

06649157

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

MODEL 700™ H24

SERIAL NO.
C6649157

ORDER NO.
5716

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

5716 C6649157

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6649157**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6/25/91	KE
600	Proof		6/25/91	KE
607	Check Headspace		6/25/91	KE
610	Dis-assemble Gun		6/25/91	KE
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	EB
618	Polish Barrel		JUL 2 8 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	EB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KE
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KE
	C) Inspect Ejector Hole for Chamfer		8/29/91	KE
	D) Oil Firing Pin Ass'y		8/29/91	KE
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	KE

op. #	BARBER, M24 0065461 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/91	JH
	G) Safety Off Force	4	4	4			9/4/91	JH
	H) Trigger Pull Test & Retainability						9/4/91	JH
	I) Firing Pin Indent	.021	.021	.021			9/4/91	JH
	J) Assemble Stock						9/5/91	JH
	K) Assemble Swivel Studs						9-12-91	AC
	L) Attach Front and Rear Sight Assemblies						9/5/91	JH
	M) Iron Sight Alignment						9/5/91	JH
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	JH
	O) Attach Scope to Rifle						9/5/91	JH
	P) Detach & Attach Scope 20 Times						9/5/91	JH
640	Gallery Target & Test						9-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-6-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	AC
	B) Trigger Pull	2.39	2.42	2.38	2.31	2.37	9-12-91	JH
	C) Function						9-12-91	AC
660	Pack						9-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6649157DATE 9-4-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.20	2.40	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.40	2.48	2.42	
PULL #3	2.42	2.36	2.44	2.38	
PULL #4	2.53	2.42	2.38	2.31	
PULL #5	2.44	2.38	2.36	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.27		
PULL #2	3.34	3.27		
PULL #3	3.29	3.28		
PULL #4	3.28	3.28		
PULL #5	3.37	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.49		4.49
PULL #2	4.49	4.57		4.51
PULL #3	4.53	4.42		4.61
PULL #4	4.58	4.23		4.58
PULL #5	4.61	4.54		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06649157

7 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.199462
1 TO	2	.36331
1 TO	3	.372937
1 TO	4	.233976
1 TO	5	.183098

48 <----POB

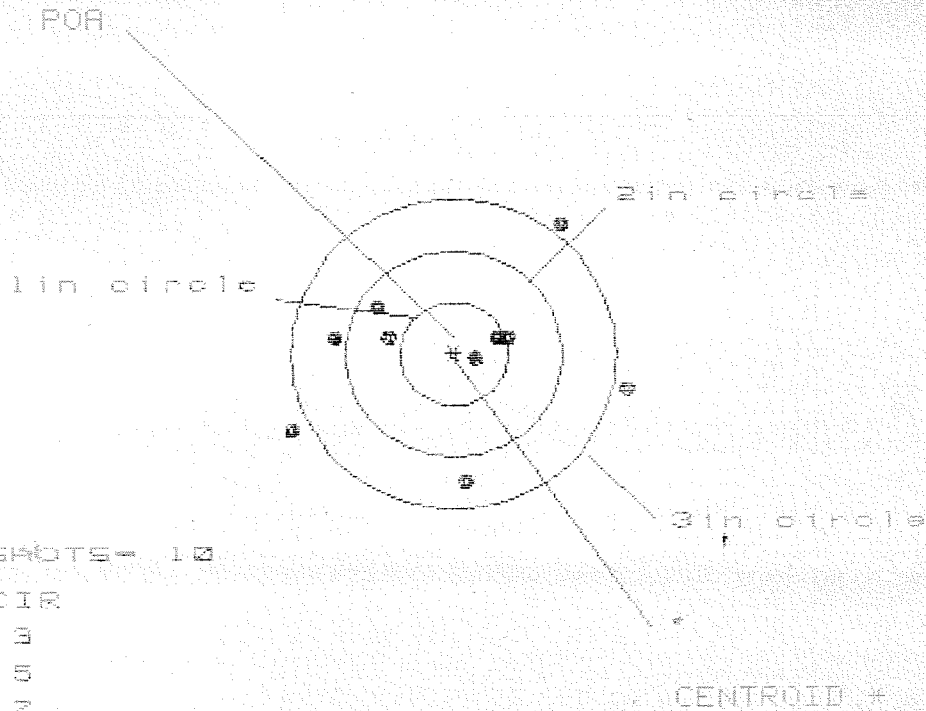
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .10446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .10461861

THE AMR FOR THIS RIFLE IS: .7556

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649157

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 3.065

VS = 2.541

GS = 3.219

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.597	1.434	1.543
MINIMUM X	-1.468	-1.248	-1.139
MAXIMUM Y	1.288	1.198	.564
MINIMUM Y	-1.261	-1.343	-1.194
CENTROID X	-.196	-.033	-.142
CENTROID Y	.037	.119	-.030
POA TO CENTROID in.	.200	.124	.145
MIN RADIUS	.248	.170	.184
MEAN RADIUS	.992	.890	.826
MAX RADIUS	1.646	1.492	1.565
HORIZONTAL SPREAD	3.065	2.682	2.682
VERTICAL SPREAD	2.541	2.541	1.758
EXTREME SPREAD	3.219	2.720	2.720
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649157

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 10

3 in = 10

HS= 1.116

VS= 1.432

GS= 1.482

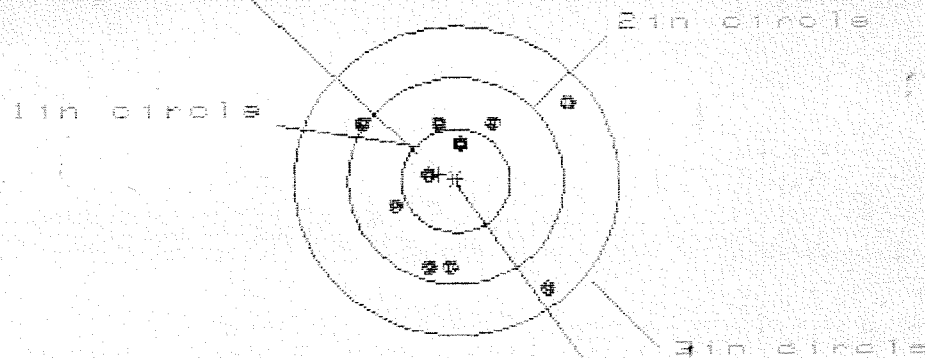
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.374	.390	.300
MINIMUM X	-.742	-.726	-.598
MAXIMUM Y	.622	.532	.483
MINIMUM Y	-.810	-.505	-.554
CENTROID X	.167	.151	.241
CENTROID Y	.1052	.142	.191
POA TO CENTROID in.	.175	.207	.300
MIN RADIUS	.299	.389	.306
MEAN RADIUS	.586	.557	.509
MAX RADIUS	.823	.827	.604
HORIZONTAL SPREAD	1.116	1.116	.838
VERTICAL SPREAD	1.432	1.037	1.037
EXTREME SPREAD	1.482	1.382	1.174
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3

POB



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.926

VS= 1.713

GS= 2.320

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.015	1.104	.592
MINIMUM X	-.911	-.822	-.684
MAXIMUM Y	.718	.607	.548
MINIMUM Y	-.995	-.930	-.854
CENTROID X	.163	.074	-.064
CENTROID Y	-.064	.047	-.029
POB TO CENTROID in.	.175	.087	.070
MIN RADIUS	.262	.183	.033
MEAN RADIUS	.780	.697	.606
MAX RADIUS	1.276	1.260	.871
HORIZONTAL SPREAD	1.926	1.926	1.276
VERTICAL SPREAD	1.713	1.537	1.402
EXTREME SPREAD	2.320	2.008	1.608
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649157

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.507

VS= 1.571

GS= 2.879

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.159	.999	.995
MINIMUM X	-1.448	-.945	-.821
MAXIMUM Y	.779	.843	.770
MINIMUM Y	-.792	-.728	-.801
CENTROID X	-.148	.013	-.112
CENTROID Y	.266	.202	.275
POA TO CENTROID in.	.304	.203	.297
MIN RADIUS	.144	.280	.179
MEAN RADIUS	.881	.808	.743
MAX RADIUS	1.557	1.211	1.258
HORIZONTAL SPREAD	2.607	1.944	1.815
VERTICAL SPREAD	1.571	1.571	1.571
EXTREME SPREAD	2.879	2.143	2.124
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.165

VS= 1.176

GS= 2.176

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	.915	.459
MINIMUM X	-1.125	-.609	-.494
MAXIMUM Y	.656	.658	.632
MINIMUM Y	-.520	-.518	-.544
CENTROID X	-.046	.079	-.036
CENTROID Y	-.068	-.070	-.044
POB TO CENTROID in.	.082	.105	.057
MIN RADIUS	.044	.040	.044
MEAN RADIUS	.539	.473	.398
MAX RADIUS	1.125	.938	.769
HORIZONTAL SPREAD	2.165	1.524	.953
VERTICAL SPREAD	1.176	1.176	1.176
EXTREME SPREAD	2.176	1.556	1.502
NUMBER IN ONE INCH CIRCLE =	5	5	5
NUMBER IN TWO INCH CIRCLE =	8	8	8
NUMBER IN THREE INCH CIRCLE =	10	10	10