

C661513

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611513
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611513



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611513**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/18/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JS

op. #	BARBER M24 0078062	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			4-22-91	DH
	G) Safety Off Force	2 1/2	2	2			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	JH
	I) Firing Pin Indent	.021	.021	.020			4-22-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4-23-91	DH
	A) Time						4-23-91	DH
	B) Malfunctions						4-23-91	DH
	C) Pierced Primers						4-23-91	DH
	D) Optical Clarity of Scope						4-23-91	DH
645	Inspect for Live Ammo						4-23-91	DH
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.43	2.37	2.42	2.50	2.44	4/22/91	JH
	C) Function						5-1-91	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. C16661513

DATE 4/19/91

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.24	2.23	2.43	MIN. SETTING,
PULL #2	2.57	2.27	2.23	2.32	NO. AVG. OF 5
PULL #3	2.17	2.16	2.20	2.42	READINGS ACCEPT-
PULL #4	2.27	2.20	2.19	2.50	ABLE LESS THAN 2#
PULL #5	2.21	2.21	2.28	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.34	3.32			
PULL #2	3.24	3.41			
PULL #3	3.21	3.33			
PULL #4	3.49	3.31			
PULL #5	3.53	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	4.31	4.33		4.31
PULL #2	4.41	4.30		4.36
PULL #3	4.39	4.30		4.31
PULL #4	4.30	4.25		4.27
PULL #5	4.40	4.29		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611513
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.155487
1 TO	2	.235128
1 TO	3	.132015
1 TO	4	.173643
1 TO	5	.352683

75 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1276
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0728
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14690
THE AMR FOR THIS RIFLE IS: .9808

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11513

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.526

VS = 2.656

CS = 3.100

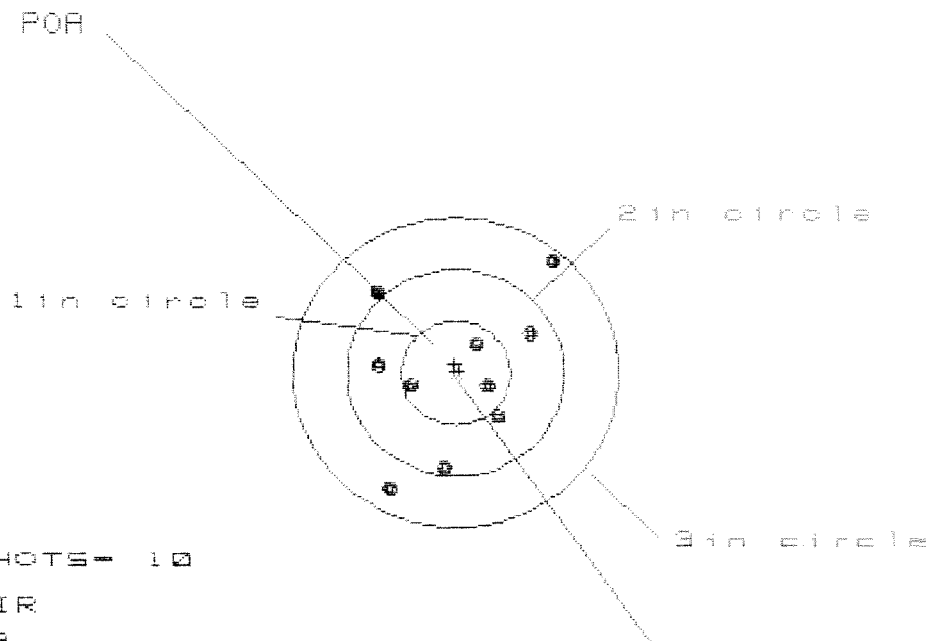
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.224	1.267	1.130
MINIMUM X	-1.302	-1.166	-1.392
MAXIMUM Y	1.420	1.283	1.133
MINIMUM Y	-1.236	-1.197	-1.286
CENTROID X	.037	-.099	.038
CENTROID Y	.151	.288	.438
POA TO CENTROID in.	.155	.304	.439
MIN RADIUS	.033	.161	.260
MEAN RADIUS	1.104	1.027	.943
MAX RADIUS	1.739	1.618	1.377
HORIZONTAL SPREAD	2.526	2.433	2.433
VERTICAL SPREAD	2.656	2.480	2.420
EXTREME SPREAD	3.100	2.944	2.449
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11513

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.604

VS = 2.174

GS = 2.677

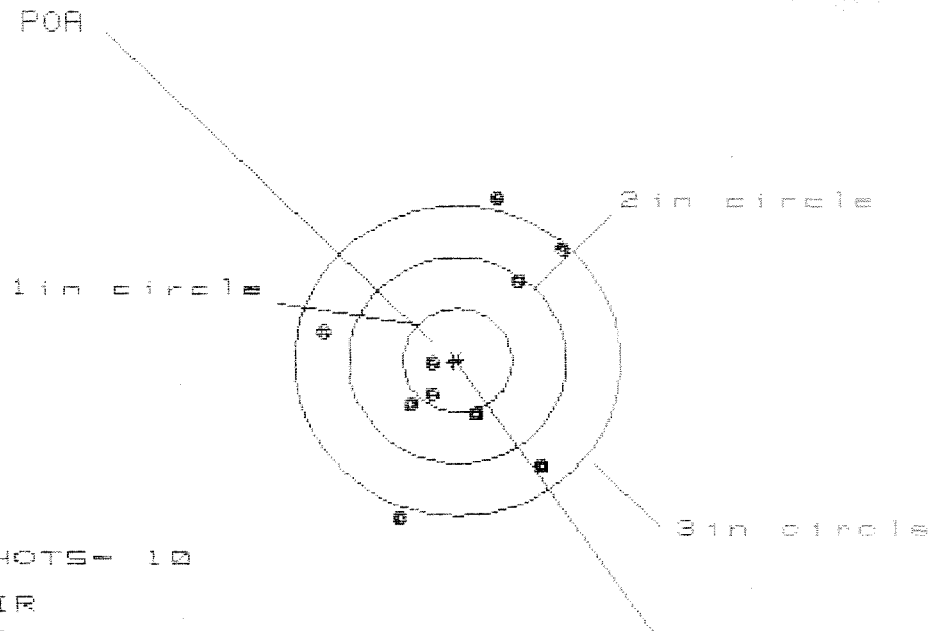
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.904	.816	.746
MINIMUM X	-.700	-.600	-.669
MAXIMUM Y	1.092	.926	.806
MINIMUM Y	-1.082	-.960	-.908
CENTROID X	-.014	-.086	-.017
CENTROID Y	-.083	-.205	-.085
POA TO CENTROID in.	.085	.222	.086
MIN RADIUS	.331	.280	.352
MEAN RADIUS	.775	.699	.635
MAX RADIUS	1.418	1.111	1.030
HORIZONTAL SPREAD	1.604	1.416	1.416
VERTICAL SPREAD	2.174	1.886	1.714
EXTREME SPREAD	2.677	2.005	1.814
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11513

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.196

VS = 3.071

GS = 3.191

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.933
MINIMUM X	-1.262
MAXIMUM Y	1.588
MINIMUM Y	-1.483
CENTROID X	.035
CENTROID Y	.019
POA TO CENTROID in.	.039
MIN RADIUS	.262
MEAN RADIUS	.999
MAX RADIUS	1.630
HORIZONTAL SPREAD	2.196
VERTICAL SPREAD	3.071
EXTREME SPREAD	3.191
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611513

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.035

VS = 3.009

GS = 3.060

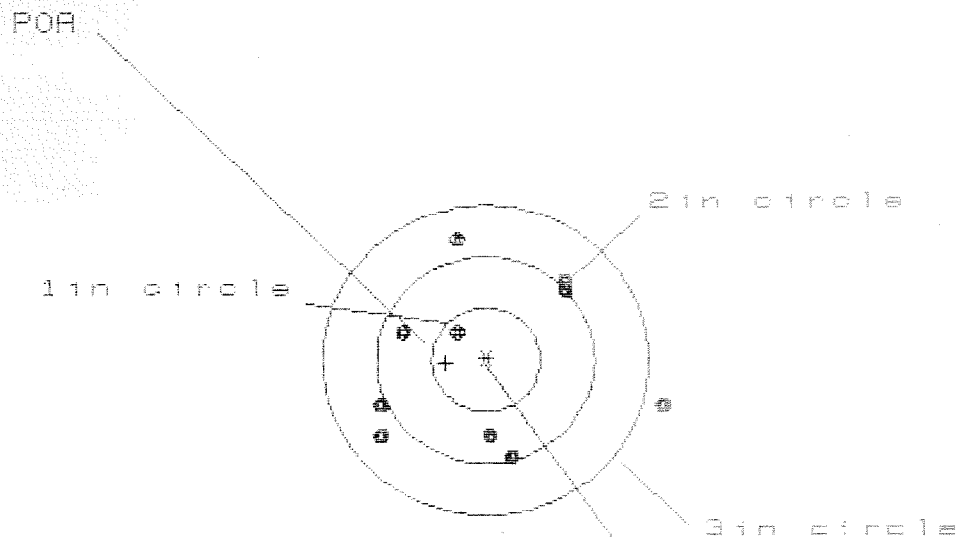
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.815	.788	.632
MINIMUM X	-1.220	-1.247	-1.063
MAXIMUM Y	1.371	1.189	1.068
MINIMUM Y	-1.638	-1.017	-1.138
CENTROID X	.183	.210	.366
CENTROID Y	.245	.427	.548
POA TO CENTROID in.	.306	.476	.659
MIN RADIUS	.270	.378	.394
MEAN RADIUS	1.025	.936	.831
MAX RADIUS	1.656	1.580	1.300
HORIZONTAL SPREAD	2.035	2.035	1.695
VERTICAL SPREAD	3.009	2.206	2.206
EXTREME SPREAD	3.060	2.648	2.245
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611513

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.552

VS= 2.064

GS= 2.567

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.591
MINIMUM X	-.961
MAXIMUM Y	1.154
MINIMUM Y	-.910
CENTROID X	.369
CENTROID Y	.032
POA TO CENTROID in.	.371
MIN RADIUS	.403
MEAN RADIUS	1.001
MAX RADIUS	1.648
HORIZONTAL SPREAD	2.552
VERTICAL SPREAD	2.064
EXTREME SPREAD	2.567
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 4
NUMBER IN THREE INCH CIRCLE	= 9