

06636305

MODEL 700™ M24

Model **SMS**™

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.
C6636305

ORDER NO.
5716

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

20

5716 C6636305

UPC

0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6636305**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KH
600	Proof		6/24/91	KH
607	Check Headspace		6/24/91	KH
610	Dis-assemble Gun		6/24/91	KH
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	SS
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7.30-91	JA

op. #	BARBER - M24 0032836 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-31-91	DH
	G) Safety Off Force	4	3 1/2	4			7-31-91	DH
	H) Trigger Pull Test & Retainability				.021	.021	7-30-91	JH
	I) Firing Pin Indent	.021	.021	.021	.021	.021	7-31-91	DH
	J) Assemble Stock						8-1-91	KH
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8-1-91	KH
	M) Iron Sight Alignment						8-1-91	KH
	N) Detach Front & Rear Sights & place in numbered container						8-1-91	KH
	O) Attach Scope to Rifle						8-1-91	KH
	P) Detach & Attach Scope 20 Times						8-1-91	KH
640	Gallery Target & Test						8-2-91	DL
	A) Time						8-2-91	DH
	B) Malfunctions						8-2-91	DH
	C) Pierced Primers						8-2-91	DH
	D) Optical Clarity of Scope						8-2-91	DH
645	Inspect for Live Ammo						8-2-91	DH
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.60	2.65	2.65	2.68	2.45	8-5-91	JH
	C) Function						8-6-91	AC
660	Pack						8-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO

C-66636305

DATE

7-30-91

TESTER

[Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.53	2.52	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.50	2.50	2.65	
PULL #3	2.60	2.51	2.50	2.65	
PULL #4	2.54	2.53	2.53	2.68	
PULL #5	2.62	2.54	2.53	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.46		
PULL #2	3.51	3.50		
PULL #3	3.37	3.53		
PULL #4	3.42	3.48		
PULL #5	3.41	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.43		4.39
PULL #2	4.30	4.40		4.50
PULL #3	4.33	4.35		4.45
PULL #4	4.32	4.35		4.46
PULL #5	4.22	4.43		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636305
2 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.330385
1 TO	2	.274221
1 TO	3	.421742
1 TO	4	.301902
1 TO	5	.337322

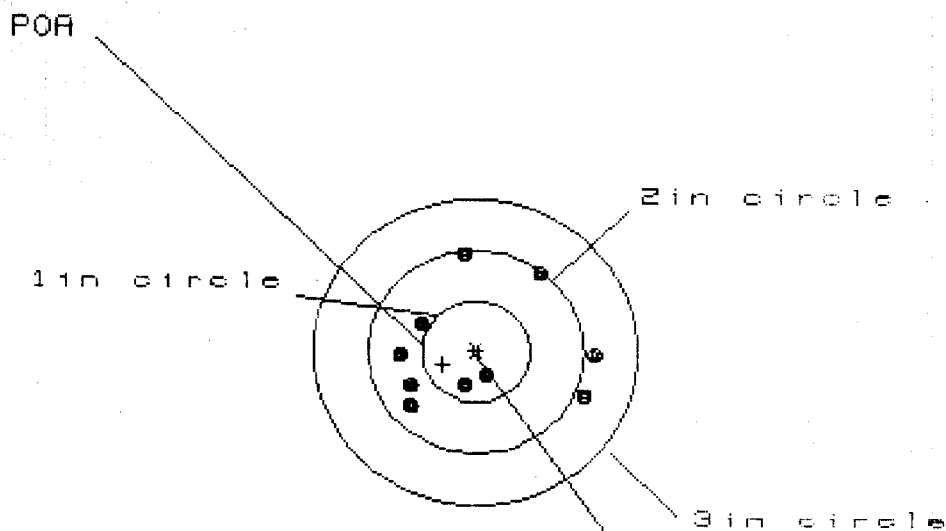
3' <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0538
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .079
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0955795
THE AMR FOR THIS RIFLE IS: .8342

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636305

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.757

VS= 1.492

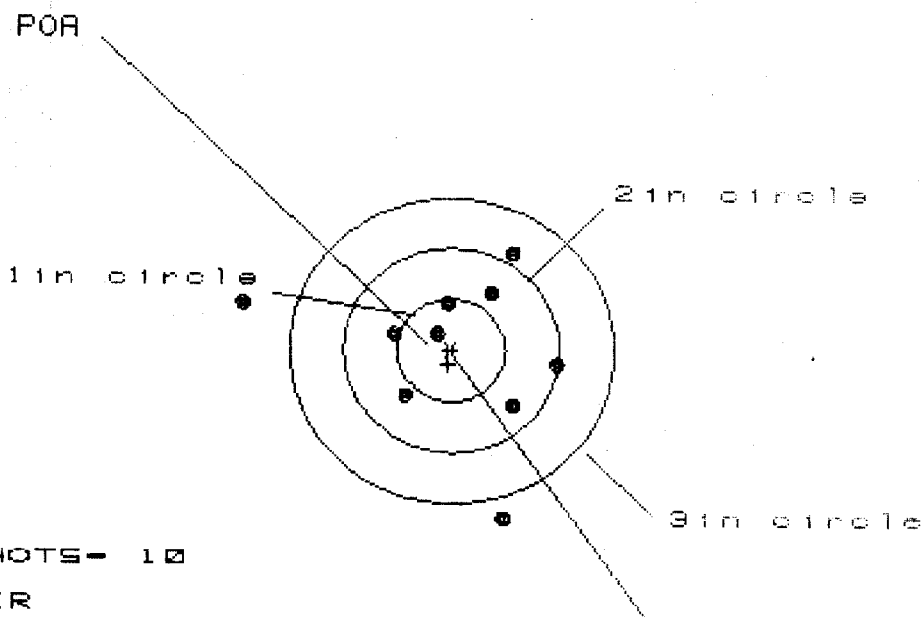
GS= 1.801

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	1.095	.813
MINIMUM X	:	-.668	-.547	-.411
MAXIMUM Y	:	.959	.954	.895
MINIMUM Y	:	-.533	-.538	-.597
CENTROID X	:	.305	.184	.048
CENTROID Y	:	.127	.132	.191
POA TO CENTROID in.	:	.331	.227	.197
MIN RADIUS	:	.228	.285	.347
MEAN RADIUS	:	.745	.685	.603
MAX RADIUS	:	1.090	1.193	1.055
HORIZONTAL SPREAD	:	1.757	1.642	1.224
VERTICAL SPREAD	:	1.492	1.492	1.492
EXTREME SPREAD	:	1.801	1.801	1.713
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.869

VS= 2.560

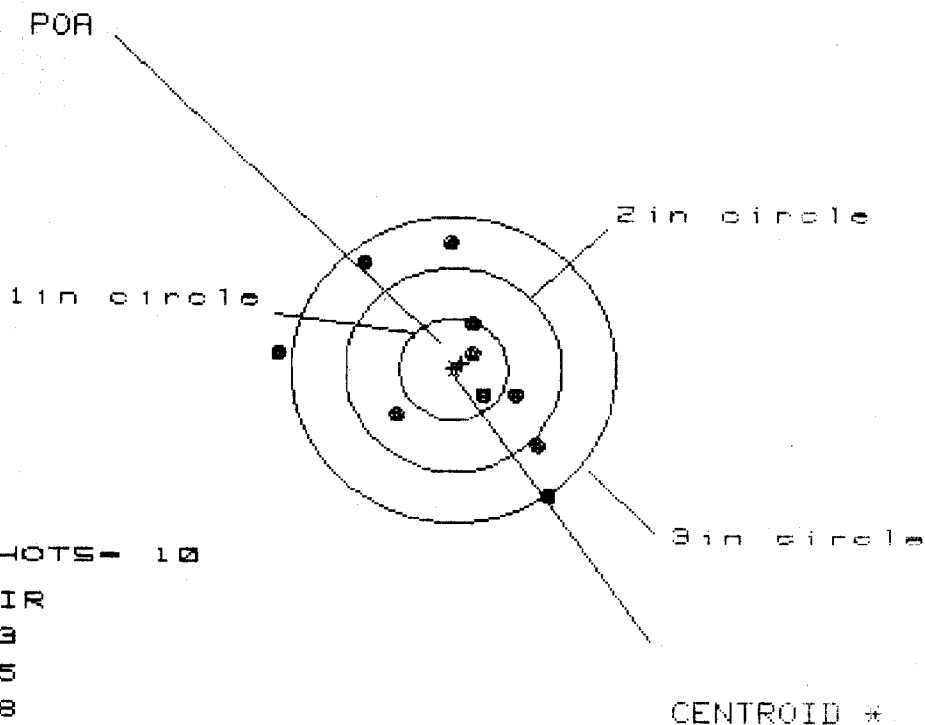
GS= 3.156

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.749	.786
MINIMUM X	:	-1.908	-.728	-.691
MAXIMUM Y	:	.958	1.006	.811
MINIMUM Y	:	-1.602	-1.554	-.666
CENTROID X	:	.031	.243	.206
CENTROID Y	:	.138	.090	.285
POA TO CENTROID in.	:	.141	.259	.351
MIN RADIUS	:	.166	.357	.268
MEAN RADIUS	:	.891	.780	.638
MAX RADIUS	:	1.955	1.582	.922
HORIZONTAL SPREAD	:	2.869	1.477	1.477
VERTICAL SPREAD	:	2.560	2.560	1.477
EXTREME SPREAD	:	3.156	2.562	1.728
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.522

VS= 2.491

GS= 2.863

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.920	.742	.732
MINIMUM X	:	-1.602	-.955	-.863
MAXIMUM Y	:	1.261	1.275	1.123
MINIMUM Y	:	-1.230	-1.216	-.920
CENTROID X	:	-.074	.104	.012
CENTROID Y	:	-.058	-.072	.080
POA TO CENTROID in.	:	.094	.127	.081
MIN RADIUS	:	.235	.137	.118
MEAN RADIUS	:	.922	.807	.734
MAX RADIUS	:	1.607	1.425	1.238
HORIZONTAL SPREAD	:	2.522	1.697	1.595
VERTICAL SPREAD	:	2.491	2.491	2.043
EXTREME SPREAD	:	2.863	2.823	2.411
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

CENTROID *

HS = 2.710

VS = 1.604

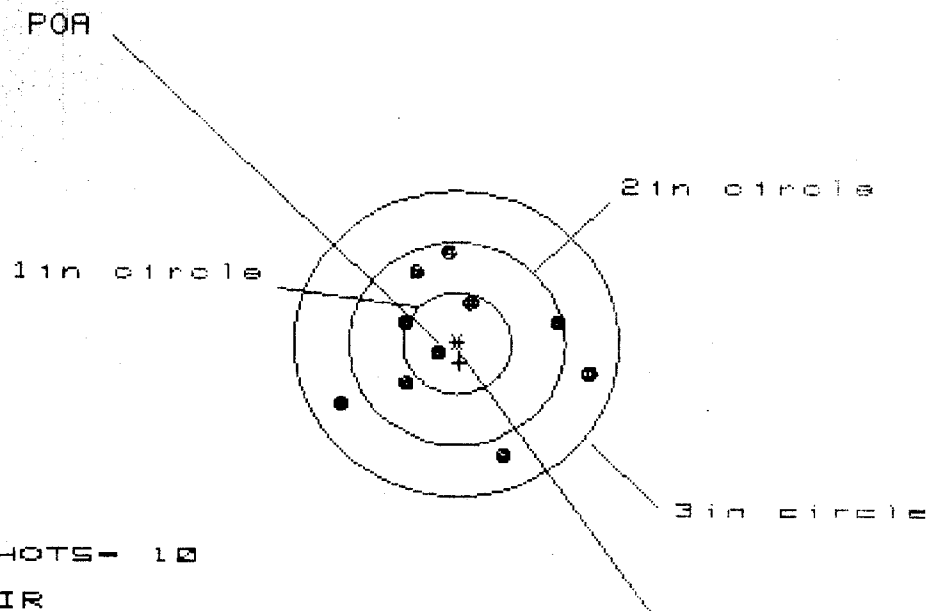
GS = 2.941

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	.975	.881
MINIMUM X	:	-.948	-.752	-.578
MAXIMUM Y	:	.860	.829	.881
MINIMUM Y	:	-.744	-.775	-.671
CENTROID X	:	.033	-.163	-.069
CENTROID Y	:	-.004	.027	-.076
POA TO CENTROID in.	:	.033	.165	.103
MIN RADIUS	:	.302	.124	.201
MEAN RADIUS	:	.809	.672	.608
MAX RADIUS	:	1.785	1.126	1.053
HORIZONTAL SPREAD	:	2.710	1.727	1.459
VERTICAL SPREAD	:	1.604	1.604	1.552
EXTREME SPREAD	:	2.941	2.219	1.982
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.250

VS = 1.962

GS = 2.278

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.068	.957
MINIMUM X	:	-1.064	-.640	-.506
MAXIMUM Y	:	.897	.829	.789
MINIMUM Y	:	-1.065	-1.133	-1.173
CENTROID X	:	-.026	.092	-.042
CENTROID Y	:	.192	.260	.300
POR TO CENTROID in.	:	.193	.276	.303
MIN RADIUS	:	.187	.323	.254
MEAN RADIUS	:	.804	.761	.685
MAX RADIUS	:	1.228	1.179	1.260
HORIZONTAL SPREAD	:	2.250	1.708	1.463
VERTICAL SPREAD	:	1.962	1.962	1.962
EXTREME SPREAD	:	2.278	2.036	2.036
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		