

Smith & Wesson®

FORM

UPC



0 47700 25716 7

C6649063

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700™ M24

SERIAL NO.

C6649063

ORDER NO.

5716

20

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



5716 C6649063

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649063

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 23	9 1	RW
610	Dis-assemble Gun	9 23	9 1	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCD
	Magnaflux Bolt	OCT	3 1991	KCD
615	Rollmark Caliber	OCT	3 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/18/91	JP

op. #	BARBER M24 0031223	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 1/2	5			11-18-91	DH
	G) Safety Off Force	3	3	3			11-18-91	DH
	H) Trigger Pull Test & Retainability						11/18/91	SH
	I) Firing Pin Indent	.020	.020	.020			11-18-91	DH
	J) Assemble Stock						11/18/91	RW
	K) Assemble Swivel Studs						11-27-91	DH
	L) Attach Front and Rear Sight Assemblies						11/18/91	RW
	M) Iron Sight Alignment						11/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/18/91	RW
	O) Attach Scope to Rifle						11/18/91	RW
	P) Detach & Attach Scope 20 Times						11/18/91	RW
640	Gallery Target & Test						11-20-91	DH
	A) Time						11-20-91	DH
	B) Malfunctions						11-20-91	DH
	C) Pierced Primers						11-20-91	DH
	D) Optical Clarity of Scope						11-20-91	DH
645	Inspect for Live Ammo						11-20-91	DH
655	Final Inspection							
	A) Headspace						11-27-91	DH
	B) Trigger Pull	248	241	247	247	249	11-20-91	DH
	C) Function						11-27-91	DH
660	Pack						12-19-91	NF

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

SERIAL NO. C-6649063DATE 11-18-90TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.35	2.48	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.46	2.39	2.41	
PULL #3	2.35	2.39	2.40	2.47	
PULL #4	2.45	2.32	2.44	2.47	
PULL #5	2.33	2.44	2.50	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.46		
PULL #2	3.39	3.38		
PULL #3	3.35	3.46		
PULL #4	3.34	3.44		
PULL #5	3.32	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.62	4.41		4.26
PULL #2	4.52	4.20		4.20
PULL #3	4.45	4.27		4.43
PULL #4	4.26	4.27		4.35
PULL #5	4.36	4.39		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649063
20 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.315025
1 TO 2	.4106
1 TO 3	.212509
1 TO 4	1.30357
1 TO 5	.87485

4

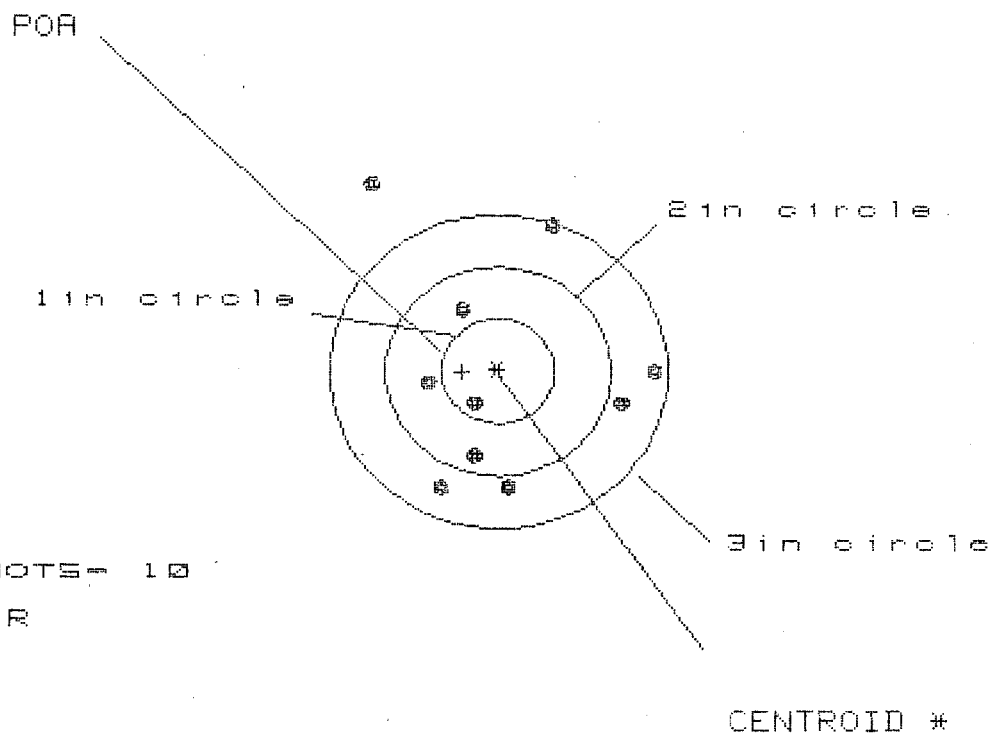
5 $\frac{2}{13}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2666
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .268966
THE RMS FOR THIS RIFLE IS: 1.045

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649063

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.573

VS = 2.966

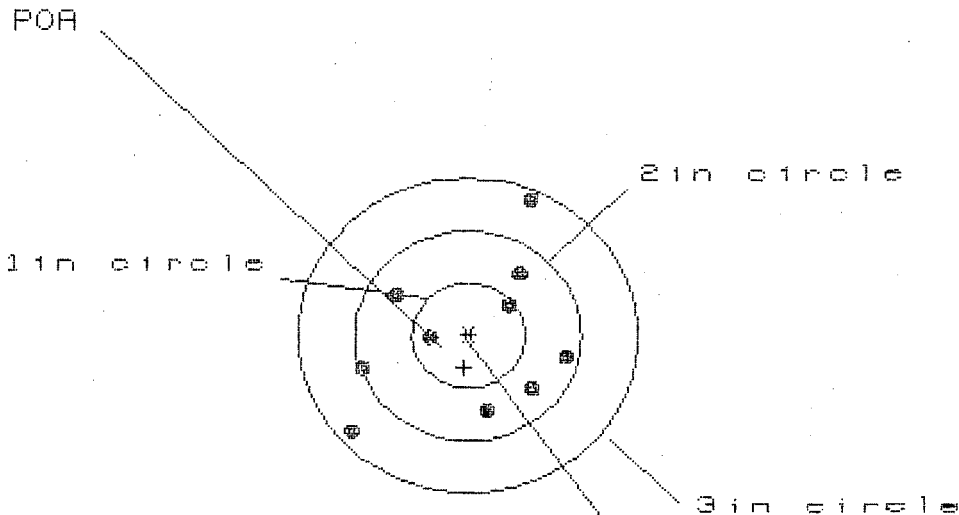
GS = 3.171

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.419	1.291	1.341
MINIMUM X	-1.154	-1.741	-1.691
MAXIMUM Y	1.817	1.551	1.002
MINIMUM Y	-1.149	-1.948	-1.754
CENTROID X	.315	.443	.393
CENTROID Y	.004	-.198	-.392
POA TO CENTROID in.	.315	.486	.555
MIN RADIUS	.358	.364	.328
MEAN RADIUS	1.096	.953	.830
MAX RADIUS	2.152	1.603	1.388
HORIZONTAL SPREAD	2.573	2.032	2.032
VERTICAL SPREAD	2.966	2.499	1.756
EXTREME SPREAD	3.171	2.720	2.252
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649063

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.883

VS= 2.158

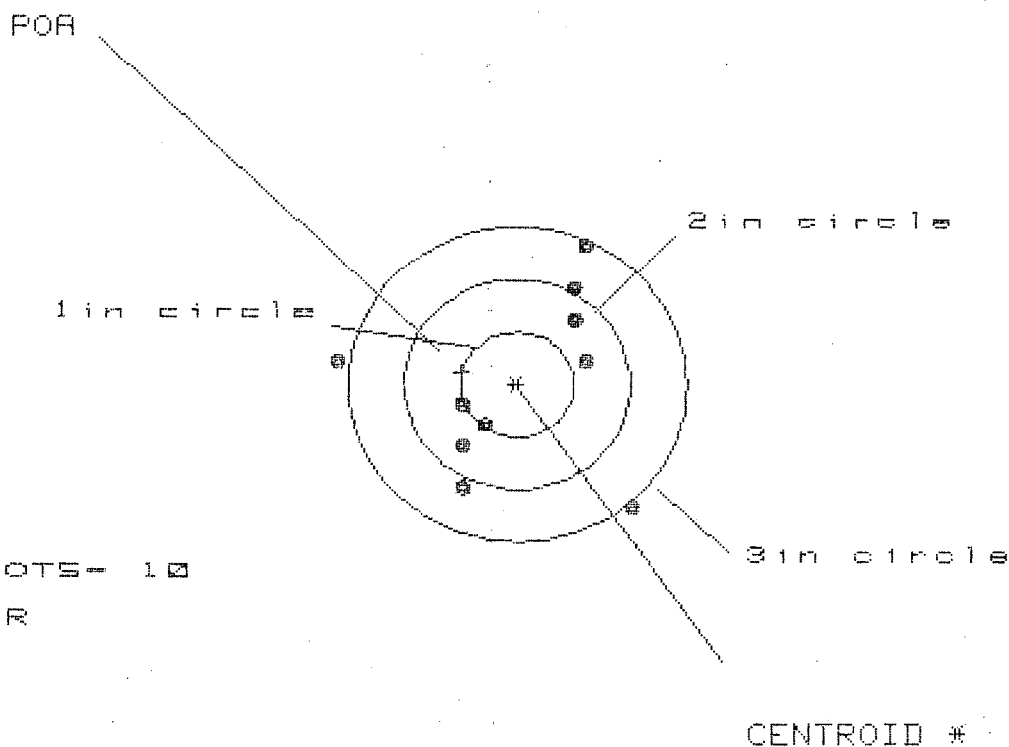
GS= 2.734

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.879	.753
MINIMUM X	:	-1.071	-1.004	-.997
MAXIMUM Y	:	1.288	.744	.653
MINIMUM Y	:	-.869	-.726	-.658
CENTROID X	:	.039	-.028	.098
CENTROID Y	:	.308	.165	.256
POA TO CENTROID in.	:	.311	.168	.274
MIN RADIUS	:	.319	.288	.380
MEAN RADIUS	:	.833	.764	.688
MAX RADIUS	:	1.424	1.239	1.025
HORIZONTAL SPREAD	:	1.883	1.883	1.750
VERTICAL SPREAD	:	2.158	1.470	1.311
EXTREME SPREAD	:	2.734	2.110	1.754
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649063

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.593

VS = 2.443

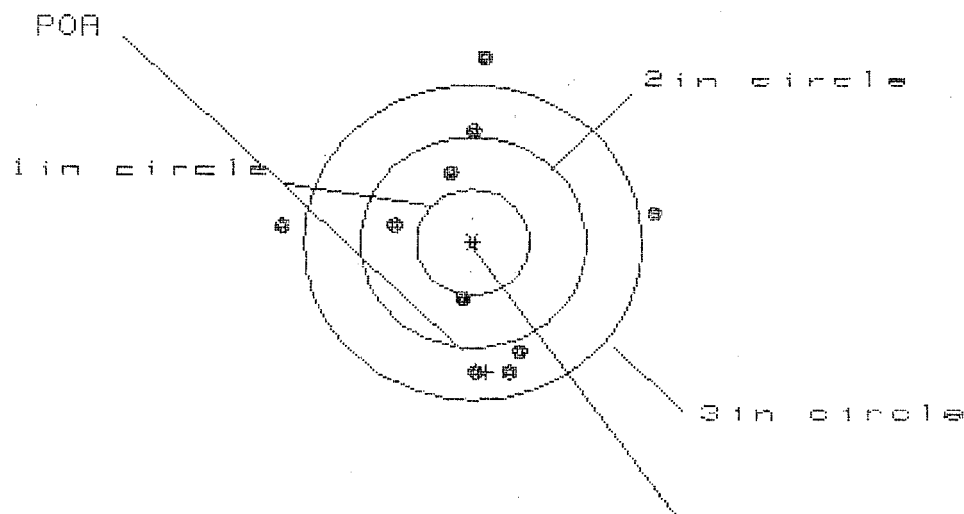
GS = 2.918

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.875	.578
MINIMUM X	:	-1.546	-.683	-.574
MAXIMUM Y	:	1.298	1.319	1.179
MINIMUM Y	:	-1.145	-1.124	-1.110
CENTROID X	:	.489	.661	.552
CENTROID Y	:	-.118	-.139	.001
POA TO CENTROID in.	:	.503	.676	.552
MIN RADIUS	:	.485	.523	.586
MEAN RADIUS	:	1.001	.938	.865
MAX RADIUS	:	1.558	1.424	1.294
HORIZONTAL SPREAD	:	2.593	1.558	1.152
VERTICAL SPREAD	:	2.443	2.443	2.289
EXTREME SPREAD	:	2.918	2.535	2.535
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649063

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.274

VS = 3.068

GS = 3.278

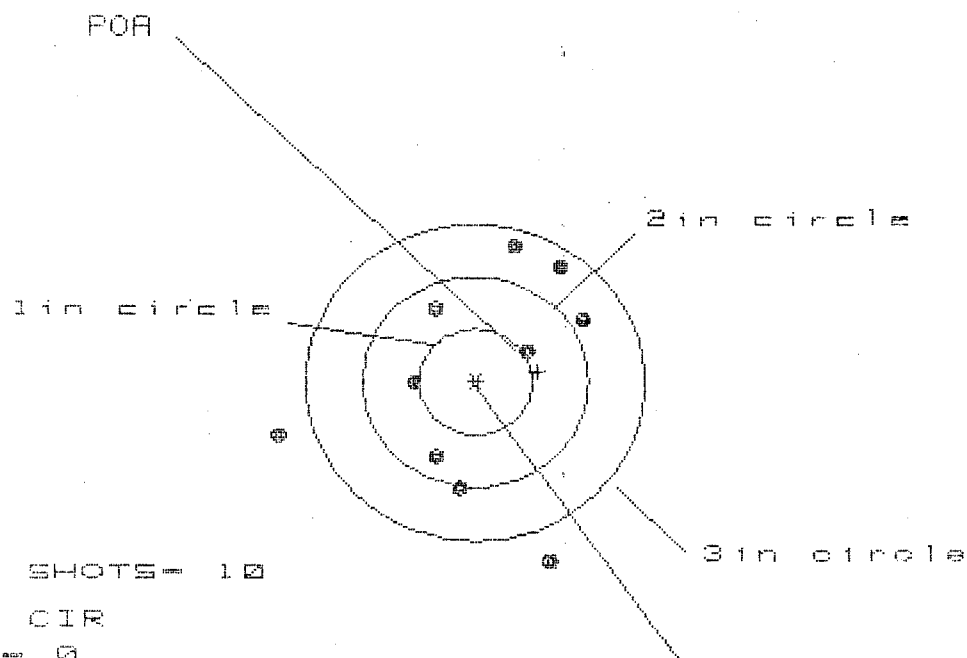
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.571	1.587	1.376
MINIMUM X	:	-1.704	-1.687	-.846
MAXIMUM Y	:	1.783	1.217	1.259
MINIMUM Y	:	-1.285	-1.087	-1.045
CENTROID X	:	-.111	-.127	.084
CENTROID Y	:	1.236	1.038	.996
POA TO CENTROID in.	:	1.241	1.045	1.000
MIN RADIUS	:	.546	.348	.403
MEAN RADIUS	:	1.171	1.077	.994
MAX RADIUS	:	1.789	1.719	1.474
HORIZONTAL SPREAD	:	3.274	3.274	2.222
VERTICAL SPREAD	:	3.068	2.304	2.304
EXTREME SPREAD	:	3.278	3.278	2.324
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			7	

20 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649063

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.790

VS= 2.969

GS= 3.084

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.997
MINIMUM X	-1.793
MAXIMUM Y	1.261
MINIMUM Y	-1.708
CENTROID X	-.554
CENTROID Y	-.097
POA TO CENTROID in.	.562
MIN RADIUS	.518
MEAN RADIUS	1.122
MAX RADIUS	1.872
HORIZONTAL SPREAD	2.790
VERTICAL SPREAD	2.969
EXTREME SPREAD	3.084
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8