

C6649124

MODEL 700TH M24

Model **SMS** TH

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

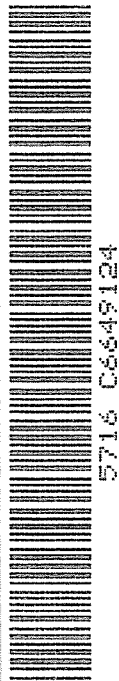
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

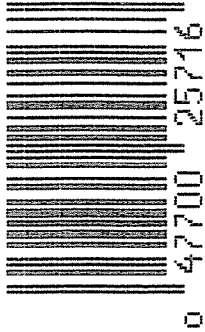
SERIAL NO.
 C6849124

ORDER NO.
 5716

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649124

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/31/91	K4
600	Proof		6/30/91	K4
607	Check Headspace		6/25/91	K4
610	Dis-assemble Gun		6/25/91	K4
612	Magnaflux Barrel Action		JUL 18 1991	GS
	Magnaflux Bolt		JUL 18 1991	GS
615	Rollmark Caliber		JUL 18 1991	GS
617	Drill and Tap Sight Holes		JUL 18 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/91	K4
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/91	K4
	C) Inspect Ejector Hole for Chamfer		8/13/91	K4
	D) Oil Firing Pin Ass'y		8/13/91	K4
	E) Adjust Trigger Pull to Min Setting and Stake		8/14/91	WB

op. #	BARBER M24 0065088 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5	4		8-14-91	DH
	G) Safety Off Force	2	2	2			8-14-91	DH
	H) Trigger Pull Test & Retainability						8/14/91	WB
	I) Firing Pin Indent	.022	.021	.021			8-14-91	DH
	J) Assemble Stock						8/15/91	KR
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/15/91	KR
	M) Iron Sight Alignment						8/15/91	KR
	N) Detach Front & Rear Sights & place in numbered container						8/15/91	KR
	O) Attach Scope to Rifle						8/15/91	KR
	P) Detach & Attach Scope 20 Times						8/15/91	KR
640	Gallery Target & Test						8-16-91	DH
	A) Time						8-16-91	DH
	B) Malfunctions						8-16-91	DH
	C) Pierced Primers						8-16-91	DH
	D) Optical Clarity of Scope						8-16-91	DH
645	Inspect for Live Ammo						8-16-91	DH
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.25	2.27	2.21	2.27	2.21	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						8-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649124
DATE 8/14/91
TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.57	2.36	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.46	2.50	2.27	
PULL #3	2.14	2.53	2.30	2.21	
PULL #4	2.42	2.45	2.33	2.27	
PULL #5	2.40	2.43	2.40	2.21	
TOTAL	11.82	12.44	11.89		
AVG.	2.36	2.49	2.38		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.41		
PULL #2	3.27	3.30		
PULL #3	3.32	3.40		
PULL #4	3.25	3.38		
PULL #5	3.22	3.34		
TOTAL	16.37	16.83		
AVG.	3.27	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.36		4.10
PULL #2	4.16	4.20		4.01
PULL #3	4.03	4.33		4.00
PULL #4	4.14	4.19		3.90
PULL #5	4.04	4.40		3.96
TOTAL	20.67	21.48		19.97
AVG.	4.13	4.29		4.00

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649124
22 Aug 1991

CENTROIDAL DISTANCES

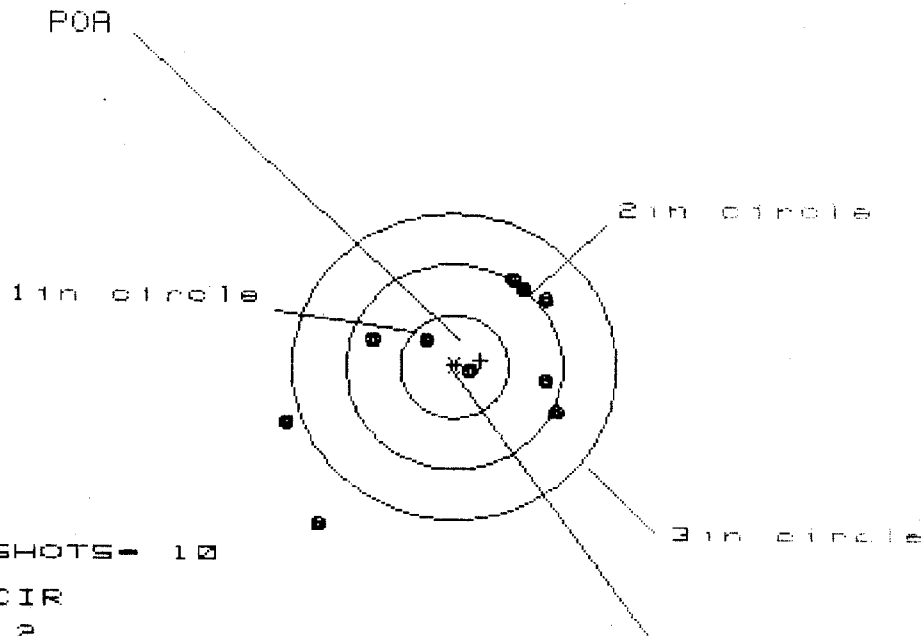
0 TO	1	.253221
1 TO	2	.2672
1 TO	3	.291062
1 TO	4	.647932
1 TO	5	.667061

135 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1078
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1198
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .161161
THE AMR FOR THIS RIFLE IS: .9988

FILE: /PATTERNING/CENTERFIRE_PATT/C8649124

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.554

VS = 2.308

GS = 2.980

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.958	.821	.605
MINIMUM X	:	-1.596	-1.733	-1.155
MAXIMUM Y	:	.819	.653	.560
MINIMUM Y	:	-1.489	-.749	-.638
CENTROID X	:	-.245	-.108	.108
CENTROID Y	:	-.064	.102	.195
POA TO CENTROID in.	:	.253	.148	.223
MIN RADIUS	:	.110	.207	.389
MEAN RADIUS	:	.987	.847	.686
MAX RADIUS	:	1.930	1.887	1.156
HORIZONTAL SPREAD	:	2.554	2.554	1.760
VERTICAL SPREAD	:	2.308	1.402	1.248
EXTREME SPREAD	:	2.980	2.752	1.879
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649124

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.424

VS= 3.178

GS= 3.270

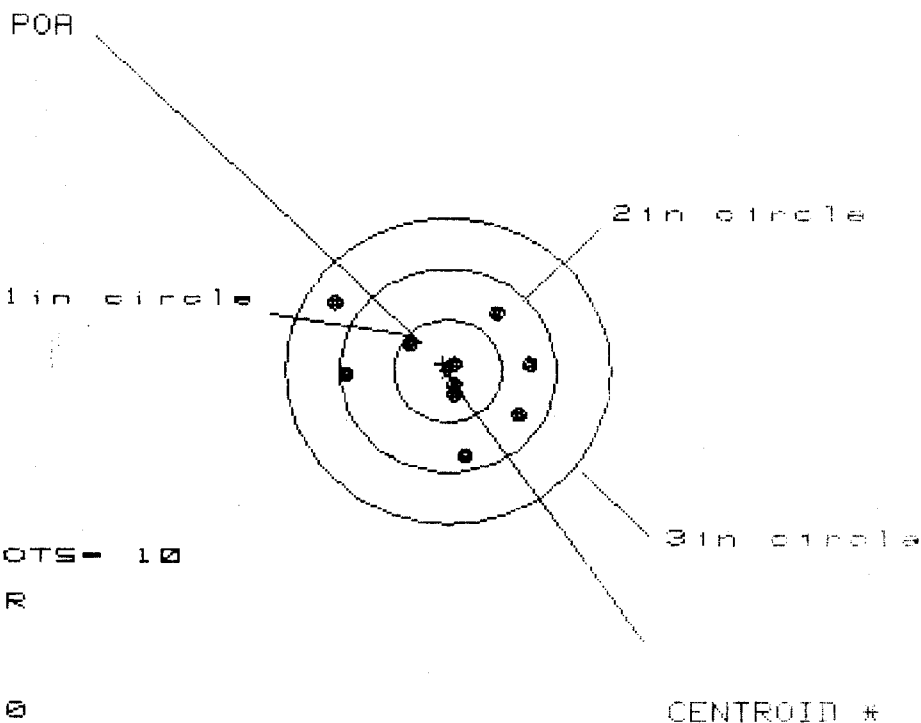
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.271	1.206	.954
MINIMUM X	-1.153	-1.218	-1.067
MAXIMUM Y	1.270	1.058	.921
MINIMUM Y	-1.908	-1.100	-1.196
CENTROID X	-.085	-.020	-.171
CENTROID Y	-.278	-.066	.071
POA TO CENTROID in.	.291	.069	.185
MIN RADIUS	.585	.740	.720
MEAN RADIUS	1.176	1.063	.973
MAX RADIUS	1.997	1.632	1.273
HORIZONTAL SPREAD	2.424	2.424	2.021
VERTICAL SPREAD	3.178	2.158	2.117
EXTREME SPREAD	3.270	2.835	2.243
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649124

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.739

VS= 1.490

GS= 1.991

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.727	.615	.482
MINIMUM X	:	-1.012	-1.065	-.559
MAXIMUM Y	:	.676	.691	.698
MINIMUM Y	:	-.814	-.739	-.732
CENTROID X	:	.046	.158	.291
CENTROID Y	:	-.070	-.145	-.152
POA TO CENTROID in.	:	.084	.215	.328
MIN RADIUS	:	.100	.076	.191
MEAN RADIUS	:	.626	.535	.476
MAX RADIUS	:	1.217	1.066	.740
HORIZONTAL SPREAD	:	1.739	1.680	1.041
VERTICAL SPREAD	:	1.490	1.430	1.430
EXTREME SPREAD	:	1.991	1.682	1.464
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649124

CENTERFIRE PATTERNS # 4

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 3.451

VS= 2.790

GS= 3.456

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.808	1.148	1.269
MINIMUM X	-1.643	-1.442	-1.321
MAXIMUM Y	1.237	1.316	1.132
MINIMUM Y	-1.553	-1.474	-0.968
CENTROID X	.401	.200	.079
CENTROID Y	-.114	-.193	-.009
POR TO CENTROID in.	.417	.278	.080
MIN RADIUS	.176	.147	.286
MEAN RADIUS	1.173	1.052	.971
MAX RADIUS	1.944	1.762	1.618
HORIZONTAL SPREAD	3.451	2.590	2.590
VERTICAL SPREAD	2.790	2.790	2.100
EXTREME SPREAD	3.456	3.184	2.755
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

22 Aug 1991

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CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 5

3 in - 8

HS = 3.189

VS = 1.890

GS = 3.218

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.888	1.677	.963
MINIMUM X	-1.301	-1.091	-.881
MAXIMUM Y	1.095	1.104	1.167
MINIMUM Y	-.795	-.786	-.723
CENTROID X	.422	.212	.002
CENTROID Y	-.073	-.082	-.145
POR TO CENTROID in.	.428	.227	.145
MIN RADIUS	.426	.431	.409
MEAN RADIUS	1.032	.914	.779
MAX RADIUS	1.890	1.751	1.178
HORIZONTAL SPREAD	3.189	2.768	1.844
VERTICAL SPREAD	1.890	1.890	1.890
EXTREME SPREAD	3.218	2.894	1.925
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		