

C6611774

MODEL 700™ M24

Model **SMS**™

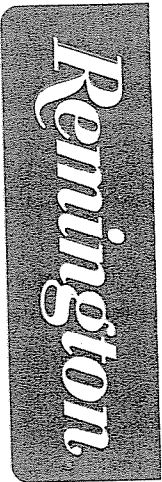
Action

Barrel Length

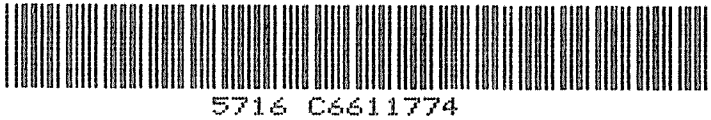
Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM N24		SERIAL NO. C6611774	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		46	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611774

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	Rw
600	Proof	3 28	91	Rw
607	Check Headspace	3 28	91	Rw
610	Dis-assemble Gun	3 28	91	Rw
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	K
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JS
	Apply Coating (Bolt)			P
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/10/91	Rw
	D) Oil Firing Pin Ass'y		4/10/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	JS

op. #	BARBER M24 0035708	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/17/91	JU
	G) Safety Off Force	4	4	4			4/17/91	JU
	H) Trigger Pull Test & Retainability						4/17/91	JU
	I) Firing Pin Indent	.023	.0235	.0235			4/17/91	JU
	J) Assemble Stock						4/23/91	RW
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/23/91	RW
	M) Iron Sight Alignment						4/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/91	RW
	O) Attach Scope to Rifle						4/23/91	RW
	P) Detach & Attach Scope 20 Times						4/23/91	RW
640	Gallery Target & Test						4-24-91	AC
	A) Time						4-24-91	AC
	B) Malfunctions						4-24-91	AC
	C) Pierced Primers						4-24-91	AC
	D) Optical Clarity of Scope						4-24-91	AC
645	Inspect for Live Ammo						4-24-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.38	2.54	2.54	2.48	2.55	4/26/91	JU
	C) Function						5-2-91	DH
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611774

DATE 4/12/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.40	2.38	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.40	2.43	2.54	
PULL #3	2.31	2.38	2.43	2.54	
PULL #4	2.34	2.38	2.36	2.48	
PULL #5	2.37	2.36	2.38	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.60		
PULL #2	3.48	3.61		
PULL #3	3.36	3.52		
PULL #4	3.60	3.32		
PULL #5	3.56	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.56		4.47
PULL #2	4.37	4.47		4.50
PULL #3	4.45	4.53		4.54
PULL #4	4.43	4.47		4.53
PULL #5	4.52	4.53		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611774
24 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.139463
1 TO	2	1.0802
1 TO	3	.486001
1 TO	4	.786649
1 TO	5	.787254

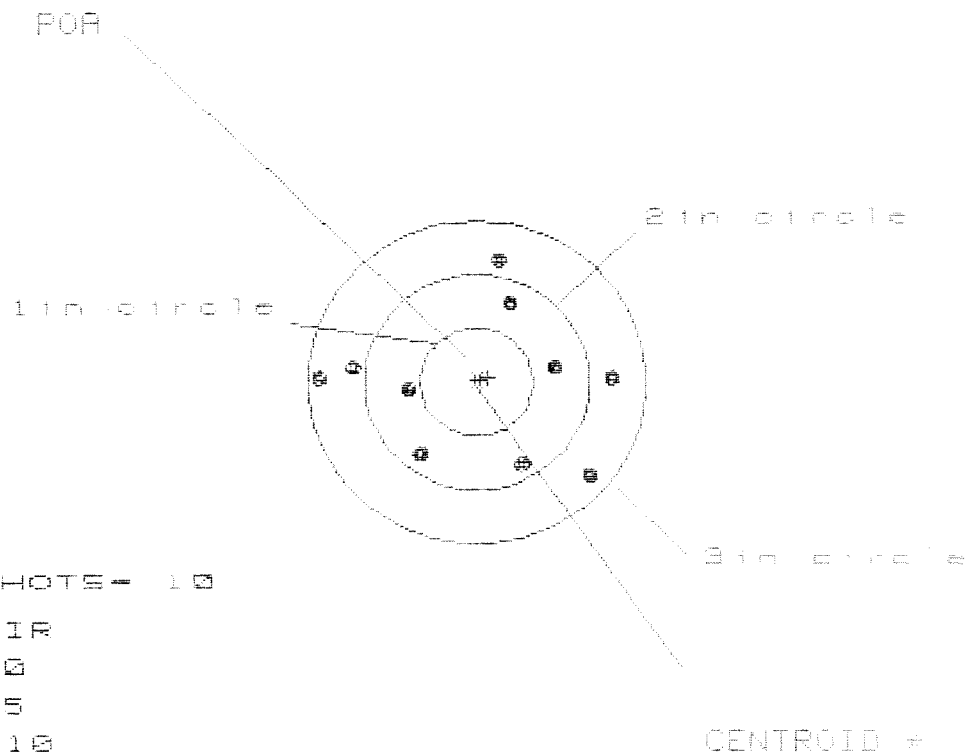
5
3
2 4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0816
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .166035
THE AMR FOR THIS RIFLE IS: 1.086

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08B11724

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS = 2.556

VS = 1.991

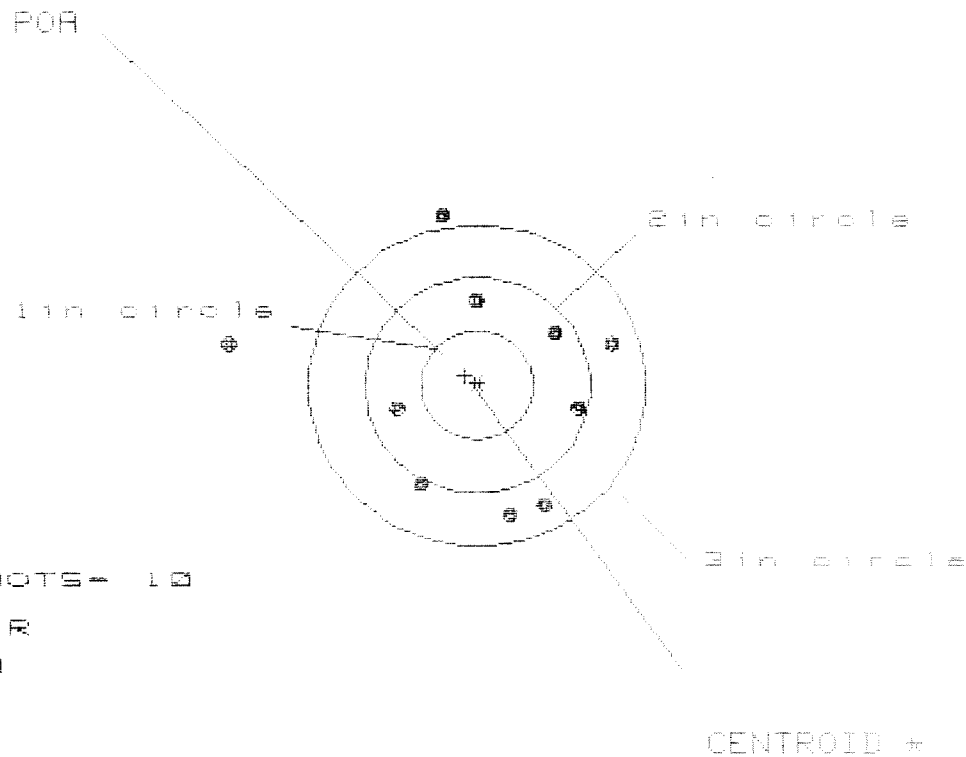
GS = 2.556

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.153	1.998	1.097
MINIMUM X	-1.403	-1.307	-1.208
MAXIMUM Y	1.168	1.171	1.069
MINIMUM Y	-.823	-.820	-.899
CENTROID X	-.097	.059	-.040
CENTROID Y	-.036	-.039	.063
POA TO CENTROID in.	.103	.071	.075
MIN RADIUS	.583	.568	.643
MEAN RADIUS	.996	.939	.907
MAX RADIUS	1.403	1.320	1.211
HORIZONTAL SPREAD	2.556	2.305	2.305
VERTICAL SPREAD	1.991	1.991	1.968
EXTREME SPREAD	2.556	2.325	2.311
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611774

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 6

HS = 3.399

VS = 2.720

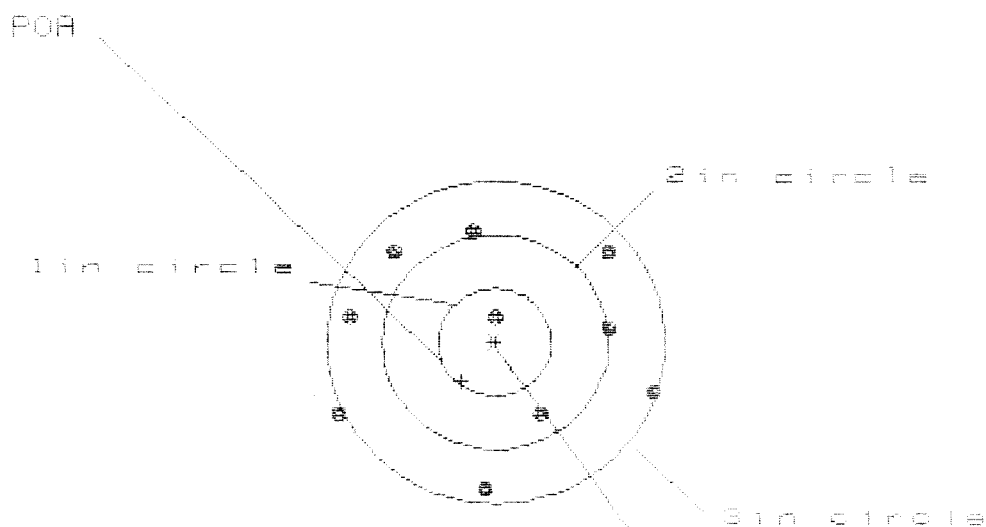
GS = 3.399

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.232	.992	.922
MINIMUM X	:	-2.167	-.908	-.978
MAXIMUM Y	:	1.549	1.592	.980
MINIMUM Y	:	-1.171	-1.128	-.929
CENTROID X	:	.109	.349	.419
CENTROID Y	:	-.087	-.130	-.329
POA TO CENTROID in.	:	.139	.373	.583
MIN RADIUS	:	.700	.644	.550
MEAN RADIUS	:	1.173	1.026	.923
MAX RADIUS	:	2.200	1.686	1.102
HORIZONTAL SPREAD	:	3.399	1.900	1.900
VERTICAL SPREAD	:	2.720	2.720	1.909
EXTREME SPREAD	:	3.399	2.788	2.168
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 9

HS = 2.718

VS = 2.417

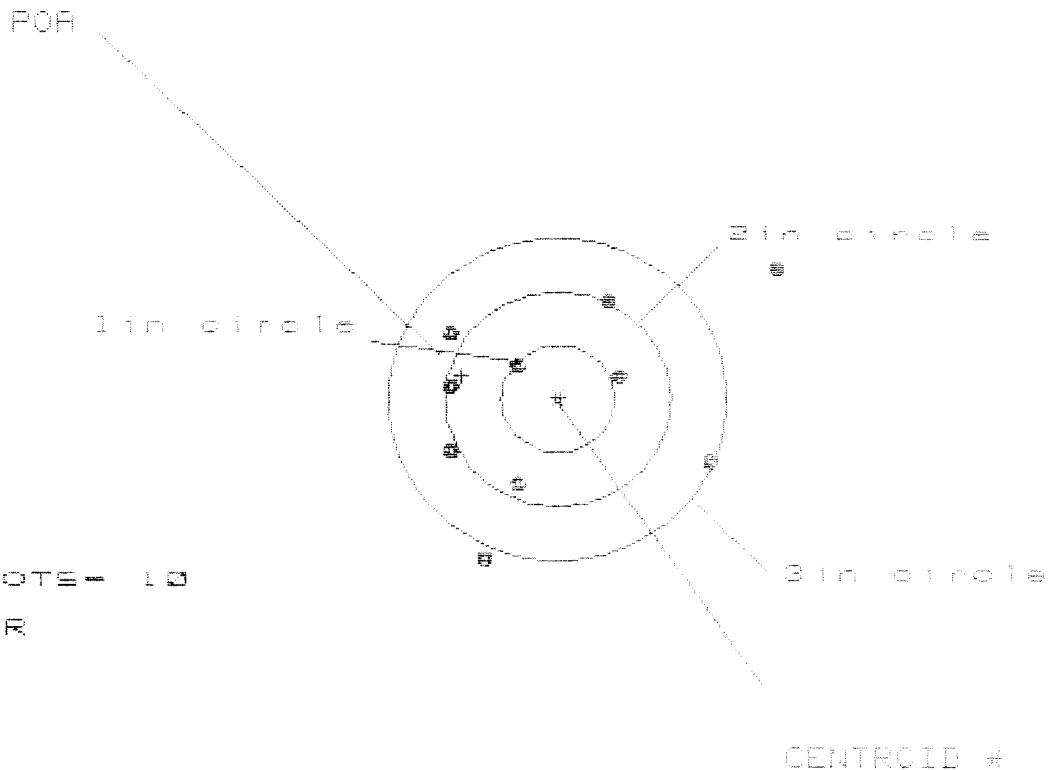
GS = 2.821

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.366	1.216	1.040
MINIMUM X	:	-1.352	-1.457	-1.305
MAXIMUM Y	:	1.037	.959	.888
MINIMUM Y	:	-1.380	-1.458	-1.530
CENTROID X	:	.295	.445	.293
CENTROID Y	:	.362	.440	.511
POA TO CENTROID in.	:	.467	.626	.590
MIN RADIUS	:	.239	.220	.090
MEAN RADIUS	:	1.128	1.064	1.011
MAX RADIUS	:	1.524	1.472	1.530
HORIZONTAL SPREAD	:	2.718	2.673	2.345
VERTICAL SPREAD	:	2.417	2.417	2.417
EXTREME SPREAD	:	2.821	2.763	2.432
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HE = 2.941

VE = 2.708

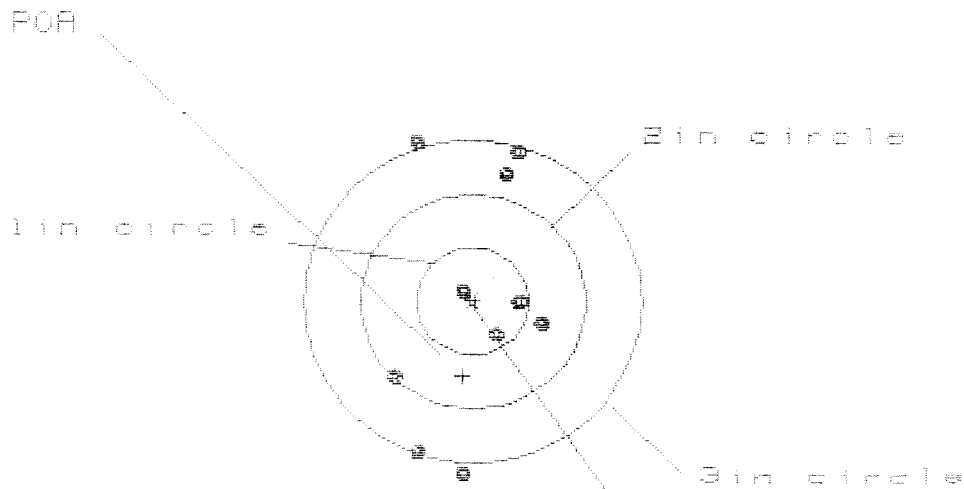
GE = 3.778

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.947	1.565	1.506
MINIMUM X	-0.994	-0.777	-0.886
MAXIMUM Y	1.210	1.022	0.852
MINIMUM Y	-1.498	-1.364	-0.810
CENTROID X	0.855	0.638	0.697
CENTROID Y	-0.216	-0.350	-0.180
POA TO CENTROID in.	0.882	0.728	0.720
MIN RADIUS	0.464	0.447	0.325
MEAN RADIUS	1.150	0.990	0.916
MAX RADIUS	2.293	1.622	1.620
HORIZONTAL SPREAD	2.941	2.342	2.342
VERTICAL SPREAD	2.708	2.386	1.662
EXTREME SPREAD	3.778	2.660	2.599
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS = 1.271

VS = 3.062

GS = 3.080

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.581	.571	.506
MINIMUM X	-.690	-.700	-.765
MAXIMUM Y	1.472	1.295	1.386
MINIMUM Y	-1.590	-1.530	-1.368
CENTROID X	.089	.099	.164
CENTROID Y	.706	.877	.715
POB TO CENTROID in.	.706	.883	.734
MIN RADIUS	.164	.126	.211
MEAN RADIUS	.982	.914	.824
MAX RADIUS	1.590	1.617	1.489
HORIZONTAL SPREAD	1.271	1.271	1.271
VERTICAL SPREAD	3.062	2.825	2.754
EXTREME SPREAD	3.080	2.903	2.903
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	