

C6649008

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



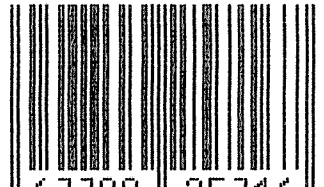
ORDER NO. 5716

20



5716 C6649008

LFC



0 "47700" 25716" 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649008

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8/23/91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	JH

op. #	DESCRIPTION	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6 1/4	5 1/2	8-29-91	DH		
	G) Safety Off Force	2 1/4	2 3/4	3	8-29-91	DH		
	H) Trigger Pull Test & Retainability				8/29/91	JH		
	I) Firing Pin Indent	.024	.023	.024	8-29-91	DH		
	J) Assemble Stock				8/30/91	RW		
	K) Assemble Swivel Studs				8-31-91	DH		
	L) Attach Front and Rear Sight Assemblies				8/30/91	RW		
	M) Iron Sight Alignment				8/30/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				8/30/91	RW		
	O) Attach Scope to Rifle				8/30/91	RW		
	P) Detach & Attach Scope 20 Times				8/30/91	RW		
640	Gallery Target & Test				8-30-91	A		
	A) Time				11	A		
	B) Malfunctions				11	A		
	C) Pierced Primers				11	A		
	D) Optical Clarity of Scope				11	A		
645	Inspect for Live Ammo				8-30-91	A		
655	Final Inspection							
	A) Headspace				8-31-91	DH		
	B) Trigger Pull	2 35	2 42	2 42	2 46	2 47	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						9/1/91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649008

DATE 8/29/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.27	2.34	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.38	2.40	2.42	
PULL #3	2.33	2.32	2.38	2.42	
PULL #4	2.26	2.27	2.25	2.46	
PULL #5	2.29	2.33	2.30	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.42		
PULL #2	3.28	3.43		
PULL #3	3.33	3.45		
PULL #4	3.41	3.40		
PULL #5	3.51	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.45		4.54
PULL #2	4.23	4.65		4.45
PULL #3	4.56	4.54		4.47
PULL #4	4.58	4.48		4.55
PULL #5	4.59	4.52		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649008
30 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.367069
1 TO	2	.229393
1 TO	3	.230417
1 TO	4	.232622
1 TO	5	.340037

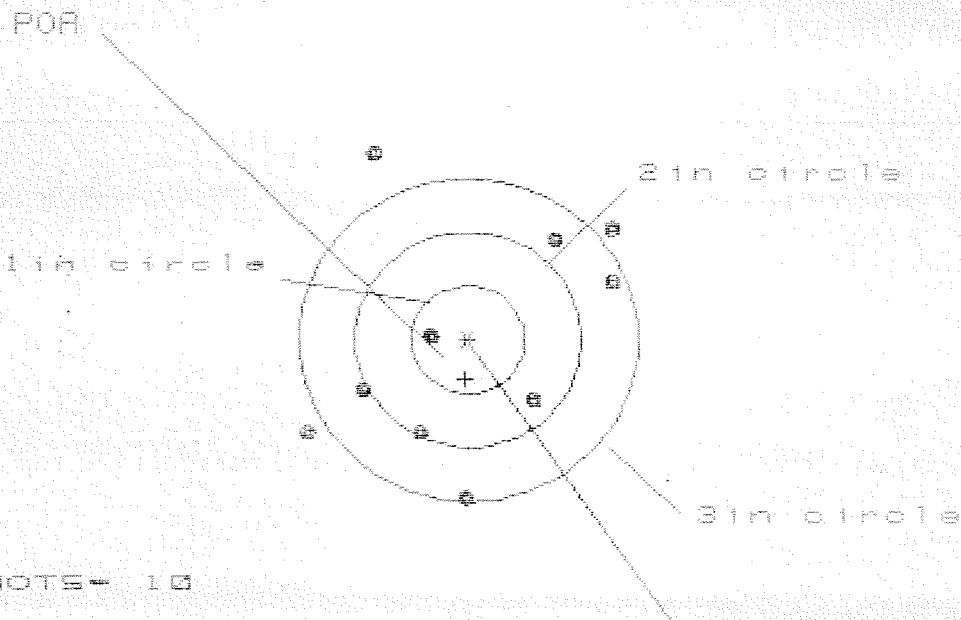
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .108
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214559
THE AMR FOR THIS RIFLE IS: .841

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B49008

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.629

VS= 3.187

GS= 3.280

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.231	1.141	.955
MINIMUM X	-1.398	-1.488	-1.187
MAXIMUM Y	1.737	1.223	1.139
MINIMUM Y	-1.450	-1.257	-1.341
CENTROID X	.028	.118	.304
CENTROID Y	.366	.173	.257
POA TO CENTROID in.	.367	.209	.398
MIN RADIUS	.308	.447	.556
MEAN RADIUS	1.221	1.124	1.063
MAX RADIUS	1.914	1.673	1.487
HORIZONTAL SPREAD	2.629	2.629	2.142
VERTICAL SPREAD	3.187	2.480	2.480
EXTREME SPREAD	3.280	3.243	2.782
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49008

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.609

VS= 1.714

GS= 1.715

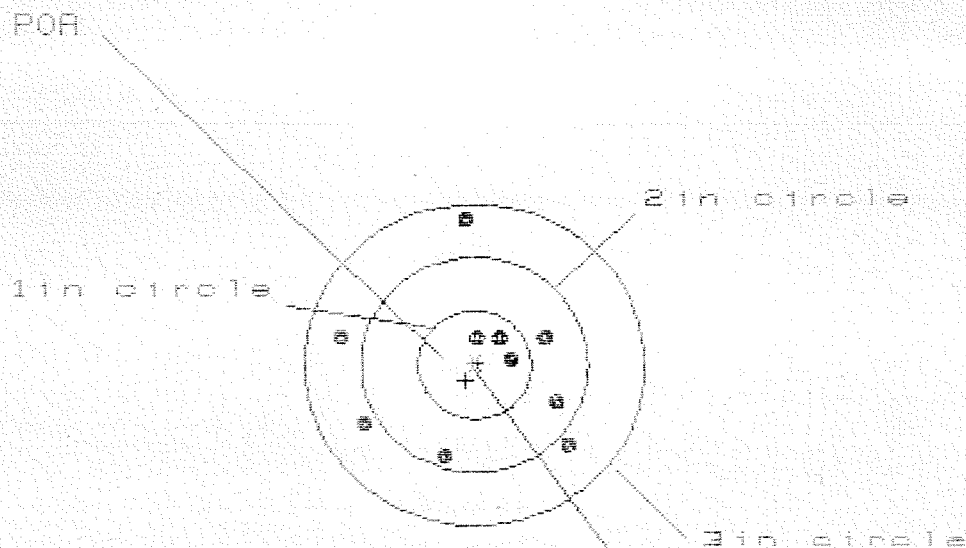
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.934	.901	.663
MINIMUM X	-.675	-.708	-.595
MAXIMUM Y	.998	.358	.366
MINIMUM Y	-.716	-.605	-.597
CENTROID X	.158	.191	.078
CENTROID Y	.177	.066	.058
POA TO CENTROID in.	.237	.202	.098
MIN RADIUS	.157	.066	.075
MEAN RADIUS	.563	.500	.444
MAX RADIUS	1.041	.903	.690
HORIZONTAL SPREAD	1.609	1.609	1.258
VERTICAL SPREAD	1.714	.953	.963
EXTREME SPREAD	1.715	1.655	1.357
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649080

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.911

VS= 2.186

GS= 2.284

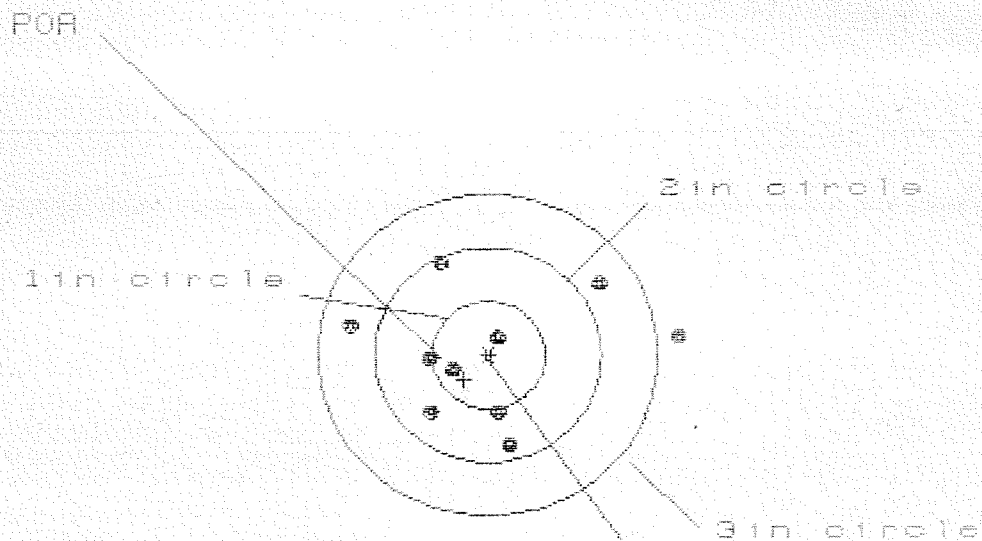
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.769	.755	.611
MINIMUM X	-1.142	-1.156	-1.185
MAXIMUM Y	1.336	.443	.492
MINIMUM Y	-.850	-.702	-.653
CENTROID X	.082	.096	.240
CENTROID Y	.142	-.006	-.055
POA TO CENTROID in.	.164	.096	.247
MIN RADIUS	.262	.360	.303
MEAN RADIUS	.803	.753	.672
MAX RADIUS	1.342	1.219	1.223
HORIZONTAL SPREAD	1.911	1.911	1.796
VERTICAL SPREAD	2.186	1.145	1.145
EXTREME SPREAD	2.284	2.158	1.637
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49008

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.813

VS= 1.657

GS= 2.914

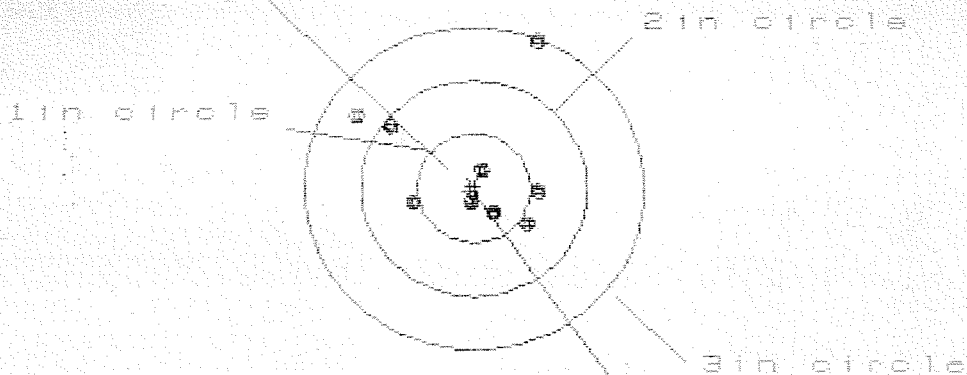
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.679	1.151	1.020
MINIMUM X	-1.234	-1.047	-.498
MAXIMUM Y	.843	.866	.905
MINIMUM Y	-.814	-.791	-.752
CENTROID X	.216	.029	.160
CENTROID Y	.229	.206	.167
POA TO CENTROID in.	.315	.208	.232
MIN RADIUS	.152	.185	.235
MEAN RADIUS	.825	.695	.648
MAX RADIUS	1.692	1.322	1.231
HORIZONTAL SPREAD	2.913	2.198	1.518
VERTICAL SPREAD	1.657	1.657	1.657
EXTREME SPREAD	2.914	2.224	1.860
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

30 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649008

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.677

VS= 3.368

GS= 3.376

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.616	.659	.734
MINIMUM X	-1.061	-1.018	-.936
MAXIMUM Y	1.369	1.146	.617
MINIMUM Y	-1.999	-.568	-.424
CENTROID X	.033	-.010	-.092
CENTROID Y	.026	.249	.105
POA TO CENTROID in.	.042	.249	.140
MIN RADIUS	.100	.133	.187
MEAN RADIUS	.793	.678	.570
MAX RADIUS	2.037	1.322	1.121
HORIZONTAL SPREAD	1.677	1.677	1.670
VERTICAL SPREAD	3.368	1.714	1.041
EXTREME SPREAD	3.376	1.879	1.810
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		