

C6523424

MODEL 700™ M24

Model **SMS**™

Action

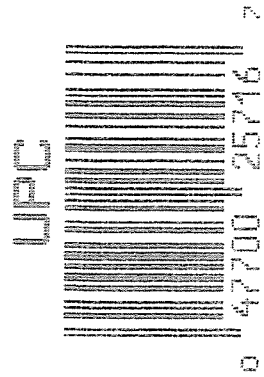
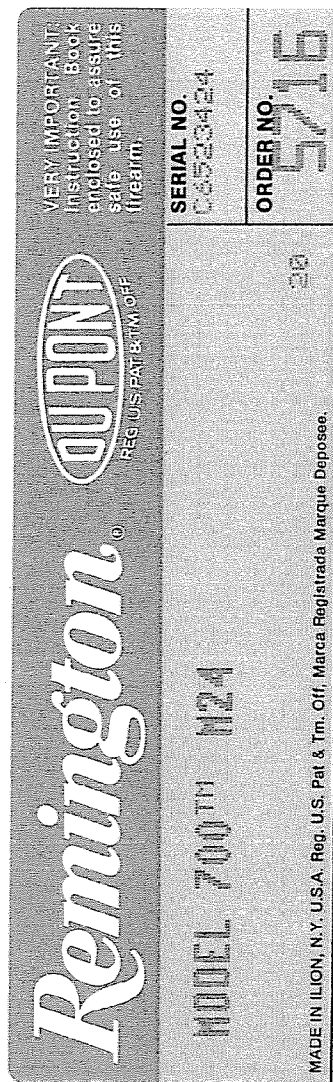
Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523424

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY REMARKS	10/4/90	KA
600	Proof		10/4/90	KA
607	Check Headspace		10/4/90	KA
610	Dis-assemble Gun		10/4/90	KA
612	Magnaflux Barrel Action		10/9/90	KR
	Magnaflux Bolt		10/9/90	KR
615	Rollmark Caliber		10/9/90	S.S.
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	KA
	Apply Coating (Bolt)			
625	Final Assembly		10/21/90	KA
	A) Clean inside of Bolt Assembly		10/21/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KA
	C) Inspect Ejector Hole for Chamfer		10/21/90	KA
	D) Oil Firing Pin Ass'y		10/21/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-2/90	KA

BARBER - M24 0027827

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5.25	5	5.25			1/18/91 1-2-90	WLB KT
	G) Safety Off Force	3.5	2.25	3.35			1/18/91 1-2-90	WLB KT
	H) Trigger Pull Test & Retainability						1-18-91	WLB
	I) Firing Pin Indent	.021 0.26	.021 0.26	.021 0.25			1/18/91 1-2-90	WLB KT
	J) Assemble Stock						11-3-90	KA
	K) Assemble Swivel Studs						2-4-91	KA
	L) Attach Front and Rear Sight Assemblies						11-3-90	KA
	M) Iron Sight Alignment						11-3-90	KA
	N) Detach Front & Rear Sights & place in numbered container						11-3-90	KA
	O) Attach Scope to Rifle						11-3-90	KA
	P) Detach & Attach Scope 20 Times						11-3-90	KA
640	Gallery Target & Test						11-5-90	DH
	A) Time						11-5-90	DH
	B) Malfunctions						11-5-90	DH
	C) Pierced Primers						11-5-90	DH
	D) Optical Clarity of Scope						11-5-90	DH
645	Inspect for Live Ammo						11-5-90	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.19	2.17	2.18	2.18	2.16	1-22-91	WLB
	C) Function						2-4-91	AC
660	Pack						3-18-91	WLB

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

SERIAL NO. C6523424DATE 1-18-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.27	2.24	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.28	2.22	2.17	
PULL #3	2.32	2.27	2.26	2.18	
PULL #4	2.31	2.29	2.28	2.18	
PULL #5	2.27	2.27	2.30	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.37		
PULL #2	3.24	3.36		
PULL #3	3.29	3.28		
PULL #4	3.27	3.32		
PULL #5	3.39	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.31		4.34
PULL #2	4.32	4.32		4.28
PULL #3	4.31	4.30		4.25
PULL #4	4.31	4.29		4.30
PULL #5	4.30	4.34		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523424
22 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.128082
1 TO	2	.221741
1 TO	3	.080025
1 TO	4	.25607
1 TO	5	.223332

PLAN <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0566
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0664
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0872498

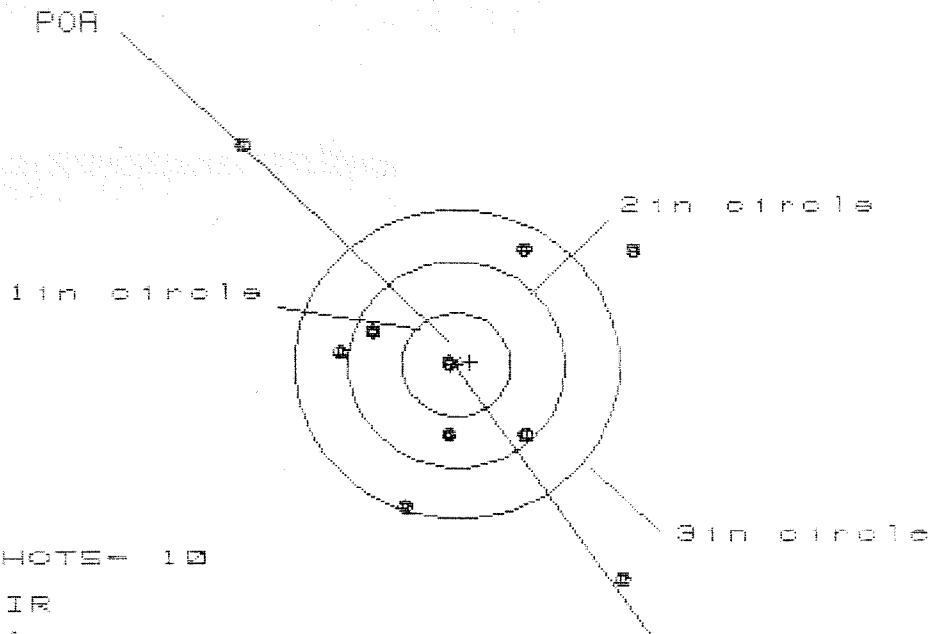
THE AMR FOR THIS RIFLE IS: 1.243

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6523424

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.615

VS = 4.252

GS = 5.483

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.671	1.456	1.620
MINIMUM X	-1.944	-1.335	-1.171
MAXIMUM Y	2.156	1.373	1.141
MINIMUM Y	-2.096	-1.856	-1.343
CENTROID X	-.126	.090	-.074
CENTROID Y	-.023	-.263	-.030
POA TO CENTROID in.	.128	.278	.080
MIN RADIUS	.095	.377	.145
MEAN RADIUS	1.389	1.225	1.057
MAX RADIUS	2.903	2.276	1.973
HORIZONTAL SPREAD	3.615	2.791	2.791
VERTICAL SPREAD	4.252	3.229	2.483
EXTREME SPREAD	5.493	3.487	3.259
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C8523424

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS = 4.900

VS = 3.400

GS = 5.788

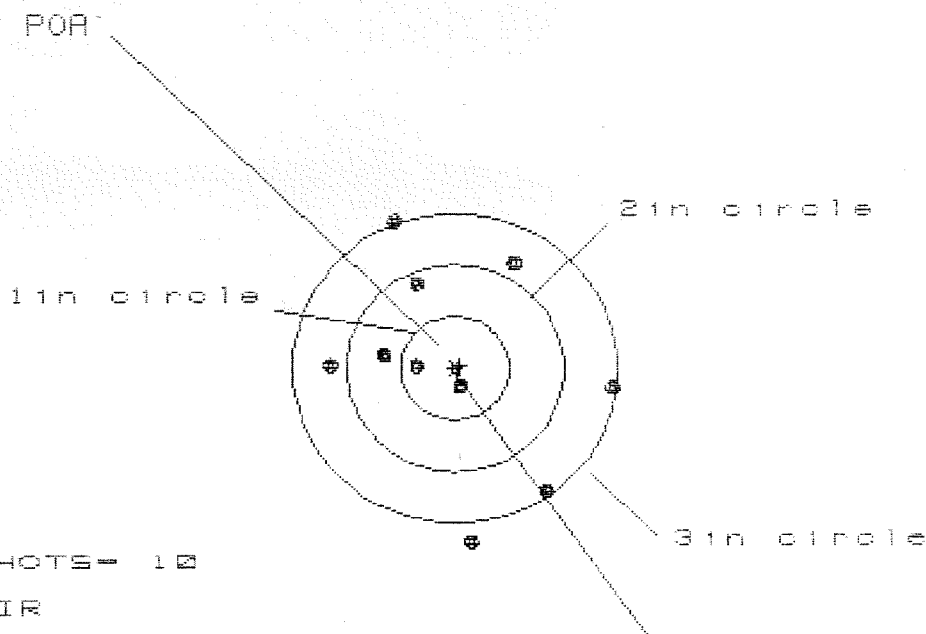
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.906	2.409	2.200
MINIMUM X	:	-1.994	-1.672	-1.824
MAXIMUM Y	:	1.797	1.655	1.216
MINIMUM Y	:	-1.611	-1.753	-1.546
CENTROID X	:	-.191	-.513	-.305
CENTROID Y	:	-.235	-.092	-.299
POA TO CENTROID in.	:	.302	.522	.427
MIN RADIUS	:	.174	.165	.144
MEAN RADIUS	:	1.553	1.350	1.218
MAX RADIUS	:	3.176	2.564	2.300
HORIZONTAL SPREAD	:	4.900	4.081	4.024
VERTICAL SPREAD	:	3.408	3.408	2.762
EXTREME SPREAD	:	5.788	4.803	4.028
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ 06523424

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.528

VS = 3.132

CS = 3.210

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.404
MINIMUM X	-1.124
MAXIMUM Y	1.405
MINIMUM Y	-1.727
CENTROID X	-.046
CENTROID Y	-.021
POA TO CENTROID in.	.050
MIN RADIUS	.218
MEAN RADIUS	1.052
MAX RADIUS	1.731
HORIZONTAL SPREAD	2.528
VERTICAL SPREAD	3.132
EXTREME SPREAD	3.210
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

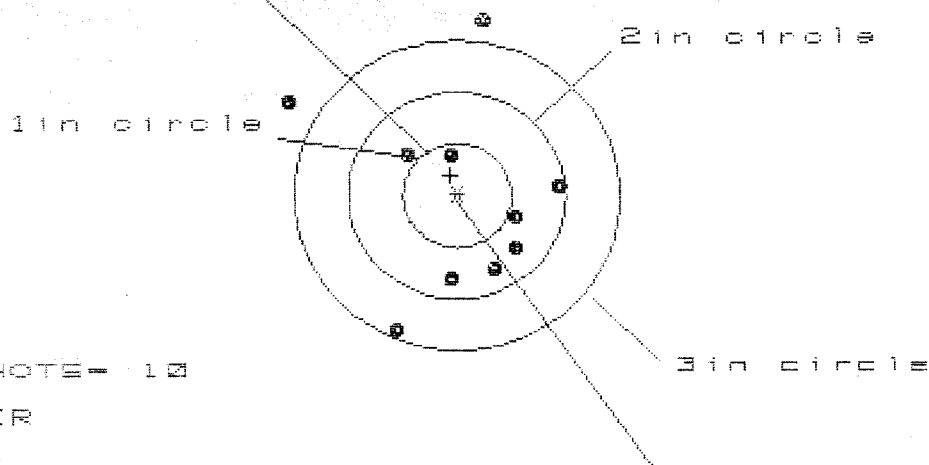
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CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.527

VS = 3.019

GS = 3.124

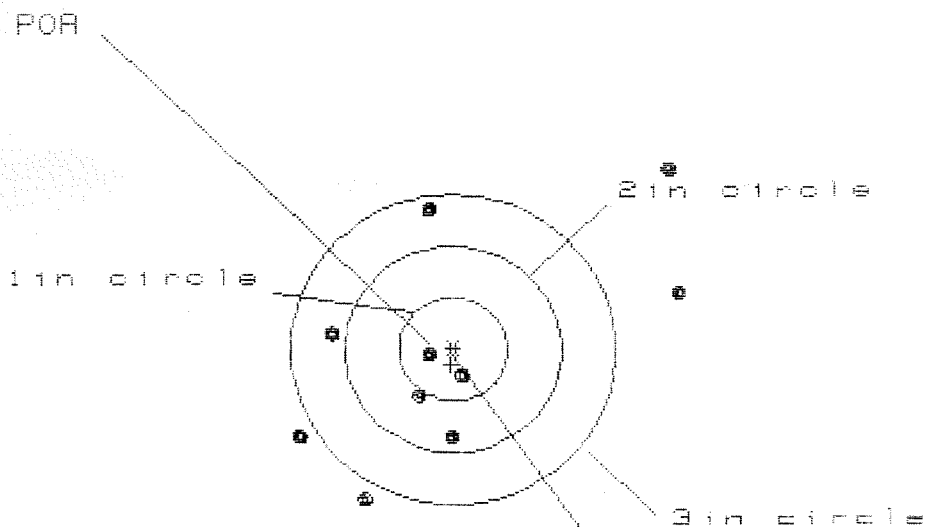
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.804	.812
MINIMUM X	:	-1.550	-.745	-.737
MAXIMUM Y	:	1.708	1.809	.757
MINIMUM Y	:	-1.311	-1.210	-.984
CENTROID X	:	.060	.233	.225
CENTROID Y	:	-.199	-.300	-.526
POA TO CENTROID in.	:	.208	.379	.572
MIN RADIUS	:	.365	.413	.391
MEAN RADIUS	:	.977	.847	.690
MAX RADIUS	:	1.798	1.810	1.230
HORIZONTAL SPREAD	:	2.527	1.549	1.549
VERTICAL SPREAD	:	3.019	3.019	1.741
EXTREME SPREAD	:	3.124	3.124	2.100
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.477

VS= 3.245

GS= 4.272

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.070	2.287	.578
MINIMUM X	-1.407	-1.190	-.904
MAXIMUM Y	1.794	1.599	1.607
MINIMUM Y	-1.451	-1.252	-1.164
CENTROID X	.020	-.197	-.483
CENTROID Y	.146	-.053	-.141
POA TO CENTROID in.	.149	.204	.503
MIN RADIUS	.196	.127	.219
MEAN RADIUS	1.245	1.003	.832
MAX RADIUS	2.650	2.393	1.710
HORIZONTAL SPREAD	3.477	3.477	1.482
VERTICAL SPREAD	3.245	2.851	2.851
EXTREME SPREAD	4.272	3.731	2.914
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		