

C6636280

MODEL 700™ M24

Model **SMS**™

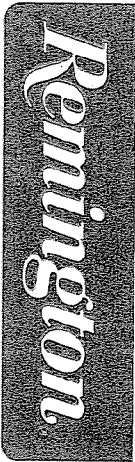
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636280

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	K.S.
600	Proof		5/3/91	K.S.
607	Check Headspace		5/3/91	K.S.
610	Dis-assemble Gun		5/3/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		G.B.
617	Drill and Tap Sight Holes	5 15 9 1		KB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	15
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	92

22222

op. #	BARBER M24 0032562	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-4-91	JK
	G) Safety Off Force	4	4	4			6-4-91	JK
	H) Trigger Pull Test & Retainability						6-4-91	JK
	I) Firing Pin Indent	10205	10205	10205			6-4-91	JK
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						6-5-91	DH
	A) Time						6-5-91	DH
	B) Malfunctions						6-5-91	DH
	C) Pierced Primers						6-5-91	DH
	D) Optical Clarity of Scope						6-5-91	DH
645	Inspect for Live Ammo						6-5-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.22	2.24	2.18	2.28	2.30	6-8-91	JK
	C) Function						6-8-91	DH
660	Pack						6-20-91	VF

Remington
MODEL 700™ M24

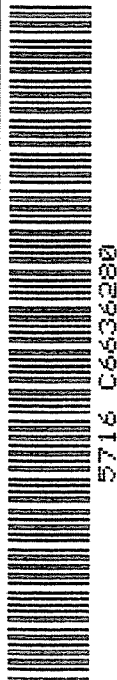
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

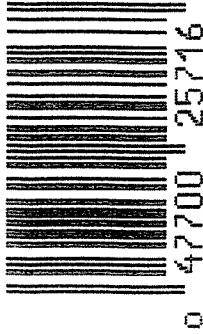
SERIAL NO.
C6636280

ORDER NO.
5716

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



LPC



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6636280

DATE 6-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.43	2.38	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.15	2.35	2.24	
PULL #3	2.36	2.59	2.30	2.18	
PULL #4	2.16	2.21	2.48	2.28	
PULL #5	2.58	2.31	2.50	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.37		
PULL #2	3.38	3.39		
PULL #3	3.30	3.32		
PULL #4	3.32	3.15		
PULL #5	3.41	3.36		
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	4.63		4.28
PULL #2	4.52	4.59		4.54
PULL #3	4.59	4.51		4.62
PULL #4	4.58	4.61		4.54
PULL #5	4.57	4.60		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636280
5 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.43115
1 TO	2	.647185
1 TO	3	.488938
1 TO	4	.453256
1 TO	5	.551599

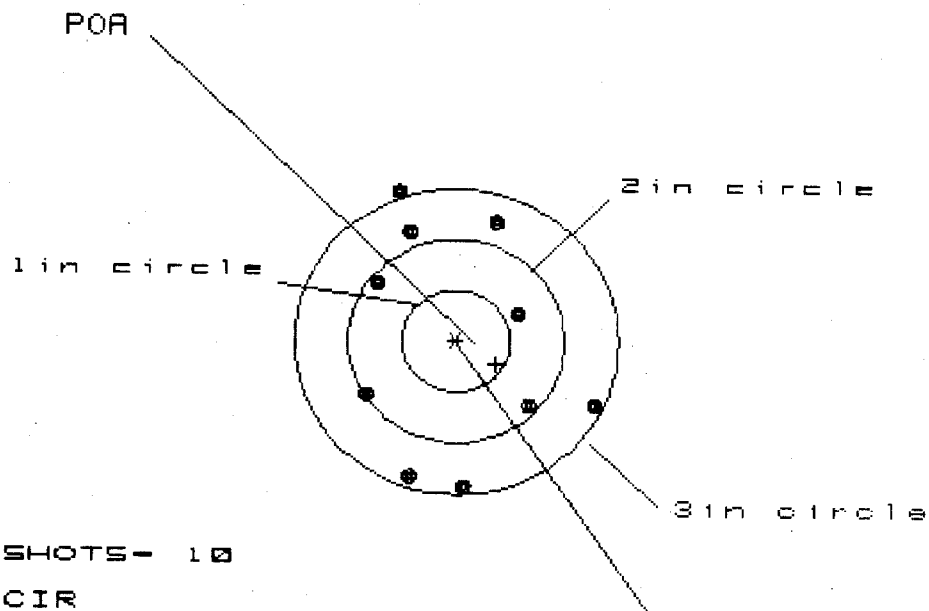
1.2 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0366
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0424985
THE AMR FOR THIS RIFLE IS: .9828

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636280

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS = 2.090

VS = 2.877

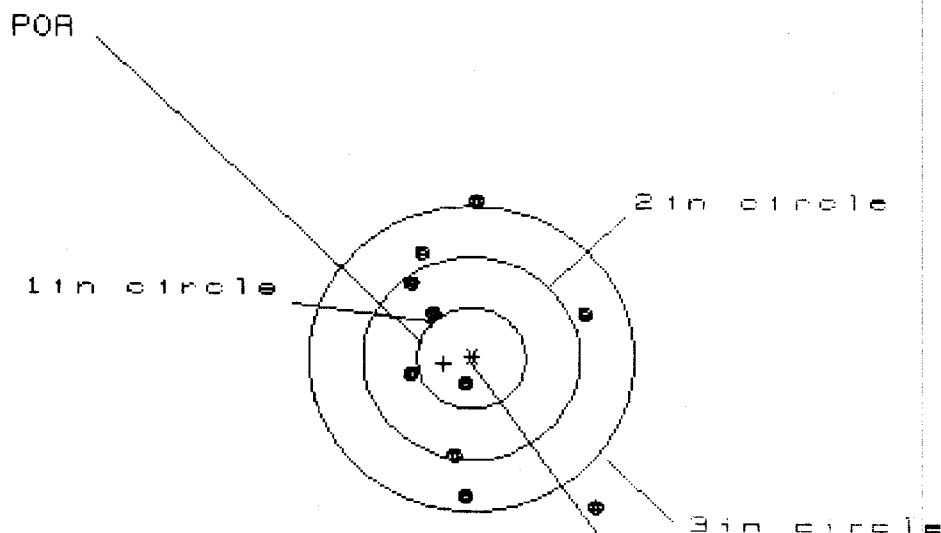
GS = 2.947

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.301	1.240	.786
MINIMUM X		-.789	-.850	-.695
MAXIMUM Y		1.438	1.325	1.262
MINIMUM Y		-1.439	-1.279	-1.342
CENTROID X		-.369	-.308	-.463
CENTROID Y		.223	.063	.126
POA TO CENTROID in.		.431	.314	.480
MIN RADIUS		.585	.624	.714
MEAN RADIUS		1.158	1.107	1.070
MAX RADIUS		1.539	1.362	1.355
HORIZONTAL SPREAD		2.090	2.090	1.481
VERTICAL SPREAD		2.877	2.604	2.604
EXTREME SPREAD		2.947	2.620	2.620
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.708

VS= 3.051

GS= 3.259

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.140	1.157
MINIMUM X	:	-.559	-.432	-.415
MAXIMUM Y	:	1.553	1.386	1.060
MINIMUM Y	:	-1.498	-1.486	-1.312
CENTROID X	:	.256	.129	.112
CENTROID Y	:	.055	.222	.048
POA TO CENTROID in.	:	.262	.256	.122
MIN RADIUS	:	.256	.334	.276
MEAN RADIUS	:	1.026	.904	.828
MAX RADIUS	:	1.888	1.487	1.315
HORIZONTAL SPREAD	:	1.708	1.572	1.572
VERTICAL SPREAD	:	3.051	2.872	2.372
EXTREME SPREAD	:	3.259	2.873	2.412
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

5 Jun 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.685

VS = 2.454

GS = 3.637

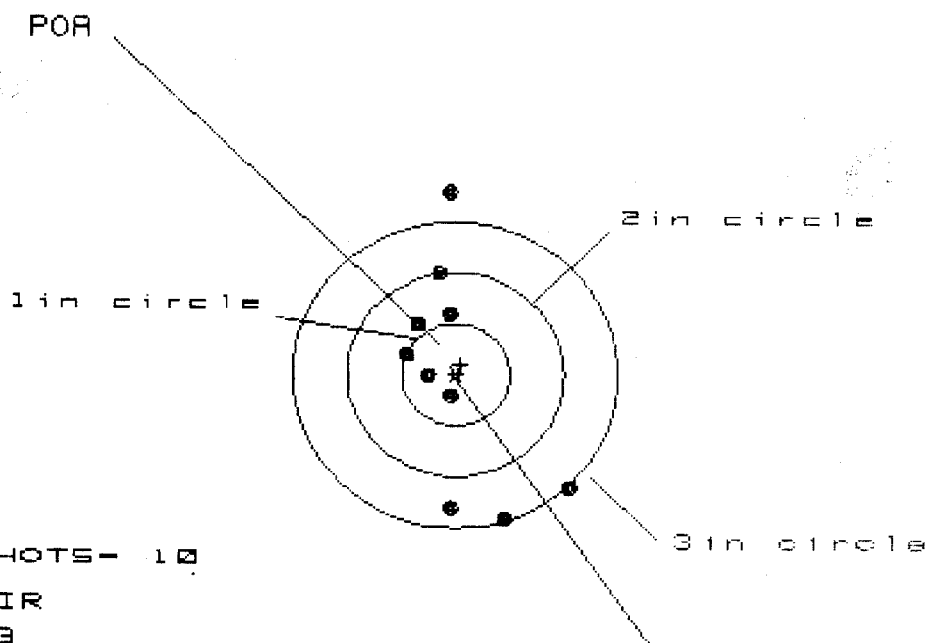
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	1.039	.922
MINIMUM X	:	-1.108	-.933	-.546
MAXIMUM Y	:	1.401	1.284	1.004
MINIMUM Y	:	-1.053	-1.002	-.842
CENTROID X	:	.029	-.146	-.029
CENTROID Y	:	-.061	.056	-.104
POA TO CENTROID in.	:	.067	.157	.108
MIN RADIUS	:	.224	.372	.183
MEAN RADIUS	:	.966	.852	.736
MAX RADIUS	:	1.896	1.587	1.364
HORIZONTAL SPREAD	:	2.685	1.972	1.469
VERTICAL SPREAD	:	2.454	2.286	1.846
EXTREME SPREAD	:	3.637	2.517	2.266
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 1.545

VS= 3.142

GS= 3.182

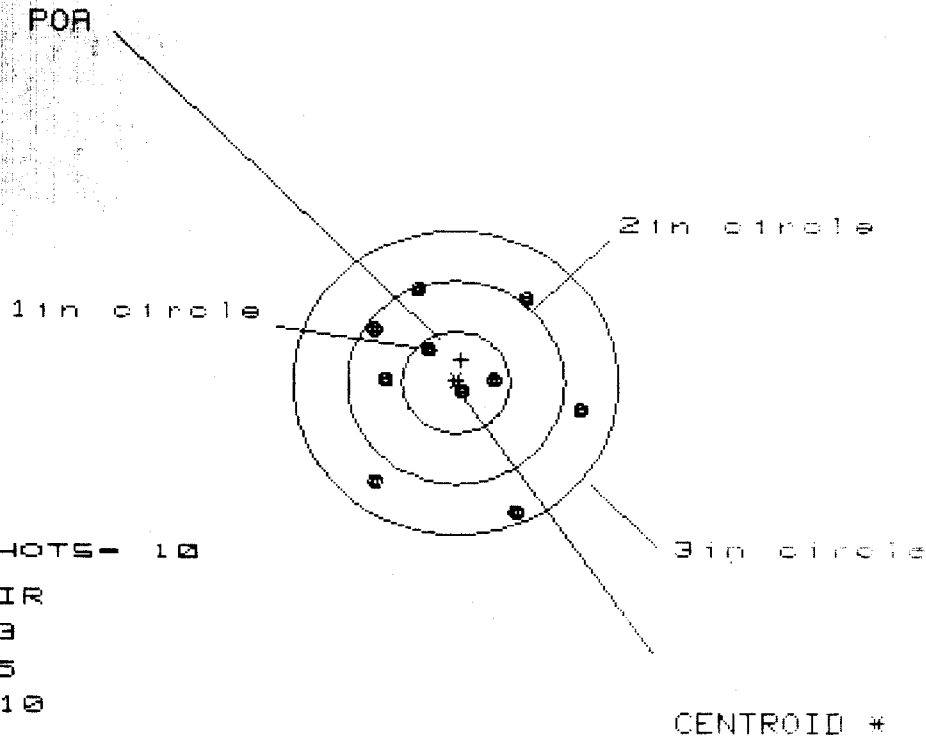
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.080	.538
MINIMUM X	:	-.455	-.465	-.330
MAXIMUM Y	:	1.757	1.170	1.062
MINIMUM Y	:	-1.385	-1.190	-1.298
CENTROID X	:	-.049	-.038	-.173
CENTROID Y	:	-.098	-.293	-.185
POA TO CENTROID in.	:	.110	.296	.254
MIN RADIUS	:	.249	.106	.143
MEAN RADIUS	:	.920	.834	.712
MAX RADIUS	:	1.760	1.384	1.405
HORIZONTAL SPREAD	:	1.545	1.545	.868
VERTICAL SPREAD	:	3.142	2.360	2.360
EXTREME SPREAD	:	3.182	2.427	2.427
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.922

VS= 2.261

GS= 2.447

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.250	1.170
MINIMUM X	:	-.736	-.672	-.752
MAXIMUM Y	:	.970	.827	.681
MINIMUM Y	:	-1.291	-1.160	-.543
CENTROID X	:	-.050	-.114	-.034
CENTROID Y	:	-.227	-.084	.061
POA TO CENTROID in.	:	.232	.142	.070
MIN RADIUS	:	.118	.271	.293
MEAN RADIUS	:	.844	.765	.695
MAX RADIUS	:	1.416	1.327	1.290
HORIZONTAL SPREAD	:	1.922	1.922	1.922
VERTICAL SPREAD	:	2.261	1.987	1.225
EXTREME SPREAD	:	2.447	2.280	2.063
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	10		