

C6649074

MODEL 700™ M24

Model **SMS**™

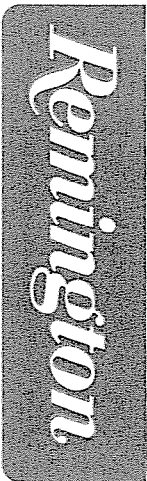
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®

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

DUPONT

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

MODEL 700™ H24

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

SERIAL NO.
C6649074

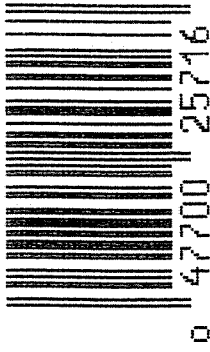
ORDER NO.
5716

20

5716 C6649074

0 47200 25716 7

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649074

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 7 2 9 1		RW
600	Proof	1 7 2 9 1		RW
607	Check Headspace	1 7 2 9 1		RW
610	Dis-assemble Gun	1 7 2 9 1		RW
612	Magnaflux Barrel Action		JUN 22 1991	GS
	Magnaflux Bolt		JUN 22 1991	GS
615	Rollmark Caliber		JUN 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8/9/91	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	MI

op. #	BARBER - M24 0031352 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-12-91	DH
	G) Safety Off Force	3	3	3			8-12-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	JH
	I) Firing Pin Indent	.020	.021	.021			8-12-91	DH
	J) Assemble Stock						8/12/91	RW
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8/12/91	RW
	M) Iron Sight Alignment						8/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/12/91	RW
	O) Attach Scope to Rifle						8/12/91	RW
	P) Detach & Attach Scope 20 Times						8/12/91	RW
640	Gallery Target & Test						8-12-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-12-91	NF
655	Final Inspection							
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.65	2.45	2.38	2.20	2.40	8-13-91	JH
	C) Function						8-13-91	DH
660	Pack						8-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + 50#
3.00# + 75#
4.00# + 100#

SERIAL NO. C6649074DATE 8-10-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.36	2.50	2.65	MIN. SETTING,
PULL #2	2.34	2.40	2.40	2.45	NO AVG. OF 5
PULL #3	2.35	2.40	2.38	2.38	READINGS ACCEPT-
PULL #4	2.35	2.49	2.42	2.20	ABLE LESS THAN 2#
PULL #5	2.36	2.43	2.42	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.49	3.55			
PULL #2	3.54	3.52			
PULL #3	3.56	3.60			
PULL #4	3.54	3.63			
PULL #5	3.56	3.62			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.35		4.37
PULL #2	4.26	4.36		4.51
PULL #3	4.26	4.34		4.50
PULL #4	4.19	4.38		4.48
PULL #5	4.35	4.47		4.50
TOTAL				
AVG.				

DISTANCE CALCULATIONS
RIFLE # C6649014
1991

POIDAL DISTANCES

0 TO	1	.332002
1 TO	2	.449782
1 TO	3	.325208
1 TO	4	.318215
1 TO	5	.674906

S²₁ <----POA

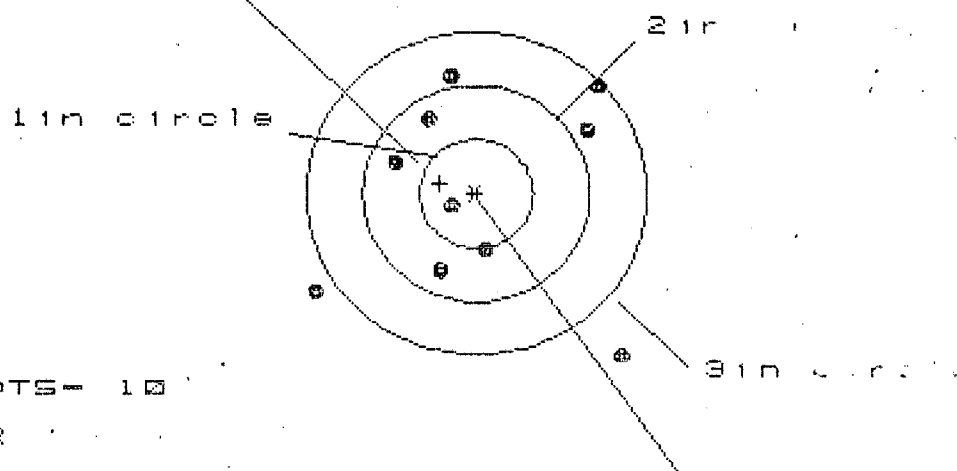
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .123
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1554
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:

T-F HMR FOR THIS RIFLE IS: .9922

FILE:/PATTERNING/CENTERFIRE_PATT/C6649074

CENTERFIRE PATTERNS

POH



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.585

VS= 2.597

GS= 3.174

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.242	1.200	1.037
MINIMUM X	-1.443	-1.305	-1.769
MAXIMUM Y	1.126	.963	.826
MINIMUM Y	-1.471	-1.090	-.997
CENTROID X	.319	.181	.344
CENTROID Y	-.092	.071	.208
POA TO CENTROID in.	.332	.195	.402
MIN RADIUS	.250	.313	.499
MEAN RADIUS	1.060	.944	.861
MAX RADIUS	1.925	1.701	1.264
HORIZONTAL SPREAD	2.685	2.505	1.806
VERTICAL SPREAD	2.597	2.053	1.023
EXTREME SPREAD	3.174	3.174	2.178
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

10 May 1981

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.984

VS = 2.311

GS = 4.116

CENTROID #

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	2.741
MINIMUM X	:	-1.243
MAXIMUM Y	:	1.146
MINIMUM Y	:	-1.165
CENTROID X	:	.279
CENTROID Y	:	.356
POA TO CENTROID in.	:	.452
MIN RADIUS	:	.111
MEAN RADIUS	:	1.068
MAX RADIUS	:	2.750
HORIZONTAL SPREAD	:	3.984
VERTICAL SPREAD	:	2.311
EXTREME SPREAD	:	4.116
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	7

12 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.443

VS= 1.793

GS= 3.446

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.681
MINIMUM X	-1.762
MAXIMUM Y	.656
MINIMUM Y	-1.137
CENTROID X	.147
CENTROID Y	.184
POA TO CENTROID in.	.236
MIN RADIUS	.420
MEAN RADIUS	1.126
MAX RADIUS	1.819
HORIZONTAL SPREAD	3.443
VERTICAL SPREAD	1.793
EXTREME SPREAD	3.446
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

12 Aug 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.151

VS= 2.064

GS= 2.988

PATTERN #

4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.929	.792	.681
MINIMUM X	-1.232	-.903	-.804
MAXIMUM Y	.753	.607	.635
MINIMUM Y	-1.311	-1.107	-1.031
CENTROID X	.188	.325	.226
CENTROID Y	.198	.344	.268
POA TO CENTROID in.	.273	.473	.351
MIN RADIUS	.454	.427	.458
MEAN RADIUS	.893	.764	.735
MAX RADIUS	1.799	1.125	1.036
HORIZONTAL SPREAD	2.161	1.695	1.485
VERTICAL SPREAD	2.064	1.714	1.666
EXTREME SPREAD	2.988	1.981	1.794
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

12 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.523

VS= 1.929

GS= 2.797

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.140
MINIMUM X	-1.382
MAXIMUM Y	1.076
MINIMUM Y	-.853
CENTROID X	-.318
CENTROID Y	.131
POA TO CENTROID in.	.343
MIN RADIUS	.144
MEAN RADIUS	.814
MAX RADIUS	1.752
HORIZONTAL SPREAD	2.523
VERTICAL SPREAD	1.929
EXTREME SPREAD	2.797
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9