882	2.609
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 2

HS = 2.553

VS = 2.551

GS = 2.739

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.087	1.163	1.173
MINIMUM X	-1.466	-1.390	-1.380
MAXIMUM Y	1.044	.879	.670
MINIMUM Y	-1.507	-1.672	-1.580
CENTROID X	-.044	-.120	-.130
CENTROID Y	.078	.243	.452
POA TO CENTROID in.	.090	.271	.471
MIN RADIUS	.256	.241	.056
MEAN RADIUS	.954	.836	.690
MAX RADIUS	1.635	1.674	1.497
HORIZONTAL SPREAD	2.553	2.553	2.553
VERTICAL SPREAD	2.551	2.551	1.250
EXTREME SPREAD	2.739	2.739	2.739
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		