

C6349111

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smeal®
No. 2-152-5L

Remington® REG. U.S. PAT. & TM. OFF.

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

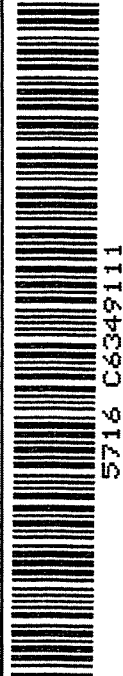
MODEL 700™ M24

SERIAL NO.
C6349111

ORDER NO.
5716

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

01



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349111

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	Rw
600	Proof	4 12	90	A
607	Check Headspace	4 12	90	A
610	Dis-assemble Gun	4 12	90	Rw
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		SA
617	Drill and Tap Sight Holes		4/23/90	LB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/28/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	Rw
	C) Inspect Ejector Hole for Chamfer		5/1/90	Rw
	D) Oil Firing Pin Ass'y		5/1/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/15/90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/15/90	JK
	G) Safety Off Force	3	3	3			5/15/90	JK
	H) Trigger Pull Test & Retainability						5/15/90	JK
	I) Firing Pin Indent	.0235	.0235	.0235			5/15/90	JK
	J) Assemble Stock						5/16/90	RW
	K) Assemble Swivel Studs						4/13/90	JK
	L) Attach Front and Rear Sight Assemblies						5/16/90	RW
	M) Iron Sight Alignment						5/16/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/16/90	RW
	O) Attach Scope to Rifle						5/16/90	JK
	P) Detach & Attach Scope 20 Times						5/16/90	JK
640	Gallery Target & Test						5-16-90	AC
	A) Time						5-16-90	AC
	B) Malfunctions						5-16-90	AC
	C) Pierced Primers						5-16-90	AC
	D) Optical Clarity of Scope						5-16-90	AC
645	Inspect for Live Ammo						5-16-90	AC
655	Final Inspection							
	A) Headspace						6/13/90	JK
	B) Trigger Pull	2.62	2.58	2.68	2.67	2.74	6/13/90	G.S.
	C) Function						6/13/90	JK
660	Pack						6-19-90	PH

TMM

BARBER - M24 0108043

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349111DATE 5/15/90TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.38	2.40	262	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.35	2.36	258	
PULL #3	2.33	2.24	2.50	268	
PULL #4	2.16	2.49	2.42	267	
PULL #5	2.38	2.45	2.35	274	
TOTAL	11.62	11.91	12.03		
AVG.	2.324	2.382	2.406		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.44		
PULL #2	3.35	3.44		
PULL #3	3.50	3.46		
PULL #4	3.40	3.43		
PULL #5	3.34	3.41		
TOTAL	17.03	17.18		
AVG.	3.406	3.436		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.52		4.32
PULL #2	4.42	4.38		4.40
PULL #3	4.42	4.44		4.40
PULL #4	4.38	4.42		4.47
PULL #5	4.38	4.35		4.49
TOTAL	21.90	22.11		22.08
AVG.	4.38	4.422		4.416

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6349111
 17 May 1990

CENTROIDAL DISTANCES

0 TO	1	.473973
1 TO	2	.0539351
1 TO	3	.439902
1 TO	4	.198313
1 TO	5	.326267

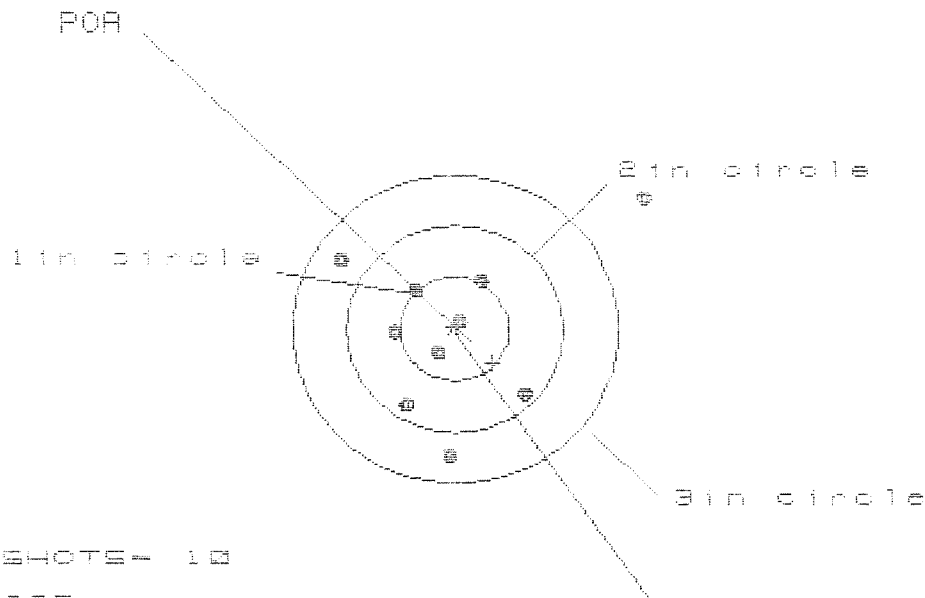
$\bar{x}_c$ <-----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2144
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1922
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .287938
 THE AMR FOR THIS RIFLE IS: .8404

17 May 1998

FILE: \PATTERNING\CENTERFIRE_PATT\08349111

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HE= 2.760

VS= 2.511

GS= 3.092

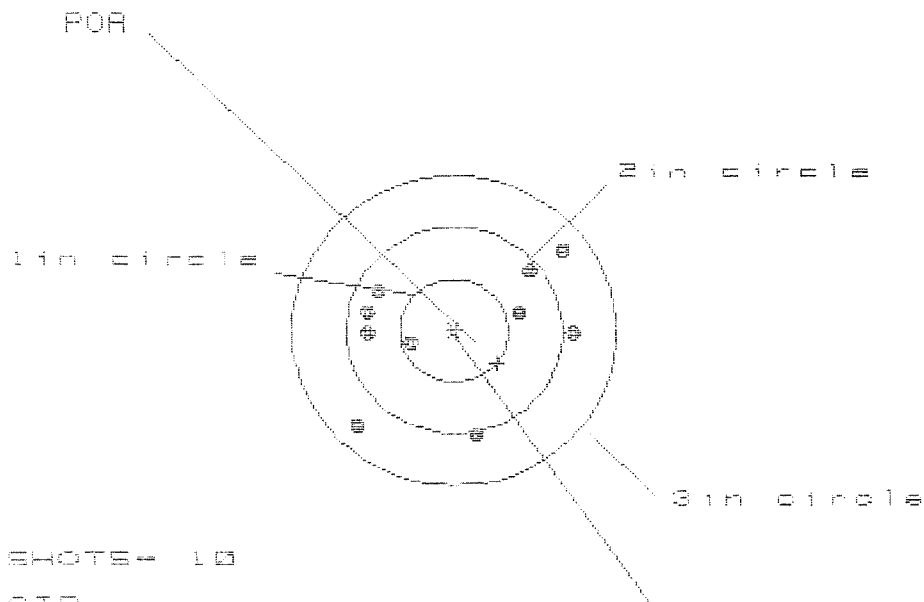
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.750	.819	.936
MINIMUM X	-1.010	-.816	-.799
MAXIMUM Y	1.307	.789	.656
MINIMUM Y	-1.204	-1.058	-.732
CENTROID X	-.345	-.539	-.556
CENTROID Y	.325	.179	.311
POR TO CENTROID in.	.473	.568	.638
MIN RADIUS	.077	.129	.231
MEAN RADIUS	.840	.662	.601
MAX RADIUS	2.184	1.135	1.034
HORIZONTAL SPREAD	2.760	1.635	1.635
VERTICAL SPREAD	2.511	1.847	1.388
EXTREME SPREAD	3.092	2.079	2.067
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.987

VS= 1.871

GS= 2.531

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.106	1.214	1.117
MINIMUM X	:	-.881	-.773	-.829
MAXIMUM Y	:	.818	.703	.601
MINIMUM Y	:	-1.053	-.962	-1.054
CENTROID X	:	-.398	-.506	-.409
CENTROID Y	:	.315	.224	.326
POR TO CENTROID in.	:	.508	.553	.523
MIN RADIUS	:	.444	.316	.437
MEAN RADIUS	:	.923	.865	.836
MAX RADIUS	:	1.268	1.230	1.117
HORIZONTAL SPREAD	:	1.987	1.987	1.946
VERTICAL SPREAD	:	1.871	1.665	1.665
EXTREME SPREAD	:	2.531	2.228	1.948
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.228

VS = 2.195

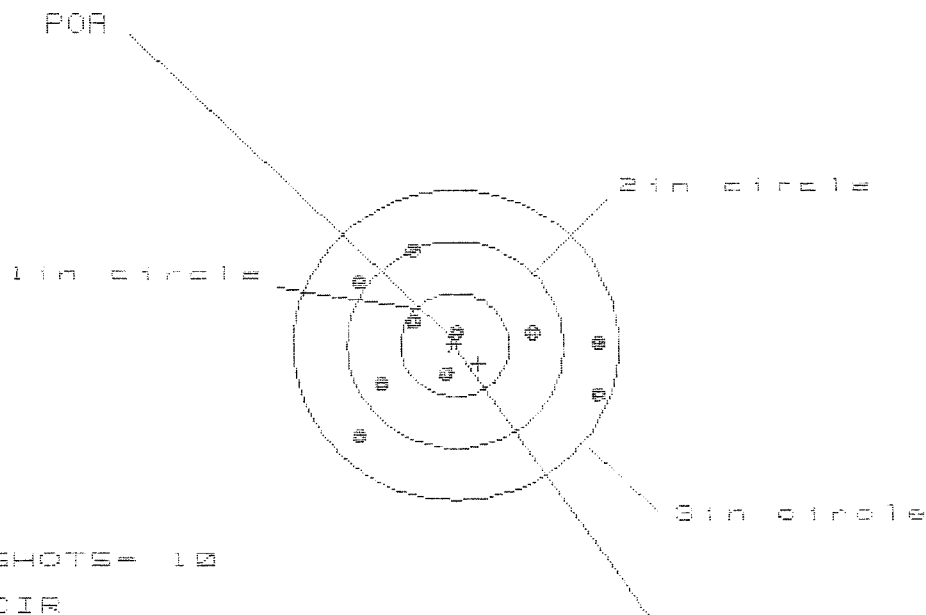
GS = 2.428

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	1.172	1.304
MINIMUM X	:	-1.139	-1.056	-.924
MAXIMUM Y	:	1.039	.814	.742
MINIMUM Y	:	-1.156	-1.040	-1.112
CENTROID X	:	-.028	-.111	-.243
CENTROID Y	:	.020	-.096	-.024
POA TO CENTROID in.	:	.035	.146	.244
MIN RADIUS	:	.431	.419	.309
MEAN RADIUS	:	.913	.867	.795
MAX RADIUS	:	1.278	1.213	1.326
HORIZONTAL SPREAD	:	2.228	2.228	2.228
VERTICAL SPREAD	:	2.195	1.854	1.854
EXTREME SPREAD	:	2.428	2.280	2.280
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.265

VS= 1.800

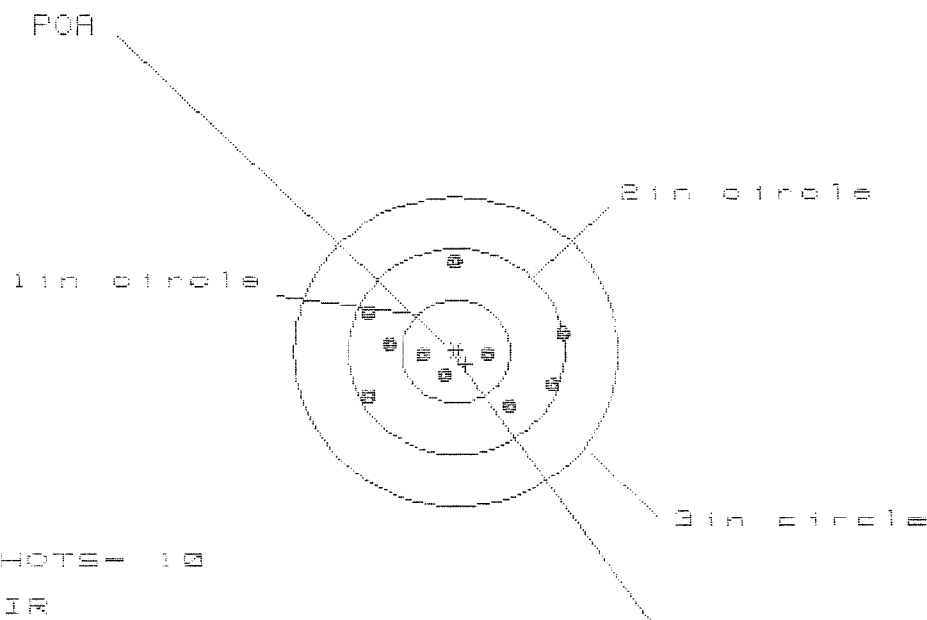
GS= 2.497

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.474	1.635
MINIMUM X	:	-.924	-.776	-.591
MAXIMUM Y	:	.893	.840	.834
MINIMUM Y	:	-.907	-.960	-.956
CENTROID X	:	-.213	-.361	-.546
CENTROID Y	:	.177	.230	.236
POA TO CENTROID in.	:	.277	.428	.594
MIN RADIUS	:	.114	.158	.220
MEAN RADIUS	:	.841	.756	.654
MAX RADIUS	:	1.420	1.475	1.117
HORIZONTAL SPREAD	:	2.265	2.250	1.626
VERTICAL SPREAD	:	1.800	1.800	1.800
EXTREME SPREAD	:	2.497	2.400	1.904
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.884

VS = 1.372

GS = 1.886

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.036
MINIMUM X	-.848
MAXIMUM Y	.827
MINIMUM Y	-.545
CENTROID X	-.088
CENTROID Y	.124
POA TO CENTROID in.	.152
MIN RADIUS	.225
MEAN RADIUS	.685
MAX RADIUS	1.058
HORIZONTAL SPREAD	1.884
VERTICAL SPREAD	1.372
EXTREME SPREAD	1.996
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	9
NUMBER IN THREE INCH CIRCLE	10