

C5649062

MODEL 700TH M24

Model SMS TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Smith
®

Remington
MODEL 700™ H24

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

DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6649062

ORDER NO.
5715

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649062

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	LS.
617	Drill and Tap Sight Holes		JUL 2 1991	KB
618	Polish Barrel		JUL 1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-1-91	JF

BARBER - M24 0031211							DATE	INIT
op. #	OP. NAME	READINGS						
625 cont.	F) Safety On Force	6	6	6			8-1-91	JH
	G) Safety Off Force	4	4	4			8-1-91	JH
	H) Trigger Pull Test & Retainability						8-1-91	JH
	I) Firing Pin Indent	.0215	.022	.022			8-1-91	JH
	J) Assemble Stock						8/5/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/5/91	RW
	M) Iron Sight Alignment						8/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/5/91	RW
	O) Attach Scope to Rifle						8/5/91	RW
	P) Detach & Attach Scope 20 Times						8/5/91	RW
640	Gallery Target & Test						8/5/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8/5/91	KJ
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.38	2.15	2.34	2.28	2.45	8-6-91	JH
	C) Function						8-6-91	AC
660	Pack						9-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6649062

DATE 8-1-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.35	2.42	2.38	MIN. SETTING,
PULL #2	2.67	2.40	2.48	2.15	NO AVG. OF 5
PULL #3	2.61	2.38	2.45	2.34	READINGS ACCEPT-
PULL #4	2.57	2.35	2.40	2.28	ABLE LESS THAN 2#
PULL #5	2.63	2.41	2.44	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.20		
PULL #2	3.52	3.68		
PULL #3	3.67	3.20		
PULL #4	3.30	3.65		
PULL #5	3.62	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.57		4.56
PULL #2	4.46	4.58		4.26
PULL #3	4.56	4.54		4.49
PULL #4	4.25	4.45		4.50
PULL #5	4.47	4.61		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649862
5 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.339423
1 TO 2	.286225
1 TO 3	.359951
1 TO 4	.420015
1 TO 5	.346539

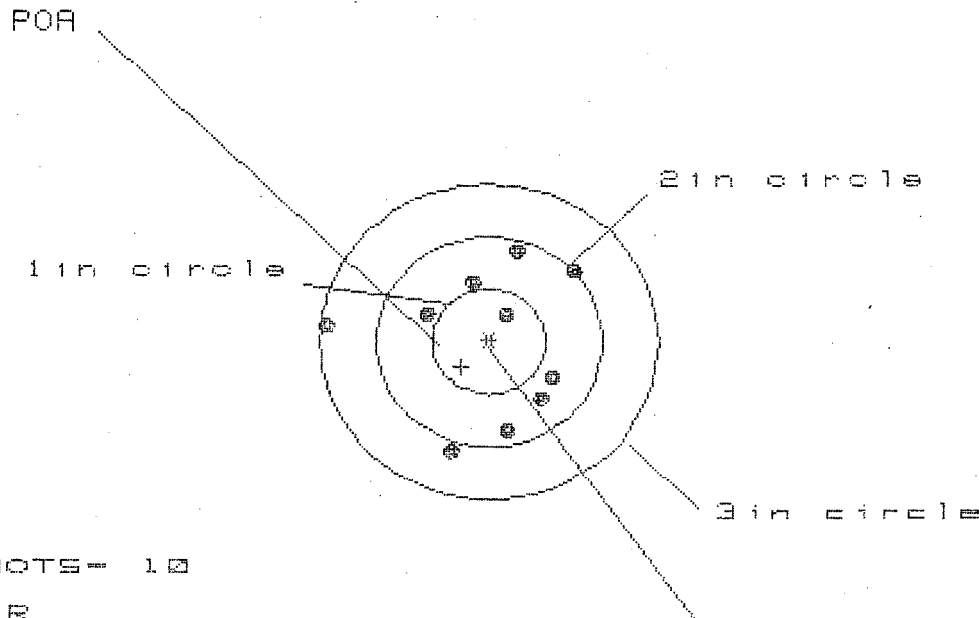
51 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0362
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .057
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0675236
THE AMR FOR THIS RIFLE IS: .9396

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649062

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.216

VS= 1.821

GS= 2.283

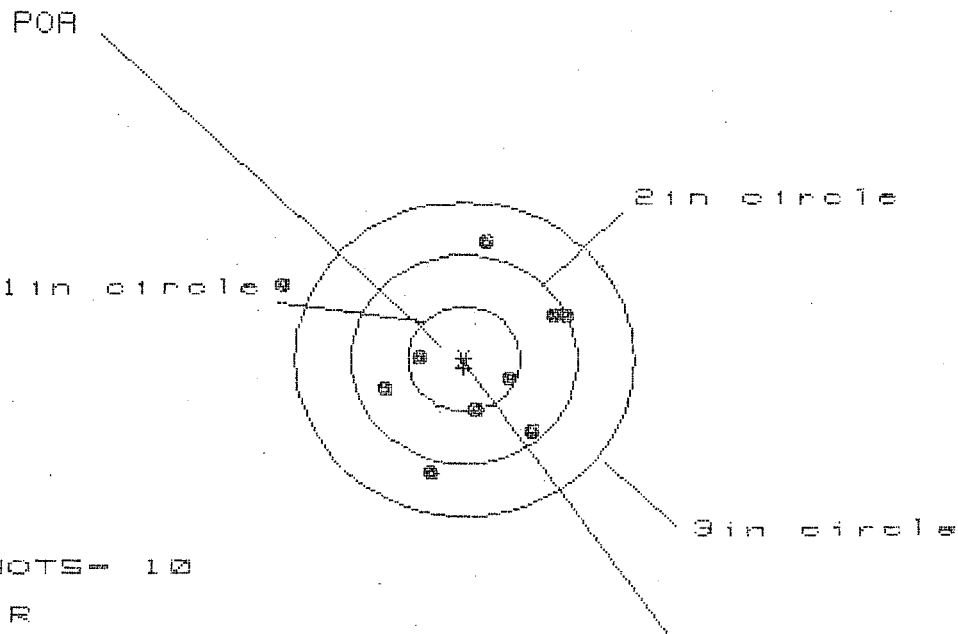
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.741	.577	.514
MINIMUM X	-1.476	-.699	-.762
MAXIMUM Y	.814	.829	.705
MINIMUM Y	-1.007	-.992	-.924
CENTROID X	.242	.406	.469
CENTROID Y	.238	.223	.347
POA TO CENTROID in.	.340	.464	.584
MIN RADIUS	.293	.236	.114
MEAN RADIUS	.803	.705	.631
MAX RADIUS	1.481	1.112	.927
HORIZONTAL SPREAD	2.216	1.276	1.276
VERTICAL SPREAD	1.821	1.821	1.629
EXTREME SPREAD	2.283	2.002	1.636
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.562

VS= 2.128

GS= 2.663

CENTROID *

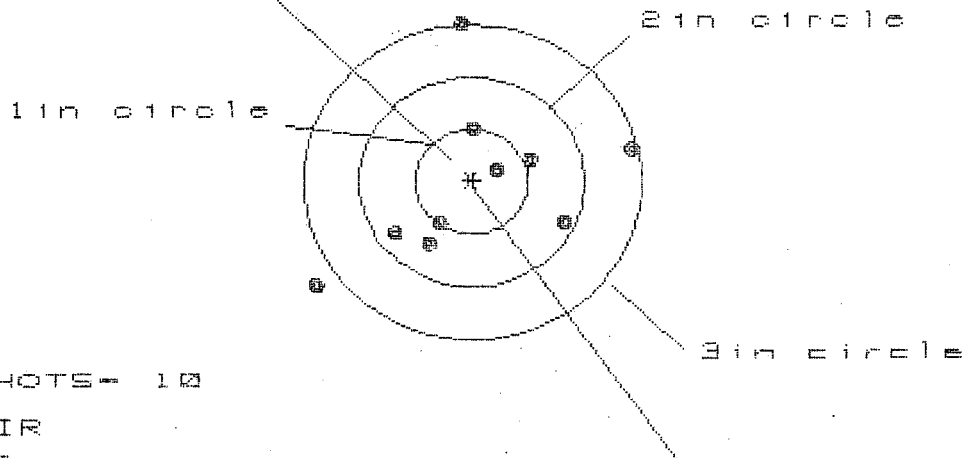
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.921	.738	.738
MINIMUM X	:	-1.641	-.858	-.858
MAXIMUM Y	:	1.084	1.166	.648
MINIMUM Y	:	-1.044	-.962	-.816
CENTROID X	:	.004	.186	.186
CENTROID Y	:	.079	-.003	-.149
POA TO CENTROID in.	:	.079	.186	.238
MIN RADIUS	:	.406	.230	.221
MEAN RADIUS	:	.888	.754	.678
MAX RADIUS	:	1.799	1.166	.982
HORIZONTAL SPREAD	:	2.562	1.596	1.596
VERTICAL SPREAD	:	2.128	2.128	1.464
EXTREME SPREAD	:	2.663	2.187	1.921
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.754

VS= 2.503

GS= 3.047

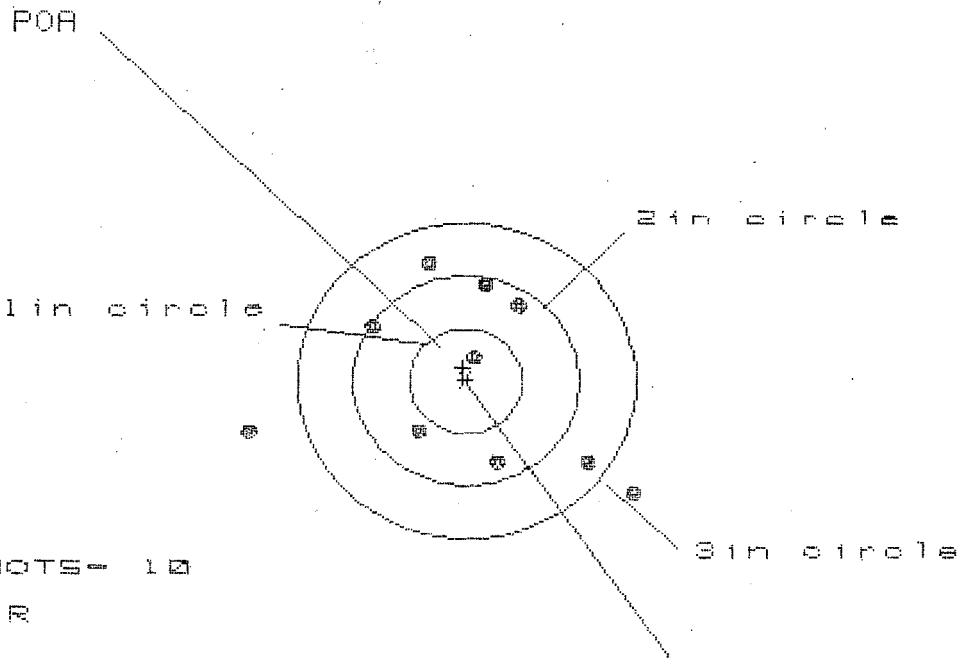
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.379	1.226	1.191
MINIMUM X	-1.375	-.841	-.876
MAXIMUM Y	1.537	1.429	.617
MINIMUM Y	-.966	-.671	-.492
CENTROID X	-.016	.137	.172
CENTROID Y	-.013	.095	-.084
POA TO CENTROID in.	.020	.166	.192
MIN RADIUS	.268	.101	.174
MEAN RADIUS	.886	.773	.682
MAX RADIUS	1.681	1.457	1.259
HORIZONTAL SPREAD	2.754	2.067	2.067
VERTICAL SPREAD	2.503	2.100	1.109
EXTREME SPREAD	3.047	2.216	2.216
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.375

VS= 2.152

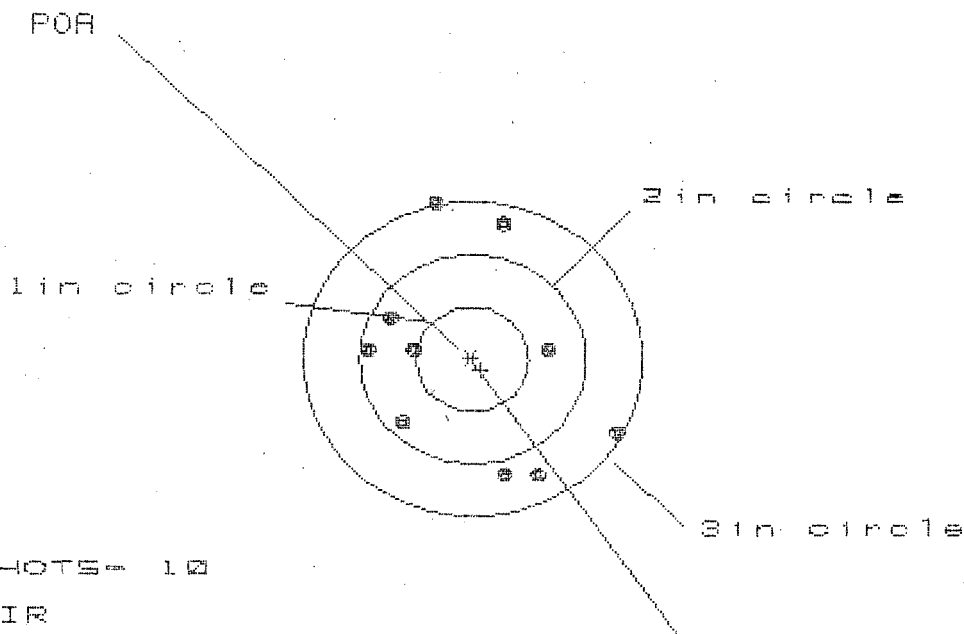
GS= 3.422

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.446	1.232	.996
MINIMUM X	-1.929	-1.066	-.912
MAXIMUM Y	1.104	1.050	.912
MINIMUM Y	-1.048	-1.102	-1.001
CENTROID X	.029	.243	.089
CENTROID Y	-.124	-.070	.068
POA TO CENTROID in.	.127	.253	.112
MIN RADIUS	.290	.247	.090
MEAN RADIUS	1.078	.963	.832
MAX RADIUS	1.989	1.653	1.365
HORIZONTAL SPREAD	3.375	2.298	1.908
VERTICAL SPREAD	2.152	2.152	1.913
EXTREME SPREAD	3.422	2.790	2.297
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.147

VS= 2.586

GS= 2.758

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.234	1.197	.784
MINIMUM X	-.913	-.950	-.801
MAXIMUM Y	1.512	1.449	1.378
MINIMUM Y	-1.074	-.906	-.977
CENTROID X	-.078	-.041	-.190
CENTROID Y	.105	-.063	.008
POA TO CENTROID in.	.131	.075	.190
MIN RADIUS	.543	.636	.470
MEAN RADIUS	1.043	.978	.907
MAX RADIUS	1.548	1.470	1.435
HORIZONTAL SPREAD	2.147	2.147	1.585
VERTICAL SPREAD	2.586	2.355	2.355
EXTREME SPREAD	2.758	2.379	2.379
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	