

Stead.

C6348732	
MODEL 700™ M24	
Model	SMS™
Action	
Barrel Length	
Capacity	
Order No.	5716
*Includes 1 in chamber.	
Remington	

Remington
MODEL 700TM H24

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

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

SERIAL NO.
C6348732

ORDER NO.
5716

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

Ø1



5716 C6348732

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348732

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		GL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/27/90	ML

BARBER - M24 0062613		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			4/27/90	JCL
	G) Safety Off Force	3	3	3			4/27/90	JCL
	H) Trigger Pull Test & Retainability						4/27/90	JCL
	I) Firing Pin Indent	1020	.022	.022			4/27/90	JCL
	J) Assemble Stock						4/30/90	RW
	K) Assemble Swivel Studs						5/1/90	WB
	L) Attach Front and Rear Sight Assemblies						4/30/90	RW
	M) Iron Sight Alignment						4/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/90	RW
	O) Attach Scope to Rifle						4/30/90	JCL
	P) Detach & Attach Scope 20 Times						4/30/90	JCL
640	Gallery Target & Test						4-30-90	DH
	A) Time						4-30-90	DH
	B) Malfunctions						4-30-90	DH
	C) Pierced Primers						4-30-90	DH
	D) Optical Clarity of Scope						4-30-90	DH
645	Inspect for Live Ammo						4-30-90	DH
655	Final Inspection						5/1/90	WB
	A) Headspace						5/1/90	WB
	B) Trigger Pull	2.55	2.76	2.59	2.73	2.71	5/1/90	WB
	C) Function						5/1/90	WB
660	Pack						6-19-90	DH

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

SERIAL NO. C6348732DATE 4/27/90TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.26	2.26	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.32	2.48	2.76	
PULL #3	2.52	2.39	2.36	2.59	
PULL #4	2.28	2.19	2.36	2.73	
PULL #5	2.37	2.54	2.40	2.71	
TOTAL	12.29	11.70	11.86		
AVG.	2.458	2.34	2.372		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.51		
PULL #2	3.43	3.41		
PULL #3	3.36	3.48		
PULL #4	3.32	3.33		
PULL #5	3.26	3.40		
TOTAL	16.92	17.13		
AVG.	3.384	3.426		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.16		4.40
PULL #2	4.23	4.25		4.41
PULL #3	4.21	4.27		4.49
PULL #4	4.25	4.25		4.49
PULL #5	4.43	4.27		4.46
TOTAL	21.56	21.20		22.25
AVG.	4.312	4.24		4.45

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348732
1 May 1998

CENTROIDAL DISTANCES

0 TO	1	.151585
1 TO	2	.553239
1 TO	3	.195133
1 TO	4	.325467
1 TO	5	.355332

$\frac{2}{5}$ $\frac{4}{5}$ (----) FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0402
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0410278
THE ANP FOR THIS RIFLE IS: .7804

May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08346792

CENTERFIRE PATTERNS

1

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

LSE = 2.619

VSE = 2.361

ESE = 2.639

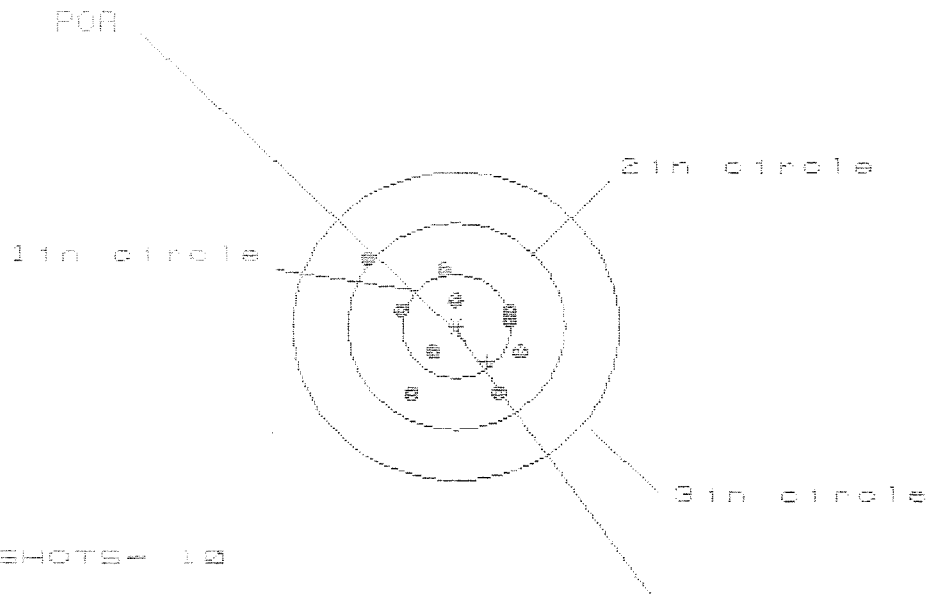
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.350	1.386	1.020
MINIMUM X	-1.269	-1.233	-1.060
MAXIMUM Y	.793	.619	.615
MINIMUM Y	-1.568	-.642	-.646
CENTROID X	-.037	-.073	-.246
CENTROID Y	-.147	.027	.031
FOR TO CENTROID in.	.152	.078	.248
MIN RADIUS	.243	.324	.197
MEAN RADIUS	.907	.815	.723
MAX RADIUS	1.601	1.386	1.120
HORIZONTAL SPREAD	2.619	2.619	2.080
VERTICAL SPREAD	2.361	1.261	1.261
EXTREME SPREAD	2.639	2.639	2.104
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

1 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6348732

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 9

3in = 10

HE = 1.467

VE = 1.261

GE = 1.753

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.638	.544	.484
MINIMUM X	-.849	-.603	-.663
MAXIMUM Y	.632	.581	.511
MINIMUM Y	-.629	-.559	-.629
CENTROID X	-.290	-.196	-.136
CENTROID Y	.345	.275	.345
POA TO CENTROID in.	.451	.338	.371
MIN RADIUS	.246	.316	.277
MEAN RADIUS	.584	.525	.480
MAX RADIUS	1.058	.737	.672
HORIZONTAL SPREAD	1.487	1.147	1.147
VERTICAL SPREAD	1.261	1.140	1.140
EXTREME SPREAD	1.753	1.240	1.240
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8343732

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.914

VS = 1.917

GS = 2.423

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.841	.869
MINIMUM X	-.884	-.770	-.655
MAXIMUM Y	.922	.811	.858
MINIMUM Y	-.995	-.818	-.716
CENTROID X	.009	-.025	-.130
CENTROID Y	-.296	-.185	-.287
POA TO CENTROID in.	.309	.187	.315
MIN RADIUS	.066	.217	.285
MEAN RADIUS	.789	.728	.655
MAX RADIUS	1.432	1.159	.909
HORIZONTAL SPREAD	1.914	1.611	1.474
VERTICAL SPREAD	1.917	1.629	1.574
EXTREME SPREAD	2.423	1.954	1.583
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C834B732

CENTERFIRE PATTERNS # 4

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 0.298

VS = 1.978

ES = 2.585

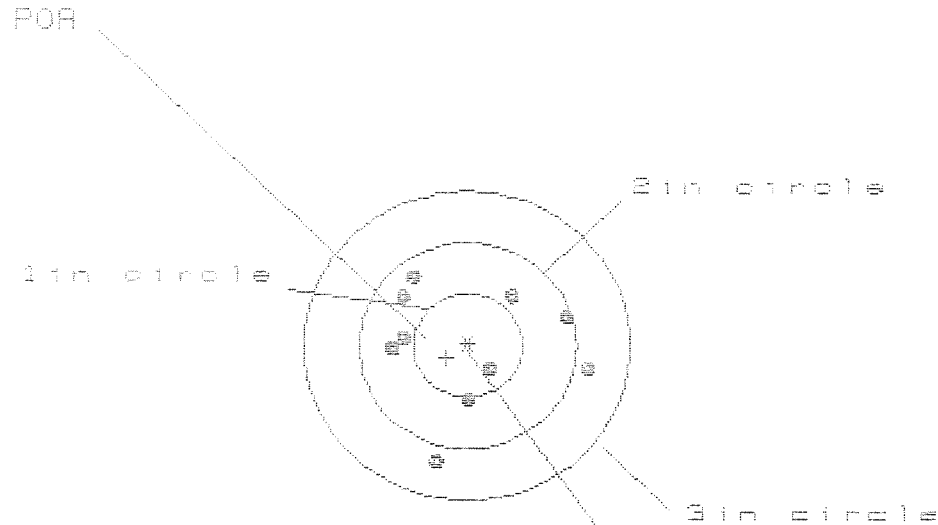
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.013	.928
MINIMUM X	-1.157	-.903	-.988
MAXIMUM Y	.879	.956	.831
MINIMUM Y	-1.099	-1.002	-.600
CENTROID X	.003	.131	.216
CENTROID Y	.176	.079	.204
POB TO CENTROID in.	.176	.153	.297
MIN RADIUS	.244	.098	.290
MEAN RADIUS	.866	.783	.725
MAX RADIUS	1.453	1.209	1.004
HORIZONTAL SPREAD	2.298	1.916	1.916
VERTICAL SPREAD	1.978	1.958	1.431
EXTREME SPREAD	2.585	2.163	1.984
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS348732

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

CENTROID *

HS = 1.825

VS = 1.765

CS = 1.886

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.128	1.039	1.013
MINIMUM X	-.697	-.572	-.598
MAXIMUM Y	.672	.648	.588
MINIMUM Y	-1.093	-1.117	-.650
CENTROID X	.194	.069	.095
CENTROID Y	.123	.147	.287
POR TO CENTROID (in.)	.230	.163	.382
MIN RADIUS	.270	.386	.447
MEAN RADIUS	.756	.700	.641
MAX RADIUS	1.149	1.138	1.016
HORIZONTAL SPREAD	1.825	1.611	1.611
VERTICAL SPREAD	1.765	1.765	1.158
EXTREME SPREAD	1.886	1.834	1.640
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	