

C6611776

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611776	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611776

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	YB
617	Drill and Tap Sight Holes	2 2 91		FB
618	Polish Barrel RBB	2 2 91		WB
620	Apply Coatings (Barrel Action)		2-11-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	JA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	JA
	C) Inspect Ejector Hole for Chamfer		2/18/91	JA
	D) Oil Firing Pin Ass'y		2/18/91	JA
	E) Adjust Trigger Pull to Min Setting and Stake		2/18/91	JA

op. #	BARBER M24 0035773	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			2/19/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/19/91	WB
	H) Trigger Pull Test & Retainability						2/19/91	WB
	I) Firing Pin Indent	.0205	.020	.020			2/19/91	WB
	J) Assemble Stock						2/19/91	KA
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/19/91	KA
	M) Iron Sight Alignment						2/19/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	KA
	O) Attach Scope to Rifle						2/19/91	KA
	P) Detach & Attach Scope 20 Times						2/19/91	KA
640	Gallery Target & Test						2-20-91	DH
	A) Time						2-20-91	DH
	B) Malfunctions						2-20-91	DH
	C) Pierced Primers						2-20-91	DH
	D) Optical Clarity of Scope						2-20-91	DH
645	Inspect for Live Ammo						2-20-91	DH
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.30	2.34	2.32	2.34	2.20	2/21/91	KA
	C) Function						2-22-91	A
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06611776

DATE 2/19/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.39	2.30	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.43	2.35	2.34	
PULL #3	2.29	2.44	2.42	2.32	
PULL #4	2.27	2.19	2.30	2.34	
PULL #5	2.32	2.34	2.31	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.21		
PULL #2	3.41	3.16		
PULL #3	3.26	3.15		
PULL #4	3.23	3.20		
PULL #5	3.24	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.47		4.39
PULL #2	4.38	4.432		4.46
PULL #3	4.28	4.46		4.45
PULL #4	4.33	4.51		4.50
PULL #5	4.34	4.51		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # ~~AMR~~ C6611776
20 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.250306
1 TO	2	.101213
1 TO	3	.145031
1 TO	4	.555757
1 TO	5	.249906

4-8 <----POA

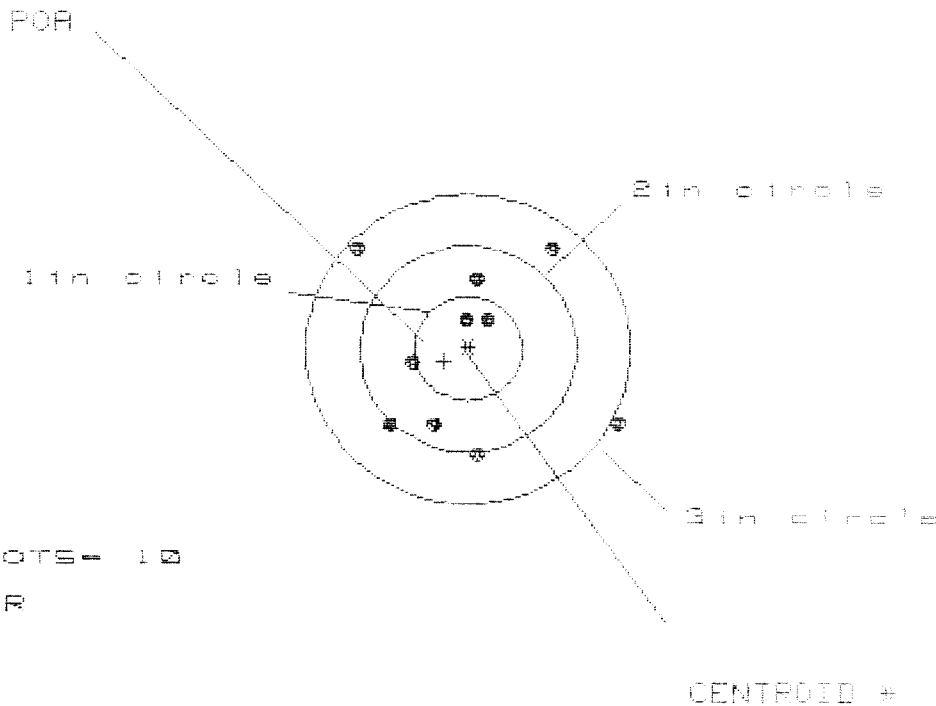
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0976
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0396
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105328

THE AMR FOR THIS RIFLE IS: .884

20 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8610776

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.365

VS = 1.971

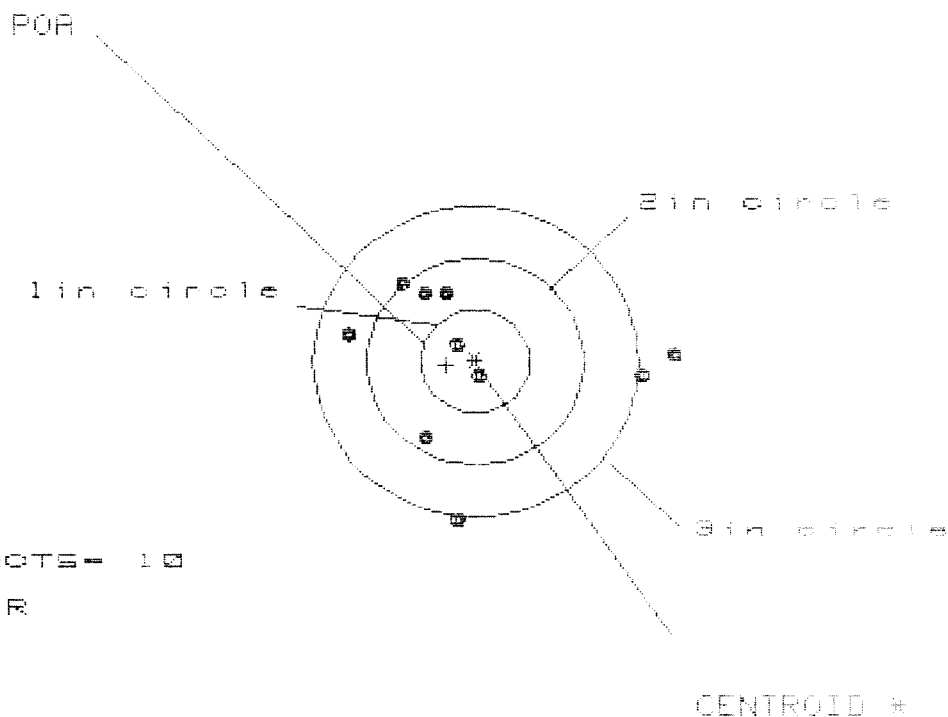
GS = 2.821

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.397	.982	.980
MINIMUM X	-.968	-.813	-.711
MAXIMUM Y	.995	.915	.992
MINIMUM Y	-.976	-1.056	-.942
CENTROID X	.218	.063	.165
CENTROID Y	.123	.203	.088
POA TO CENTROID in.	.250	.212	.187
MIN RADIUS	.306	.302	.367
MEAN RADIUS	.891	.801	.745
MAX RADIUS	1.571	1.317	1.327
HORIZONTAL SPREAD	2.365	1.795	1.591
VERTICAL SPREAD	1.971	1.971	1.934
EXTREME SPREAD	2.921	2.278	2.278
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 = 5

3 in = 7

HS = 2.927

VS = 2.304

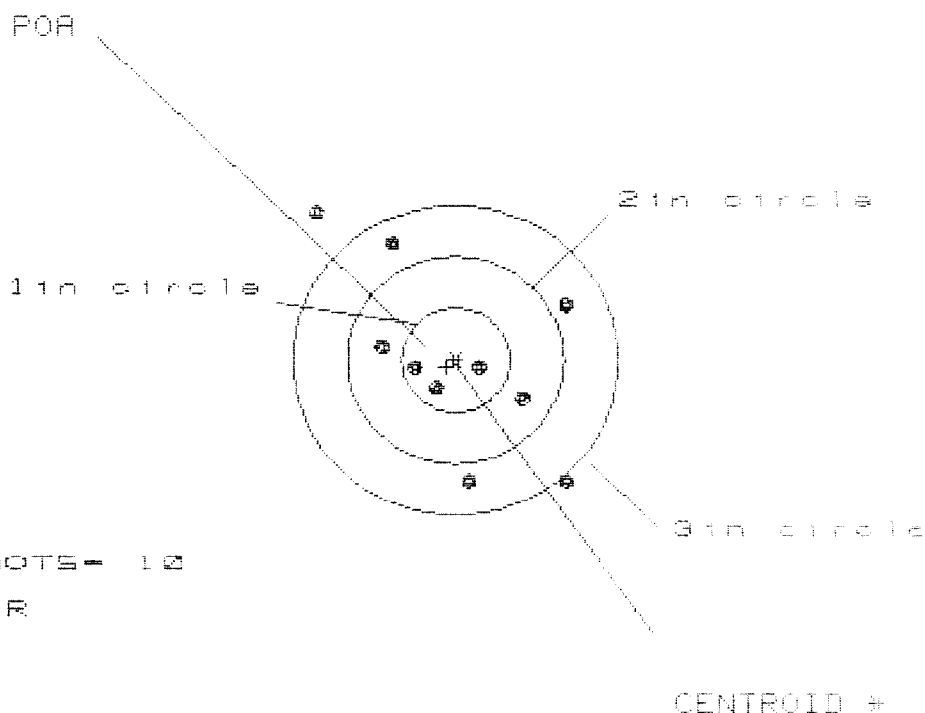
GS = 2.936

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.799	1.772	.443
MINIMUM X	:	-1.128	-.928	-.707
MAXIMUM Y	:	.792	.794	.776
MINIMUM Y	:	-1.512	-1.510	-1.528
CENTROID X	:	.268	.068	-.153
CENTROID Y	:	.035	.033	.051
POA TO CENTROID in.	:	.271	.076	.161
MIN RADIUS	:	.137	.285	.328
MEAN RADIUS	:	.994	.872	.750
MAX RADIUS	:	1.799	1.777	1.562
HORIZONTAL SPREAD	:	2.927	2.700	1.150
VERTICAL SPREAD	:	2.304	2.304	2.364
EXTREME SPREAD	:	2.936	2.729	2.369
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.241

VS = 2.652

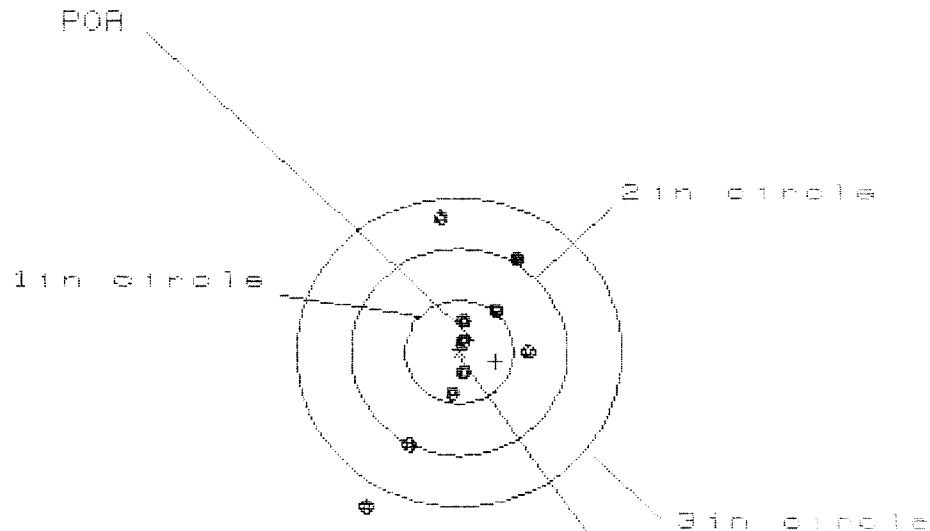
GS = 3.456

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.989
MINIMUM X	-1.252
MAXIMUM Y	1.436
MINIMUM Y	-1.216
CENTROID X	.083
CENTROID Y	.070
POA TO CENTROID in.	.108
MIN RADIUS	.240
MEAN RADIUS	.934
MAX RADIUS	1.905
HORIZONTAL SPREAD	2.241
VERTICAL SPREAD	2.652
EXTREME SPREAD	3.456
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



OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 9

HS = 1.526

VS = 2.722

GS = 2.807

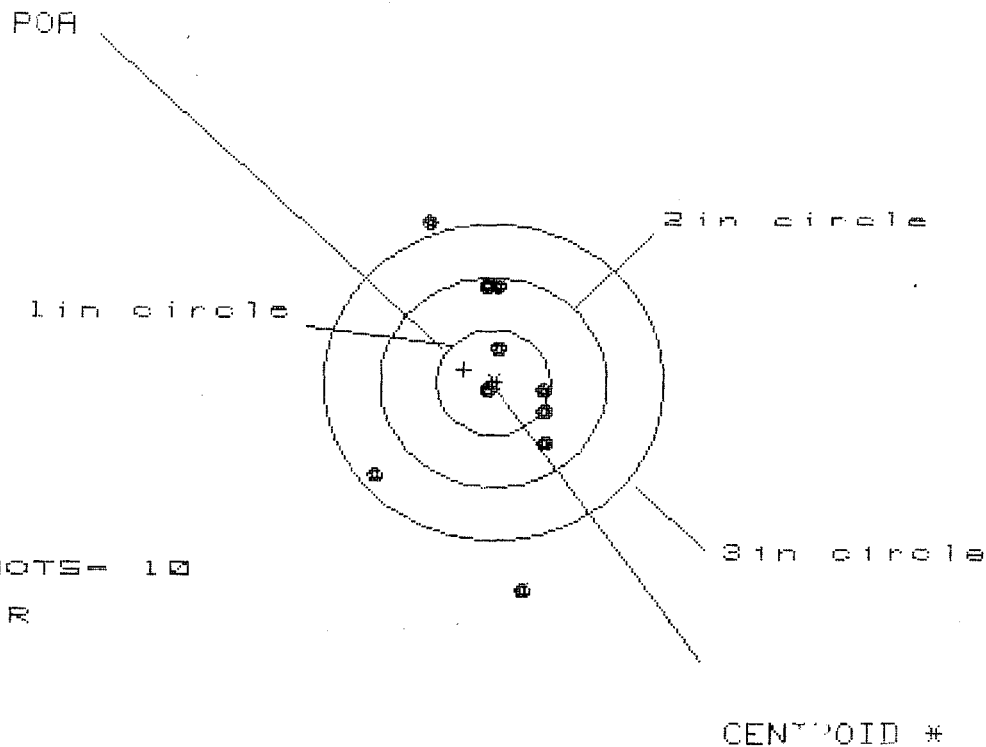
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.658	.562	.527
MINIMUM X	:	-.868	-.512	-.547
MAXIMUM Y	:	1.263	1.101	.876
MINIMUM Y	:	-1.459	-1.044	-.906
CENTROID X	:	-.337	-.241	-.206
CENTROID Y	:	.094	.256	.118
POA TO CENTROID in.	:	.350	.351	.237
MIN RADIUS	:	.077	.116	.121
MEAN RADIUS	:	.705	.575	.500
MAX RADIUS	:	1.697	1.163	1.058
HORIZONTAL SPREAD	:	1.526	1.074	1.074
VERTICAL SPREAD	:	2.722	2.145	1.782
EXTREME SPREAD	:	2.807	2.158	1.996
NUMBER IN ONE INCH CIRCLE	=		5	
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 = 3

2in = 7

3in = 8

HS = 1.475

VS = 3.506

GS = 3.605

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.466	.498	.433
MINIMUM X	-1.009	-.977	-1.042
MAXIMUM Y	1.552	1.335	.897
MINIMUM Y	-1.954	-1.050	-.883
CENTROID X	.256	.224	.289
CENTROID Y	-.124	.093	-.074
POA TO CENTROID in.	.285	.242	.298
MIN RADIUS	.079	.177	.138
MEAN RADIUS	.896	.772	.664
MAX RADIUS	1.975	1.434	1.365
HORIZONTAL SPREAD	1.475	1.475	1.475
VERTICAL SPREAD	3.506	2.385	1.780
EXTREME SPREAD	3.605	2.429	2.063
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		