

C6636319

MODEL 700™ M24

Model **SMS**™

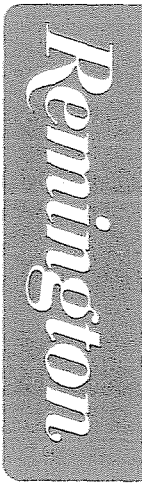
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



MOD. _____		GA. CAL. _____	GUN # <u>6319</u>
INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
KT	1st	Rear Trigger Plate Screw, Head Stripped	KS
	6/5		
	2nd	Repaired New Screw	KS
	4/7/91		
	3rd		
	4th		

FINAL INSPECTION RD 6657 Rev 1

Remington DU PONT REG. U.S. PAT. & TM. OFF		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6636319
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716
 5716 C6636319		

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636319

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	JA
	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		6/3/91	JA

op. #	BARBER M24 0032993	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6/3/91	JP
	G) Safety Off Force	3	3	3			6/3/91	JP
	H) Trigger Pull Test & Retainability						6/3/91	JP
	I) Firing Pin Indent	0.0205	0.021	0.021			6/3/91	JP
	J) Assemble Stock						6/4/91	KS
	K) Assemble Swivel Studs						6-13-91	KS
	L) Attach Front and Rear Sight Assemblies						6/4/91	KS
	M) Iron Sight Alignment						6/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	KS
	O) Attach Scope to Rifle						6/4/91	KS
	P) Detach & Attach Scope 20 Times						6/4/91	KS
640	Gallery Target & Test						6/5/91	KT
	A) Time						6/5/91	KT
	B) Malfunctions						6/5/91	KT
	C) Pierced Primers						6/5/91	KT
	D) Optical Clarity of Scope						6/5/91	KT
645	Inspect for Live Ammo						6/5/91	KT
655	Final Inspection							
	A) Headspace						6-13-91	KS
	B) Trigger Pull	2.51	2.58	2.50	2.48	2.42	6-13-91	JP
	C) Function						6-13-91	KS
660	Pack						6-20-91	KS

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

SERIAL NO. C6636319DATE 6-3-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.44	2.44	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	2.43	2.53	2.58	
PULL #3	2.49	2.45	2.48	2.50	
PULL #4	2.44	2.53	2.51	2.48	
PULL #5	2.51	2.27	2.51	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.64	3.60		
PULL #2	3.60	3.56		
PULL #3	3.52	3.66		
PULL #4	3.62	3.47		
PULL #5	3.54	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.53		4.30
PULL #2	4.26	4.46		4.36
PULL #3	4.22	4.41		4.35
PULL #4	4.17	4.39		4.37
PULL #5	4.17	4.37		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636319
5 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.145014
1 TO 2	.11952
1 TO 3	.216924
1 TO 4	.0751665
1 TO 5	.251149

100

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.095
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0322
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .100309
THE AMR FOR THIS RIFLE IS: 1.041

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636313

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 2

3in = 5

HS= 3.576

VS= 5.057

GS= 5.130

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.630	1.658	1.418
MINIMUM X	-1.946	-1.918	-1.518
MAXIMUM Y	2.009	1.671	1.827
MINIMUM Y	-3.048	-1.423	-1.267
CENTROID X	-0.070	-0.098	.142
CENTROID Y	-1.127	.211	.055
POA TO CENTROID in.	.145	.233	.152
MIN RADIUS	.188	.152	.226
MEAN RADIUS	1.542	1.375	1.216
MAX RADIUS	3.058	2.289	1.905
HORIZONTAL SPREAD	3.576	3.576	2.936
VERTICAL SPREAD	5.057	3.094	3.094
EXTREME SPREAD	5.130	3.842	3.471
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636319

CENTERFIRE PATTERNS

2

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

CENTROID #

HS= 2.406

VS= 3.807

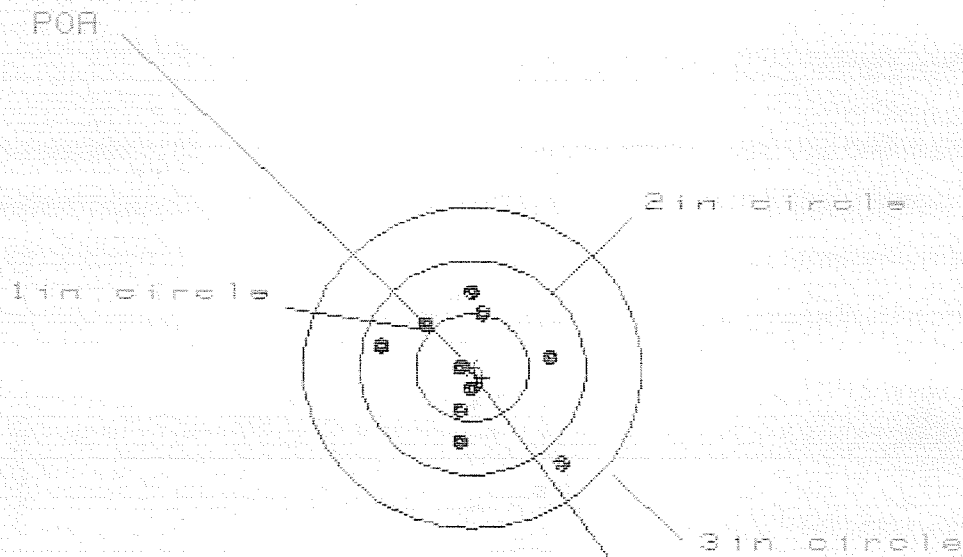
GS= 3.852

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.883	.933	.923
MINIMUM X	:	-1.523	-1.473	-1.483
MAXIMUM Y	:	2.115	1.605	1.423
MINIMUM Y	:	-1.692	-1.457	-1.083
CENTROID X	:	-.156	-.206	-.196
CENTROID Y	:	-.044	-.279	-.097
FOR TO CENTROID in.	:	.162	.347	.219
MIN RADIUS	:	.506	.342	.477
MEAN RADIUS	:	1.274	1.147	1.109
MAX RADIUS	:	2.163	1.733	1.561
HORIZONTAL SPREAD	:	2.406	2.406	2.406
VERTICAL SPREAD	:	3.807	3.062	2.506
EXTREME SPREAD	:	3.852	3.149	2.592
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636319

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

CENTROID *

HS= 1.510

VS= 1.562

GS= 1.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.750	.777	.692
MINIMUM X	-.760	-.676	-.423
MAXIMUM Y	.717	.623	.643
MINIMUM Y	-.845	-.778	-.758
CENTROID X	-.090	-.174	-.089
CENTROID Y	.089	.183	.163
POA TO CENTROID in.	.127	.253	.186
MIN RADIUS	.135	.066	.132
MEAN RADIUS	.578	.504	.482
MAX RADIUS	1.130	.779	.761
HORIZONTAL SPREAD	1.510	1.453	1.115
VERTICAL SPREAD	1.562	1.401	1.401
EXTREME SPREAD	1.868	1.462	1.402
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C853B313

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.423

VS= 3.467

GS= 3.622

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.270	1.191	1.224
MINIMUM X	:	-1.153	-1.232	-1.199
MAXIMUM Y	:	2.141	1.388	1.252
MINIMUM Y	:	-1.325	-1.088	-1.035
CENTROID X	:	-.065	.014	-.019
CENTROID Y	:	-.202	-.439	-.304
POA TO CENTROID in.	:	.212	.440	.304
MIN RADIUS	:	.287	.386	.300
MEAN RADIUS	:	1.171	1.010	.999
MAX RADIUS	:	2.255	1.503	1.401
HORIZONTAL SPREAD	:	2.423	2.423	2.423
VERTICAL SPREAD	:	3.467	2.476	2.288
EXTREME SPREAD	:	3.622	2.587	2.479
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86636319

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.085

VS= 1.841

GS= 2.466

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.051
MINIMUM X	-1.034
MAXIMUM Y	.675
MINIMUM Y	-1.166
CENTROID X	-.094
CENTROID Y	.123
POA TO CENTROID in.	.154
MIN RADIUS	.054
MEAN RADIUS	.641
MAX RADIUS	1.569
HORIZONTAL SPREAD	2.085
VERTICAL SPREAD	1.841
EXTREME SPREAD	2.466
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9