

~~9760~~ C6348723

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

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

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

MODEL 700™ H24

SERIAL NO.	C6348723
ORDER NO.	5716

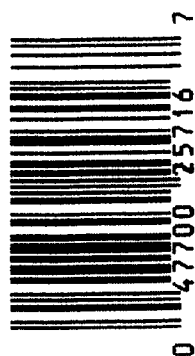
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



5716 C6348723

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348723

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	12-20 89	RW
600	Proof		12-20 89	A
607	Check Headspace		12-20 89	A
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action		1-5-90	KCR
	Magnaflux Bolt		1-5-90	
615	Rollmark Caliber		1/9/90	CS
617	Drill and Tap Sight Holes		1/10/90	LB
618	Polish Barrel LB		1/10/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/6/90	TS

BARBER - M24 0062346								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-26-90	GU
	G) Safety Off Force	3	3	3			1-26-90	GU
	H) Trigger Pull Test & Retainability						2/6/90	GU
	I) Firing Pin Indent	.0225	.0225	.0225			1-26-90	GU
	J) Assemble Stock						1-31-90	RU
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						1-31-90	RU
	M) Iron Sight Alignment						1-31-90	- RU
	N) Detach Front & Rear Sights & place in numbered container						1-31-90	RU
	O) Attach Scope to Rifle						2-23-90	GU
	P) Detach & Attach Scope 20 Times						2-23-90	GU
640	Gallery Target & Test						2-27-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						2-27-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace							
	B) Trigger Pull	2.74	2.75	2.74	2.74	2.78	3/13/90	GS
	C) Function						3/13/90	WB
660	Pack						60/11/11/90	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348723
DATE 26 Jan 90
TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	249	234	221	274	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	229	219	223	275	
PULL #3	216	227	219	274	
PULL #4	227	217	218	274	
PULL #5	215	223	222	278	
TOTAL	1136	1120	1102		
AVG.	2.274	2.24	2.204		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	359	344		
PULL #2	357	339		
PULL #3	361	333		
PULL #4	344	332		
PULL #5	342	331		
TOTAL	1763	1689		
AVG.	3.526	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	422	432		414
PULL #2	417	420		414
PULL #3	422	434		413
PULL #4	421	420		413
PULL #5	415	418		417
TOTAL	2097	2124		2071
AVG.	4.194	4.248		4.142

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348723
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.04272
1 TO	2	.368879
1 TO	3	.2022
1 TO	4	.399125
1 TO	5	.493794

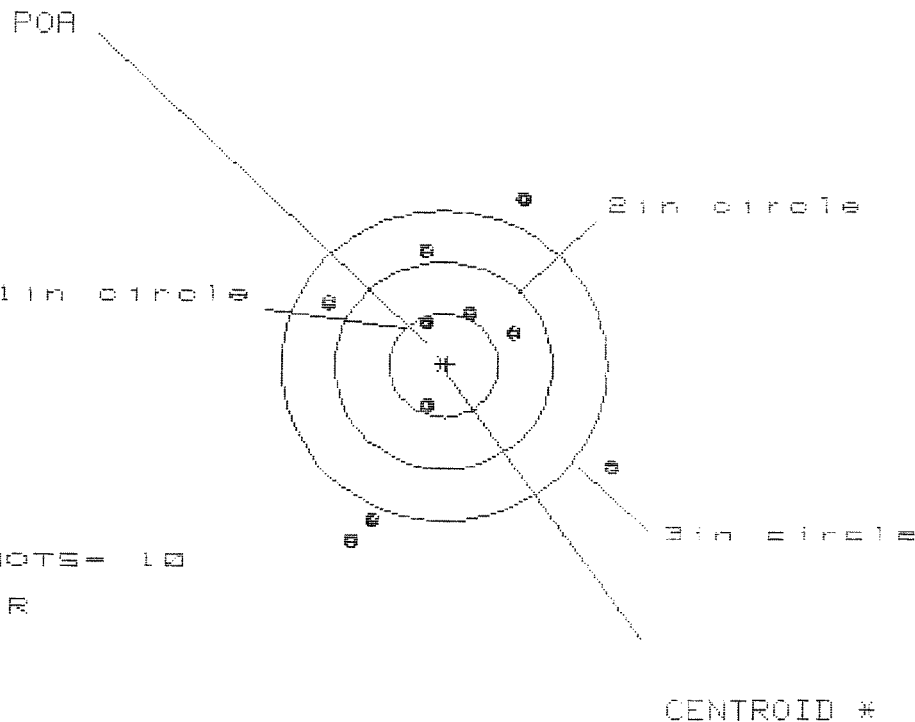
σ^2 s <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0072912
THE AMR FOR THIS RIFLE IS: 1.13

27 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06348723

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.594

VS= 3.306

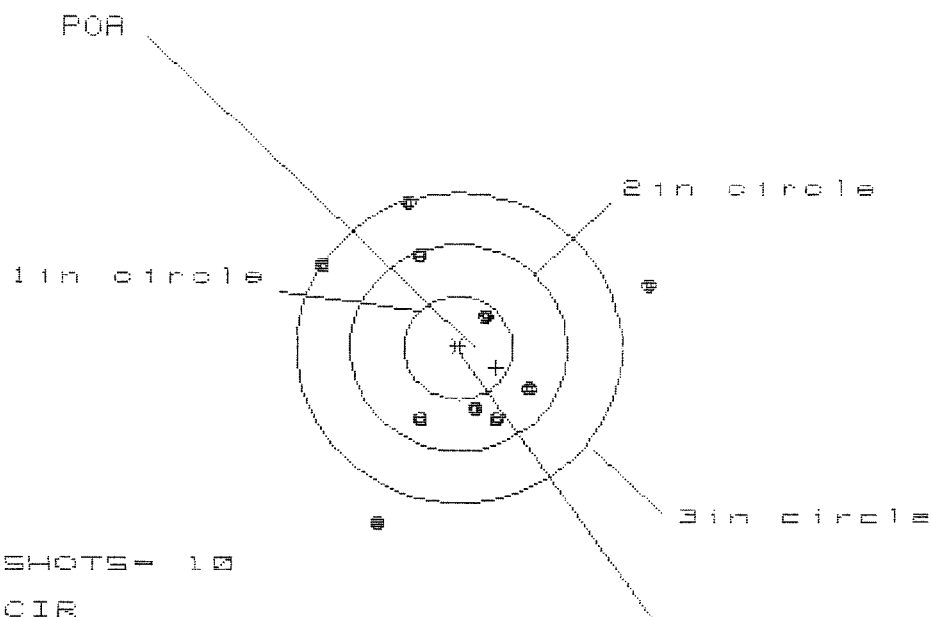
GS= 3.710

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.498	1.397	1.481
MINIMUM X	-1.096	-1.197	-1.113
MAXIMUM Y	1.621	1.434	1.143
MINIMUM Y	-1.685	-1.634	-1.455
CENTROID X	-.040	.061	-.023
CENTROID Y	-.015	.172	-.097
POA TO CENTROID in.	.042	.183	.024
MIN RADIUS	.423	.321	.429
MEAN RADIUS	1.157	1.036	.982
MAX RADIUS	1.913	1.818	1.778
HORIZONTAL SPREAD	2.594	2.594	2.594
VERTICAL SPREAD	3.306	3.068	2.596
EXTREME SPREAD	3.710	3.376	3.019
NUMBER IN ONE INCH CIRCLE	2		
NUMBER IN TWO INCH CIRCLE	4		
NUMBER IN THREE INCH CIRCLE	6		

27 Feb 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS = 2.929

VS = 3.154

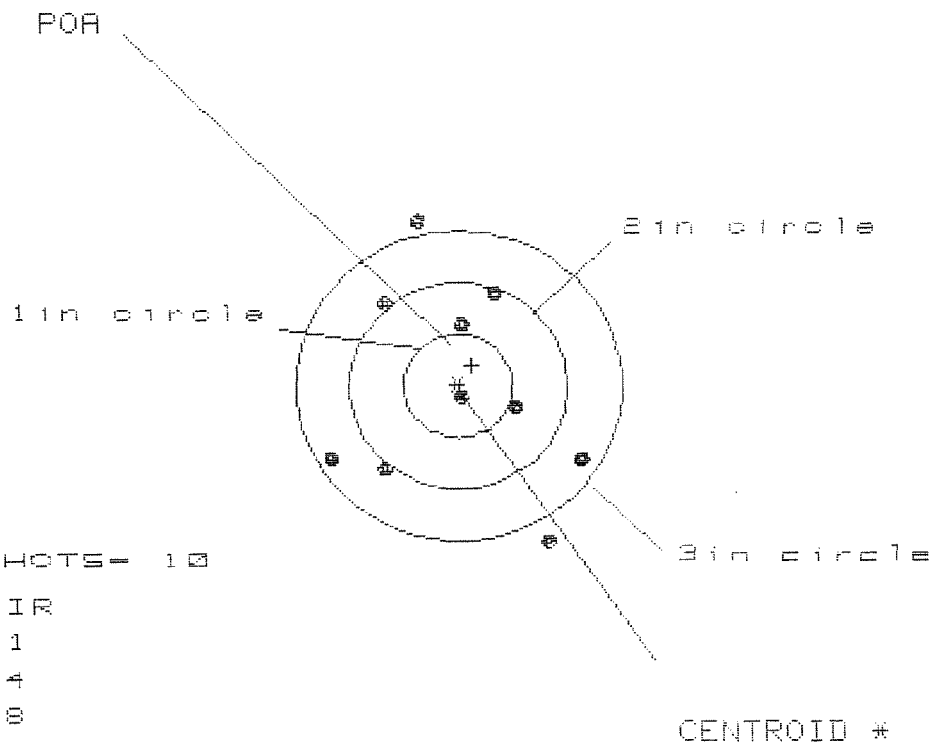
GS = 3.417

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.703	1.618	.798
MINIMUM X	:	-1.226	-1.311	-1.109
MAXIMUM Y	:	1.445	1.255	1.313
MINIMUM Y	:	-1.709	-.930	-.872
CENTROID X	:	-.346	-.261	-.464
CENTROID Y	:	.191	.381	.323
POA TO CENTROID in.	:	.395	.462	.565
MIN RADIUS	:	.434	.243	.448
MEAN RADIUS	:	1.096	1.005	.922
MAX RADIUS	:	1.872	1.684	1.355
HORIZONTAL SPREAD	:	2.929	2.929	1.898
VERTICAL SPREAD	:	3.154	2.185	2.185
EXTREME SPREAD	:	3.417	2.932	2.258
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.323

VS = 3.108

GS = 3.335

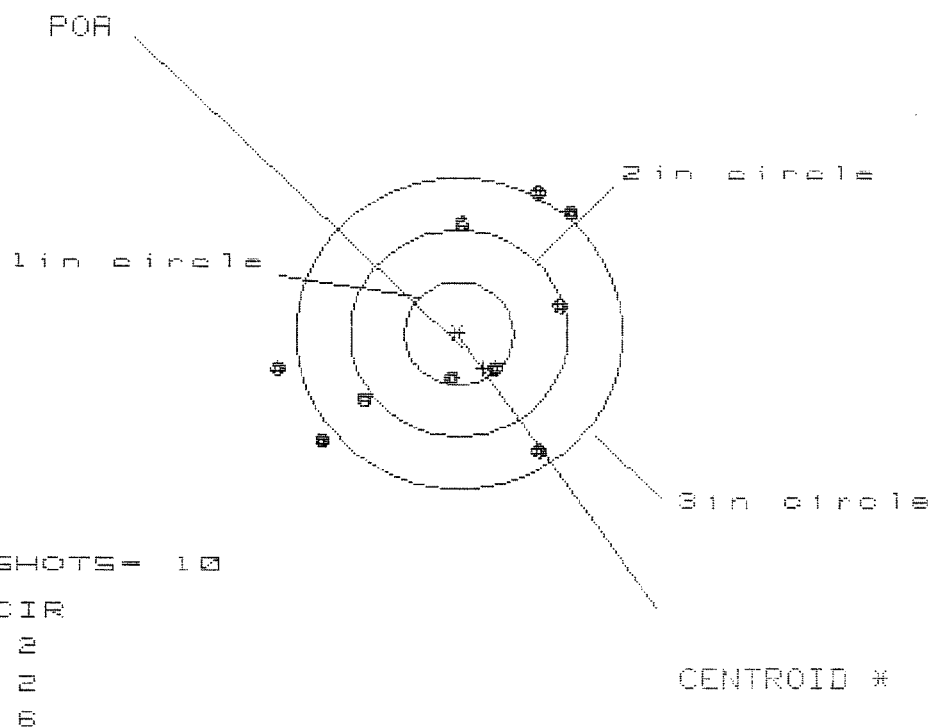
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.266	1.234
MINIMUM X	:	-1.152	-1.057	-1.089
MAXIMUM Y	:	1.609	1.443	.906
MINIMUM Y	:	-1.499	-.975	-.795
CENTROID X	:	-.126	-.221	-.189
CENTROID Y	:	-.198	-.032	-.212
POA TO CENTROID in.	:	.235	.223	.284
MIN RADIUS	:	.060	.250	.090
MEAN RADIUS	:	1.035	.955	.878
MAX RADIUS	:	1.726	1.528	1.406
HORIZONTAL SPREAD	:	2.323	2.323	2.323
VERTICAL SPREAD	:	3.108	2.418	1.701
EXTREME SPREAD	:	3.335	2.756	2.353
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 2

3 in = 6

HS= 2.721

VS= 2.515

GS= 3.120

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	.842	.666
MINIMUM X	:	-1.691	-1.410	-1.203
MAXIMUM Y	:	1.409	1.377	1.244
MINIMUM Y	:	-1.106	-1.138	-1.071
CENTROID X	:	-.230	-.042	.134
CENTROID Y	:	.336	.368	.501
POA TO CENTROID in.	:	.407	.371	.518
MIN RADIUS	:	.429	.423	.539
MEAN RADIUS	:	1.177	1.101	1.007
MAX RADIUS	:	1.715	1.764	1.441
HORIZONTAL SPREAD	:	2.721	2.252	1.869
VERTICAL SPREAD	:	2.515	2.515	2.515
EXTREME SPREAD	:	3.120	3.120	2.568
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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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= 3.073

VS= 3.126

GS= 3.487

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.272
MINIMUM X	-0.801
MAXIMUM Y	1.471
MINIMUM Y	-1.655
CENTROID X	.453
CENTROID Y	.013
POA TO CENTROID in.	.454
MIN RADIUS	.144
MEAN RADIUS	1.184
MAX RADIUS	1.839
HORIZONTAL SPREAD	2.073
VERTICAL SPREAD	3.126
EXTREME SPREAD	3.487
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	7