

C6611715

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

DUPONT

SERIAL NO.
C6611715

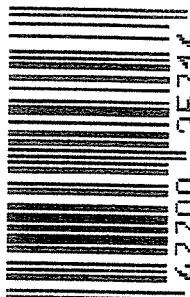
ORDER NO.
5716

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



5716 C6611715

UPC



0 47700 25716 7

GUN SERIAL # C6611715

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 91		RW
612	Magnaflux Barrel Action	5 6 91		KCK
	Magnaflux Bolt	5 6 91		KCK
615	Rollmark Caliber	5 6 91		GB
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		6-6-91	RM

op. #	BARBER M24 0034702	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	JU
	G) Safety Off Force	3	3	3			6-6-91	JU
	H) Trigger Pull Test & Retainability						6-6-91	JU
	I) Firing Pin Indent	.0215	.0215	.0215			6-6-91	JU
	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						6-7-91	AC
	A) Time						6-7-91	AC
	B) Malfunctions						6-7-91	AC
	C) Pierced Primers						6-7-91	AC
	D) Optical Clarity of Scope						6-7-91	AC
645	Inspect for Live Ammo						6-7-91	AC
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.12	2.15	2.15	2.16	2.15	6-13-91	JU
	C) Function						6-13-91	A
660	Pack						6-20-91	NF

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

SERIAL NO. C-6611715DATE 6-6-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.40	2.38	2.12	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.36	2.40	2.15	
PULL #3	2.38	2.35	2.44	2.15	
PULL #4	2.24	2.41	2.28	2.16	
PULL #5	2.24	2.37	2.20	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.50		
PULL #2	3.15	3.53		
PULL #3	3.36	3.55		
PULL #4	3.46	3.51		
PULL #5	3.40	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.30		4.32
PULL #2	4.43	4.42		4.42
PULL #3	4.33	4.20		4.45
PULL #4	4.32	4.37		4.44
PULL #5	4.41	4.28		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611715
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.397955
1 TO	2	.22102
1 TO	3	.369878
1 TO	4	.110023
1 TO	5	.323736

3.5
2.5
1
+-----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4358
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .506342

THE AMR FOR THIS RIFLE IS: .9318

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.249

VS= 1.202

GS= 2.499

CENTROID *

PATTERN #

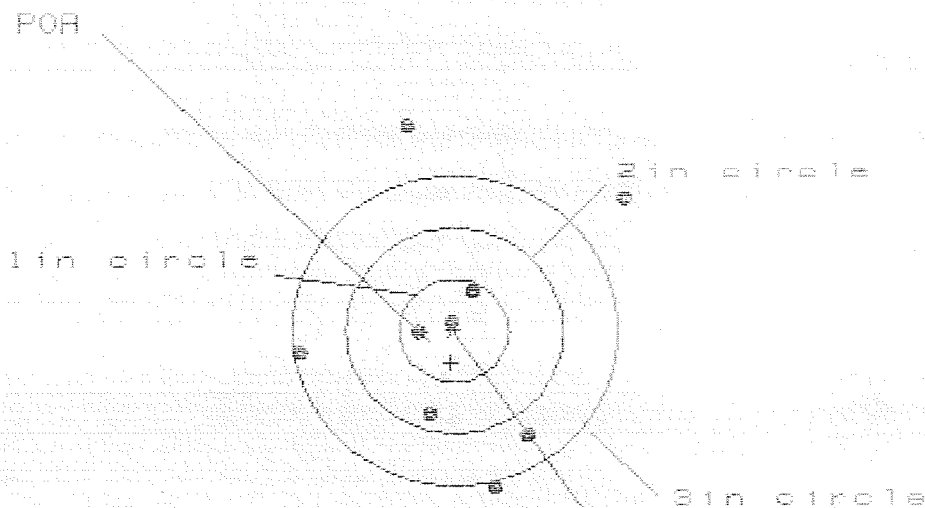
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	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	.853	.743
MINIMUM X	-1.014	-.877	-.659
MAXIMUM Y	.649	.547	.501
MINIMUM Y	-.553	-.481	-.527
CENTROID X	.252	.115	.225
CENTROID Y	.308	.236	.282
POA TO CENTROID in.	.398	.262	.360
MIN RADIUS	.404	.340	.376
MEAN RADIUS	.791	.699	.672
MAX RADIUS	1.395	.951	.792
HORIZONTAL SPREAD	2.249	1.730	1.402
VERTICAL SPREAD	1.202	1.028	1.028
EXTREME SPREAD	2.499	1.862	1.458
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	8	8	8
NUMBER IN THREE INCH CIRCLE =	10	10	10

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 3.0320

VS= 3.496

GS= 3.575

CENTROID #

PATTERN #

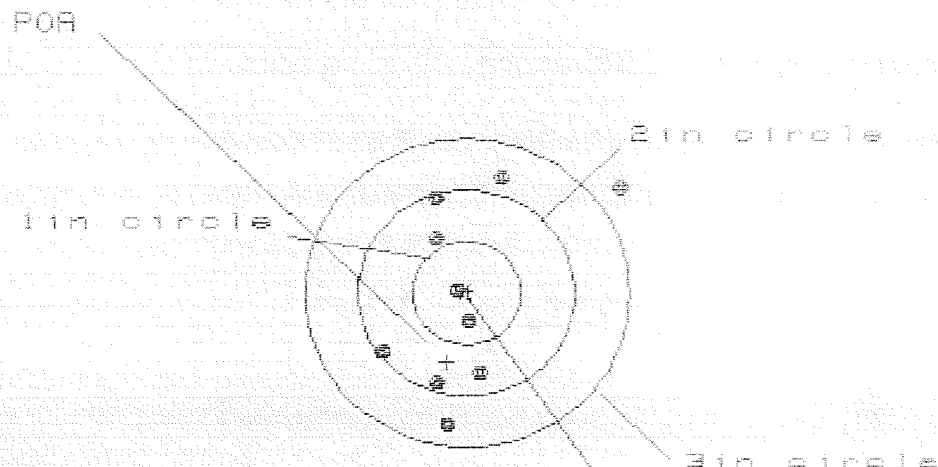
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.578	.816	.789
MINIMUM X	-1.442	-1.267	-1.294
MAXIMUM Y	1.949	2.094	.801
MINIMUM Y	-1.547	-1.402	-1.140
CENTROID X	.031	-.144	-.117
CENTROID Y	.311	.166	-.096
POA TO CENTROID in.	.313	.220	.151
MIN RADIUS	.045	.176	.404
MEAN RADIUS	1.032	.895	.771
MAX RADIUS	2.050	2.105	1.314
HORIZONTAL SPREAD	3.020	2.083	2.083
VERTICAL SPREAD	3.496	3.496	1.941
EXTREME SPREAD	3.575	3.575	2.260
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.252

VS= 2.424

GS= 2.858

CENTROID *

PATTERN #

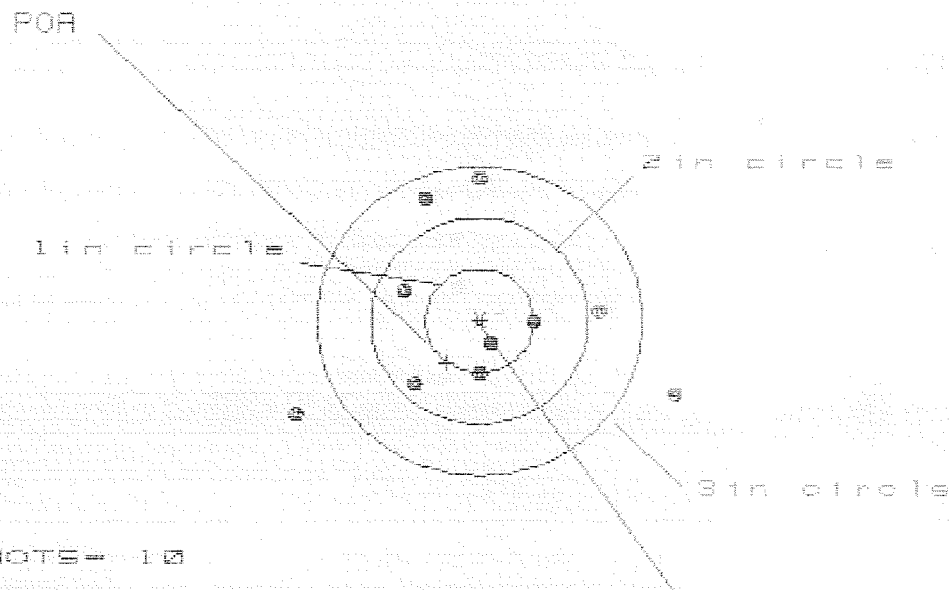
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.462	.500	.494
MINIMUM X	-.790	-.627	-.633
MAXIMUM Y	1.150	1.266	1.121
MINIMUM Y	-1.274	-1.158	-.942
CENTROID X	.181	.018	.024
CENTROID Y	.671	.555	.700
POA TO CENTROID in.	.695	.555	.700
MIN RADIUS	.115	.159	.047
MEAN RADIUS	.893	.767	.712
MAX RADIUS	1.797	1.361	1.225
HORIZONTAL SPREAD	2.252	1.127	1.127
VERTICAL SPREAD	2.424	2.424	2.063
EXTREME SPREAD	2.858	2.485	2.157
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.457

VS = 2.384

GS = 3.467

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.791

1.324

1.140

MINIMUM X

-1.666

-1.467

-1.726

MAXIMUM Y

1.436

1.359

1.231

MINIMUM Y

-1.948

-1.025

-1.770

CENTROID X

.300

.101

.285

CENTROID Y

.407

.484

.612

POA TO CENTROID in.

.506

.494

.675

MIN RADIUS

.261

.442

.457

MEAN RADIUS

1.057

.971

.863

MAX RADIUS

1.918

1.790

1.231

HORIZONTAL SPREAD

3.457

2.791

1.866

VERTICAL SPREAD

2.384

2.384

2.001

EXTREME SPREAD

3.467

2.994

2.088

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611715

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 2.036

VS = 2.599

GS = 3.128

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.070

.987

1.101

MINIMUM X

-.966

-1.049

-.935

MAXIMUM Y

1.151

.990

.874

MINIMUM Y

-1.448

-.693

-.569

CENTROID X

.525

.608

.494

CENTROID Y

.482

.643

.519

POR TO CENTROID IN

.713

.885

.716

MIN RADIUS

.351

.421

.349

MEAN RADIUS

.886

.803

.711

MAX RADIUS

1.628

1.348

1.240

HORIZONTAL SPREAD

2.036

2.036

2.036

VERTICAL SPREAD

2.599

1.683

1.443

EXTREME SPREAD

3.128

2.514

2.039

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8