

C6636223

MODEL 700™ M24

Model **SMS**™

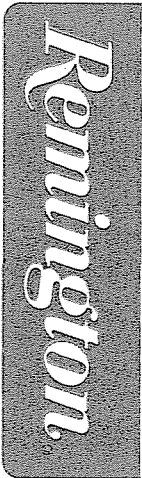
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®



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

MODEL 700™ M24

SERIAL NO.
C6636223

ORDER NO.
5716

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

20



5716 C6636223

UPC



BARBER - M24 0031904

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0031904

MOD. _____		GA. CAL. _____	GUN # <u>6223</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
NF	1st 6/6	Ejector! N.F.G.	RW
	2nd 6/8	Reamed Ejector hole + New	RW
	9/1	Ejector 100 Rd Test	
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 R.I. test June 12, 1991 OK	RW
TEST DH		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636223

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	1	RW
612	Magnaflux Barrel Action	5 6	91	Kcd
	Magnaflux Bolt	5 6	91	Kcd
615	Rollmark Caliber	5 6	91	GR
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	GL

op. #	BARBER - M24 0031908	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 $\frac{1}{4}$	5			6-5-91	D/H
	G) Safety Off Force	3	3 $\frac{3}{4}$	3			6-5-91	D/H
	H) Trigger Pull Test & Retainability						6/5/91	JH
	I) Firing Pin Indent	.021	.020	.020			6-5-91	D/H
	J) Assemble Stock						6/6/91	RW
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/6/91	RW
	M) Iron Sight Alignment						6/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	RW
	O) Attach Scope to Rifle						6/6/91	RW
	P) Detach & Attach Scope 20 Times						6/6/91	RW
640	Gallery Target & Test						6-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-10-91	NF
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.56	2.57	2.59	2.53	2.57	6-13-91	JH
	C) Function						6-13-91	AC
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6636223DATE 6-5-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.41	2.40	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.36	2.39	2.57	
PULL #3	2.38	2.38	2.45	2.59	
PULL #4	2.39	2.45	2.38	2.53	
PULL #5	2.42	2.44	2.30	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.39		
PULL #2	3.37	3.45		
PULL #3	3.39	3.20		
PULL #4	3.43	3.42		
PULL #5	3.39	3.39		
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	4.58		4.46
PULL #2	4.60	4.60		4.47
PULL #3	4.60	4.57		4.48
PULL #4	4.61	4.59		4.56
PULL #5	4.56	4.57		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636223
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.218506
1 TO	2	.208255
1 TO	3	.567516
1 TO	4	.181739
1 TO	5	.424134

$\frac{x^2}{n}$

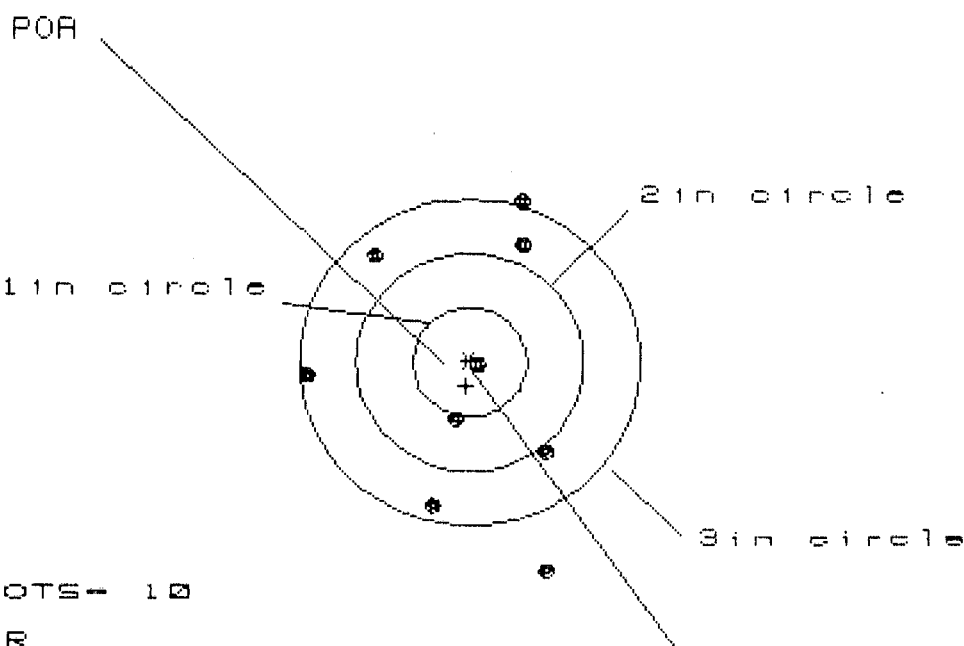
<----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .088
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0915371
THE AMR FOR THIS RIFLE IS: 1.062

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06696223

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS = 2.073

VS = 3.422

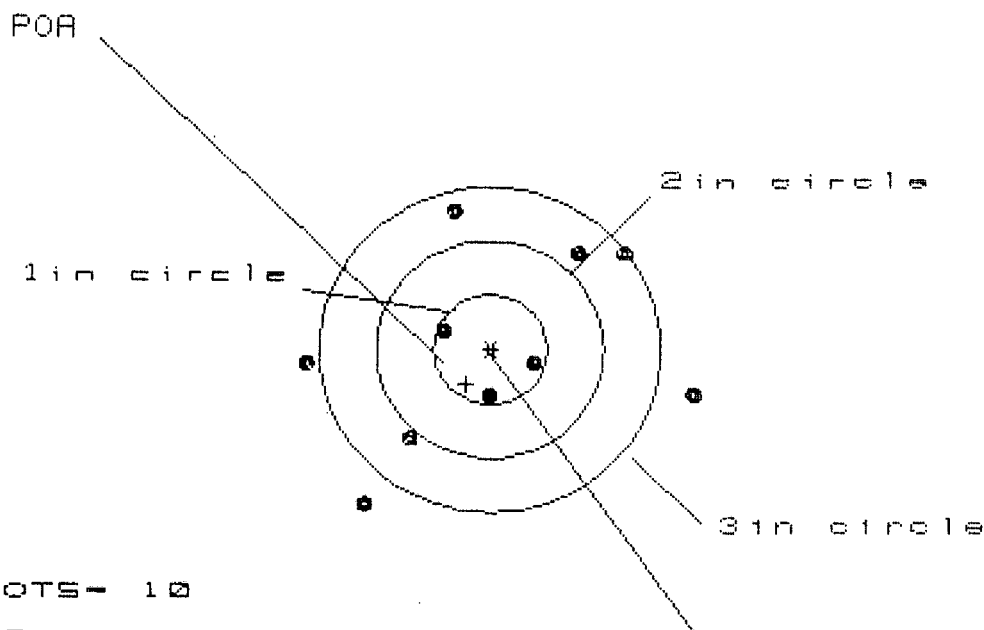
GS = 3.431

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.679	.705	.769
MINIMUM X	-1.394	-1.319	-1.255
MAXIMUM Y	1.497	1.283	1.076
MINIMUM Y	-1.925	-1.522	-1.362
CENTROID X	.033	-.042	-.106
CENTROID Y	.216	.430	.270
POA TO CENTROID in.	.219	.433	.290
MIN RADIUS	.060	.284	.204
MEAN RADIUS	1.165	1.078	1.020
MAX RADIUS	2.042	1.544	1.376
HORIZONTAL SPREAD	2.073	2.024	2.024
VERTICAL SPREAD	3.422	2.805	2.438
EXTREME SPREAD	3.431	2.907	2.559
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

6 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 7

HS= 3.412

VS= 2.707

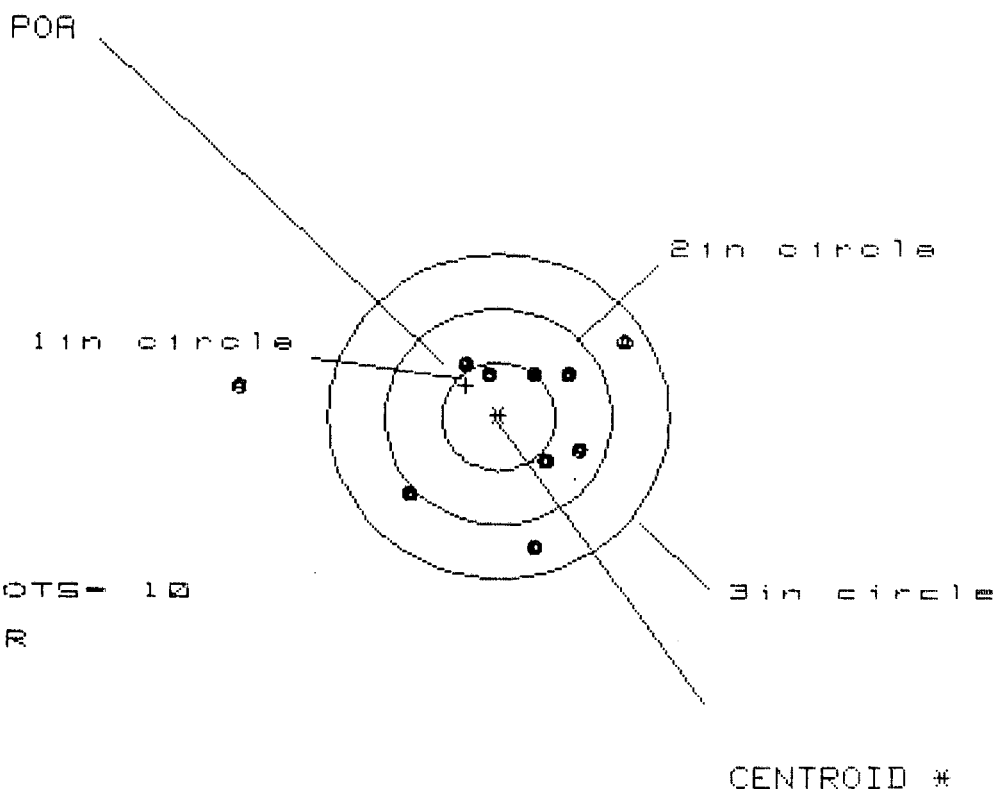
GS= 3.429

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.808	1.344	1.224
MINIMUM X	:	-1.604	-1.404	-1.524
MAXIMUM Y	:	1.318	1.267	1.087
MINIMUM Y	:	-1.389	-1.440	-1.062
CENTROID X	:	.214	.014	.134
CENTROID Y	:	.319	.370	.550
POA TO CENTROID in.	:	.384	.370	.566
MIN RADIUS	:	.395	.288	.352
MEAN RADIUS	:	1.170	1.085	1.000
MAX RADIUS	:	1.865	1.731	1.564
HORIZONTAL SPREAD	:	3.412	2.748	2.748
VERTICAL SPREAD	:	2.707	2.707	2.149
EXTREME SPREAD	:	3.429	3.234	2.924
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 3.405

VS= 1.936

GS= 3.435

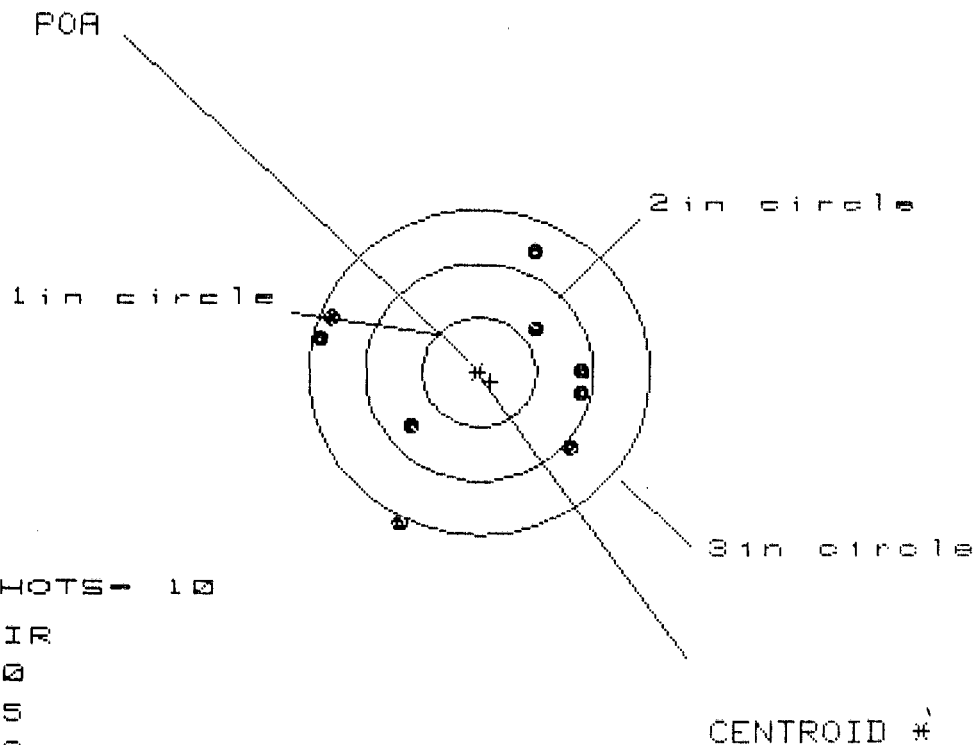
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.150	.899	.537
MINIMUM X	:	-2.255	-1.069	-.957
MAXIMUM Y	:	.699	.726	.572
MINIMUM Y	:	-1.238	-1.210	-1.119
CENTROID X	:	.288	.539	.426
CENTROID Y	:	-.291	-.318	-.409
POA TO CENTROID in.	:	.409	.626	.591
MIN RADIUS	:	.432	.361	.339
MEAN RADIUS	:	.945	.751	.714
MAX RADIUS	:	2.269	1.284	1.140
HORIZONTAL SPREAD	:	3.405	1.968	1.494
VERTICAL SPREAD	:	1.936	1.936	1.691
EXTREME SPREAD	:	3.435	2.437	1.795
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.354

VS = 2.504

GS = 2.778

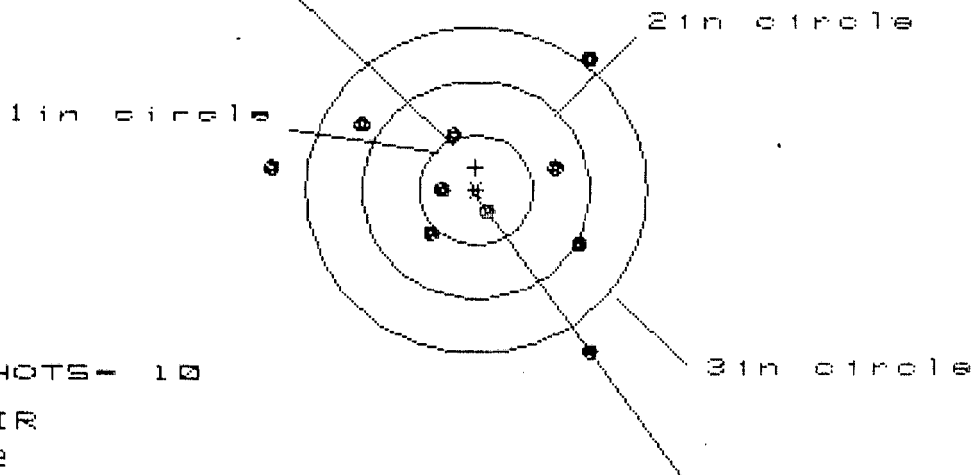
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.903	.824	.633
MINIMUM X	:	-1.451	-1.530	-1.558
MAXIMUM Y	:	1.108	.953	.969
MINIMUM Y	:	-1.396	-.807	-.791
CENTROID X	:	-.097	-.018	.174
CENTROID Y	:	.089	.244	.228
POA TO CENTROID in.	:	.132	.245	.287
MIN RADIUS	:	.614	.458	.323
MEAN RADIUS	:	1.056	.966	.835
MAX RADIUS	:	1.570	1.535	1.603
HORIZONTAL SPREAD	:	2.354	2.354	2.191
VERTICAL SPREAD	:	2.504	1.760	1.760
EXTREME SPREAD	:	2.778	2.469	2.423
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.779

VS= 2.696

GS= 3.240

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	1.108	.900
MINIMUM X	-1.780	-1.671	-1.105
MAXIMUM Y	1.180	1.012	1.012
MINIMUM Y	-1.516	-.631	-.631
CENTROID X	.002	-.107	.101
CENTROID Y	-.207	-.039	-.039
POA TO CENTROID in.	.207	.114	.109
MIN RADIUS	.214	.284	.357
MEAN RADIUS	.973	.878	.780
MAX RADIUS	1.809	1.671	1.354
HORIZONTAL SPREAD	2.779	2.779	2.005
VERTICAL SPREAD	2.696	1.643	1.643
EXTREME SPREAD	3.240	2.958	2.195
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		