

C6636024

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Remington[®]

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

DUPONT

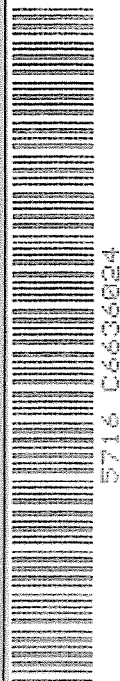
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TH M24

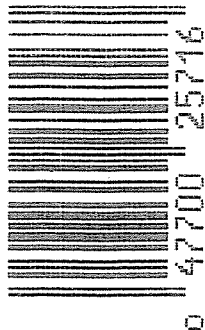
SERIAL NO.
C6636824

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636024

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KL
600	Proof		6/27/91	KL
607	Check Headspace		6/27/91	KL
610	Dis-assemble Gun		6/27/91	KL
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	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		6-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/19/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	KL
	C) Inspect Ejector Hole for Chamfer		8/19/91	KL
	D) Oil Firing Pin Ass'y		8/19/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	JH

op. #	BARBER MEM24 0036803	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/20/91	JH
	G) Safety Off Force	4	4	4			8/20/91	JH
	H) Trigger Pull Test & Retainability						8-20-91	JH
	I) Firing Pin Indent	.0205	.0215	.0215			8-20-91	JH
	J) Assemble Stock						8/20/91	JH
	K) Assemble Swivel Studs						8/22/91	JH
	L) Attach Front and Rear Sight Assemblies						8/30/91	JH
	M) Iron Sight Alignment						8/30/91	JH
	N) Detach Front & Rear Sights & place in numbered container						8/30/91	JH
	O) Attach Scope to Rifle						8/30/91	JH
	P) Detach & Attach Scope 20 Times						8/30/91	JH
640	Gallery Target & Test						8-21-91	JH
	A) Time							JH
	B) Malfunctions							JH
	C) Pierced Primers							JH
	D) Optical Clarity of Scope							JH
645	Inspect for Live Ammo						8-21-91	JH
655	Final Inspection							
	A) Headspace						8/22/91	JH
	B) Trigger Pull	2.56	2.52	2.62	2.57	2.63	8-22-91	JH
	C) Function						8/22/91	JH
660	Pack						9-18-91	JH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06636024

DATE 8-20-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.19	2.49	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.47	2.52	2.52	
PULL #3	2.41	2.42	2.45	2.62	
PULL #4	2.41	2.43	2.44	2.57	
PULL #5	2.46	2.46	2.48	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.31		
PULL #2	3.45	3.34		
PULL #3	3.37	3.30		
PULL #4	3.29	3.35		
PULL #5	3.20	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	4.54	4.40		4.40
PULL #2	4.43	4.39		4.51
PULL #3	4.34	4.49		4.12
PULL #4	4.39	4.53		4.44
PULL #5	4.45	4.50		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 RIFLE # 066368024
 20 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0794796
1 TO	2	.0291204
1 TO	3	.231102
1 TO	4	.0130384
1 TO	5	.302789

34 <----POA

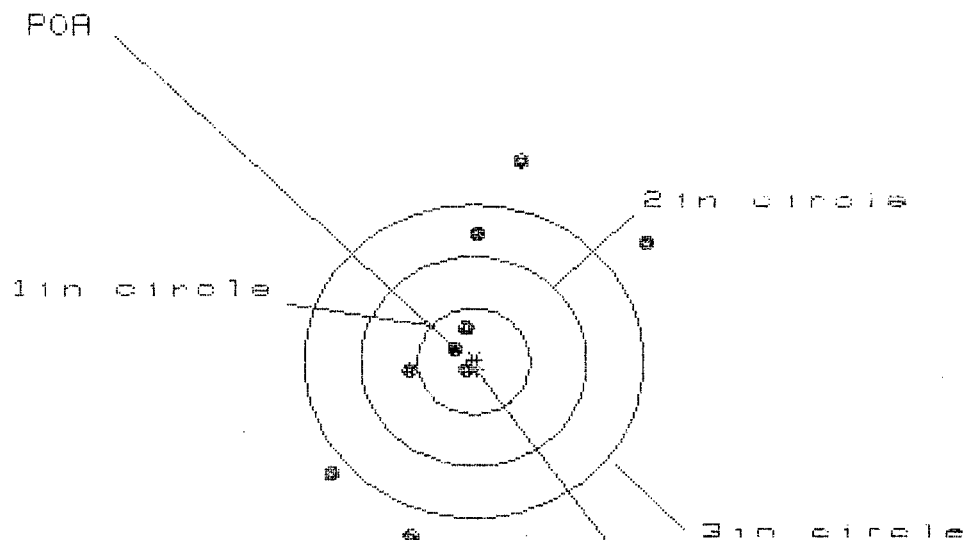
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.132
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0784
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153527

THE AMR FOR THIS RIFLE IS: 1.058

23 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/06636024

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 5

HS= 2.794

VS= 3.822

GS= 3.842

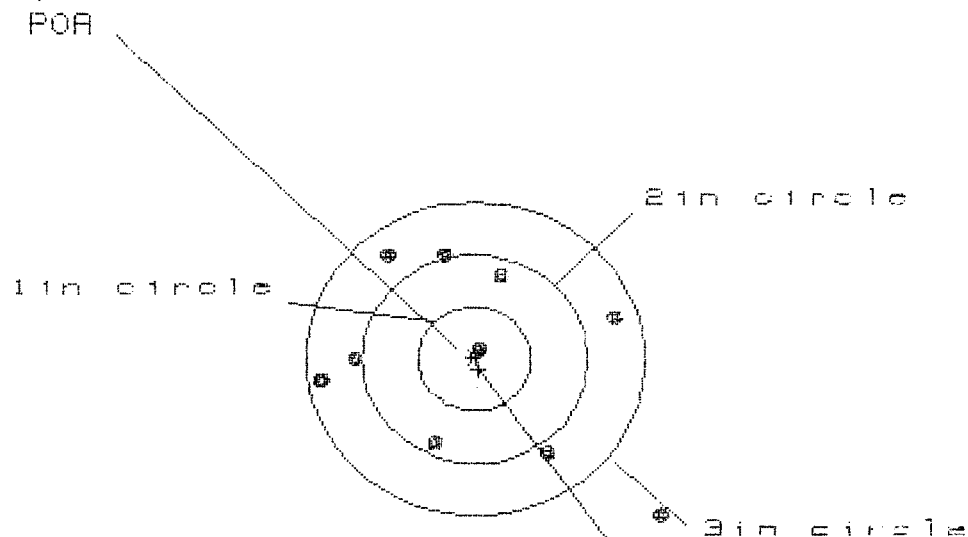
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.492	1.588	1.660
MINIMUM X	-1.302	-1.206	-1.134
MAXIMUM Y	1.887	1.672	1.223
MINIMUM Y	-1.935	-1.867	-1.658
CENTROID X	-.029	-.125	-.197
CENTROID Y	.074	.289	.080
POA TO CENTROID in.	.080	.315	.213
MIN RADIUS	.077	.078	.112
MEAN RADIUS	1.184	1.034	.941
MAX RADIUS	2.121	1.931	2.004
HORIZONTAL SPREAD	2.794	2.794	2.794
VERTICAL SPREAD	3.822	3.539	2.881
EXTREME SPREAD	3.842	3.696	3.543
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 3

3in = 9

HS= 3.071

VS= 2.511

GS= 3.506

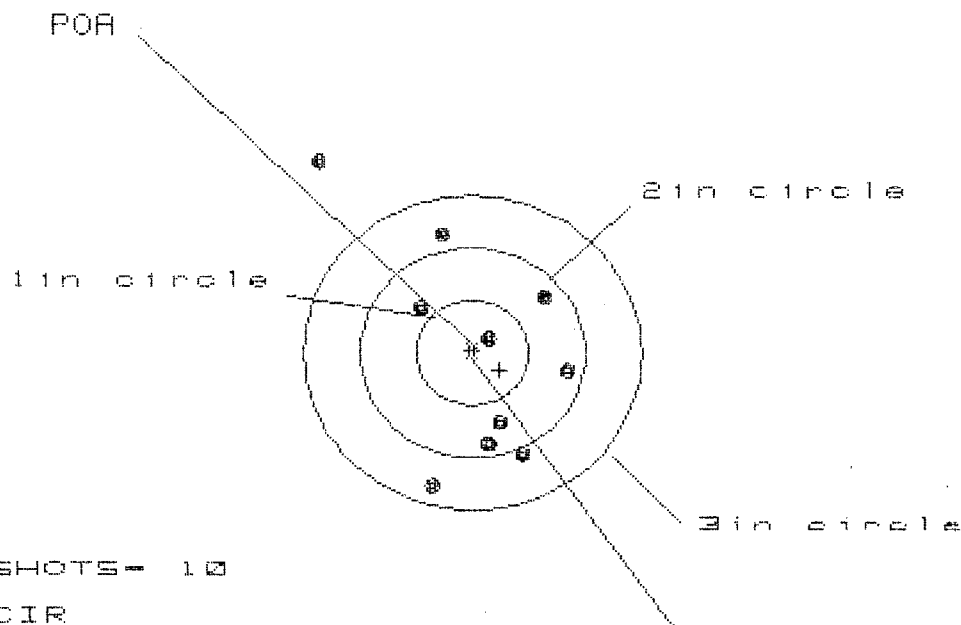
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.678	1.374	1.223
MINIMUM X	:	-1.393	-1.207	-.982
MAXIMUM Y	:	1.024	.859	.814
MINIMUM Y	:	-1.487	-1.028	-1.073
CENTROID X	:	-.037	-.223	-.072
CENTROID Y	:	.102	.267	.312
POA TO CENTROID in.	:	.108	.348	.320
MIN RADIUS	:	.146	.247	.121
MEAN RADIUS	:	1.124	.973	.917
MAX RADIUS	:	2.242	1.402	1.279
HORIZONTAL SPREAD	:	3.071	2.581	2.205
VERTICAL SPREAD	:	2.511	1.887	1.887
EXTREME SPREAD	:	3.506	2.658	2.368
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.212

VS= 3.167

GS= 3.350

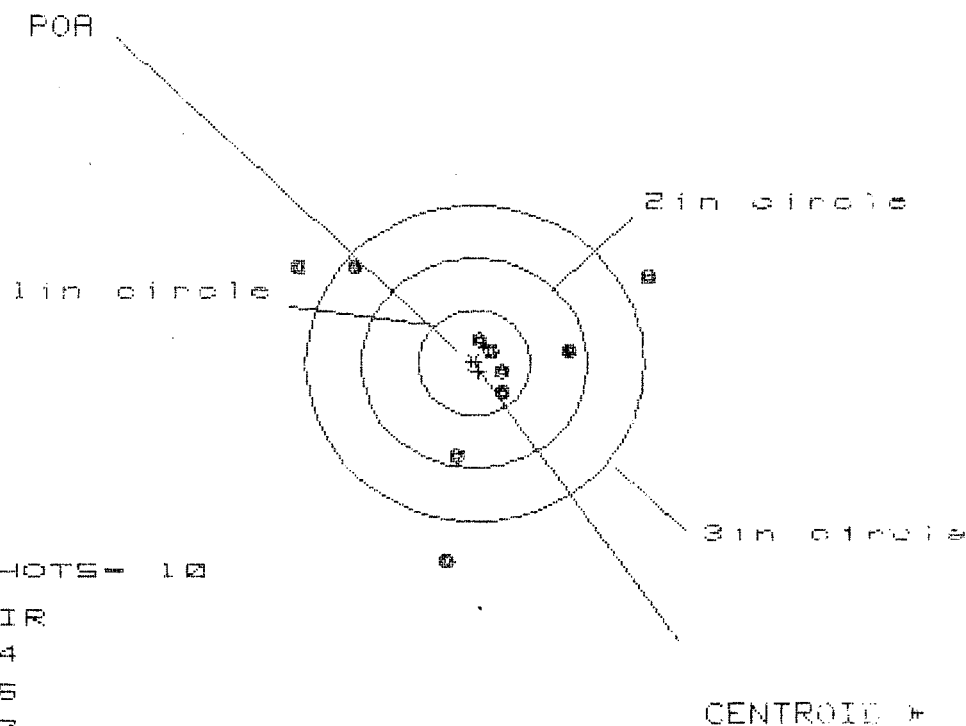
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.659	.592
MINIMUM X	:	-1.398	-.570	-.637
MAXIMUM Y	:	1.853	1.317	1.179
MINIMUM Y	:	-1.314	-1.108	-.887
CENTROID X	:	-.241	-.086	-.019
CENTROID Y	:	.166	-.040	.098
POA TO CENTROID in.	:	.293	.095	.100
MIN RADIUS	:	.185	.303	.177
MEAN RADIUS	:	.997	.809	.743
MAX RADIUS	:	2.321	1.395	1.291
HORIZONTAL SPREAD	:	2.212	1.229	1.229
VERTICAL SPREAD	:	3.167	2.425	2.066
EXTREME SPREAD	:	3.350	2.426	2.192
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 7

HS= 3.039

VS= 2.770

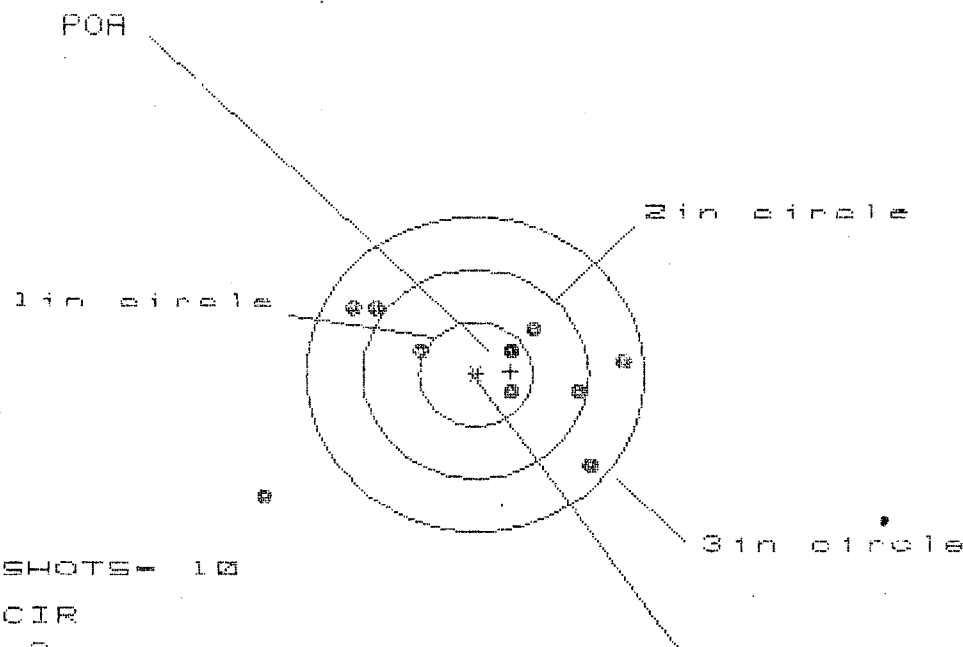
GS= 3.204

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.505	1.475	1.280
MINIMUM X	:	-1.534	-1.564	-1.332
MAXIMUM Y	:	.921	.715	.762
MINIMUM Y	:	-1.849	-1.121	-1.031
CENTROID X	:	-.040	-.010	.105
CENTROID Y	:	.081	.287	.197
POA TO CENTROID in.	:	.091	.287	.271
MIN RADIUS	:	.213	.010	.059
MEAN RADIUS	:	.970	.854	.703
MAX RADIUS	:	1.869	1.719	1.535
HORIZONTAL SPREAD	:	3.039	3.039	2.612
VERTICAL SPREAD	:	2.770	1.836	1.794
EXTREME SPREAD	:	3.204	3.041	2.613
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.240

VS= 1.794

GS= 3.461

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.358	1.149	.898
MINIMUM X	-1.882	-1.315	-1.171
MAXIMUM Y	.661	.535	.530
MINIMUM Y	-1.133	-1.025	-1.030
CENTROID X	-.313	-.104	-.248
CENTROID Y	-.031	.095	.100
POA TO CENTROID in.	.315	.141	.267
MIN RADIUS	.301	.151	.282
MEAN RADIUS	1.014	.822	.797
MAX RADIUS	2.196	1.419	1.366
HORIZONTAL SPREAD	3.240	2.464	2.069
VERTICAL SPREAD	1.794	1.560	1.360
EXTREME SPREAD	3.461	2.591	2.591
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		