

C6649122

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

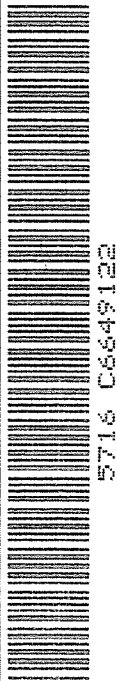
Capacity

Order No. **5715**

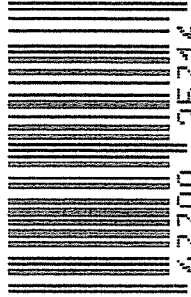
* Includes 1 in chamber.

Remington

Remington® MODEL 700™ H24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
DUPONT REG. U.S. PAT. & T.M. OFF.		SERIAL NO. C6649122
20		ORDER NO. 5716



UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649122**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	KA

op. #	OP. NAME BARBER, M24 0065066	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7	8	10-91	DH	
	G) Safety Off Force	3	3	3 3/4		8-10-91	DH	
	H) Trigger Pull Test & Retainability					8-10-91	JL	
	I) Firing Pin Indent	.022	.022	.021		8-10-91	DH	
	J) Assemble Stock					8/12/91	KL	
	K) Assemble Swivel Studs					8-14-91	DH	
	L) Attach Front and Rear Sight Assemblies					8/12/91	KL	
	M) Iron Sight Alignment					8/12/91	KL	
	N) Detach Front & Rear Sights & place in numbered container					8/12/91	KL	
	O) Attach Scope to Rifle					8/12/91	KL	
	P) Detach & Attach Scope 20 Times					8/12/91	KL	
640	Gallery Target & Test					8-13-91	NF	
	A) Time					"	NF	
	B) Malfunctions					"	NF	
	C) Pierced Primers					"	NF	
	D) Optical Clarity of Scope					"	NF	
645	Inspect for Live Ammo					8-13-91	NF	
655	Final Inspection							
	A) Headspace					8-14-91	DH	
	B) Trigger Pull	2.48	2.55	2.44	2.39	2.43	8-14-91	JL
	C) Function					8-14-91	DH	
660	Pack					9-18-91	NF	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649122
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.182937
1 TO 2	.186698
1 TO 3	.257049
1 TO 4	.17623
1 TO 5	.209172

3 <----POA

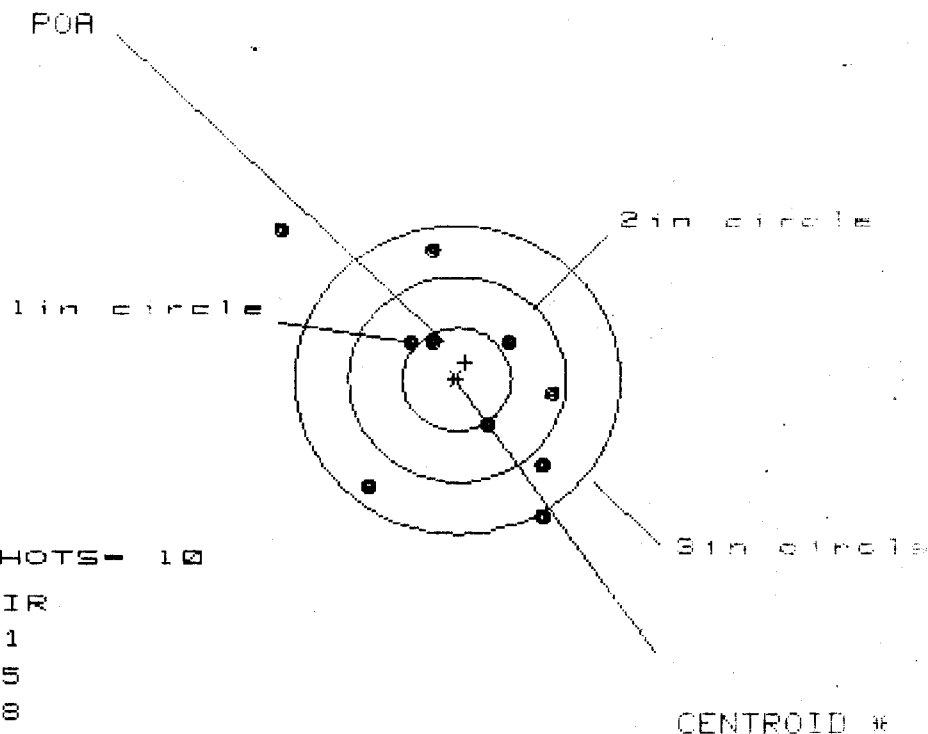
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0994
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0994016

THE AMR FOR THIS RIFLE IS: .802

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FILE:/PATTERNING/CENTERFIRE_PATT/C8649122

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.480

VS= 2.779

GS= 3.675

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.896	.720	.800
MINIMUM X	-1.584	-1.004	-.923
MAXIMUM Y	1.425	1.439	1.289
MINIMUM Y	-1.354	-1.195	-1.040
CENTROID X	-.079	.097	.016
CENTROID Y	-.165	-.324	-.174
POA TO CENTROID in.	.183	.338	.175
MIN RADIUS	.404	.312	.461
MEAN RADIUS	1.046	.904	.835
MAX RADIUS	2.131	1.505	1.391
HORIZONTAL SPREAD	2.480	1.724	1.724
VERTICAL SPREAD	2.779	2.634	2.329
EXTREME SPREAD	3.675	2.849	2.396
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 2.068

VS= 1.818

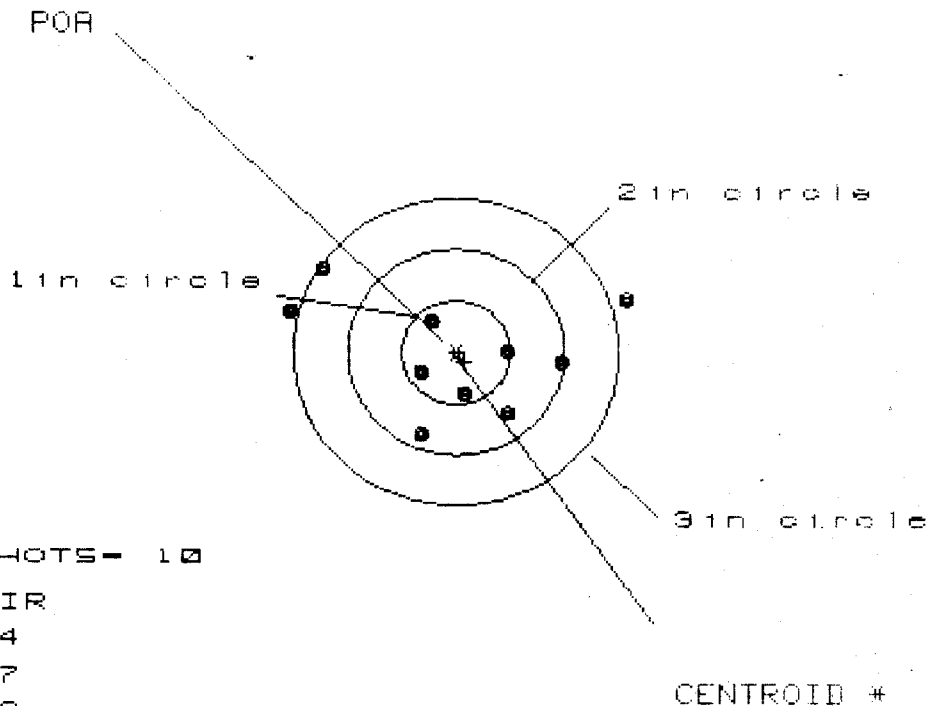
GS= 2.339

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	.629	.685
MINIMUM X	:	-.928	-.801	-.745
MAXIMUM Y	:	.935	.837	.976
MINIMUM Y	:	-.883	-.459	-.354
CENTROID X	:	.055	-.072	-.128
CENTROID Y	:	-.295	-.197	-.302
POA TO CENTROID in.	:	.300	.210	.328
MIN RADIUS	:	.169	.176	.058
MEAN RADIUS	:	.641	.547	.459
MAX RADIUS	:	1.442	.952	.776
HORIZONTAL SPREAD	:	2.068	1.430	1.430
VERTICAL SPREAD	:	1.818	1.296	.730
EXTREME SPREAD	:	2.339	1.516	1.475
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 7

3 in - 8

HS- 3.049

VS- 1.566

GS- 3.050

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	1.163	.995
MINIMUM X	:	-1.514	-1.343	-1.177
MAXIMUM Y	:	.778	.838	.902
MINIMUM Y	:	-.788	-.728	-.664
CENTROID X	:	-.074	-.245	-.077
CENTROID Y	:	.092	.032	-.032
POA TO CENTROID in.	:	.119	.247	.084
MIN RADIUS	:	.330	.216	.307
MEAN RADIUS	:	.882	.789	.678
MAX RADIUS	:	1.629	1.438	1.483
HORIZONTAL SPREAD	:	3.049	2.506	2.172
VERTICAL SPREAD	:	1.566	1.566	1.566
EXTREME SPREAD	:	3.050	2.561	2.334
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= .998

VS= 2.321

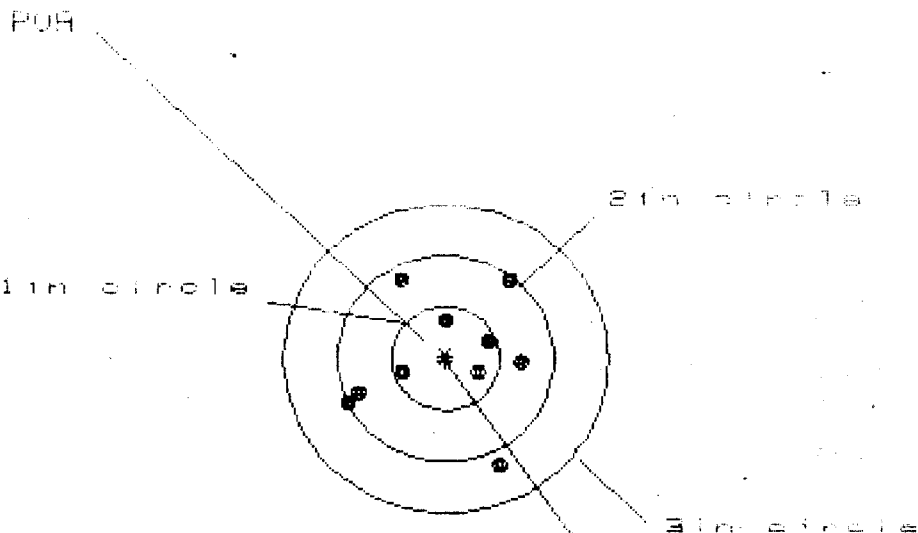
GS= 2.380

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.468	.409	.401
MINIMUM X	:	-.530	-.544	-.552
MAXIMUM Y	:	1.116	1.046	.911
MINIMUM Y	:	-1.205	-1.081	-.625
CENTROID X	:	.097	.156	.164
CENTROID Y	:	-.156	-.280	-.145
POA TO CENTROID in.	:	.184	.320	.219
MIN RADIUS	:	.308	.303	.240
MEAN RADIUS	:	.725	.642	.590
MAX RADIUS	:	1.235	1.142	1.023
HORIZONTAL SPREAD	:	.998	.953	.953
VERTICAL SPREAD	:	2.321	2.127	1.536
EXTREME SPREAD	:	2.380	2.163	1.646
3 in ONE INCH CIRCLE	=	3		
7 in TWO INCH CIRCLE	=	7		
10 in THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 10

ME = 1.617

MS = 1.848

GS = 2.017

CENTROID #

PATTERN #	:	5		
LOADS (BEST OF)	:	10	9	8
MAXIMUM X	:	.713	.766	.849
MINIMUM X	:	-.904	-.851	-.768
MAXIMUM Y	:	.790	.673	.711
MINIMUM Y	:	-1.055	-.592	-.419
CENTROID X	:	.064	-.040	-.132
CENTROID Y	:	.027	.145	.061
FOR TO CENTROID in.	:	.028	.153	.146
1IN RADIUS	:	.241	.247	.274
2IN RADIUS	:	.716	.658	.621
3IN RADIUS	:	1.158	.989	.874
CENTRAL SPREAD	:	1.617	1.617	1.617
SPREAD	:	1.848	1.176	1.130
SPREAD	:	2.017	1.922	1.654
ONE INCH CIRCLE	=		4	
TWO INCH CIRCLE	=		8	
THREE INCH CIRCLE	=		10	

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

SERIAL NO C-6649122
DATE 8-10-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.35	2.34	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.34	2.30	2.55	
PULL #3	2.35	2.35	2.38	2.44	
PULL #4	2.34	2.33	2.44	2.39	
PULL #5	2.35	2.36	2.40	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.18		
PULL #2	3.32	3.24		
PULL #3	3.29	3.24		
PULL #4	3.15	3.30		
PULL #5	3.25	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.43		4.45
PULL #2	4.39	4.37		4.39
PULL #3	4.40	4.39		4.35
PULL #4	4.36	4.39		4.43
PULL #5	4.38	4.35		4.43
TOTAL				
AVG.				