

C6649019

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

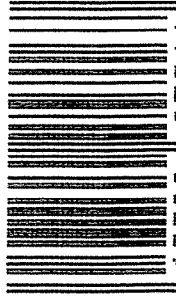
Remington

Remington MODEL 700™ H24		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.		SERIAL NO. C6649019	ORDER NO. 5716



5716 C6649019

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649019

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	2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	LB
620	Apply Coatings (Barrel Action)		7-28-91	LB
	Apply Coating (Bolt)		7-28-91	LB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-9-91	SL

op. #	BARBER - M24 0030700 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{3}{4}$	5 $\frac{1}{2}$	5 $\frac{1}{2}$			9-9-91	DH
	G) Safety Off Force	2	2	2			9-9-91	DH
	H) Trigger Pull Test & Retainability						9/9/91	JH.
	I) Firing Pin Indent	.020	.021	.020			9-9-91	DH
	J) Assemble Stock						9/12/91	RW
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						9/12/91	RW
	M) Iron Sight Alignment						9/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	RW
	O) Attach Scope to Rifle						9/12/91	RW
	P) Detach & Attach Scope 20 Times						9/12/91	RW
640	Gallery Target & Test						9/12/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/12/91	KT
655	Final Inspection							
	A) Headspace						9/13/91	JH
	B) Trigger Pull	2-18	2-21	2-23	2-22	2-25	9/13/91	JH
	C) Function						9/13/91	JH
660	Pack						9-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649019DATE 9-9-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.34	2.43	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.30	2.40	2.21	
PULL #3	2.34	2.31	2.38	2.23	
PULL #4	2.32	2.40	2.42	2.22	
PULL #5	2.30	2.35	2.44	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.26		
PULL #2	3.27	3.29		
PULL #3	3.40	3.28		
PULL #4	3.39	3.23		
PULL #5	3.39	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.66		4.63
PULL #2	4.50	4.52		4.61
PULL #3	4.52	4.53		4.61
PULL #4	4.50	4.58		4.62
PULL #5	4.54	4.55		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649819
13 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.0730616
1 TO 2	.383094
1 TO 3	.255539
1 TO 4	.129402
1 TO 5	.0920869

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117563

THE AMR FOR THIS RIFLE IS: 1.009

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8645013

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.994

VS = 2.467

GS = 2.679

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.965

1.044

1.013

MINIMUM X

:

-1.029

-.950

-.981

MAXIMUM Y

:

1.243

1.107

1.132

MINIMUM Y

:

-1.224

-1.086

-.947

CENTROID X

:

.073

-.006

.025

CENTROID Y

:

.003

.139

.000

POA TO CENTROID in.

:

.073

.139

.025

MIN RADIUS

:

.335

.248

.366

MEAN RADIUS

:

.902

.830

.789

MAX RADIUS

:

1.417

1.136

1.170

HORIZONTAL SPREAD

:

1.994

1.994

1.994

VERTICAL SPREAD

:

2.467

2.193

2.079

EXTREME SPREAD

:

2.679

2.196

2.129

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

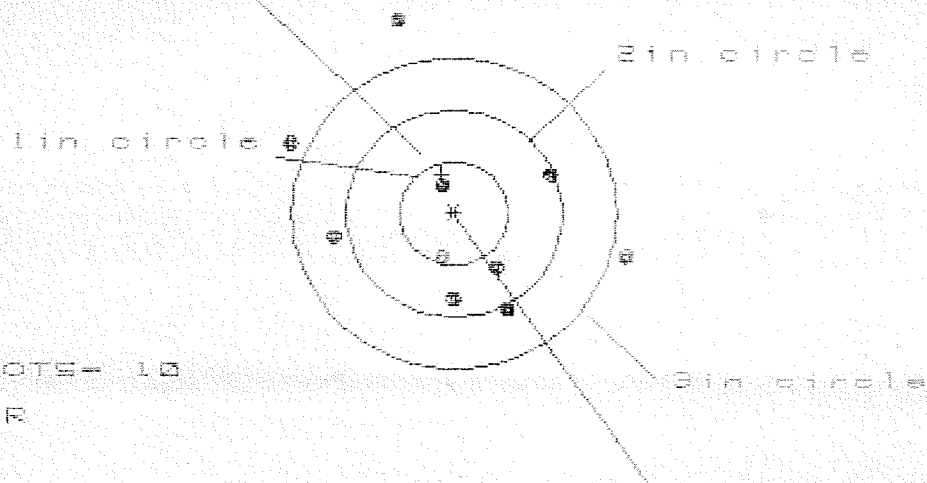
10

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649019

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.098

VS= 2.825

GS= 3.281

CENTROID *

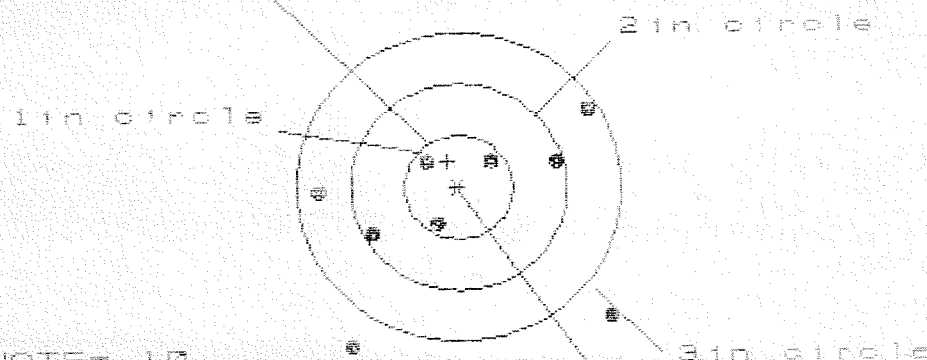
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.631	1.575	.987
MINIMUM X	-1.467	-1.523	-1.326
MAXIMUM Y	1.901	.899	.877
MINIMUM Y	-.924	-.713	-.736
CENTROID X	.113	.169	-.028
CENTROID Y	-.379	-.589	-.567
POA TO CENTROID in.	.394	.613	.567
MIN RADIUS	.314	.294	.275
MEAN RADIUS	1.059	.912	.833
MAX RADIUS	1.967	1.769	1.590
HORIZONTAL SPREAD	3.098	3.098	2.313
VERTICAL SPREAD	2.825	1.612	1.612
EXTREME SPREAD	3.281	3.281	2.540
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8645019

CENTERFIRE PATTERNS # 3

POB



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.696

VS= 3.614

GS= 3.730

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.361	1.353	1.227
MINIMUM X	-1.335	-1.343	-1.469
MAXIMUM Y	2.029	.993	.823
MINIMUM Y	-1.585	-1.359	-1.203
CENTROID X	.101	.109	.235
CENTROID Y	-.251	-.477	-.307
POB TO CENTROID (in.)	.271	.489	.386
MIN RADIUS	.408	.262	.375
MEAN RADIUS	1.171	1.077	.983
MAX RADIUS	2.031	1.702	1.719
HORIZONTAL SPREAD	2.696	2.696	2.696
VERTICAL SPREAD	3.614	2.352	2.026
EXTREME SPREAD	3.730	3.234	2.972
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B49019

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.241

VS= 1.958

GS= 2.241

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	1.110	1.144
MINIMUM X	-1.159	-1.131	-1.097
MAXIMUM Y	.728	.592	.430
MINIMUM Y	-1.230	-1.291	-.955
CENTROID X	-.018	-.046	-.080
CENTROID Y	.095	.231	.392
POA TO CENTROID (in.)	.096	.236	.401
MIN RADIUS	.347	.287	.208
MEAN RADIUS	.868	.786	.667
MAX RADIUS	1.255	1.319	1.161
HORIZONTAL SPREAD	2.241	2.241	2.241
VERTICAL SPREAD	1.958	1.883	1.386
EXTREME SPREAD	2.241	2.241	2.241
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649019

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

CENTROID *

HS = 2.459

VS = 2.545

GS = 2.693

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.703
MINIMUM X	-1.756
MAXIMUM Y	1.302
MINIMUM Y	-1.243
CENTROID X	-0.019
CENTROID Y	-0.001
POA TO CENTROID in.	0.019
MIN RADIUS	0.579
MEAN RADIUS	1.047
MAX RADIUS	1.716
HORIZONTAL SPREAD	2.459
VERTICAL SPREAD	2.545
EXTREME SPREAD	2.693
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9