

C6225282

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Sweat®

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225282

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT 4 4	89	RW
600	Proof	4 4	89	RW
607	Check Headspace	4 4	89	RW
610	Dis-assemble Gun	4 4	89	RW
612	Magnaflux Barrel Action	4-6	89	KCR
	Magnaflux Bolt	4-7	89	KCR
615	Rollmark Caliber	4-7	89	G.S.
617	Drill and Tap Sight Holes	4 7	89	YB
618	Polish Barrel	4 7	89	BT
620	Apply Coatings (Barrel Action)		4-19-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/89	RW
	C) Inspect Ejector Hole for Chamfer		4/24/89	RW
	D) Oil Firing Pin Ass'y		4/24/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/26/89	D.S.

op. #	BARBER - M24 0012035 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			4/24/89	JS
	G) Safety Off Force	3	3	3			4/24/89	JS
	H) Trigger Pull Test & Retainability						4/24/89	D.S.
	I) Firing Pin Indent	.020	.021	.022			4/26/89	JS
	J) Assemble Stock						5/1/89	RW
	K) Assemble Swivel Studs						16 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/1/89	RW
	M) Iron Sight Alignment						5/1/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/1/89	RW
	O) Attach Scope to Rifle						5/1/89	JS
	P) Detach & Attach Scope 20 Times						5/2/89	JS
640	Gallery Target & Test	104 R	47 L				5/2/89	A
	A) Time						5/2/89	A
	B) Malfunctions						5/2/89	A
	C) Pierced Primers						5/2/89	A
	D) Optical Clarity of Scope						5/2/89	A
645	Inspect for Live Ammo						5/2/89	A
655	Final Inspection A) Headspace						16 May 89	JS
	B) Trigger Pull	2.46	2.72	2.64	2.77	2.69	16 May 89	JS
	C) Function						16 May 89	JS
660	Pack						27 June 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225282

DATE 3-28-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.38		2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.40		2.41	
PULL #3	2.39	2.40		2.40	
PULL #4	2.35	2.40		2.41	
PULL #5	2.42	2.38		2.40	
TOTAL	11.97	11.96		12.03	
AVG.	2.394	2.392		2.406	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.39		
PULL #2	3.20	3.36		
PULL #3	3.21	3.34		
PULL #4	3.21	3.35		
PULL #5	3.25	3.19		
TOTAL	16.10	16.61		
AVG.	3.22	3.322		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.31		
PULL #2	4.34	4.37		
PULL #3	4.25	4.36		
PULL #4	4.40	4.34		
PULL #5	4.38	4.37		
TOTAL	21.80	21.75		
AVG.	4.36	4.35		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225282
3 May 1989

CENTROIDAL DISTANCES

0 TO	1	.412176
1 TO	2	.291548
1 TO	3	.941269
1 TO	4	.19462
1 TO	5	.45957

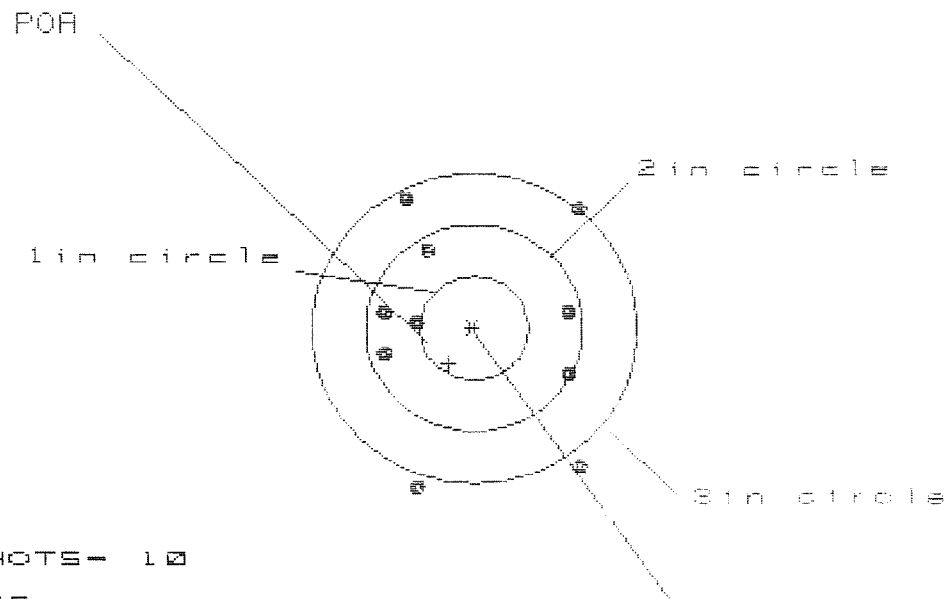

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .034
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0518
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0619616
 THE AMR FOR THIS RIFLE IS: 1.04

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225282

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 1.830

VS= 2.806

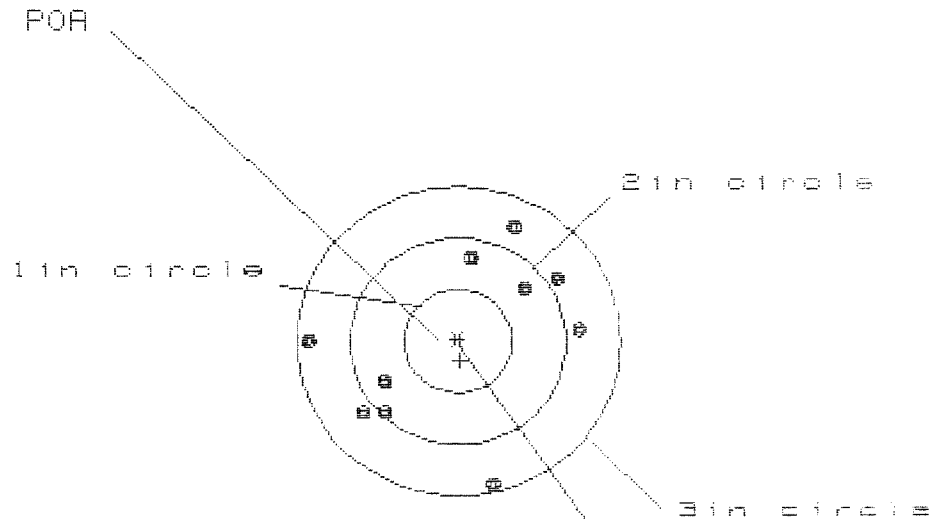
GS= 3.130

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.012	1.118	1.068
MINIMUM X	:	-.819	-.712	-.778
MAXIMUM Y	:	1.282	1.130	.920
MINIMUM Y	:	-1.524	-1.676	-.758
CENTROID X	:	.233	.126	.184
CENTROID Y	:	.340	.492	.702
POA TO CENTROID in.	:	.412	.508	.726
MIN RADIUS	:	.514	.427	.524
MEAN RADIUS	:	1.129	1.037	.943
MAX RADIUS	:	1.677	1.741	1.335
HORIZONTAL SPREAD	:	1.830	1.830	1.830
VERTICAL SPREAD	:	2.806	2.806	1.678
EXTREME SPREAD	:	3.130	3.130	2.338
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225282

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS = 2.455

VS = 2.507

GS = 2.515

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.106	1.137	.972
MINIMUM X	:	-1.349	-1.318	-1.024
MAXIMUM Y	:	1.145	.994	.980
MINIMUM Y	:	-1.362	-.889	-.903
CENTROID X	:	-.017	-.048	.117
CENTROID Y	:	.190	.341	.355
POA TO CENTROID in.	:	.191	.344	.374
MIN RADIUS	:	.750	.691	.544
MEAN RADIUS	:	1.067	1.016	.953
MAX RADIUS	:	1.390	1.323	1.365
HORIZONTAL SPREAD	:	2.455	2.455	1.996
VERTICAL SPREAD	:	2.507	1.883	1.883
EXTREME SPREAD	:	2.515	2.456	2.326
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS223282

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.189

VS= 2.815

GS= 3.294

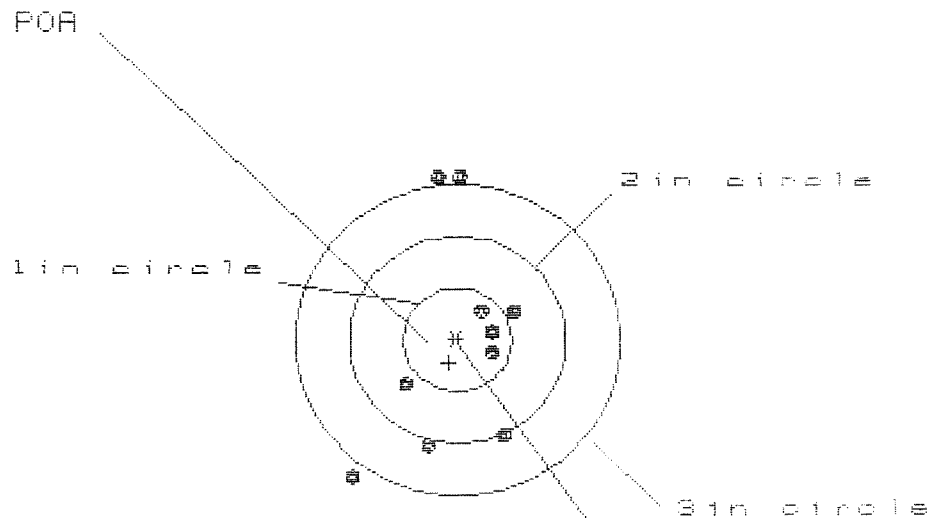
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	1.007	1.120
MINIMUM X	:	-1.964	-1.385	-1.272
MAXIMUM Y	:	1.556	1.544	1.385
MINIMUM Y	:	-1.259	-1.271	-1.238
CENTROID X	:	.025	.243	.130
CENTROID Y	:	-.578	-.566	-.407
POA TO CENTROID in.	:	.578	.616	.427
MIN RADIUS	:	.460	.244	.401
MEAN RADIUS	:	1.174	1.049	.985
MAX RADIUS	:	1.967	1.642	1.455
HORIZONTAL SPREAD	:	3.189	2.392	2.392
VERTICAL SPREAD	:	2.815	2.815	2.623
EXTREME SPREAD	:	3.294	3.172	2.660
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/082252B2

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 1.552

VS= 2.854

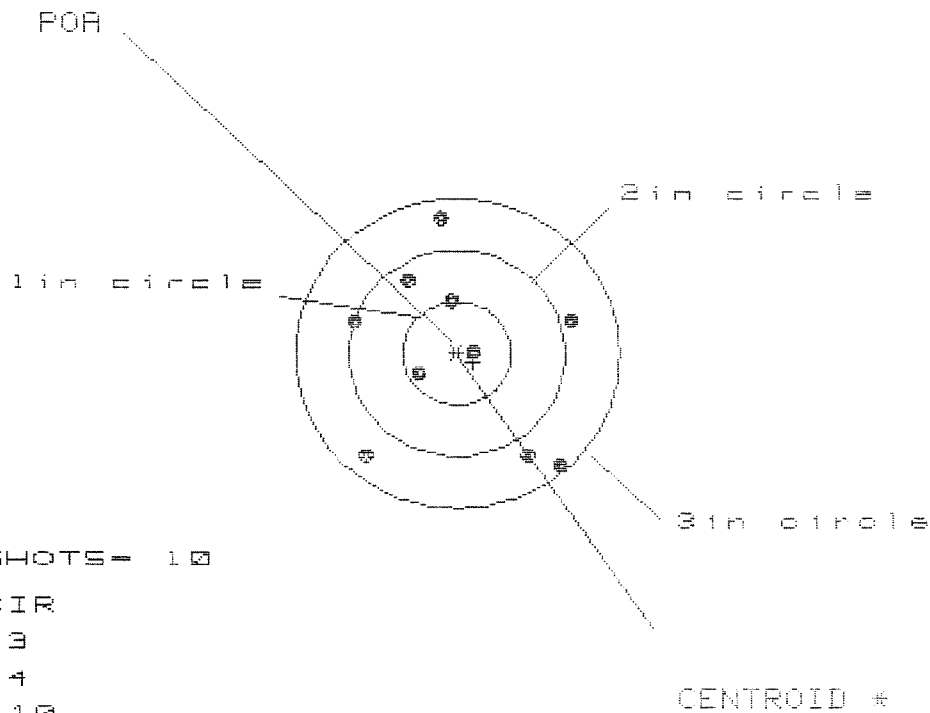
GS= 2.989

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.558	.448	.417
MINIMUM X	:	-.994	-.575	-.606
MAXIMUM Y	:	1.583	1.442	1.571
MINIMUM Y	:	-1.271	-1.193	-1.013
CENTROID X	:	.079	.189	.220
CENTROID Y	:	.221	.362	.182
POA TO CENTROID in.	:	.235	.409	.285
MIN RADIUS	:	.349	.170	.214
MEAN RADIUS	:	.913	.802	.699
MAX RADIUS	:	1.613	1.463	1.574
HORIZONTAL SPREAD	:	1.552	1.023	1.023
VERTICAL SPREAD	:	2.854	2.635	2.584
EXTREME SPREAD	:	2.989	2.641	2.608
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225282

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS= 2.001

VS= 2.413

GS= 2.682

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.010
MINIMUM X	-.991
MAXIMUM Y	1.350
MINIMUM Y	-1.063
CENTROID X	-.150
CENTROID Y	.086
POR TO CENTROID in.	.173
MIN RADIUS	.124
MEAN RADIUS	.916
MAX RADIUS	1.458
HORIZONTAL SPREAD	2.001
VERTICAL SPREAD	2.413
EXTREME SPREAD	2.682
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	10

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

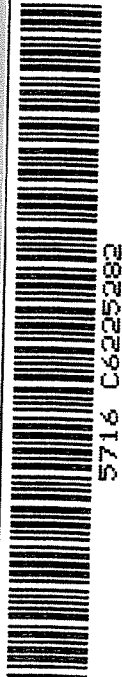
MODEL 700™ H24

SERIAL NO.
C6225282

ORDER NO.
5716

Q1

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UPC

