

C6349191

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
H24

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

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

SERIAL NO.
C6349191

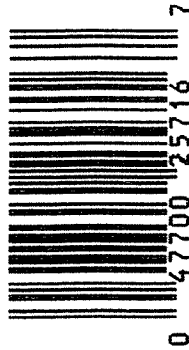
ORDER NO.
5716

01

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

5716 C6349191

UPC



RC BARBER - M24 0109788
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349191

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	A
607	Check Headspace	12-20	89	E
610	Dis-assemble Gun	12-20	89	RW
612	Magnaflux Barrel Action	1-5-90		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/3/90	JS
17	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RCB		1/2/90	WB
620	Apply Coatings (Barrel Action)		1-5-90	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-25-90	RL
	G) Safety Off Force	3	3	3			1-28-90	RL
	H) Trigger Pull Test & Retainability						2/4/90	ES
	I) Firing Pin Indent	.023	.023	.023			1-25-90	RL
	J) Assemble Stock						1/26/90	RW
	K) Assemble Swivel Studs						4/18/90	WLB
	L) Attach Front and Rear Sight Assemblies						1/26/90	RW
	M) Iron Sight Alignment						1/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/26/90	RW
	O) Attach Scope to Rifle						1/26/90	WLB
	P) Detach & Attach Scope 20 Times						1/26/90	WLB
640	Gallery Target & Test						2/26/90	DA
	A) Time						2/26/90	DA
	B) Malfunctions						2/26/90	DA
	C) Pierced Primers						2/26/90	DA
	D) Optical Clarity of Scope						2/26/90	DA
645	Inspect for Live Ammo						2/26/90	DA
655	Final Inspection						4/18/90	WLB
	A) Headspace							
	B) Trigger Pull	2.44	2.45	2.48	2.45	2.35	2/27/90	WLB
	C) Function						2/28/90	WLB
660	Pack						2/28/90	ES

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349191

DATE 24 Jan 90

TESTER 628

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.05	2.62	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.19	2.57	2.45	
PULL #3	2.46	2.20	2.52	2.48	
PULL #4	2.47	2.21	2.48	2.45	
PULL #5	2.50	2.22	2.41	2.35	
TOTAL	12.28	10.87	12.60		
AVG.	2.456	2.174	2.52		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.97	2.87		
PULL #2	2.95	3.00		
PULL #3	2.97	3.06		
PULL #4	2.97	2.95		
PULL #5	3.01	2.91		
TOTAL	14.87	14.79		
AVG.	2.974	2.958		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.07		4.03
PULL #2	4.10	4.12		4.10
PULL #3	4.09	4.15		4.14
PULL #4	4.15	4.15		4.12
PULL #5	4.21	3.92		4.21
TOTAL	20.71	20.41		20.60
AVG.	4.142	4.082		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349191
26 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.232246
1 TO	2	.122381
1 TO	3	.256236
1 TO	4	.47237
1 TO	5	.101272

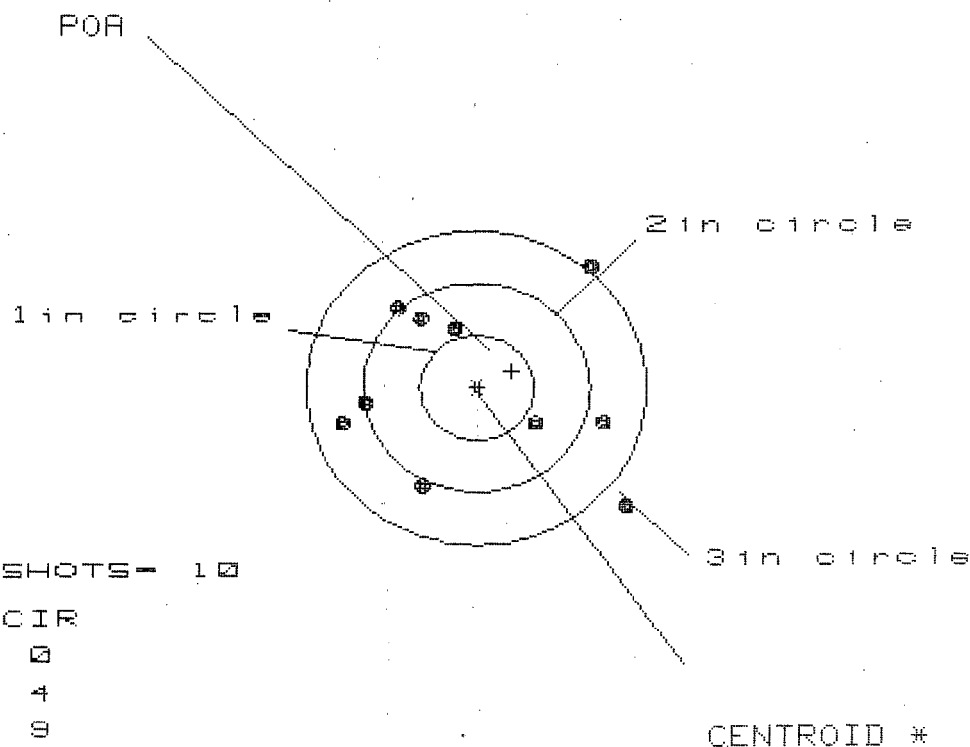
4.21 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3046
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .305205
THE AMR FOR THIS RIFLE IS: .9996

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349191

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 9

HS- 2.557

VS- 2.232

GS- 2.802

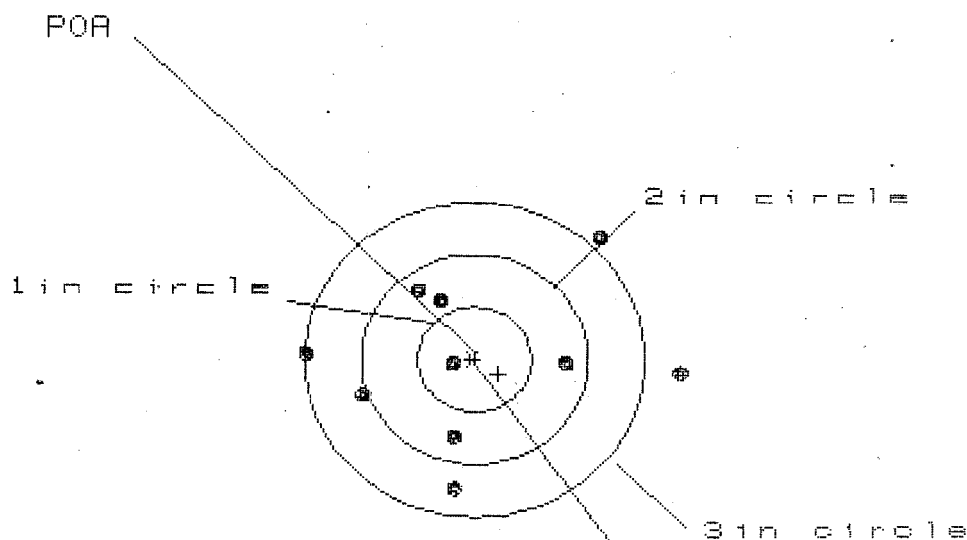
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.361
MINIMUM X	-1.196
MAXIMUM Y	1.118
MINIMUM Y	-1.114
CENTROID X	-.313
CENTROID Y	-.162
POA TO CENTROID in.	.353
MIN RADIUS	.580
MEAN RADIUS	1.070
MAX RADIUS	1.759
HORIZONTAL SPREAD	2.557
VERTICAL SPREAD	2.232
EXTREME SPREAD	2.802
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349191

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS - 3.301

VS - 2.366

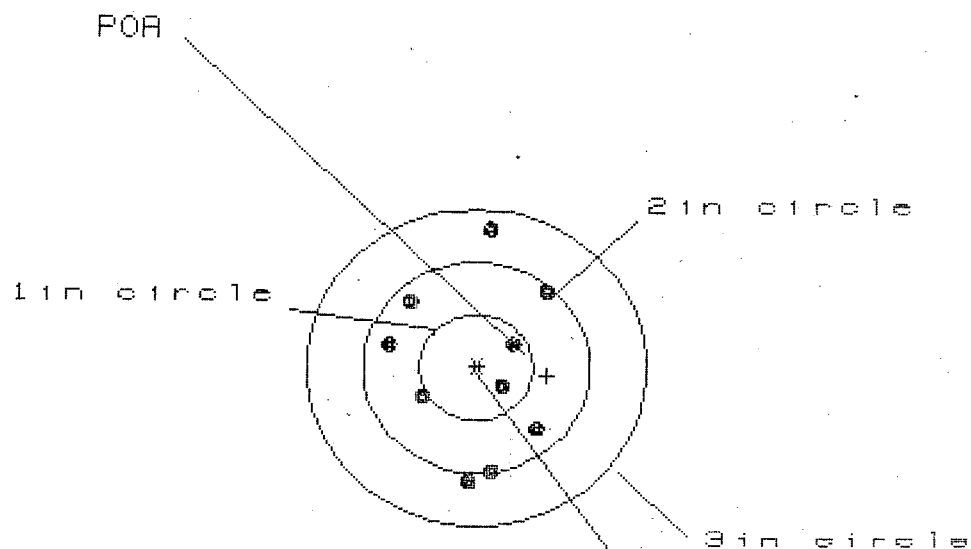
GS - 3.307

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.831
MINIMUM X	-1.470
MAXIMUM Y	1.157
MINIMUM Y	-1.209
CENTROID X	-.208
CENTROID Y	.133
POA TO CENTROID in.	.247
MIN RADIUS	.223
MEAN RADIUS	1.052
MAX RADIUS	1.833
HORIZONTAL SPREAD	3.301
VERTICAL SPREAD	2.366
EXTREME SPREAD	3.307
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

26 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CG349191

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.347

VS= 2.385

GS= 2.396

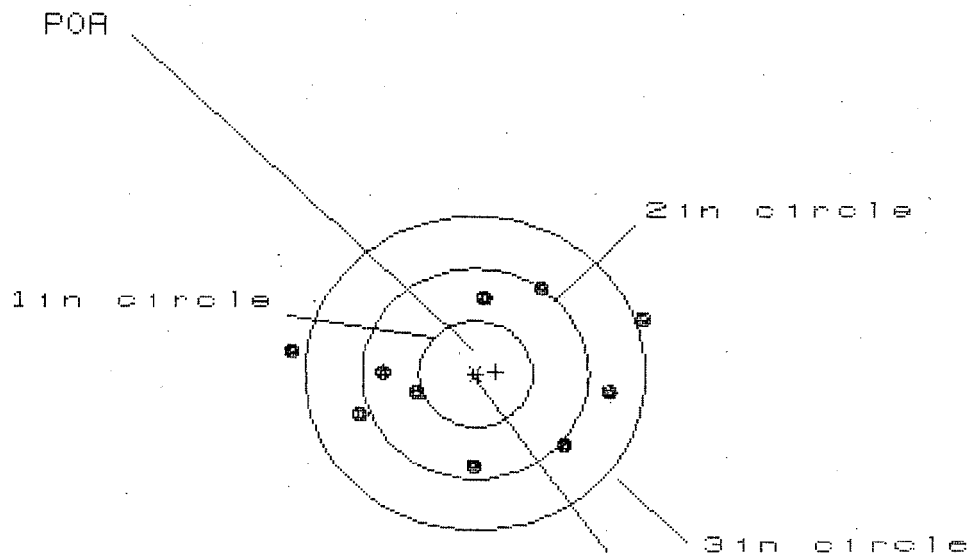
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.615	.632	.623
MINIMUM X	-.732	-.715	-.724
MAXIMUM Y	1.342	.845	.734
MINIMUM Y	-1.043	-.894	-.981
CENTROID X	-.624	-.641	-.632
CENTROID Y	.079	-.070	.042
POA TO CENTROID in.	.629	.645	.633
MIN RADIUS	.245	.224	.234
MEAN RADIUS	.800	.727	.700
MAX RADIUS	1.350	1.055	.996
HORIZONTAL SPREAD	1.347	1.347	1.347
VERTICAL SPREAD	2.385	1.739	1.715
EXTREME SPREAD	2.396	1.875	1.832
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349191

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.100

VS= 1.700

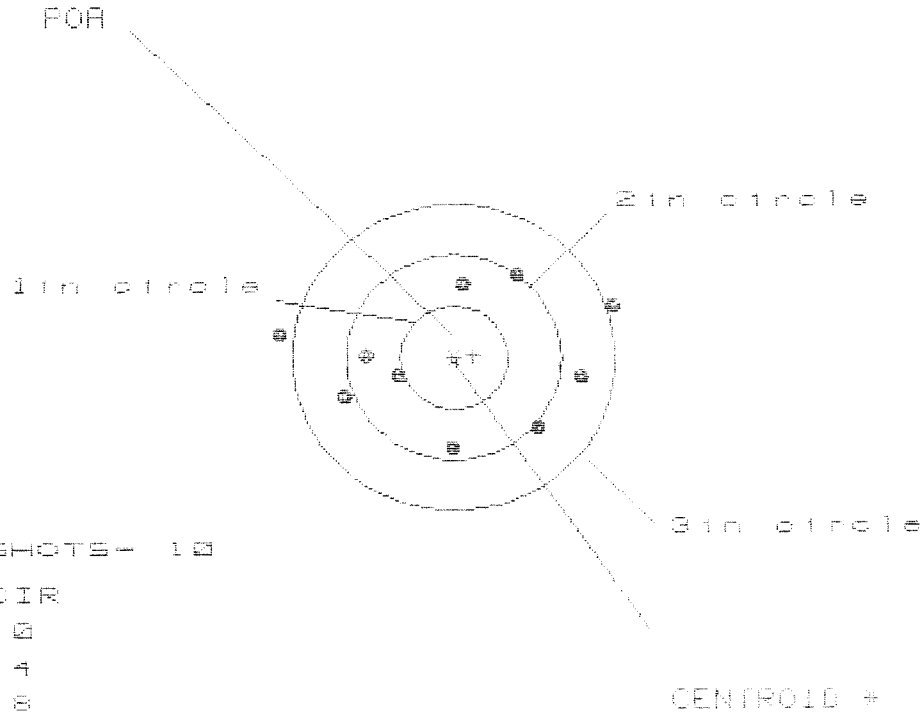
GS= 3.110

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.445	1.262	1.183
MINIMUM X	-1.655	-1.194	-1.037
MAXIMUM Y	.867	.897	.965
MINIMUM Y	-.833	-.803	-.735
CENTROID X	-.181	.002	-.155
CENTROID Y	-.023	-.053	-.121
POA TO CENTROID in.	.183	.053	.197
MIN RADIUS	.591	.746	.587
MEAN RADIUS	1.058	.988	.918
MAX RADIUS	1.676	1.374	1.189
HORIZONTAL SPREAD	3.100	2.456	2.220
VERTICAL SPREAD	1.700	1.700	1.700
EXTREME SPREAD	3.110	2.630	2.230
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

28 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08348181

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.100

VS= 1.700

GS= 3.110

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.445
MINIMUM X	-1.655
MAXIMUM Y	.867
MINIMUM Y	-.893
CENTROID X	-.181
CENTROID Y	-.023
POA TO CENTROID in.	.183
MIN RADIUS	.591
MEAN RADIUS	1.058
MAX RADIUS	1.676
HORIZONTAL SPREAD	3.100
VERTICAL SPREAD	1.700
EXTREME SPREAD	3.110
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 4
NUMBER IN THREE INCH CIRCLE	= 8