

C6225301

MODEL 700™ M24

Model **SMS**™

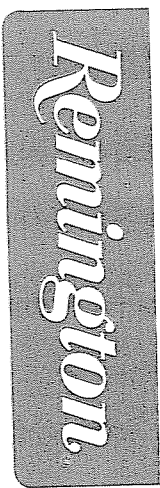
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
REMINGTON & CO. N.Y. U.S.A. REG. U.S. PAT. & TM. OFF. MARCA REGISTRADA MARQUE DEPOSEE.

MODEL 700™ H24

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

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

SERIAL NO.
C6225301

ORDER NO.
5716

01

5716 C6225301

0 47700 25716 7

Replace

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225301

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20 89		RW
600	Proof	12-20 89		A
607	Check Headspace	12-20 89		A
610	Dis-assemble Gun	12-20 89		RW
612	Magnaflux Barrel Action	1-5-90		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/8/90	GS
617	Drill and Tap Sight Holes		1/10/90	FB
618	Polish Barrel RB		1/10/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	PA
	Apply Coating (Bolt)			
625	Final Assembly		2/1/90	WB
	A) Clean inside of Bolt Assembly		1/16/90	
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/16/90	GS

BARBER - M24 0012340

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	1-16-90	gcl
	G) Safety Off Force	5	3	3	1-16-90	gcl
	H) Trigger Pull Test & Retainability				16 MAR 90	gcl
	I) Firing Pin Indent	1020	1021	10205	1-16-90	gcl
	J) Assemble Stock				3/15/90	RW
	K) Assemble Swivel Studs				16 MAR 90	gcl
	L) Attach Front and Rear Sight Assemblies				3/15/90	RW
	M) Iron Sight Alignment				3/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container				3/15/90	RW
	O) Attach Scope to Rifle				15 MAR 90	gcl
	P) Detach & Attach Scope 20 Times				15 MAR 90	gcl
640	Gallery Target & Test				3-15-90	A
	A) Time				"	A
	B) Malfunctions				"	A
	C) Pierced Primers				"	A
	D) Optical Clarity of Scope				"	A
645	Inspect for Live Ammo				3-15-90	A
655	Final Inspection				16 MAR 90	gcl
	A) Headspace				16 MAR 90	gcl
	B) Trigger Pull	278	280	279	16 MAR 90	gcl
	C) Function				16 MAR 90	gcl
660	Pack				19 MAR 90	gcl

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225301DATE 16 Jan 90TESTER JES

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.42	2.52	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.53	2.51	2.80	
PULL #3	2.45	2.31	2.49	2.79	
PULL #4	2.34	2.47	2.49	2.77	
PULL #5	2.49	2.33	2.58	2.79	
TOTAL	12.17	12.06	12.59	13.91	
AVG.	2.434	2.412	2.518	2.782	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	2.86		
PULL #2	2.87	2.90		
PULL #3	2.99	2.89		
PULL #4	3.05	2.89		
PULL #5	2.91	2.85		
TOTAL	14.84	14.39		
AVG.	2.968	2.878		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.96	3.89		3.90
PULL #2	3.94	3.89		4.08
PULL #3	3.97	3.87		3.84
PULL #4	3.95	3.81		4.09
PULL #5	3.93	3.84		4.10
TOTAL	19.75	19.30		20.01
AVG.	3.95	3.86		4.002

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225301
15 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.388171
1 TO	2	.437321
1 TO	3	.402826
1 TO	4	.41389
1 TO	5	.839849

z_j^5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .08
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0754
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .109933
THE AMR FOR THIS RIFLE IS: .9234

15 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06225381

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.826

VS= 1.972

GS= 2.281

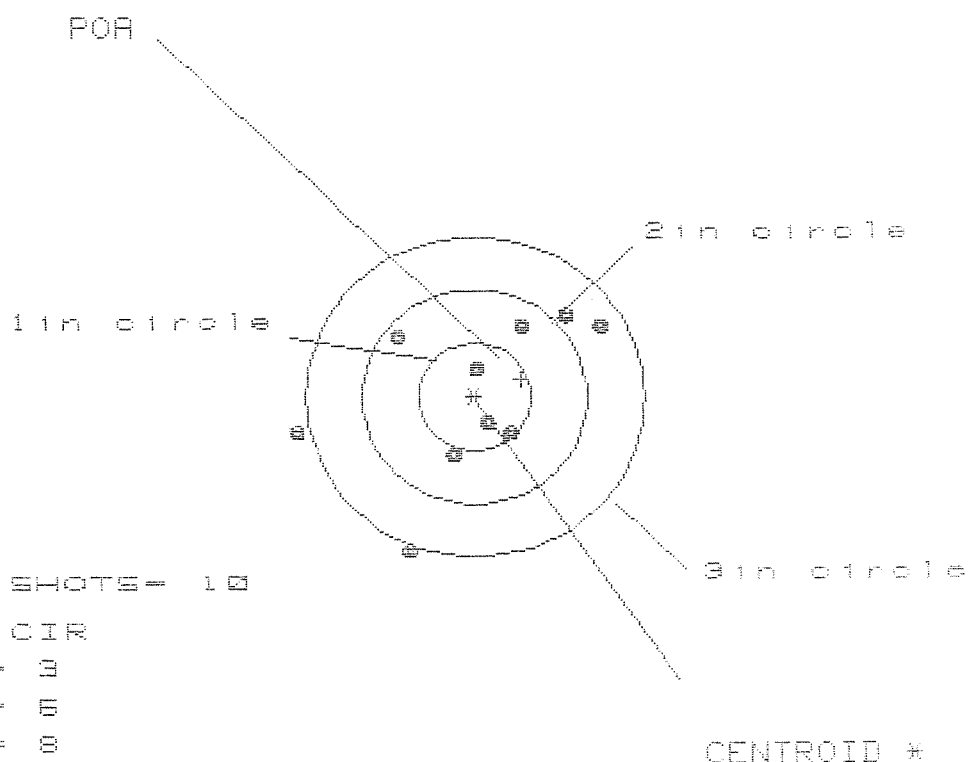
CENTROID *

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	.963	.687
MINIMUM X	:	-.777	-.822	-.782
MAXIMUM Y	:	1.013	.906	.848
MINIMUM Y	:	-.959	-.924	-.982
CENTROID X	:	-.041	.045	-.075
CENTROID Y	:	-.386	-.279	-.221
POR TO CENTROID in.	:	.388	.283	.233
MIN RADIUS	:	.192	.243	.343
MEAN RADIUS	:	.848	.797	.764
MAX RADIUS	:	1.234	1.116	1.105
HORIZONTAL SPREAD	:	1.826	1.785	1.389
VERTICAL SPREAD	:	1.972	1.830	1.830
EXTREME SPREAD	:	2.281	2.024	2.024
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Mar 1980

FILE:/PATTERNING/CENTERFIRE_PATT/08225081

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.713

VS= 2.113

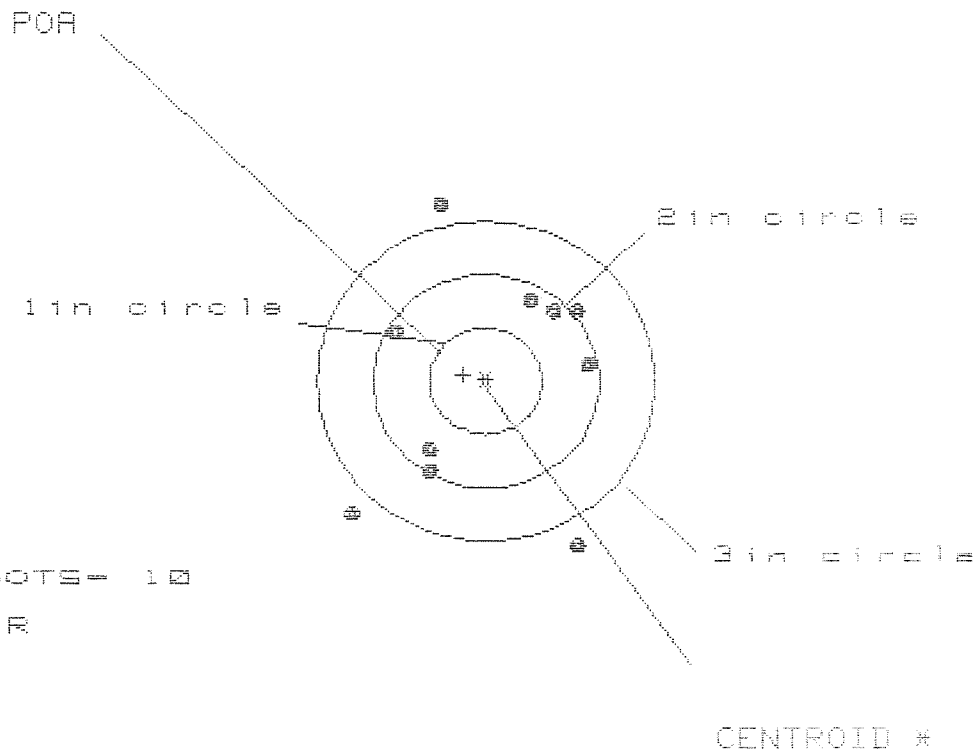
GS= 2.904

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.131	.955	.861
MINIMUM X	:	-1.582	-.816	-.910
MAXIMUM Y	:	.716	.678	.499
MINIMUM Y	:	-1.397	-1.435	-.770
CENTROID X	:	-.416	-.240	-.146
CENTROID Y	:	-.161	-.123	.056
POA TO CENTROID in.	:	.446	.270	.156
MIN RADIUS	:	.293	.286	.240
MEAN RADIUS	:	.885	.783	.669
MAX RADIUS	:	1.618	1.620	.987
HORIZONTAL SPREAD	:	2.713	1.771	1.771
VERTICAL SPREAD	:	2.113	2.113	1.269
EXTREME SPREAD	:	2.904	2.705	1.819
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

15 Mar 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 7

HS = 2.055

VS = 3.112

GS = 3.365

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.729	.618
MINIMUM X	:	-1.193	-.971	-.882
MAXIMUM Y	:	1.619	1.477	1.272
MINIMUM Y	:	-1.492	-1.635	-1.196
CENTROID X	:	.197	.330	.241
CENTROID Y	:	-.061	.082	.287
POA TO CENTROID in.	:	.206	.340	.375
MIN RADIUS	:	.784	.623	.496
MEAN RADIUS	:	1.144	1.044	.927
MAX RADIUS	:	1.754	1.781	1.362
HORIZONTAL SPREAD	:	2.055	1.700	1.700
VERTICAL SPREAD	:	3.112	3.112	2.468
EXTREME SPREAD	:	3.365	3.365	2.469
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

15 Mar 1998

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.521

VS= 1.384

GS= 2.731

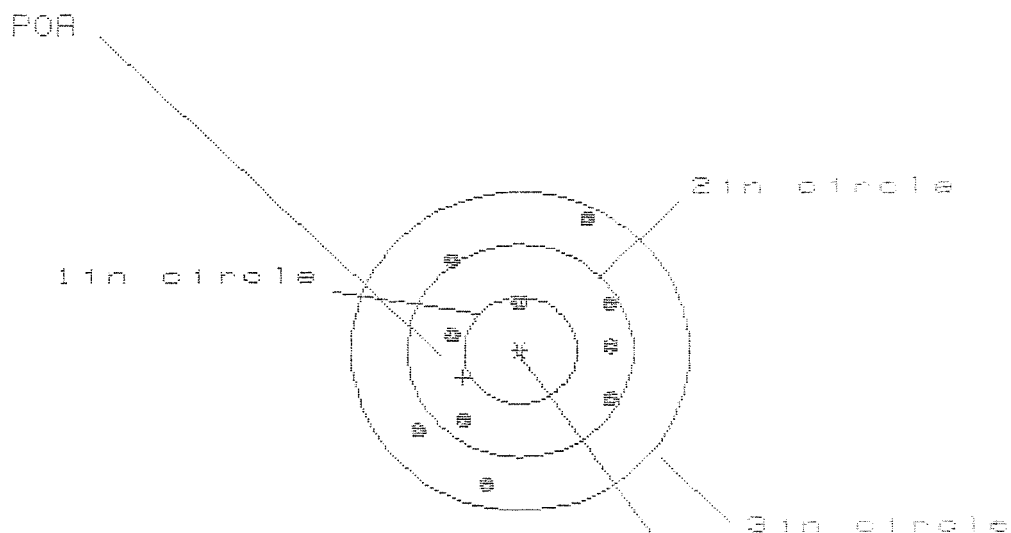
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.475	.810	.698
MINIMUM X	:	-1.146	-.982	-1.182
MAXIMUM Y	:	.771	.763	.566
MINIMUM Y	:	-.613	-.621	-.526
CENTROID X	:	.156	-.008	.112
CENTROID Y	:	-.022	-.014	-.109
POA TO CENTROID in.	:	.158	.016	.157
MIN RADIUS	:	.068	.178	.046
MEAN RADIUS	:	.798	.738	.643
MAX RADIUS	:	1.477	1.225	1.188
HORIZONTAL SPREAD	:	2.621	1.792	1.792
VERTICAL SPREAD	:	1.384	1.384	1.091
EXTREME SPREAD	:	2.731	2.164	1.848
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Mar 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.773

VS= 2.440

GS= 2.617

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.832	.901	.869
MINIMUM X	-.941	-.872	-.904
MAXIMUM Y	1.202	.966	.828
MINIMUM Y	-1.238	-1.105	-.716
CENTROID X	.504	.435	.467
CENTROID Y	.253	.119	.257
FOR TO CENTROID in.	.564	.451	.533
MIN RADIUS	.494	.602	.489
MEAN RADIUS	.942	.893	.847
MAX RADIUS	1.353	1.134	1.153
HORIZONTAL SPREAD	1.773	1.773	1.773
VERTICAL SPREAD	2.440	2.071	1.544
EXTREME SPREAD	2.617	2.130	2.130
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		