

C6348757

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348757

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-2	89	RW
610	Dis-assemble Gun	10-2	89	RW
612	Magnaflux Barrel Action	REJECTED	11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test			
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo			
655	Final Inspection A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348757

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	LB
618	Polish Barrel RB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		16 Dec 89	928

BARBER - M24 0063224								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	6 Dec 89	JS		
	G) Safety Off Force	3	3	3	6 Dec 89	JS		
	H) Trigger Pull Test & Retainability				6 Dec 89	JS		
	I) Firing Pin Indent	.022	.0215	.0215	6 Dec 89	JS		
	J) Assemble Stock				12/7/89	RW		
	K) Assemble Swivel Studs				8 Dec 89	JS		
	L) Attach Front and Rear Sight Assemblies				12/7/89	RW		
	M) Iron Sight Alignment				12/7/89	RW		
	N) Detach Front & Rear Sights & place in numbered container				12/7/89	RW		
	O) Attach Scope to Rifle				7 Dec 89	JS		
	P) Detach & Attach Scope 20 Times				7 Dec 89	JS		
640	Gallery Target & Test				12-8-89	A		
	A) Time				12-8-89	A		
	B) Malfunctions				12-8-89	A		
	C) Pierced Primers				12-8-89	A		
	D) Optical Clarity of Scope				12-8-89	A		
645	Inspect for Live Ammo				12-8-89	A		
655	Final Inspection							
	A) Headspace				8 Dec 89	JS		
	B) Trigger Pull	264	283	268	274	251	8 Dec 89	JS
	C) Function						8 Dec 89	JS
660	Pack						12-15	AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 26348757DATE 4/3/90TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.30	2.29		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.31	2.31		
PULL #3	2.41	2.31	2.29		
PULL #4	2.39	2.29	2.32		
PULL #5	2.29	2.29	2.32		
TOTAL	11.89	11.50	11.53		
AVG.	2.37	2.30	2.31		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.40		
PULL #2	3.34	3.38		
PULL #3	3.35	3.35		
PULL #4	3.37	3.35		
PULL #5	3.37	3.33		
TOTAL	16.73	16.81		
AVG.	3.34	3.36		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.43		
PULL #2	4.37	4.36		
PULL #3	4.20	4.29		
PULL #4	4.38	4.31		
PULL #5	4.39	4.22		
TOTAL	21.70	21.66		
AVG.	4.34	4.33		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348757
8 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.0834086
1 TO	2	.2067
1 TO	3	.36749
1 TO	4	.508146
1 TO	5	.345306

$\frac{1}{5} \sum_{i=1}^5 x_i$ -----POA

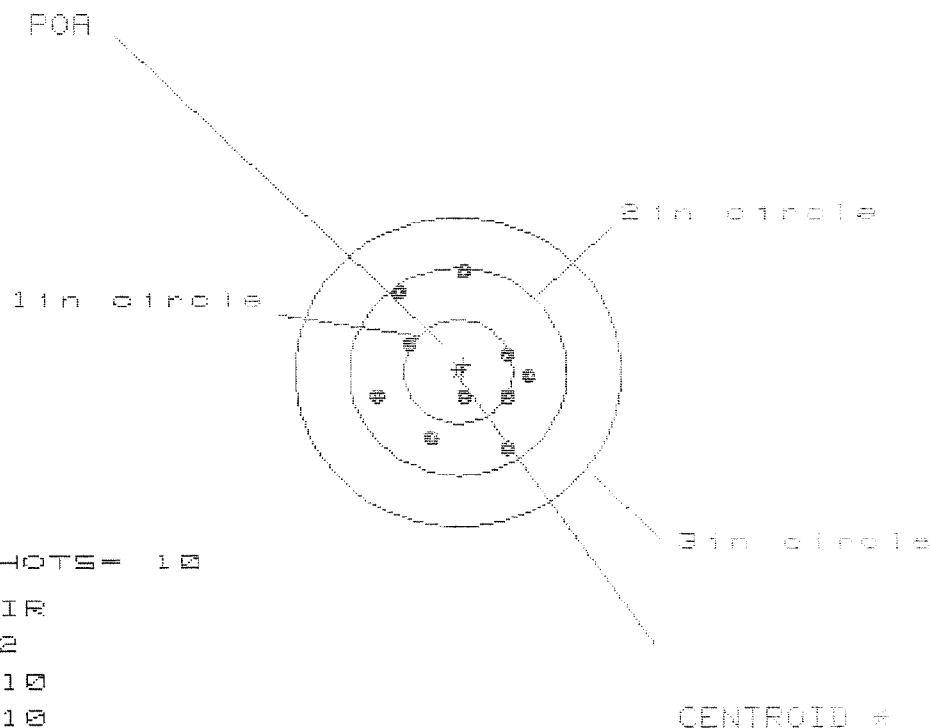
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0416
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .227633
THE AMR FOR THIS RIFLE IS: .9634

8 Dec 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06348757

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.374

VS= 1.668

GS= 1.778

CENTROID *

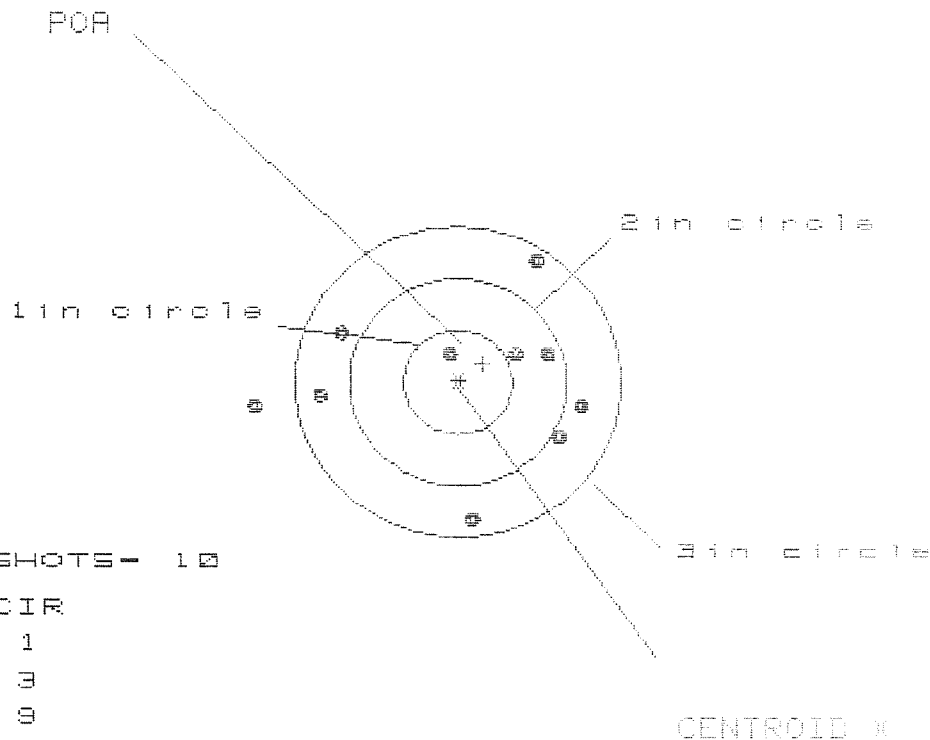
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.601	.606	.533
MINIMUM X	:	-.773	-.768	-.841
MAXIMUM Y	:	.969	.863	.436
MINIMUM Y	:	-.699	-.591	-.483
CENTROID X	:	-.051	-.056	.017
CENTROID Y	:	-.066	-.174	-.282
POA TO CENTROID in.	:	.083	.183	.232
MIN RADIUS	:	.238	.139	.016
MEAN RADIUS	:	.657	.603	.516
MAX RADIUS	:	.970	1.039	.842
HORIZONTAL SPREAD	:	1.374	1.374	1.374
VERTICAL SPREAD	:	1.668	1.454	.919
EXTREME SPREAD	:	1.778	1.778	1.398
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Dec 1989

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CENTERFIRE PATTERNS

2

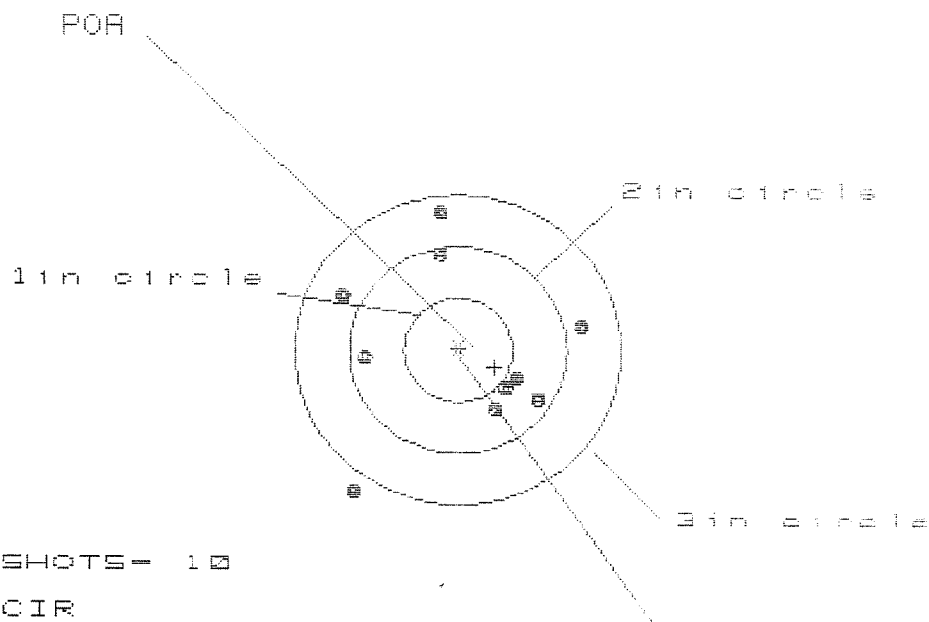


PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.142
MINIMUM X	:	-1.917
MAXIMUM Y	:	1.206
MINIMUM Y	:	-1.356
CENTROID X	:	-.229
CENTROID Y	:	-.176
POA TO CENTROID in.	:	.289
MIN RADIUS	:	.319
MEAN RADIUS	:	1.110
MAX RADIUS	:	1.932
HORIZONTAL SPREAD	:	3.059
VERTICAL SPREAD	:	2.562
EXTREME SPREAD	:	3.059
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 = 0

2in = 6

3in = 9

HS= 2.165

VS= 2.647

GS= 2.779

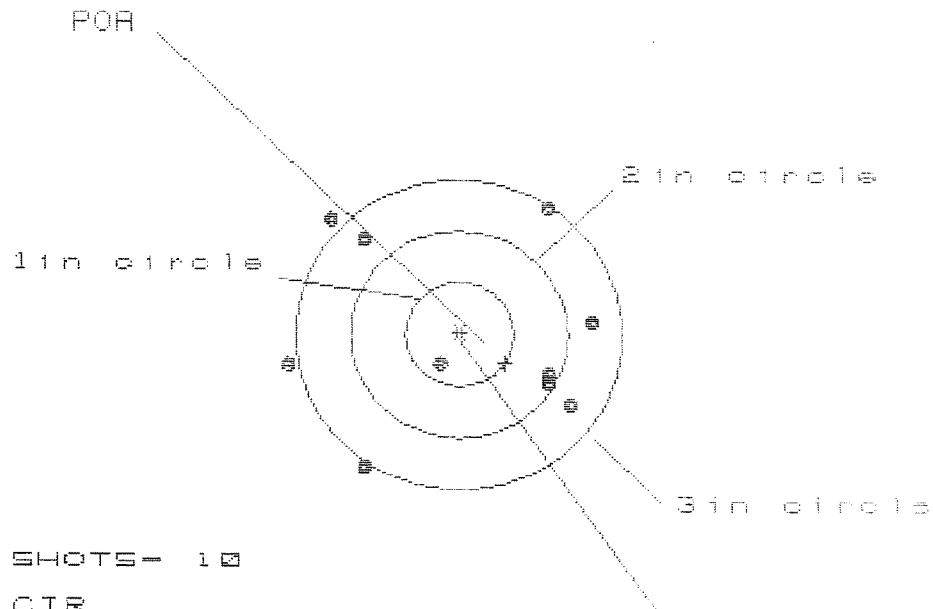
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.112	1.004	.975
MINIMUM X	-1.053	-1.161	-1.190
MAXIMUM Y	1.330	1.184	.914
MINIMUM Y	-1.317	-.720	-.572
CENTROID X	-.336	-.228	-.199
CENTROID Y	.166	.312	.164
POA TO CENTROID in.	.374	.387	.258
MIN RADIUS	.573	.603	.473
MEAN RADIUS	.979	.898	.824
MAX RADIUS	1.635	1.227	1.309
HORIZONTAL SPREAD	2.165	2.165	2.165
VERTICAL SPREAD	2.647	1.904	1.486
EXTREME SPREAD	2.779	2.185	2.185
NUMBER IN ONE INCH CIRCLE =		0	
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 = 1

2in = 3

3in = 7

HS = 2.873

VS = 2.537

GS = 3.040

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.257
MINIMUM X	-1.616
MAXIMUM Y	1.251
MINIMUM Y	-1.286
CENTROID X	-.425
CENTROID Y	.278
POA TO CENTROID in.	.508
MIN RADIUS	.325
MEAN RADIUS	1.238
MAX RADIUS	1.655
HORIZONTAL SPREAD	2.873
VERTICAL SPREAD	2.537
EXTREME SPREAD	3.040
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	7

8 Dec 1985

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 1.895

VS= 2.421

GS= 2.605

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.950	.832
MINIMUM X	:	-.902	-.945	-.712
MAXIMUM Y	:	.937	.772	.613
MINIMUM Y	:	-1.484	-1.273	-.643
CENTROID X	:	-.081	-.038	.030
CENTROID Y	:	-.410	-.245	-.088
POA TO CENTROID in.	:	.418	.248	.113
MIN RADIUS	:	.296	.279	.269
MEAN RADIUS	:	.843	.755	.650
MAX RADIUS	:	1.533	1.585	.904
HORIZONTAL SPREAD	:	1.895	1.895	1.544
VERTICAL SPREAD	:	2.421	2.045	1.256
EXTREME SPREAD	:	2.605	2.605	1.553
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

BARBER - M24 0063232

Remington



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

MODEL 700TM H24

SERIAL NO.
C6348757

ORDER NO.
5716

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

Ø1



5716 C6348757

UPC



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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0063232

M2400063271