

06649077

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700[™] H24

SERIAL NO. C6649077

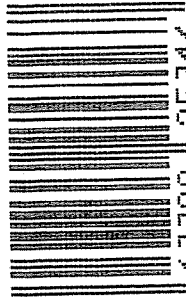
ORDER NO. 5716

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

20

5716 C6649077

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6649077**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8/7/91	KA
	Apply Coating (Bolt)		8/7/91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/10/91	D/H

op. #	UP. NAME BARBER, M24 0031385	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 1/4	5			8-10-91	DH
	G) Safety Off Force	3	3	3			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	D/H
	I) Firing Pin Indent	.020	.022	.021			8-10-91	DH
	J) Assemble Stock						8/10/91	KL
	K) Assemble Swivel Studs						8-15-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/10/91	KL
	M) Iron Sight Alignment						8/10/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	KL
	O) Attach Scope to Rifle						8/10/91	KL
	P) Detach & Attach Scope 20 Times						8/10/91	KL
640	Gallery Target & Test						8-13-91	D/H
	A) Time						8-13-91	DH
	B) Malfunctions						8-13-91	DH
	C) Pierced Primers						8-13-91	DH
	D) Optical Clarity of Scope						8-13-91	DH
645	Inspect for Live Ammo						8-13-91	D/H
655	Final Inspection						8-15-91	D/H
	A) Headspace							
	B) Trigger Pull	2.36	2.29	2.35	2.39	2.35	8-14-91	KL
	C) Function						8-15-91	DH
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. C6649077

DATE 8-10-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.67	2.69	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.66	2.70	2.29	
PULL #3	2.35	2.56	2.73	2.35	
PULL #4	2.33	2.51	2.73	2.39	
PULL #5	2.44	2.51	2.84	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.38		
PULL #2	3.32	3.08		
PULL #3	3.31	3.29		
PULL #4	3.25	3.01		
PULL #5	3.27	3.04		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.32		4.33
PULL #2	4.14	4.25		4.45
PULL #3	4.46	4.43		4.27
PULL #4	4.32	4.43		4.34
PULL #5	4.49	4.03		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649077
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.233137
1 TO	2	.343862
1 TO	3	.383861
1 TO	4	.209022
1 TO	5	.340906

34
FF <----POA

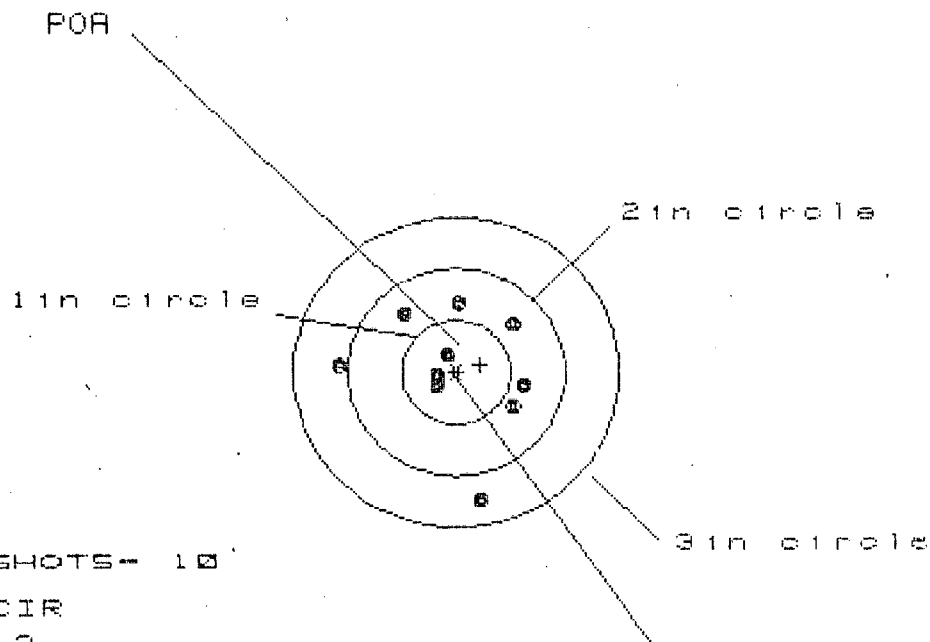
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1848
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .227101

THE AMR FOR THIS RIFLE IS: .8408

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649077

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.776

VS= 1.880

GS= 1.885

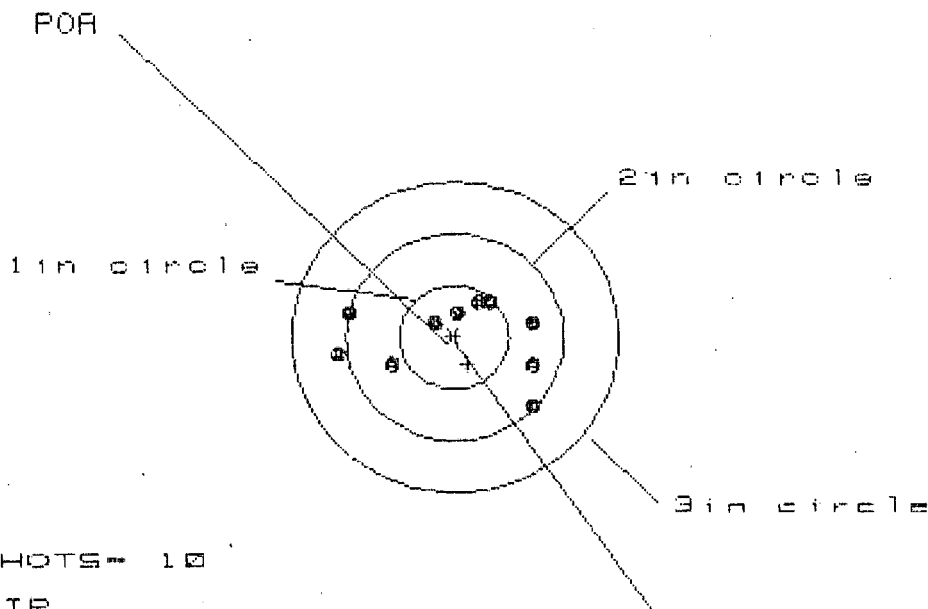
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.656	.676	.538
MINIMUM X	-1.120	-1.100	-.549
MAXIMUM Y	.650	.513	.509
MINIMUM Y	-1.230	-.474	-.478
CENTROID X	-.223	-.243	-.105
CENTROID Y	-.068	.069	.072
POA TO CENTROID in.	.233	.252	.128
MIN RADIUS	.155	.023	.154
MEAN RADIUS	.618	.532	.472
MAX RADIUS	1.243	1.101	.679
HORIZONTAL SPREAD	1.776	1.776	1.087
VERTICAL SPREAD	1.880	.987	.987
EXTREME SPREAD	1.885	1.796	1.292
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68649027

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.791

VS= .971

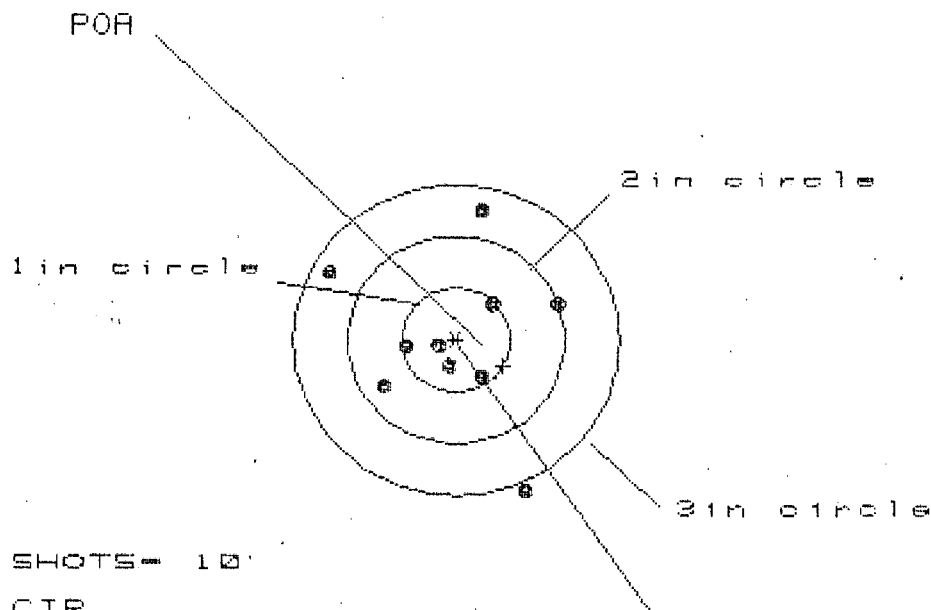
GS= 1.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.721	.602	.468
MINIMUM X	-1.070	-1.072	-.791
MAXIMUM Y	.349	.327	.350
MINIMUM Y	-.622	-.644	-.621
CENTROID X	-.123	-.004	.130
CENTROID Y	.261	.283	.260
POA TO CENTROID in.	.289	.283	.290
MIN RADIUS	.206	.198	.288
MEAN RADIUS	.636	.568	.499
MAX RADIUS	1.089	1.089	.843
HORIZONTAL SPREAD	1.791	1.674	1.259
VERTICAL SPREAD	.971	.971	.971
EXTREME SPREAD	1.868	1.868	1.337
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649077

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 6

3 in = 9

HS= 2.115

VS= 2.763

GS= 2.800

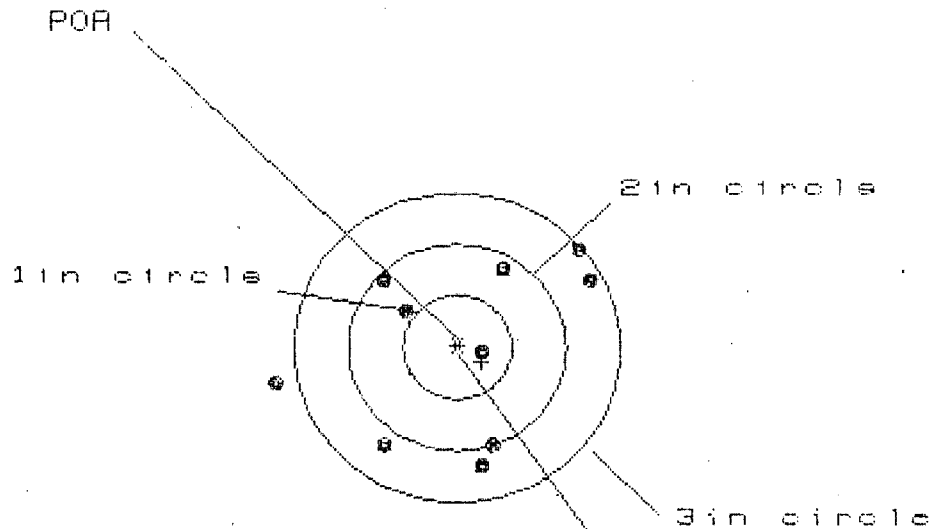
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.953	1.026	1.062
MINIMUM X	-1.162	-1.089	-1.053
MAXIMUM Y	1.298	1.135	.581
MINIMUM Y	-1.465	-.592	-.450
CENTROID X	-.438	-.511	-.547
CENTROID Y	.250	.413	.271
POA TO CENTROID in.	.504	.657	.610
MIN RADIUS	.129	.226	.080
MEAN RADIUS	.777	.705	.599
MAX RADIUS	1.608	1.174	1.203
HORIZONTAL SPREAD	2.115	2.115	2.115
VERTICAL SPREAD	2.763	1.727	1.031
EXTREME SPREAD	2.800	2.125	2.125
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649077

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.966

VS= 2.172

GS= 3.126

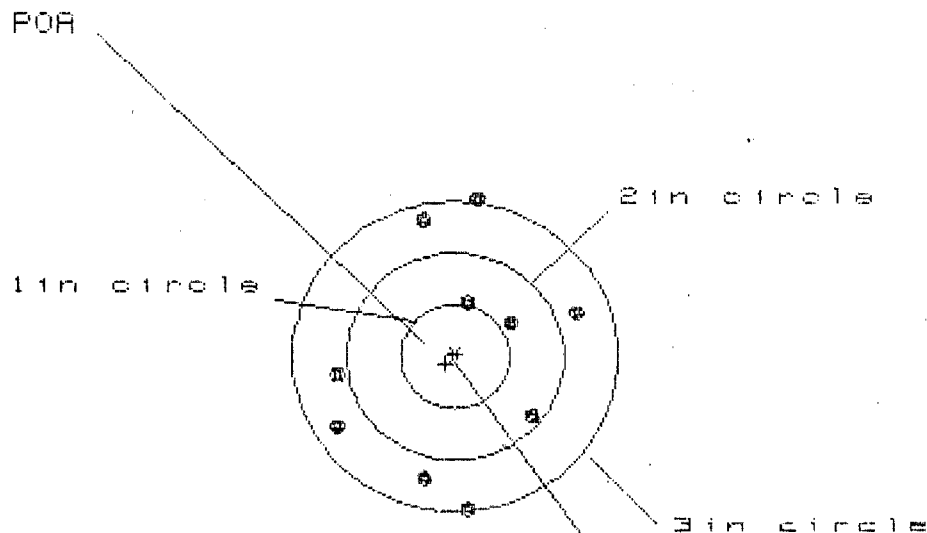
CENTROID *

PATTERN #	4	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.254	1.063	1.177	
MINIMUM X	-1.712	-0.866	-0.752	
MAXIMUM Y	.989	.948	.859	
MINIMUM Y	-1.183	-1.224	-1.106	
CENTROID X	-.226	-.035	-.149	
CENTROID Y	.141	.182	.064	
POA TO CENTROID in.	.266	.186	.162	
MIN RADIUS	.192	.064	.126	
MEAN RADIUS	1.050	.954	.904	
MAX RADIUS	1.752	1.312	1.367	
HORIZONTAL SPREAD	2.966	1.929	1.929	
VERTICAL SPREAD	2.172	2.172	1.965	
EXTREME SPREAD	3.126	2.589	2.453	
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		5		
NUMBER IN THREE INCH CIRCLE =		9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649027

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.200

VS= 2.934

GS= 2.937

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.115	1.136	1.148
MINIMUM X	-1.085	-1.064	-1.052
MAXIMUM Y	1.490	1.488	1.328
MINIMUM Y	-1.444	-1.278	-1.219
CENTROID X	.086	.065	.053
CENTROID Y	.076	-.090	.070
POA TO CENTROID in.	.115	.111	.088
MIN RADIUS	.564	.709	.578
MEAN RADIUS	1.123	1.080	1.038
MAX RADIUS	1.503	1.517	1.358
HORIZONTAL SPREAD	2.200	2.200	2.200
VERTICAL SPREAD	2.934	2.766	2.547
EXTREME SPREAD	2.937	2.793	2.547
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	9	9	9