

C6349105

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6349105

ORDER NO.
5716

01

5716 C6349105

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349105

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5 9	90	RW
612	Magnaflux Barrel Action	5-15-90		KER
	Magnaflux Bolt	5-15-90		KER
615	Rollmark Caliber	5-15-90		BS
617	Drill and Tap Sight Holes		5/17/90	K-B
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/90	RW

BARBER - M24 0107884		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	4 1/4	4 1/4	4			5/30/90	WB
	G) Safety Off Force	2	2	2			5/30/90	WB
	H) Trigger Pull Test & Retainability						5/29/90	gll
	I) Firing Pin Indent	.024	.024	.024			5/30/90	WB
	J) Assemble Stock						5/30/90	RW
	K) Assemble Swivel Studs						6-6-90	DS
	L) Attach Front and Rear Sight Assemblies						5/30/90	RW
	M) Iron Sight Alignment						5/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/90	RW
	O) Attach Scope to Rifle						5/30/90	WB
	P) Detach & Attach Scope 20 Times						5/30/90	WB
640	Gallery Target & Test						6-1-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						6-1-90	A
655	Final Inspection							
	A) Headspace						6-8-90	DS
	B) Trigger Pull	255	263	242	271	263	6-6-90	DS
	C) Function						6-6-90	DS
660	Pack						6-19-90	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349105

DATE 5/29/90

TESTER 94

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.34	2.35	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.30	2.29	2.63	
PULL #3	2.36	2.30	2.33	2.42	
PULL #4	2.36	2.35	2.32	2.71	
PULL #5	2.34	2.30	2.43	2.63	
TOTAL	11.63	11.59	11.72		
AVG.	2.326	2.318	2.344		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.41		
PULL #2	3.43	3.45		
PULL #3	3.44	3.38		
PULL #4	3.43	3.41		
PULL #5	3.45	3.39		
TOTAL	17.20	16.99		
AVG.	3.44	3.398		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.28		4.37
PULL #2	4.31	4.29		4.28
PULL #3	4.27	4.31		4.24
PULL #4	4.28	4.25		4.29
PULL #5	4.29	4.29		4.30
TOTAL	21.45	21.42		21.48
AVG.	4.29	4.284		4.296

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349105
1 Jun 1990

CENTROIDAL DISTANCES

0 TO 1	.220708
1 TO 2	.123822
1 TO 3	.443803
1 TO 4	.302106
1 TO 5	.42184

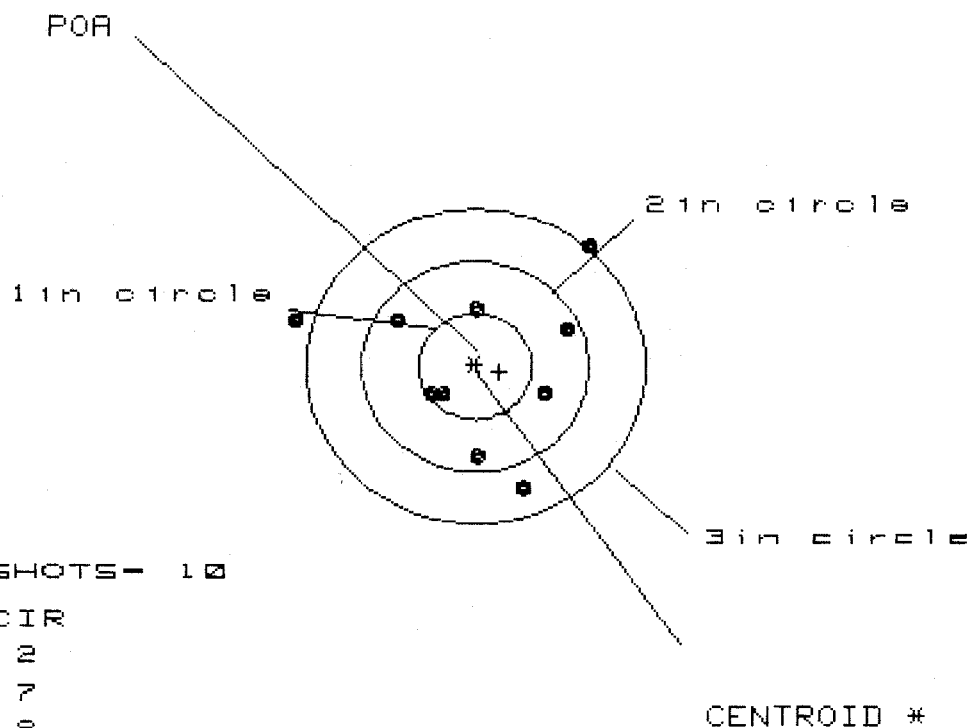
$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0688
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111702
THE AMR FOR THIS RIFLE IS: .9734

1 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349105

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 8

HS= 2.583

VS= 2.291

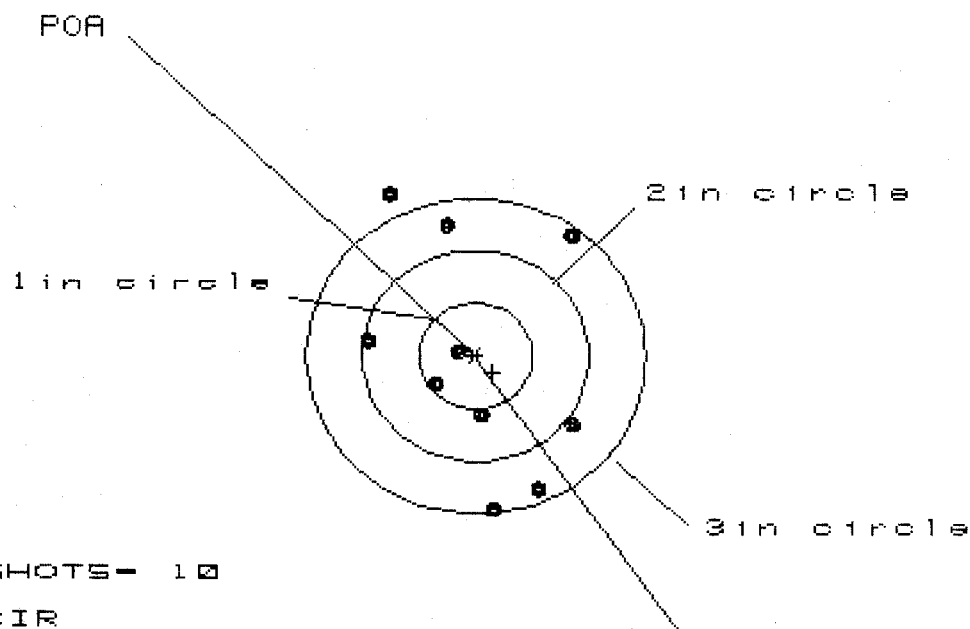
GS= 2.676

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.841	.726
MINIMUM X	:	-1.568	-.906	-.801
MAXIMUM Y	:	1.118	1.165	.696
MINIMUM Y	:	-1.173	-1.126	-.980
CENTROID X	:	-.214	-.040	-.145
CENTROID Y	:	.054	.007	-.139
POA TO CENTROID in.	:	.221	.040	.201
MIN RADIUS	:	.339	.469	.335
MEAN RADIUS	:	.901	.820	.717
MAX RADIUS	:	1.623	1.437	1.043
HORIZONTAL SPREAD	:	2.583	1.747	1.527
VERTICAL SPREAD	:	2.291	2.291	1.676
EXTREME SPREAD	:	2.676	2.366	2.010
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

1 Jun 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 4

3 in - 9

HS - 1.854

VS - 2.998

GS - 3.140

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.883	.900	.812
MINIMUM X	-.981	-1.064	-1.052
MAXIMUM Y	1.583	1.446	1.291
MINIMUM Y	-1.415	-1.239	-1.261
CENTROID X	-.150	-.067	-.079
CENTROID Y	.160	-.016	.139
POA TO CENTROID in.	.219	.069	.160
MIN RADIUS	.140	.310	.214
MEAN RADIUS	1.048	.954	.922
MAX RADIUS	1.750	1.522	1.400
HORIZONTAL SPREAD	1.864	1.864	1.864
VERTICAL SPREAD	2.998	2.685	2.552
EXTREME SPREAD	3.140	2.721	2.675
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

1 Jun 1990

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 7

3 in = 10

HS= 2.176

VS= 1.966

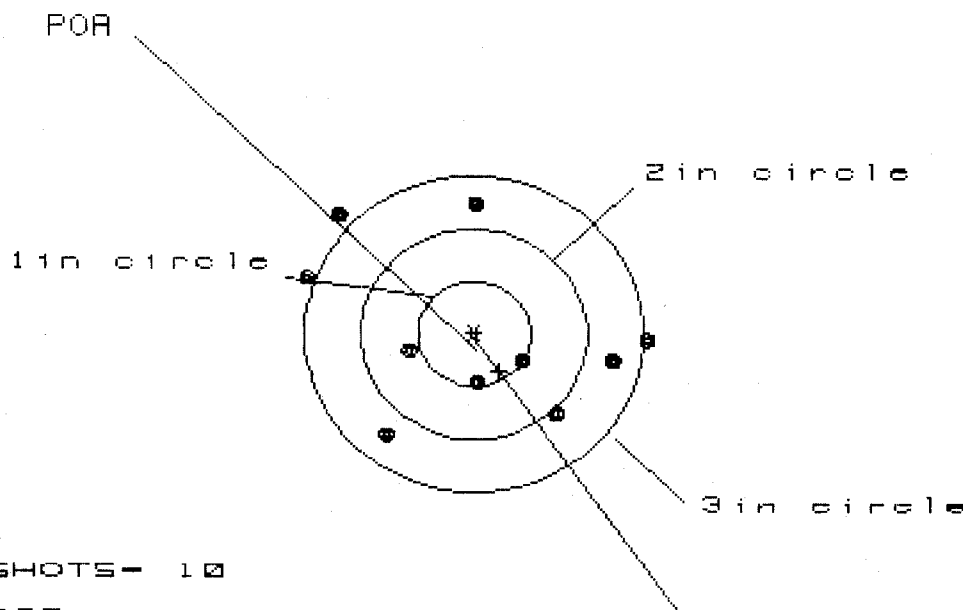
GS= 2.434

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.816	.765
MINIMUM X	:	-1.224	-.794	-.845
MAXIMUM Y	:	.872	.943	.815
MINIMUM Y	:	-1.094	-1.023	-.503
CENTROID X	:	.051	.187	.238
CENTROID Y	:	-.302	-.373	-.245
POA TO CENTROID in.	:	.306	.418	.342
MIN RADIUS	:	.349	.487	.522
MEAN RADIUS	:	.872	.808	.761
MAX RADIUS	:	1.383	1.100	.916
HORIZONTAL SPREAD	:	2.176	1.610	1.610
VERTICAL SPREAD	:	1.966	1.966	1.318
EXTREME SPREAD	:	2.434	1.969	1.813
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.005

VS= 2.174

GS= 3.054

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.565	1.440	1.268
MINIMUM X	:	-1.440	-1.565	-1.385
MAXIMUM Y	:	1.215	1.338	1.352
MINIMUM Y	:	-.959	-.836	-.822
CENTROID X	:	-.222	-.097	-.277
CENTROID Y	:	.356	.233	.219
POA TO CENTROID in.	:	.419	.252	.353
MIN RADIUS	:	.410	.315	.278
MEAN RADIUS	:	1.095	1.005	.945
MAX RADIUS	:	1.579	1.697	1.539
HORIZONTAL SPREAD	:	3.005	3.005	2.653
VERTICAL SPREAD	:	2.174	2.174	2.174
EXTREME SPREAD	:	3.054	3.054	2.771
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.548

VS= 2.745

GS= 3.140

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.100	.939	.928
MINIMUM X	:	-1.448	-.733	-.744
MAXIMUM Y	:	1.421	1.274	.855
MINIMUM Y	:	-1.324	-1.111	-.952
CENTROID X	:	.191	.352	.363
CENTROID Y	:	.172	.319	.160
POA TO CENTROID in.	:	.257	.475	.397
MIN RADIUS	:	.409	.253	.246
MEAN RADIUS	:	.951	.798	.742
MAX RADIUS	:	1.962	1.331	1.208
HORIZONTAL SPREAD	:	2.548	1.672	1.672
VERTICAL SPREAD	:	2.745	2.385	1.807
EXTREME SPREAD	:	3.140	2.472	2.183
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	