

C6636342

MODEL 700™ M24

Model **SMS**™

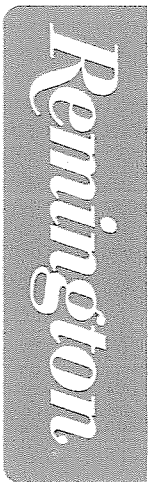
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



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

Remington[®]

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

MODEL 700[™] H24

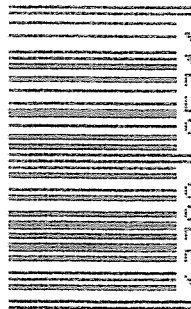
SERIAL NO.
C6636342

ORDER NO.
5716

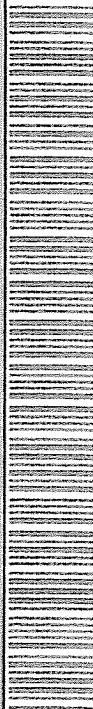
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

UPC



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5716 C6636342

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636342

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	WB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8/16/91	JA
	Apply Coating (Bolt)		8/16/91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		8/17/91	JA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/91	JA
	C) Inspect Ejector Hole for Chamfer		8/17/91	JA
	D) Oil Firing Pin Ass'y		8/17/91	JA
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	JA

op. # BARBER M24 0033268		READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			8-19-91	JH
	G) Safety Off Force	3	3	3			8-19-91	JH
	H) Trigger Pull Test & Retainability						8-19-91	JH
	I) Firing Pin Indent	.021	.021	.021			8-19-91	JH
	J) Assemble Stock						8/20/91	KL
	K) Assemble Swivel Studs						8/22/91	KL
	L) Attach Front and Rear Sight Assemblies						8/20/91	KL
	M) Iron Sight Alignment						8/20/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	KL
	O) Attach Scope to Rifle						8/20/91	KL
	P) Detach & Attach Scope 20 Times						8/20/91	KL
640	Gallery Target & Test						8/21/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						8/21/91	KT
655	Final Inspection							
	A) Headspace						8/22/91	JH
	B) Trigger Pull	2.65	2.68	2.54	2.56	2.55	8/22/91	JH
	C) Function						8/22/91	JH
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6636342DATE 8-19-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.60	2.50	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.42	2.48	2.68	
PULL #3	2.46	2.47	2.55	2.54	
PULL #4	2.36	2.52	2.51	2.56	
PULL #5	2.29	2.41	2.56	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.26		
PULL #2	3.39	3.24		
PULL #3	3.34	3.37		
PULL #4	3.32	3.18		
PULL #5	3.31	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.55		4.70
PULL #2	4.49	4.55		4.66
PULL #3	4.43	4.48		4.68
PULL #4	4.59	4.42		4.46
PULL #5	4.50	4.51		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636342
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0941541
1 TO	2	.123004
1 TO	3	.0562939
1 TO	4	.109165
1 TO	5	.125936

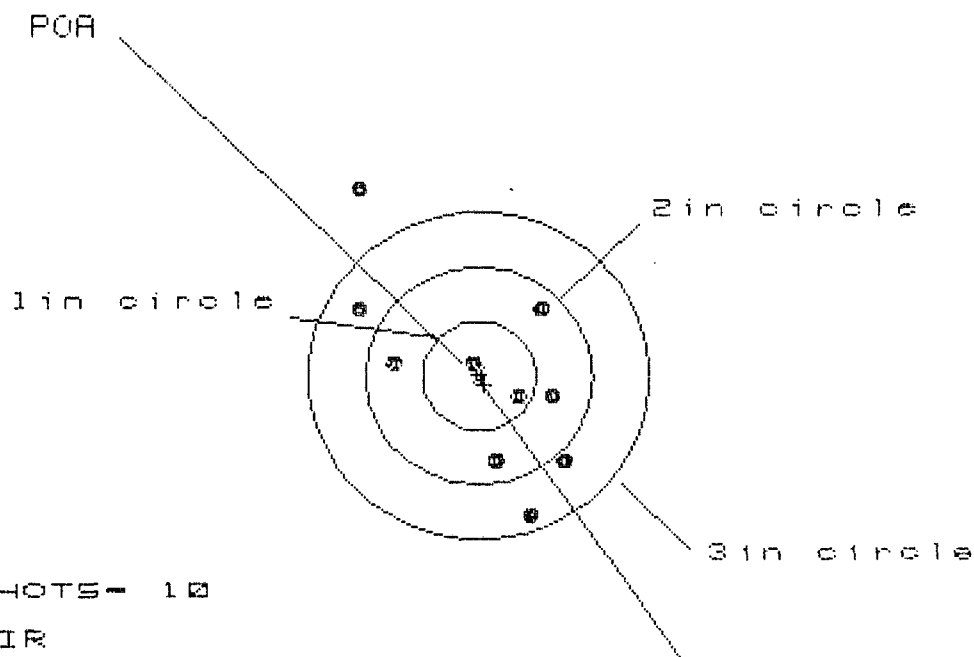
⊗ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .033
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0810247
THE AMR FOR THIS RIFLE IS: 1.097

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8696342

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.790

VS= 3.012

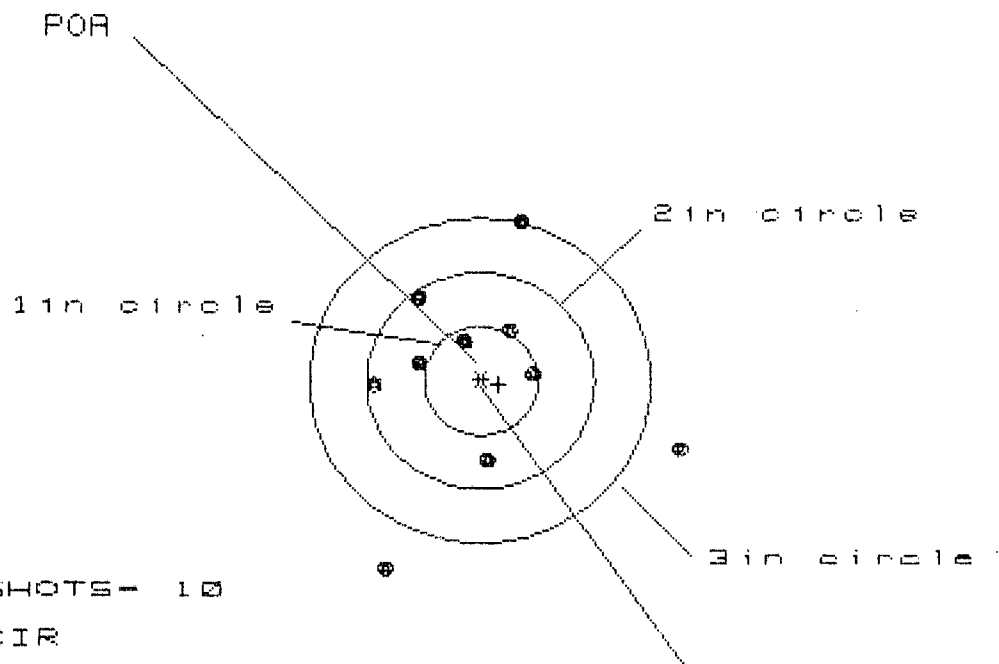
GS= 3.331

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.729	.616	.654
MINIMUM X	-1.061	-1.174	-1.136
MAXIMUM Y	1.718	.775	.638
MINIMUM Y	-1.294	-1.104	-.723
CENTROID X	-.048	.065	.027
CENTROID Y	.081	-.109	.029
POA TO CENTROID in.	.094	.127	.039
MIN RADIUS	.088	.237	.177
MEAN RADIUS	.914	.767	.715
MAX RADIUS	1.993	1.407	1.303
HORIZONTAL SPREAD	1.790	1.790	1.790
VERTICAL SPREAD	3.012	1.879	1.361
EXTREME SPREAD	3.331	2.388	2.249
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.753

VS= 3.155

GS= 3.343

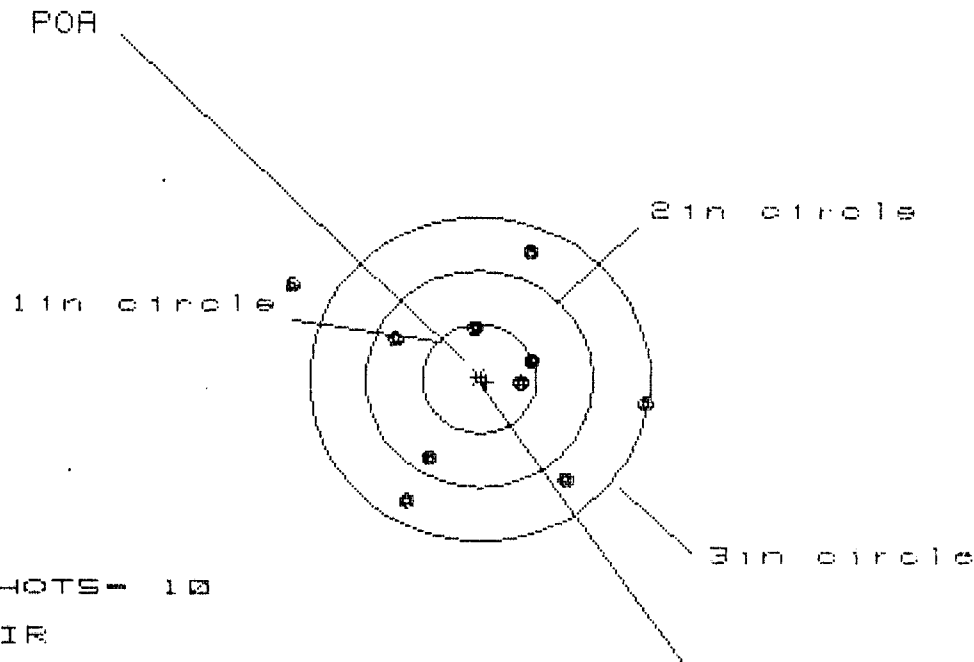
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.885	.666	.592
MINIMUM X	-.948	-.748	-.822
MAXIMUM Y	1.431	1.359	1.135
MINIMUM Y	-1.724	-1.796	-1.069
CENTROID X	-.159	-.359	-.285
CENTROID Y	.028	.100	.324
POA TO CENTROID in.	.161	.373	.432
MIN RADIUS	.412	.319	.092
MEAN RADIUS	.986	.851	.672
MAX RADIUS	1.917	1.891	1.216
HORIZONTAL SPREAD	2.753	1.414	1.414
VERTICAL SPREAD	3.155	3.155	2.204
EXTREME SPREAD	3.343	3.343	2.219
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 = 9

HS= 3.059

VS= 2.215

GS= 3.257

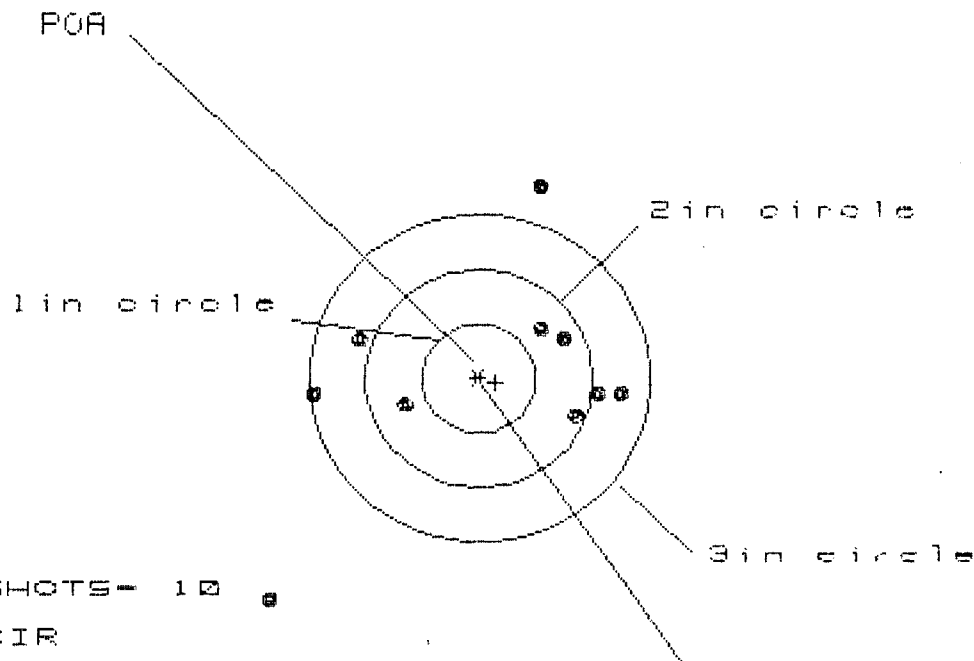
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.455	1.277	.749
MINIMUM X	:	-1.604	-.964	-.805
MAXIMUM Y	:	1.124	1.222	1.204
MINIMUM Y	:	-1.091	-.993	-1.011
CENTROID X	:	-.060	.118	-.041
CENTROID Y	:	.026	-.072	-.054
POA TO CENTROID in.	:	.065	.138	.068
MIN RADIUS	:	.325	.159	.308
MEAN RADIUS	:	.982	.864	.816
MAX RADIUS	:	1.828	1.285	1.285
HORIZONTAL SPREAD	:	3.059	2.241	1.554
VERTICAL SPREAD	:	2.215	2.215	2.215
EXTREME SPREAD	:	3.257	2.456	2.456
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	1.084	1.128
MINIMUM X	:	-1.878	-1.686	-1.642
MAXIMUM Y	:	1.737	1.512	.395
MINIMUM Y	:	-2.021	-.520	-.331
CENTROID X	:	-.147	.062	.018
CENTROID Y	:	.035	.260	.071
POA TO CENTROID in.	:	.151	.267	.073
MIN RADIUS	:	.695	.411	.562
MEAN RADIUS	:	1.269	1.042	.977
MAX RADIUS	:	2.759	1.717	1.648
HORIZONTAL SPREAD	:	3.171	2.770	2.770
VERTICAL SPREAD	:	3.758	2.032	.726
EXTREME SPREAD	:	4.478	2.770	2.770
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.989

VS= 4.312

GS= 4.506

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.543	1.403	1.392
MINIMUM X	-1.446	-1.586	-1.597
MAXIMUM Y	1.697	1.406	.938
MINIMUM Y	-2.615	-1.699	-1.523
CENTROID X	.044	.184	.195
CENTROID Y	-.005	.285	.109
POA TO CENTROID in.	.044	.339	.224
MIN RADIUS	.192	.220	.216
MEAN RADIUS	1.335	1.116	1.076
MAX RADIUS	2.903	1.705	1.615
HORIZONTAL SPREAD	2.989	2.989	2.989
VERTICAL SPREAD	4.312	3.105	2.461
EXTREME SPREAD	4.506	3.105	2.989
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	