

05611815

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

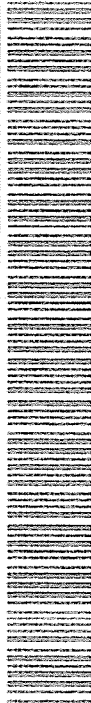
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO. C6611815

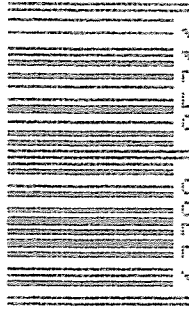
ORDER NO. 5716

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



5716 C6611815

UPC



0 47700 25716

MOD. _____		GA. CAL. _____	GUN # <u>1815</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
K7	1st	Bolt Handle Hits Stock	K5
	2/21		
	2nd	FILED BOLT HDL SLOT	2/21/91 KS
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611815

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		1/	KR
615	Rollmark Caliber		1/	GL
617	Drill and Tap Sight Holes	2 2 91		LB
618	Polish Barrel <i>ABB</i>	2 2 91		LB
620	Apply Coatings (Barrel Action)		2-11-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/14/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/14/91	KL
	C) Inspect Ejector Hole for Chamfer		2/14/91	KL
	D) Oil Firing Pin Ass'y		2/14/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7 1/2	7			2/16/91	WB
	G) Safety Off Force	3	3	3			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/15/91	JJ
	I) Firing Pin Indent	.020	.0205	.0205			2/16/91	WB
	J) Assemble Stock						2/19/91	KJ
	K) Assemble Swivel Studs						2-22-91	K
	L) Attach Front and Rear Sight Assemblies						2/19/91	KJ
	M) Iron Sight Alignment						2/19/91	KJ
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	KJ
	O) Attach Scope to Rifle						2/19/91	KJ
	P) Detach & Attach Scope 20 Times						2/19/91	KJ
640	Gallery Target & Test						2/24/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						2/21/91	KJ
655	Final Inspection						2-22-91	K
	A) Headspace							
	B) Trigger Pull	2.51	2.53	2.51	2.55	2.55	2/22/91	JJ
	C) Function						2-22-91	K
660	Pack						3-18-91	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C611815

DATE 2/19/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.45	2.48	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.47	2.50	2.53	
PULL #3	2.47	2.49	2.48	2.51	
PULL #4	2.52	2.47	2.50	2.55	
PULL #5	2.51	2.50	2.48	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.31		
PULL #2	3.21	3.28		
PULL #3	3.31	3.28		
PULL #4	3.27	3.25		
PULL #5	3.05	3.24		
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	4.51		4.42
PULL #2	4.21	4.41		4.42
PULL #3	4.52	4.40		4.14
PULL #4	4.48	4.36		4.36
PULL #5	4.51	4.39		4.12
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611815
22 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0552268
1 TO	2	.21285
1 TO	3	.0487847
1 TO	4	.135004
1 TO	5	.0926175

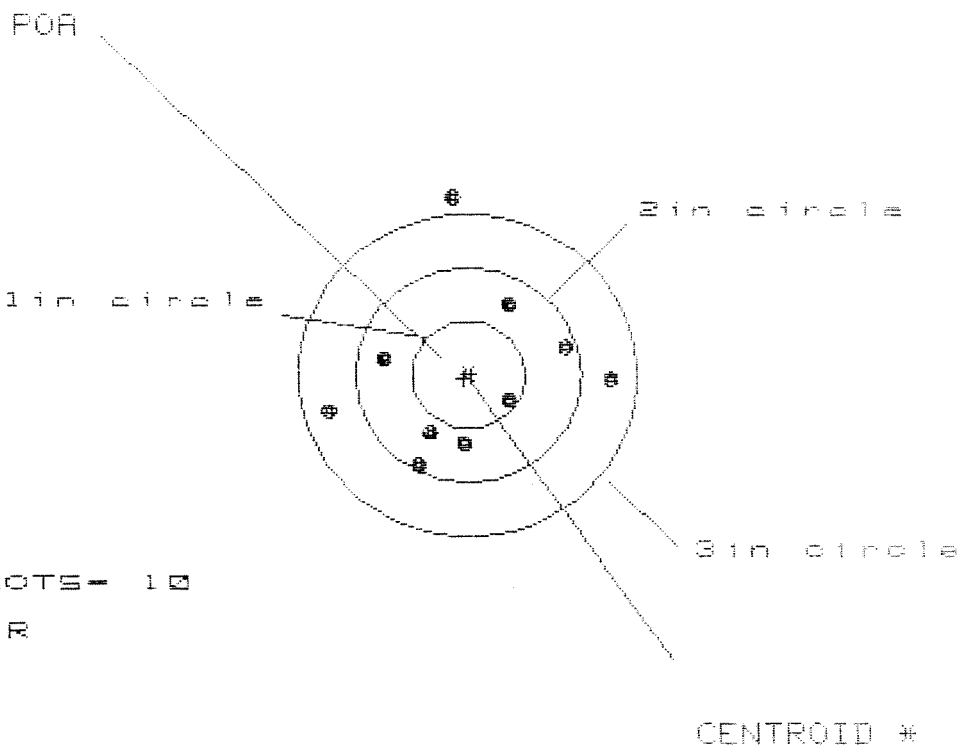
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0416
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0026
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0416812
THE AMR FOR THIS RIFLE IS: 1.016

21 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611815

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.451

VS= 2.504

GS= 2.524

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.265	1.254	.980
MINIMUM X	:	-1.196	-1.207	-1.050
MAXIMUM Y	:	1.632	.868	.880
MINIMUM Y	:	-.872	-.691	-.679
CENTROID X	:	.041	.052	-.105
CENTROID Y	:	.037	-.144	-.156
FOR TO CENTROID in.	:	.055	.153	.188
MIN RADIUS	:	.461	.394	.391
MEAN RADIUS	:	.929	.817	.750
MAX RADIUS	:	1.635	1.258	1.068
HORIZONTAL SPREAD	:	2.461	2.461	2.030
VERTICAL SPREAD	:	2.504	1.559	1.559
EXTREME SPREAD	:	2.524	2.474	2.108
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

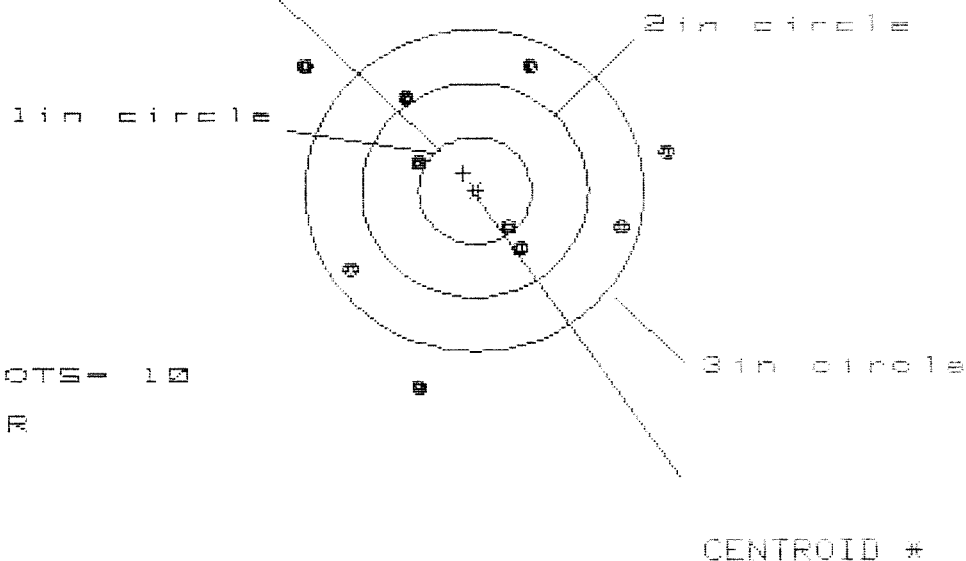
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CENTERFIRE PATTERNS

2

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.120

VS= 3.008

GS= 3.223

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.654	1.598	1.408
MINIMUM X	:	-1.466	-1.522	-1.315
MAXIMUM Y	:	1.199	.998	1.116
MINIMUM Y	:	-1.809	-.945	-.827
CENTROID X	:	.105	.161	.351
CENTROID Y	:	-.166	.035	-.083
POA TO CENTROID in.	:	.196	.165	.361
MIN RADIUS	:	.464	.578	.420
MEAN RADIUS	:	1.214	1.137	1.033
MAX RADIUS	:	1.879	1.791	1.554
HORIZONTAL SPREAD	:	3.120	3.120	2.723
VERTICAL SPREAD	:	3.008	1.943	1.943
EXTREME SPREAD	:	3.223	3.223	2.930
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 4.422

VS = 2.109

GS = 4.480

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.747	1.450	.396
MINIMUM X	:	-2.675	-.857	-.676
MAXIMUM Y	:	1.017	.983	1.030
MINIMUM Y	:	-1.092	-1.126	-1.079
CENTROID X	:	.054	.351	.170
CENTROID Y	:	-.010	.024	-.023
POA TO CENTROID in.	:	.055	.352	.172
MIN RADIUS	:	.229	.134	.156
MEAN RADIUS	:	1.028	.791	.703
MAX RADIUS	:	2.693	1.499	1.105
HORIZONTAL SPREAD	:	4.422	2.307	1.072
VERTICAL SPREAD	:	2.109	2.109	2.109
EXTREME SPREAD	:	4.480	2.634	2.203
NUMBER IN ONE INCH CIRCLE	=		2	
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

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.840

VS = 2.261

GS = 2.977

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	1.025	.928
MINIMUM X	-1.633	-1.131	-1.228
MAXIMUM Y	1.464	1.487	1.249
MINIMUM Y	-.796	-.774	-.588
CENTROID X	.040	.222	.319
CENTROID Y	.172	.149	-.037
POA TO CENTROID in.	.176	.267	.321
MIN RADIUS	.152	.323	.443
MEAN RADIUS	1.071	.996	.874
MAX RADIUS	1.646	1.679	1.346
HORIZONTAL SPREAD	2.840	2.156	2.156
VERTICAL SPREAD	2.261	2.261	1.837
EXTREME SPREAD	2.977	2.811	2.340
NUMBER IN ONE INCH CIRCLE	1		

NUMBER IN TWO INCH CIRCLE =
NUMBER IN THREE INCH CIRCLE =
BARBER - M24 0036466

4
8

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.450

VS= 2.360

GS= 3.002

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

10

9

8

1.166

1.023

.728

-1.292

-.836

-.708

.973

.819

.842

-1.387

-.806

-.783

-.032

.111

-.017

-.020

.134

.111

.038

.174

.112

.360

.250

.300

.839

.690

.647

1.895

1.161

1.056

2.458

1.859

1.436

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0036466 M2400036505

VERTICAL SPREAD :	2.360	1.625	1.625
EX BARBER - M24 0036467	3.002	2.106	1.734
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	