

C6611625

MODEL 700™ M24

Model 515™

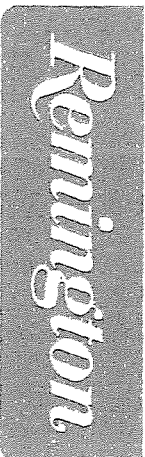
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Smith & Wesson®

Remington®

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

DUPONT

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

MODEL 700™ H24

		SERIAL NO.
		06611625
		ORDER NO.
		5716

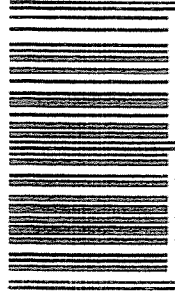
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

46



5716 06611625

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611625

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 91		Rw
600	Proof	2 1 91		Rw
607	Check Headspace	2 1 91		Rw
610	Dis-assemble Gun	2 1 91		Rw
612	Magnaflux Barrel Action	2 11 91		Ked
	Magnaflux Bolt	2 11 91		Ked
615	Rollmark Caliber	2 11 91		ES
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RAB	2 13 91		WB
620	Apply Coatings (Barrel Action)		3/25/91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/8/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-10-91	DH
	G) Safety Off Force	2	3	2			4-10-91	DH
	H) Trigger Pull Test & Retainability						4/9/91	JH
	I) Firing Pin Indent	.022	.022	.022			4-10-91	DH
	J) Assemble Stock						4/12/91	RW
	K) Assemble Swivel Studs						4-17-91	K
	L) Attach Front and Rear Sight Assemblies						4/12/91	RW
	M) Iron Sight Alignment						4/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	RW
	O) Attach Scope to Rifle						4/12/91	RW
	P) Detach & Attach Scope 20 Times						4/12/91	RW
640	Gallery Target & Test						4-12-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-9-91	AF
655	Final Inspection							
	A) Headspace						4-17-91	K
	B) Trigger Pull	2.39	2.48	2.50	2.53	2.58	4/16/91	JH
	C) Function						4-17-91	K
660	Pack						6-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611625
DATE 4/8/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.57	2.40	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.54	2.38	2.48	
PULL #3	2.55	2.29	2.36	2.50	
PULL #4	2.46	2.38	2.42	2.53	
PULL #5	2.43	2.38	2.24	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.35		
PULL #2	3.48	3.50		
PULL #3	3.46	3.28		
PULL #4	3.46	3.31		
PULL #5	3.42	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.28		4.35
PULL #2	4.43	4.18		4.35
PULL #3	4.41	4.31		4.42
PULL #4	4.41	4.36		4.42
PULL #5	4.41	4.42		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611625
12 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.3246
1 TO	2	.323489
1 TO	3	.38684
1 TO	4	.178617
1 TO	5	.191565

塔 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1402
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1362
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .195465
THE AMR FOR THIS RIFLE IS: .9116

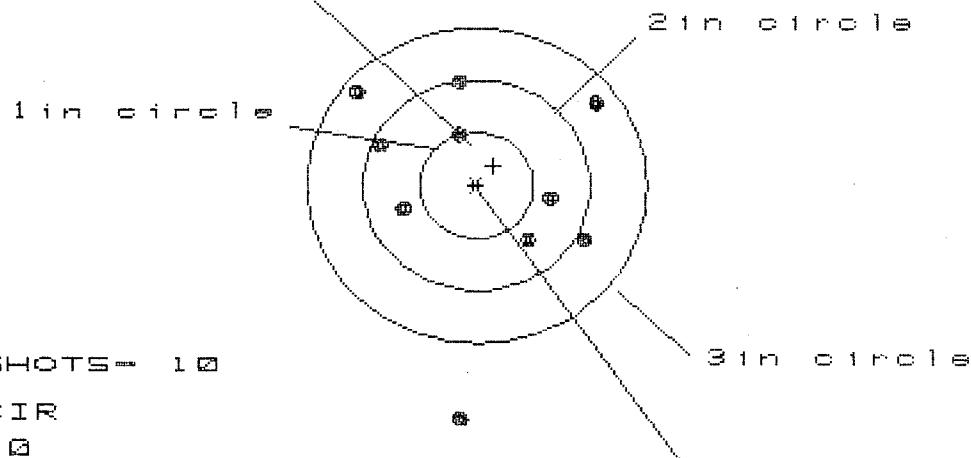
12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611625

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in - 0

2in - 6

3in - 9

HS- 2.066

VS- 3.197

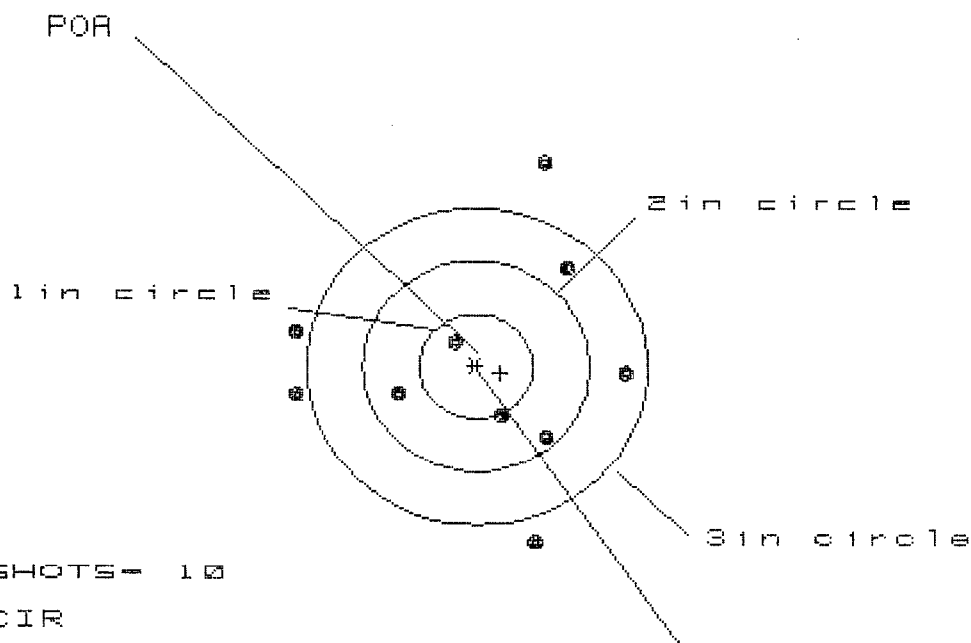
GS- 3.246

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	1.028	.898
MINIMUM X	:	-1.017	-1.038	-1.044
MAXIMUM Y	:	.954	.705	.784
MINIMUM Y	:	-2.243	-.770	-.691
CENTROID X	:	-.149	-.128	.002
CENTROID Y	:	-.185	.064	-.015
POA TO CENTROID in.	:	.238	.143	.015
MIN RADIUS	:	.549	.340	.486
MEAN RADIUS	:	1.058	.892	.850
MAX RADIUS	:	2.251	1.216	1.073
HORIZONTAL SPREAD	:	2.066	2.066	1.942
VERTICAL SPREAD	:	3.197	1.475	1.475
EXTREME SPREAD	:	3.246	2.425	2.084
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 2.918

VS= 3.551

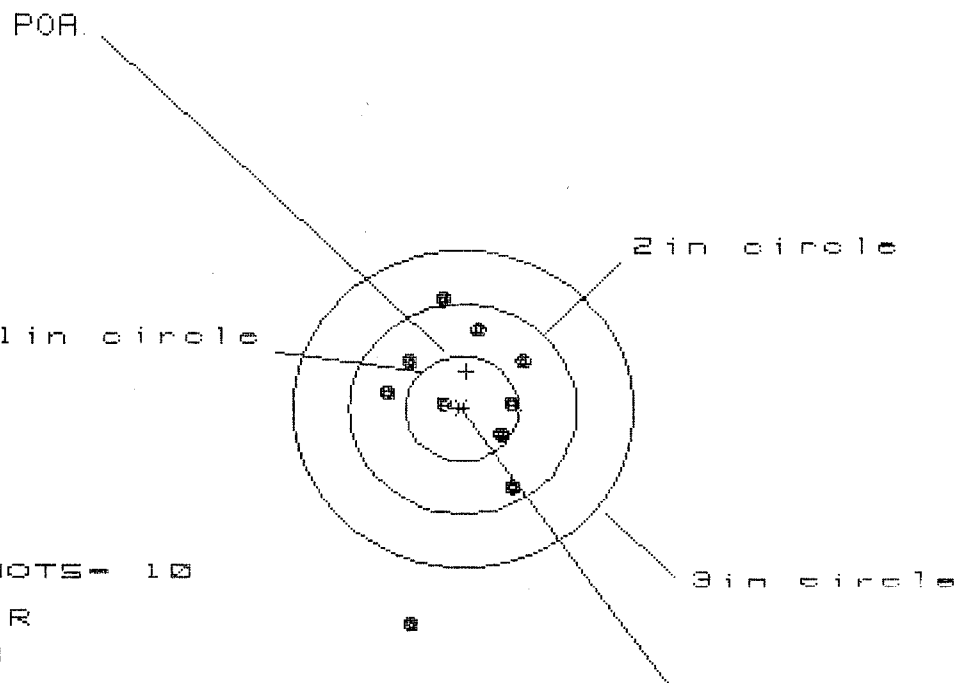
GS= 3.551

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.319	1.385	1.462
MINIMUM X	:	-1.599	-1.533	-1.456
MAXIMUM Y	:	1.910	1.155	.976
MINIMUM Y	:	-1.641	-1.429	-.614
CENTROID X	:	-.213	-.279	-.356
CENTROID Y	:	.062	-.150	.029
POA TO CENTROID in.	:	.222	.317	.357
MIN RADIUS	:	.308	.368	.253
MEAN RADIUS	:	1.197	1.087	1.020
MAX RADIUS	:	2.001	1.639	1.511
HORIZONTAL SPREAD	:	2.918	2.918	2.918
VERTICAL SPREAD	:	3.551	2.584	1.590
EXTREME SPREAD	:	3.551	2.954	2.954
NUMBER IN ONE INCH CIRCLE	=	1		
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 - 3

2 in - 8

3 in - 9

HS - 1.234

VS - 3.104

GS - 3.121

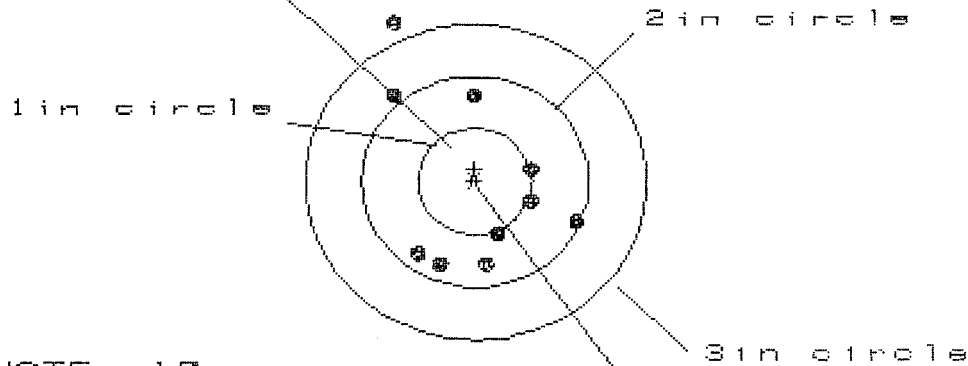
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.552	.502	.481
MINIMUM X	-.682	-.732	-.753
MAXIMUM Y	1.088	.864	.606
MINIMUM Y	-2.016	-.919	-.811
CENTROID X	-.035	.015	.036
CENTROID Y	-.355	-.131	-.239
POA TO CENTROID in.	.357	.132	.242
MIN RADIUS	.197	.306	.275
MEAN RADIUS	.788	.617	.577
MAX RADIUS	2.065	.998	.891
HORIZONTAL SPREAD	1.234	1.234	1.234
VERTICAL SPREAD	3.104	1.783	1.417
EXTREME SPREAD	3.121	1.869	1.464
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4

FOR



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 1.639

VS= 2.326

GS= 2.472

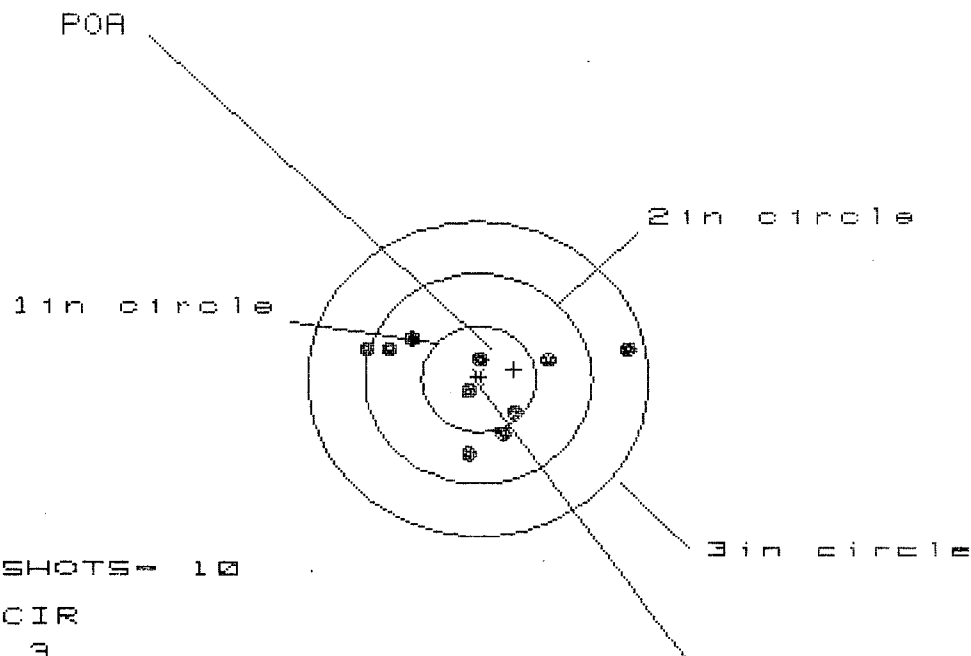
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.934	.855	.758
MINIMUM X	:	-.705	-.778	-.653
MAXIMUM Y	:	1.498	1.027	1.069
MINIMUM Y	:	-.828	-.662	-.533
CENTROID X	:	.009	.088	.185
CENTROID Y	:	-.117	-.283	-.412
FOR TO CENTROID in.	:	.117	.297	.451
MIN RADIUS	:	.508	.365	.213
MEAN RADIUS	:	.859	.724	.612
MAX RADIUS	:	1.656	1.289	1.088
HORIZONTAL SPREAD	:	1.639	1.633	1.411
VERTICAL SPREAD	:	2.326	1.689	1.602
EXTREME SPREAD	:	2.472	2.034	1.632
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	0	8	8
NUMBER IN THREE INCH CIRCLE	=	0	9	9

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 3

2in - 9

3in - 10

HS- 2.263

VS- 1.057

GS- 2.264

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.320	.770	.671
MINIMUM X	:	-.943	-.796	-.754
MAXIMUM Y	:	.361	.388	.430
MINIMUM Y	:	-.696	-.669	-.627
CENTROID X	:	-.313	-.460	-.361
CENTROID Y	:	-.086	-.113	-.155
POA TO CENTROID in.	:	.325	.474	.392
MIN RADIUS	:	.115	.112	.031
MEAN RADIUS	:	.656	.577	.519
MAX RADIUS	:	1.344	.863	.846
HORIZONTAL SPREAD	:	2.263	1.566	1.425
VERTICAL SPREAD	:	1.057	1.057	1.057
EXTREME SPREAD	:	2.264	1.570	1.429
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	