

C6611651

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington [®]		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6611651	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716	



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611651

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	KR
615	Rollmark Caliber		APR 2 1991	GL
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/15/91	SD

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/15/91	921
	G) Safety Off Force	3	3	3			4/15/91	921
	H) Trigger Pull Test & Retainability						4/15/91	921
	I) Firing Pin Indent	.023	.023	.023			4/15/91	921
	J) Assemble Stock						4/17/91	921
	K) Assemble Swivel Studs						4-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/17/91	921
	M) Iron Sight Alignment						4/17/91	921
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	921
	O) Attach Scope to Rifle						4/17/91	921
	P) Detach & Attach Scope 20 Times						4/17/91	921
640	Gallery Target & Test						4-18-91	D/H
	A) Time						4-18-91	D/H
	B) Malfunctions						4-18-91	D/H
	C) Pierced Primers						4-18-91	D/H
	D) Optical Clarity of Scope						4-18-91	D/H
645	Inspect for Live Ammo						4-18-91	D/H
655	Final Inspection							
	A) Headspace						4-22-91	D/H
	B) Trigger Pull	2.44	2.43	2.40	2.48	2.45	4/22/91	921
	C) Function						4-22-91	D/H
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611651

DATE 4/15/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.34	2.30	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.34	2.32	2.43	
PULL #3	2.38	2.35	2.32	2.40	
PULL #4	2.39	2.37	2.38	2.48	
PULL #5	2.42	2.32	2.34	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.19		
PULL #2	3.35	3.35		
PULL #3	3.20	3.35		
PULL #4	3.34	3.24		
PULL #5	3.31	3.37		
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	4.48		4.47
PULL #2	3.34	4.47		4.50
PULL #3	4.40	4.40		4.42
PULL #4	4.47	4.34		4.42
PULL #5	4.29	4.44		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611651
18 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.496856
1 TO	2	.60455
1 TO	3	.440647
1 TO	4	.706135
1 TO	5	.5001

$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1294
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .216521
THE AMR FOR THIS RIFLE IS: .9022

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11651

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 7

HS- 1.539

VS- 3.225

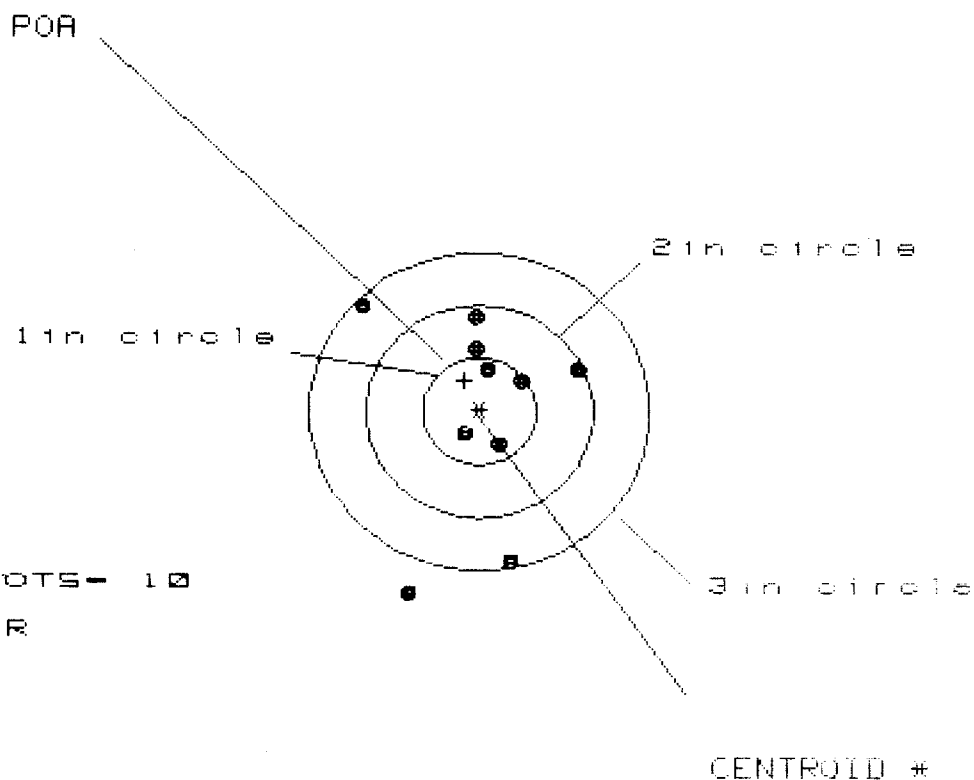
GS- 3.440

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.982	.958	1.037
MINIMUM X	-.557	-.581	-.502
MAXIMUM Y	1.394	1.191	.959
MINIMUM Y	-1.831	-1.852	-1.048
CENTROID X	.445	.469	.390
CENTROID Y	.221	.424	.656
POA TO CENTROID in.	.496	.632	.763
MIN RADIUS	.216	.248	.100
MEAN RADIUS	.978	.833	.631
MAX RADIUS	1.843	1.957	1.413
HORIZONTAL SPREAD	1.539	1.539	1.539
VERTICAL SPREAD	3.225	3.043	2.007
EXTREME SPREAD	3.440	3.061	2.529
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	7		

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611651

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 4

2in - 6

3in = 9

HS- 1.960

VS= 2.743

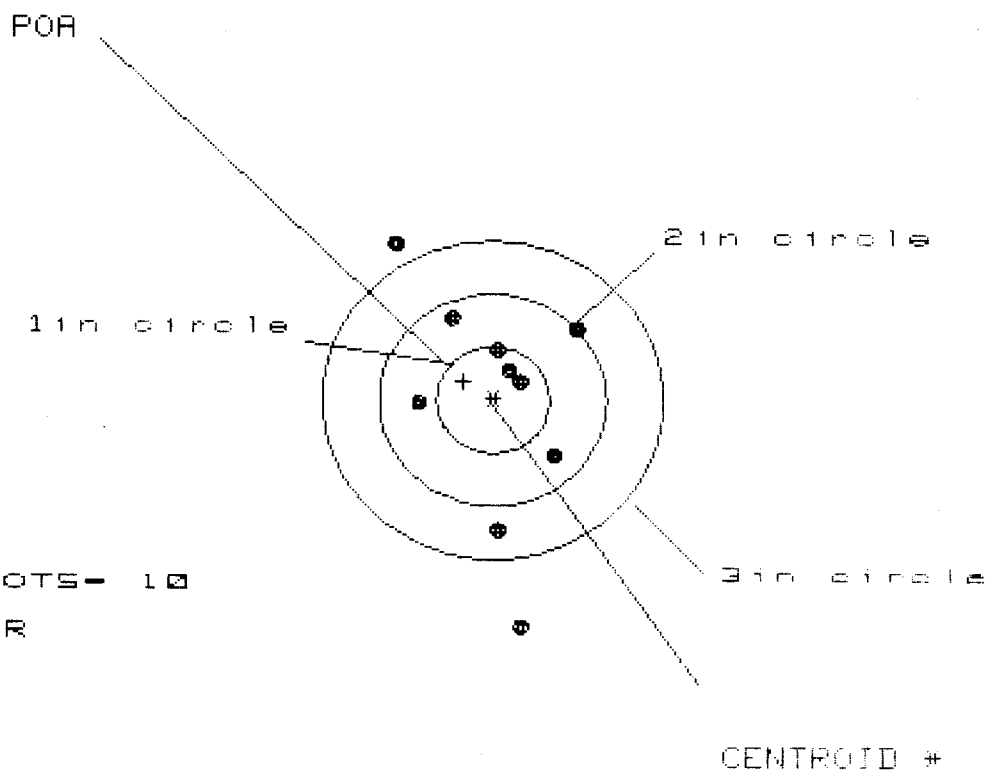
GS= 2.816

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.919	.850	.875
MINIMUM X	:	-1.041	-1.110	-1.085
MAXIMUM Y	:	1.041	.852	.647
MINIMUM Y	:	-1.702	-1.639	-.691
CENTROID X	:	.130	.199	.174
CENTROID Y	:	-.295	-.106	.099
POA TO CENTROID in.	:	.322	.226	.200
MIN RADIUS	:	.215	.236	.030
MEAN RADIUS	:	.872	.727	.572
MAX RADIUS	:	1.812	1.652	1.263
HORIZONTAL SPREAD	:	1.960	1.960	1.960
VERTICAL SPREAD	:	2.743	2.491	1.338
EXTREME SPREAD	:	2.816	2.816	2.058
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611651

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in = 8

HS- 1.632

VS= 3.604

GS= 3.773

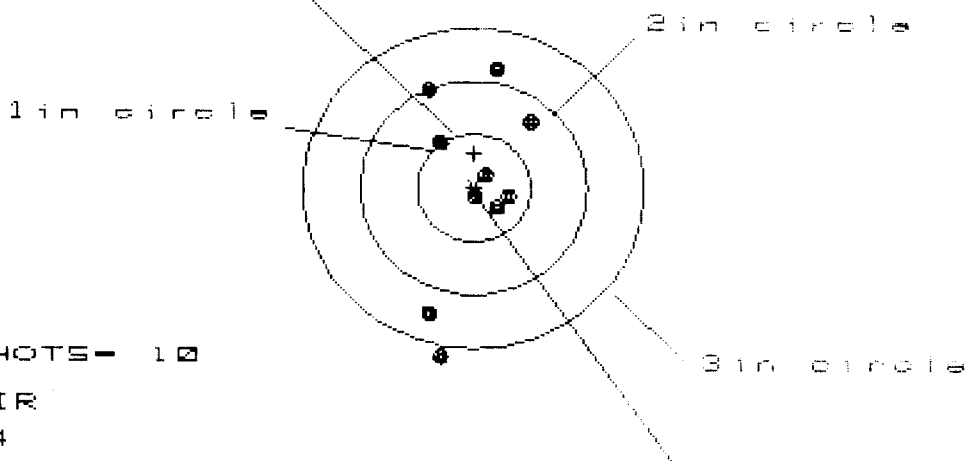
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.732	.756	.646
MINIMUM X	:	-.900	-.876	-.761
MAXIMUM Y	:	1.514	1.282	.663
MINIMUM Y	:	-2.090	-1.416	-1.256
CENTROID X	:	.258	.234	.344
CENTROID Y	:	-.178	.054	-.106
POA TO CENTROID in.	:	.314	.240	.360
MIN RADIUS	:	.291	.193	.181
MEAN RADIUS	:	.931	.751	.651
MAX RADIUS	:	2.101	1.553	1.256
HORIZONTAL SPREAD	:	1.632	1.632	1.407
VERTICAL SPREAD	:	3.604	2.698	1.919
EXTREME SPREAD	:	3.773	2.861	1.959
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611651

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= .916

VS= 2.740

GS= 2.782

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.504	.474	.418
MINIMUM X	:	-.412	-.442	-.472
MAXIMUM Y	:	1.148	.971	.796
MINIMUM Y	:	-1.592	-1.394	-.574
CENTROID X	:	-.004	.026	.082
CENTROID Y	:	-.324	-.147	.028
POA TO CENTROID in.	:	.324	.149	.086
MIN RADIUS	:	.082	.073	.193
MEAN RADIUS	:	.729	.615	.522
MAX RADIUS	:	1.616	1.463	.806
HORIZONTAL SPREAD	:	.916	.916	.890
VERTICAL SPREAD	:	2.740	2.365	1.370
EXTREME SPREAD	:	2.782	2.445	1.370
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

18 Apr 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6611651

CENTERFIRE PATTERNS

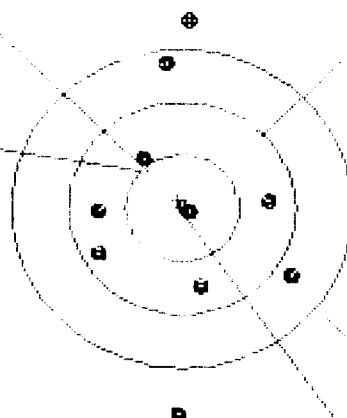
5

POA

1 in circle

2 in circle

3 in circle



CENTROID #

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

HS- 1.709

VS- 3.660

GS- 3.661

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	.987	.988
MINIMUM X	:	-.714	-.722	-.721
MAXIMUM Y	:	1.773	1.563	1.406
MINIMUM Y	:	-1.887	-.937	-.741
CENTROID X	:	.039	.047	.046
CENTROID Y	:	-.071	.139	-.057
POA TO CENTROID in.	:	.081	.147	.073
MIN RADIUS	:	.099	.226	.093
MEAN RADIUS	:	1.001	.911	.794
MAX RADIUS	:	1.889	1.563	1.416
HORIZONTAL SPREAD	:	1.709	1.709	1.709
VERTICAL SPREAD	:	3.660	2.500	2.147
EXTREME SPREAD	:	3.661	2.535	2.349
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	