

C6649112

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington




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

MODEL 700TM H24

SERIAL NO.
C6649112

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

ORDER NO.
5716



5716 C6649112



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649112

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 20	91	RW
610	Dis-assemble Gun	4 30		RW
612	Magnaflux Barrel Action	5 6 9 1		Kcd
	Magnaflux Bolt	5 6 9 1		Kcd
615	Rollmark Caliber	5 6 9 1		GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/20/91	TA
	Apply Coating (Bolt)		5/20/91	TA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	JH

op. #	BARBER - M24 0064952	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-31-91	DH
	G) Safety Off Force	4	3	3			5-31-91	DH
	H) Trigger Pull Test & Retainability						5/31/91	JH
	I) Firing Pin Indent	.021	.021	.023			5-31-91	DH
	J) Assemble Stock						6/3/91	Rw
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/3/91	Rw
	M) Iron Sight Alignment						6/3/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	Rw
	O) Attach Scope to Rifle						6/3/91	Rw
	P) Detach & Attach Scope 20 Times						6/3/91	Rw
640	Gallery Target & Test						6-4-91	AC
	A) Time						6-4-91	AC
	B) Malfunctions						6-4-91	AC
	C) Pierced Primers						6-4-91	AC
	D) Optical Clarity of Scope						6-4-91	AC
645	Inspect for Live Ammo						6-4-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.15	2.18	2.20	2.22	2.18	6-8-91	DH
	C) Function						6-8-91	DH
660	Pack						6-20-91	NF

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

SERIAL NO R6649112DATE 5/31/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.24	2.44	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.25	2.50	2.18	
PULL #3	2.22	2.19	2.44	2.20	
PULL #4	2.34	2.51	2.43	2.22	
PULL #5	2.20	2.43	2.38	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.44		
PULL #2	3.37	3.42		
PULL #3	3.19	3.42		
PULL #4	3.57	3.44		
PULL #5	3.55	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.40		4.48
PULL #2	4.40	4.39		4.49
PULL #3	4.40	4.45		4.36
PULL #4	4.41	4.49		4.22
PULL #5	4.37	4.44		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649112
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.102883
1 TO	2	.204443
1 TO	3	.235342
1 TO	4	.719334
1 TO	5	.481007

5 4 <----POA

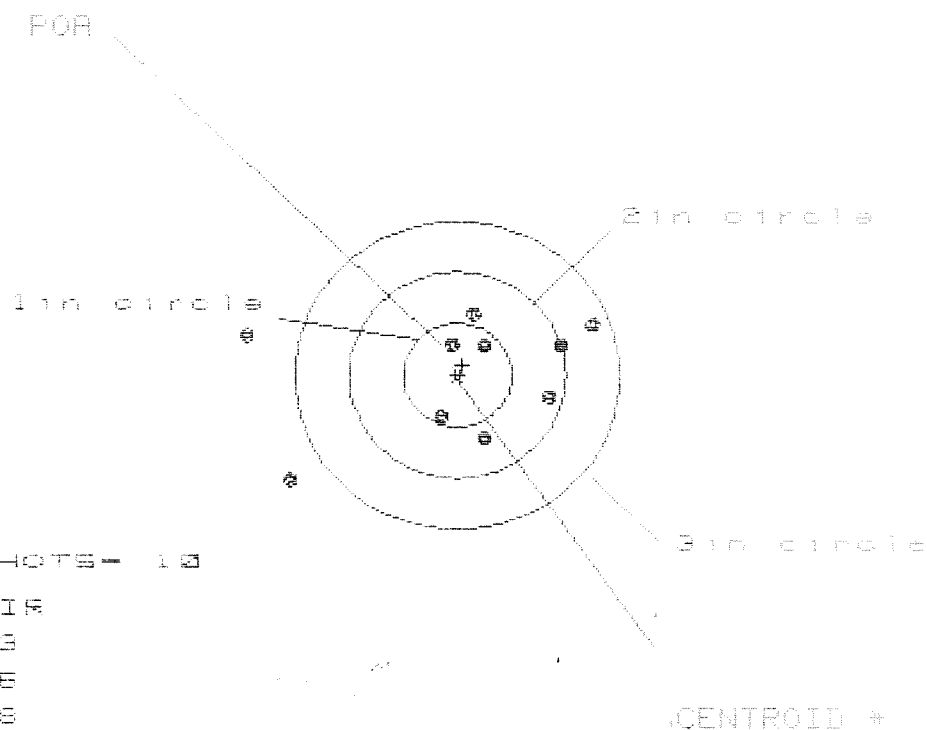
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115059

THE AMR FOR THIS RIFLE IS: .7996

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649112

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 0.885

VS = 1.673

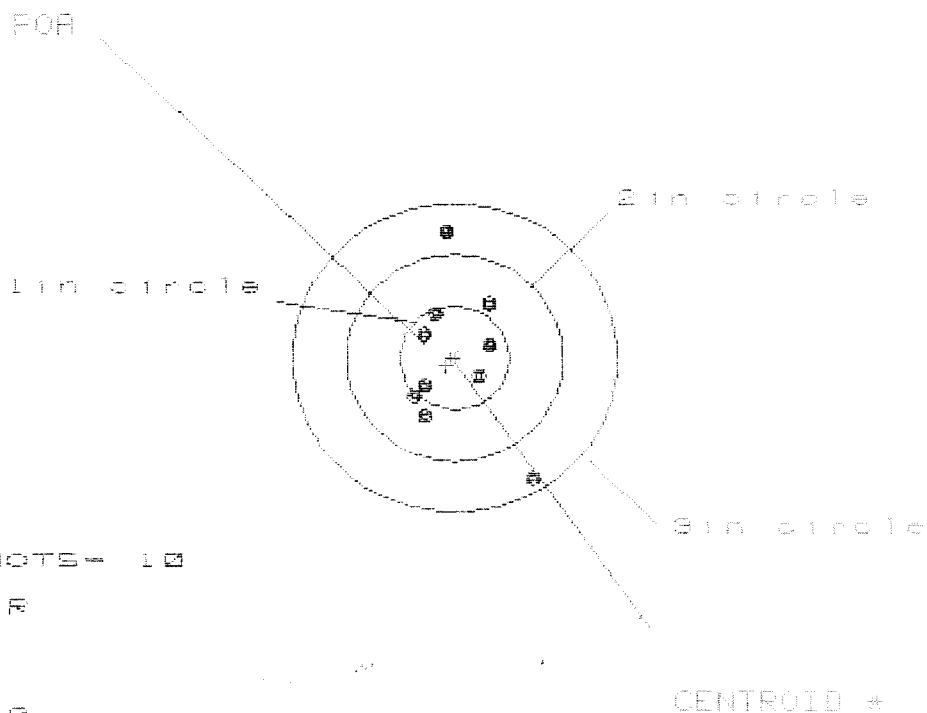
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PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.031	.885
MINIMUM X	-1.957	-1.807	-1.586
MAXIMUM Y	.626	.664	.533
MINIMUM Y	-1.047	-1.009	-1.672
CENTROID X	-.048	.169	.395
CENTROID Y	-.091	-.129	-.083
POA TO CENTROID in.	.103	.213	.395
MIN RADIUS	.302	.329	.274
MEAN RADIUS	.956	.803	.615
MAX RADIUS	1.986	2.070	.989
HORIZONTAL SPREAD	3.205	2.838	1.365
VERTICAL SPREAD	1.673	1.673	1.210
EXTREME SPREAD	3.237	3.237	1.650
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.084

VS = 2.441

GS = 2.563

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.749	.399	.397
MINIMUM X	-.335	-.252	-.245
MAXIMUM Y	1.249	1.116	.512
MINIMUM Y	-1.192	-.736	-.596
CENTROID X	.078	-.005	-.012
CENTROID Y	.070	.203	.063
FOR TO CENTROID in.	.105	.203	.084
MIN RADIUS	.231	.258	.301
MEAN RADIUS	.628	.535	.448
MAX RADIUS	1.408	1.117	.647
HORIZONTAL SPREAD	1.034	.642	.642
VERTICAL SPREAD	2.441	1.852	1.168
EXTREME SPREAD	2.563	1.875	1.277
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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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 = 9

3 in = 9

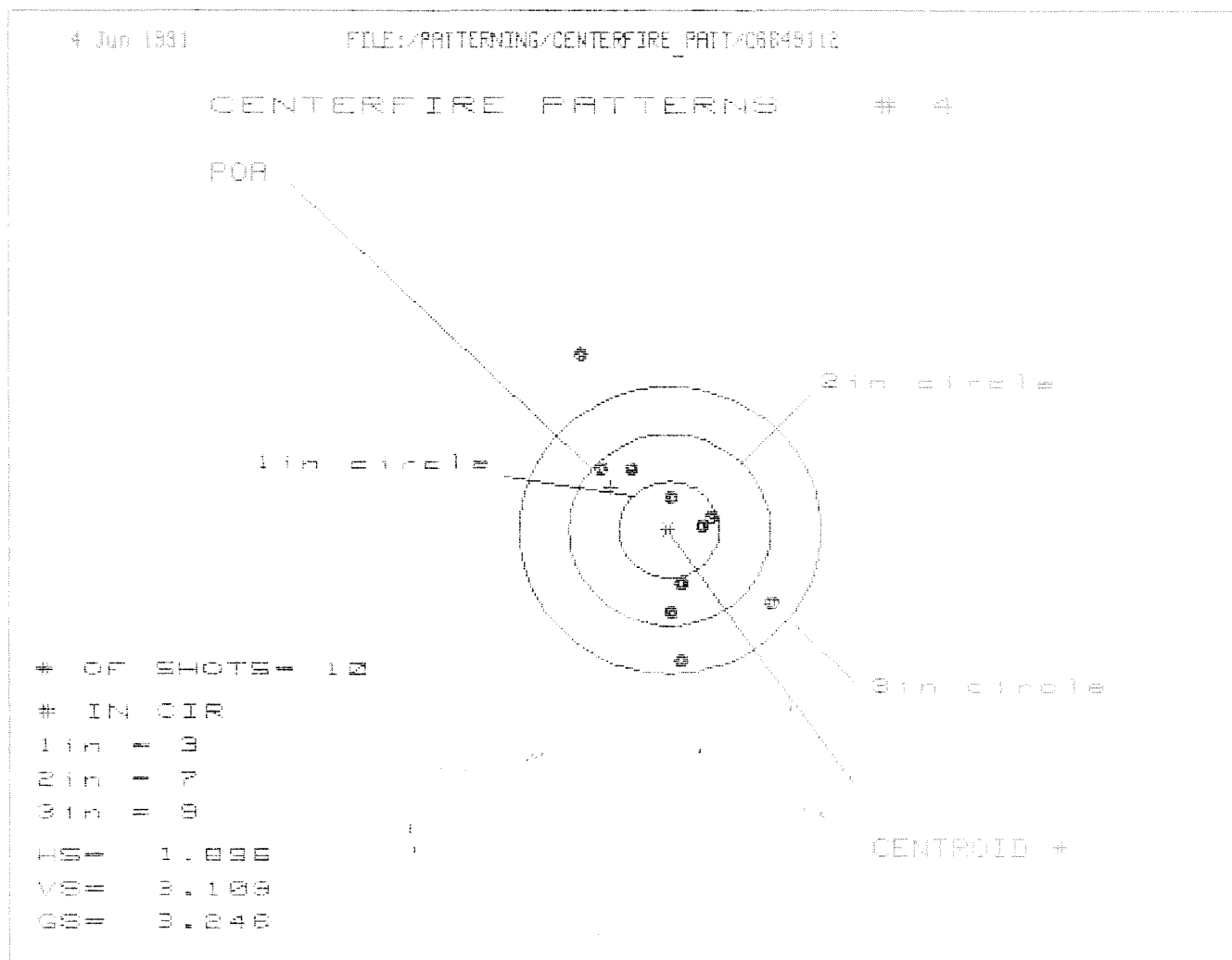
HS = 2.929

VS = 1.533

GS = 2.834

*CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.067	.530	.544
MINIMUM X	-.862	-.632	-.566
MAXIMUM Y	.651	.613	.497
MINIMUM Y	-.882	-.920	-.541
CENTROID X	.183	-.047	-.113
CENTROID Y	-.136	-.098	.017
POA TO CENTROID in.	.228	.108	.114
MIN RADIUS	.121	.125	.037
MEAN RADIUS	.763	.565	.476
MAX RADIUS	2.096	1.062	.691
HORIZONTAL SPREAD	2.929	1.162	1.110
VERTICAL SPREAD	1.533	1.533	1.005
EXTREME SPREAD	2.934	1.537	1.333
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

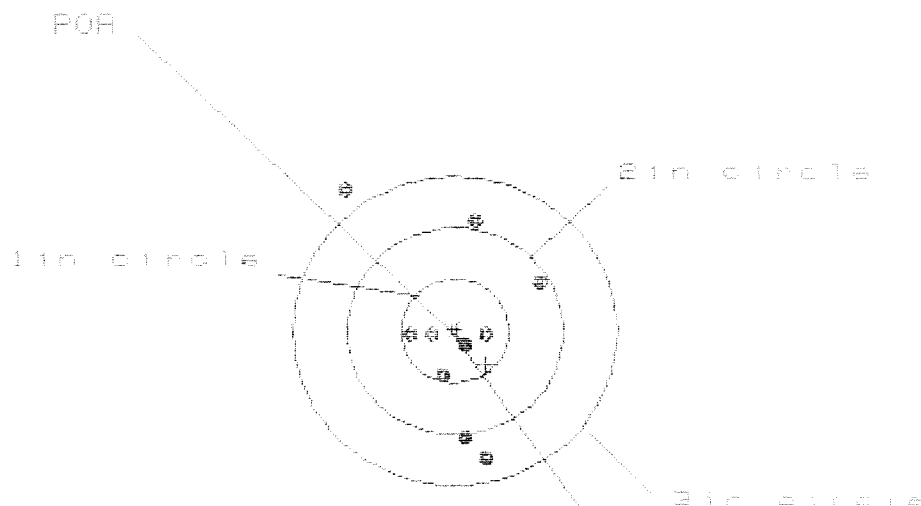


PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.855	.961	.961
MINIMUM X	-.841	-.816	-.816
MAXIMUM Y	1.795	.882	.743
MINIMUM Y	-1.314	-1.115	-1.793
CENTROID X	.581	.675	.675
CENTROID Y	-.440	-.639	-.580
POR TO CENTROID in.	.729	.930	.840
MIN RADIUS	.276	.292	.302
MEAN RADIUS	.886	.750	.684
MAX RADIUS	1.932	1.137	1.261
HORIZONTAL SPREAD	1.896	1.777	1.777
VERTICAL SPREAD	3.189	1.997	1.536
EXTREME SPREAD	3.246	2.246	2.246
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 6

3 in = 9

HS = 1.811

VS = 2.657

GS = 2.946

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.784	.670	.686
MINIMUM X	-1.027	-.556	-.540
MAXIMUM Y	1.403	1.251	1.113
MINIMUM Y	-1.254	-1.098	-1.043
CENTROID X	-.286	-.172	-.182
CENTROID Y	.327	.171	.309
POA TO CENTROID in.	.404	.242	.361
MIN RADIUS	.173	.057	.150
MEAN RADIUS	.765	.634	.579
MAX RADIUS	1.739	1.257	1.122
HORIZONTAL SPREAD	1.811	1.226	1.226
VERTICAL SPREAD	2.657	2.349	2.156
EXTREME SPREAD	2.946	2.349	2.156
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		