

C5649208

MODEL 700™ M24

Model SMS™

Action

Barrel Length

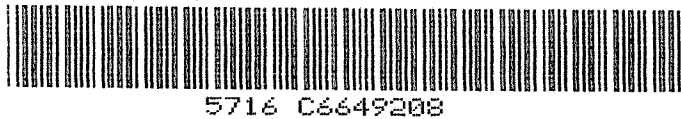
Capacity

Order No. 5715

*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 700TM H24		SERIAL NO. C6649208	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.			



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649208

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/2/91	KA
600	Proof		8/2/91	KA
607	Check Headspace		8/2/91	KA
610	Dis-assemble Gun		8/2/91	KA
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	SL
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 3 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	KA
	Apply Coating (Bolt)			
625	Final Assembly		9/4/91	KA
	A) Clean inside of Bolt Assembly		9/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KA
	C) Inspect Ejector Hole for Chamfer		9/4/91	KA
	D) Oil Firing Pin Ass'y		9/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9/7/91	KA

op. #	BARBER - M24 0066389 OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	9/7/91	SH		
	G) Safety Off Force	4	4	4	9/7/91	SH		
	H) Trigger Pull Test & Retainability				9/7/91	SH		
	I) Firing Pin Indent	.0215	.021	.0215	9/7/91	SH		
	J) Assemble Stock				9/10/91	KL		
	K) Assemble Swivel Studs				9/13/91	SH		
	L) Attach Front and Rear Sight Assemblies				9/10/91	KL		
	M) Iron Sight Alignment				9/10/91	KL		
	N) Detach Front & Rear Sights & place in numbered container				9/10/91	KL		
	O) Attach Scope to Rifle				9/10/91	KL		
	P) Detach & Attach Scope 20 Times				9/10/91	KL		
640	Gallery Target & Test				9-11-91	AC		
	A) Time				9-11-91	AC		
	B) Malfunctions				9-11-91	AC		
	C) Pierced Primers				9-11-91	AC		
	D) Optical Clarity of Scope				9-11-91	AC		
645	Inspect for Live Ammo				9-11-91	AC		
655	Final Inspection							
	A) Headspace				9/13/91	SH		
	B) Trigger Pull	2.63	2.65	2.61	2.66	2.69	9-12-91	SH
	C) Function						9/13/91	SH
660	Pack						9-21-91	D/H

TIME

BARBER - M24 0066390

SWS TRIGGER PULL TEST

7.00

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

SERIAL NO. C6649208DATE 9-7-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.29	2.33	2.63	MIN. SETTING,
PULL #2	2.25	2.29	2.35	2.65	NO AVG. OF 5
PULL #3	2.46	2.43	2.25	2.61	READINGS ACCEPT-
PULL #4	2.32	2.23	2.23	2.66	ABLE LESS THAN 2#
PULL #5	2.37	2.24	2.20	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.30		
PULL #2	3.42	3.33		
PULL #3	3.37	3.31		
PULL #4	3.42	3.35		
PULL #5	3.30	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.25		4.34
PULL #2	4.47	4.20		4.36
PULL #3	4.39	4.41		4.41
PULL #4	4.31	4.31		4.38
PULL #5	4.34	4.33		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649208
11 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.17791
1 TO	2	.220057
1 TO	3	.331688
1 TO	4	.295256
1 TO	5	.557571

5 <----POB

VELOCITY P-COORDINATE FOR THIS RIFLE IS: .0674
VELOCITY X-COORDINATE FOR THIS RIFLE IS: -.0056
VELOCITY Y-COORDINATE FOR THIS RIFLE IS: .0676322
VELOCITY Z-COORDINATE FOR THIS RIFLE IS: .9230

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649208

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.918

VS= 1.982

GS= 3.029

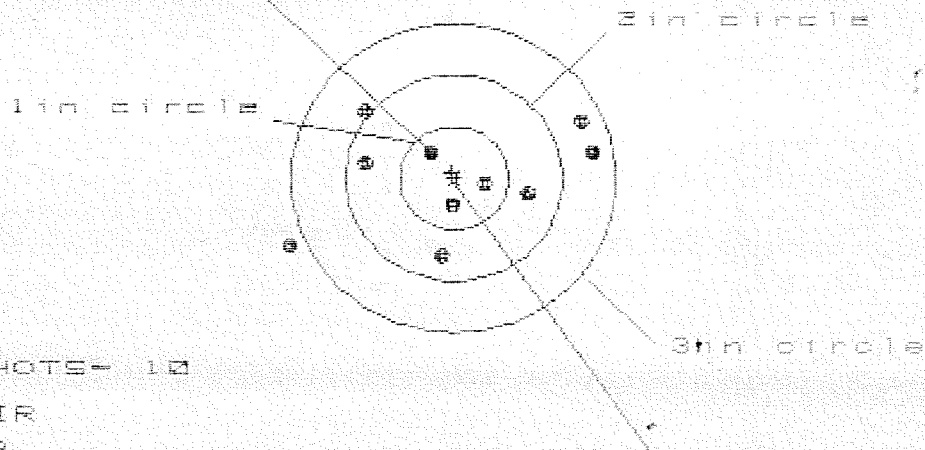
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.500	1.342	.854
MINIMUM X	-1.418	-.828	-.660
MAXIMUM Y	1.269	1.190	1.193
MINIMUM Y	-.713	-.739	-.736
CENTROID X	-.166	-.008	-.176
CENTROID Y	.064	.143	.140
POA TO CENTROID in.	.178	.143	.225
MIN RADIUS	.289	.227	.218
MEAN RADIUS	.929	.852	.772
MAX RADIUS	1.587	1.343	1.223
HORIZONTAL SPREAD	2.918	2.170	1.514
VERTICAL SPREAD	1.982	1.929	1.929
EXTREME SPREAD	3.029	2.299	2.141
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		

11 Sep 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06649283

CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.757

VS= 1.415

GS= 2.966

CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.274	1.110	1.239
MINIMUM X	-1.483	-.994	-.865
MAXIMUM Y	.638	.561	.624
MINIMUM Y	-.777	-.854	-.791
CENTROID X	.021	.185	.056
CENTROID Y	-.052	.025	-.038
POR TO CENTROID in.	.056	.187	.067
MIN RADIUS	.243	.197	.263
MEAN RADIUS	.850	.758	.692
MAX RADIUS	1.635	1.149	1.259
HORIZONTAL SPREAD	2.757	2.104	2.104
VERTICAL SPREAD	1.415	1.415	1.415
EXTREME SPREAD	2.966	2.133	2.133
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

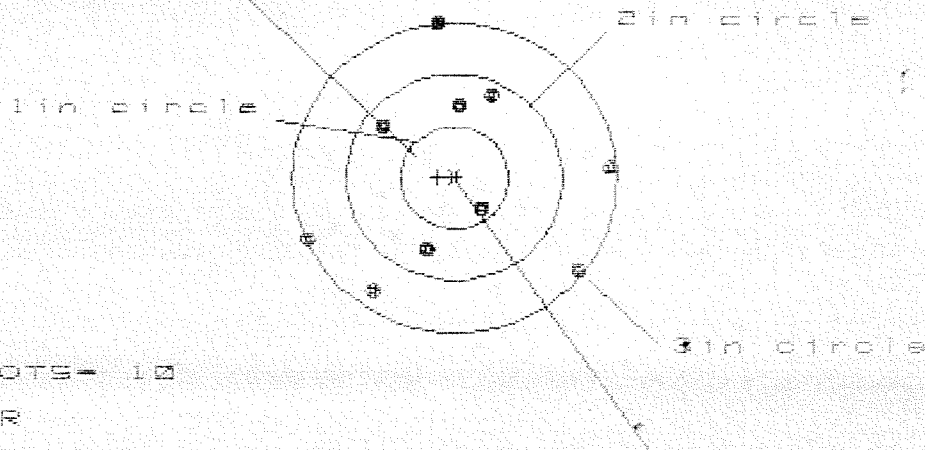
11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06645208

CENTERFIRE PATTERNS

3

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.767

VS = 2.567

GS = 2.852

CENTROID #

PATTERN # : 3

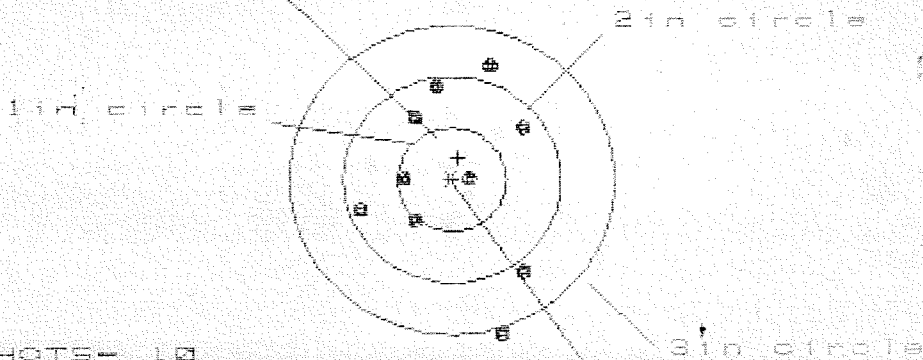
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.392	1.239	1.283
MINIMUM X	-1.375	-1.909	-1.945
MAXIMUM Y	1.463	1.396	.887
MINIMUM Y	-1.104	-1.171	-1.997
CENTROID X	.158	.311	.347
CENTROID Y	-.007	.060	-.114
POA TO CENTROID in.	.158	.316	.365
MIN RADIUS	.387	.355	.182
MEAN RADIUS	1.075	1.015	.950
MAX RADIUS	1.503	1.483	1.374
HORIZONTAL SPREAD	2.767	2.148	2.148
VERTICAL SPREAD	2.567	2.567	1.884
EXTREME SPREAD	2.852	2.653	2.454
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649288

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.464

VS = 2.548

GS = 2.548

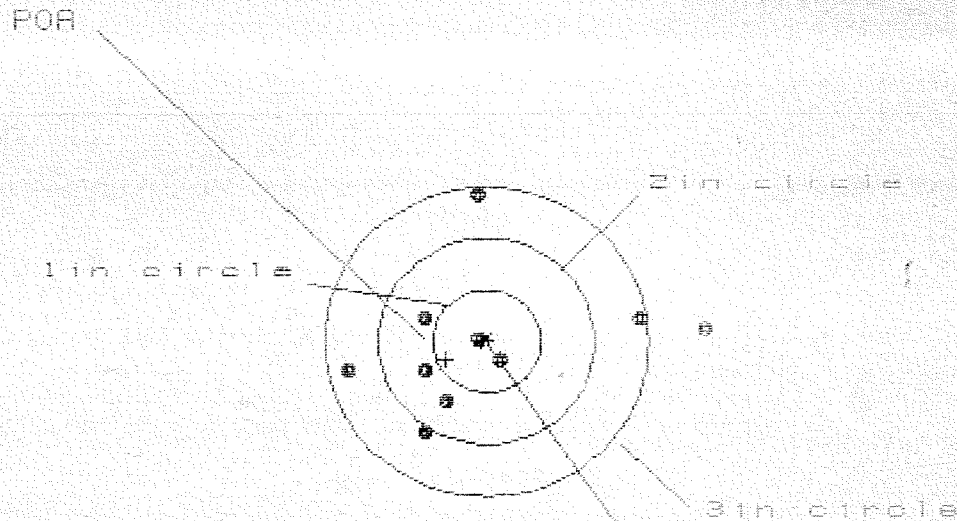
CENTROID *

PATTERN #	1	4	9	8
SHOTS (BEST OF)	10			
MAXIMUM X	.636	.682	.735	
MINIMUM X	-.828	-.782	-.729	
MAXIMUM Y	1.090	.928	.873	
MINIMUM Y	-1.458	-1.013	-.897	
CENTROID X	-.056	-.102	-.155	
CENTROID Y	-.210	-.048	-.164	
POA TO CENTROID in.	.217	.113	.226	
MIN RADIUS	.108	.234	.215	
MEAN RADIUS	.810	.722	.670	
MAX RADIUS	1.515	1.221	1.159	
HORIZONTAL SPREAD	1.464	1.464	1.464	
VERTICAL SPREAD	2.548	1.941	1.770	
EXTREME SPREAD	2.548	1.958	1.953	
NUMBER IN ONE INCH CIRCLE =		2		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		9		

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849208

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.331

VS= 2.291

GS= 3.357

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.006
MINIMUM X	-1.325
MAXIMUM Y	1.399
MINIMUM Y	-0.892
CENTROID X	.380
CENTROID Y	.177
POB TO CENTROID IN.	.419
MIN RADIUS	.043
MEAN RADIUS	.955
MAX RADIUS	2.014
HORIZONTAL SPREAD	3.331
VERTICAL SPREAD	2.291
EXTREME SPREAD	3.357
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649208
16 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.228878
1 TO 2	.0968297
1 TO 3	.525595
1 TO 4	.152266
1 TO 5	.416587

3
5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0296
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0374
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0476961
THE AMR FOR THIS RIFLE IS: 1.001

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849208.1

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS = 2.293

VS = 2.605

GS = 2.858

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.099

1.003

1.831

MINIMUM X

-1.194

-1.290

-1.262

MAXIMUM Y

1.200

1.044

1.970

MINIMUM Y

-1.405

-.933

-.802

CENTROID X

-.224

-.128

-.156

CENTROID Y

-.047

.109

-.022

POA TO CENTROID in.

.229

.168

.158

MIN RADIUS

.526

.660

.534

MEAN RADIUS

1.085

1.015

.996

MAX RADIUS

1.646

1.325

1.279

HORIZONTAL SPREAD

2.293

2.293

2.293

VERTICAL SPREAD

2.605

1.977

1.772

EXTREME SPREAD

2.858

2.309

2.309

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

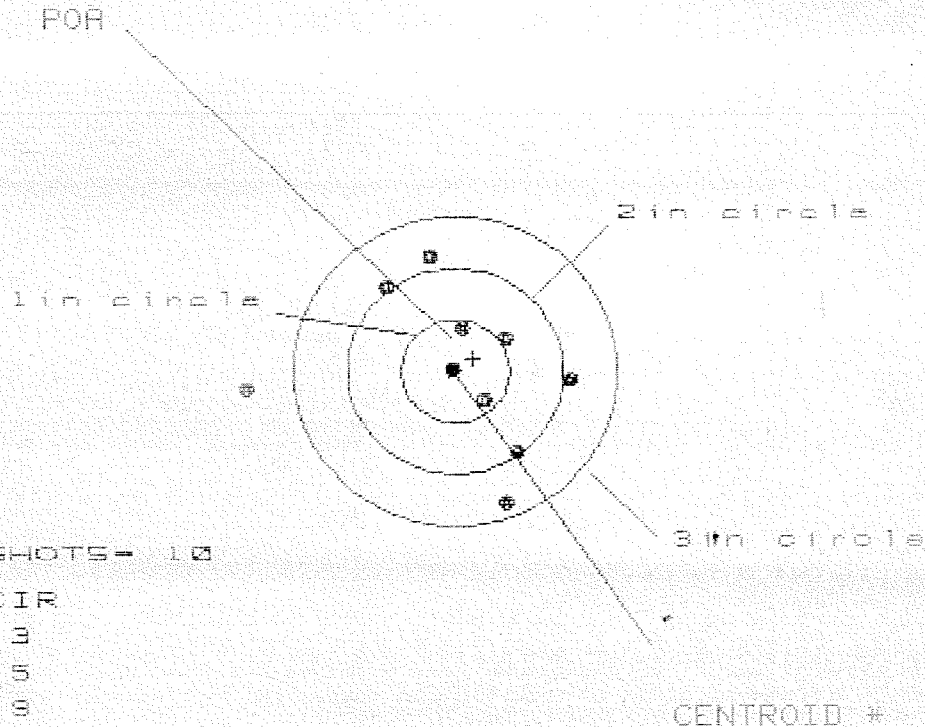
NUMBER IN THREE INCH CIRCLE =

9

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649288.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.960

VS= 2.454

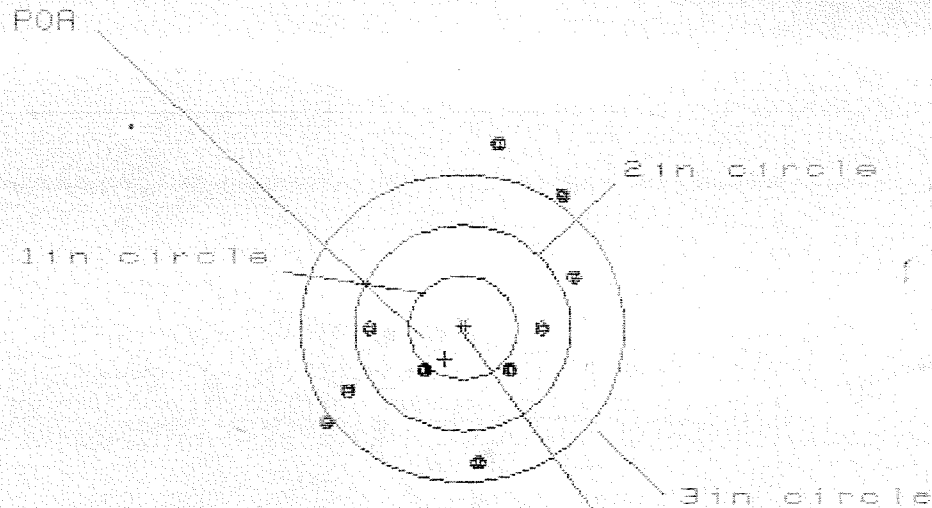
GS= 2.962

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.021
MINIMUM X	:	-1.939
MAXIMUM Y	:	1.132
MINIMUM Y	:	-1.322
CENTROID X	:	-1.164
CENTROID Y	:	-1.123
POA TO CENTROID in.	:	.205
MIN RADIUS	:	.036
MEAN RADIUS	:	.887
MAX RADIUS	:	1.946
HORIZONTAL SPREAD	:	2.960
VERTICAL SPREAD	:	2.454
EXTREME SPREAD	:	2.962
NUMBER IN ONE INCH CIRCLE	=	3
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	9

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649208.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.311

VS= 3.060

GS= 3.180

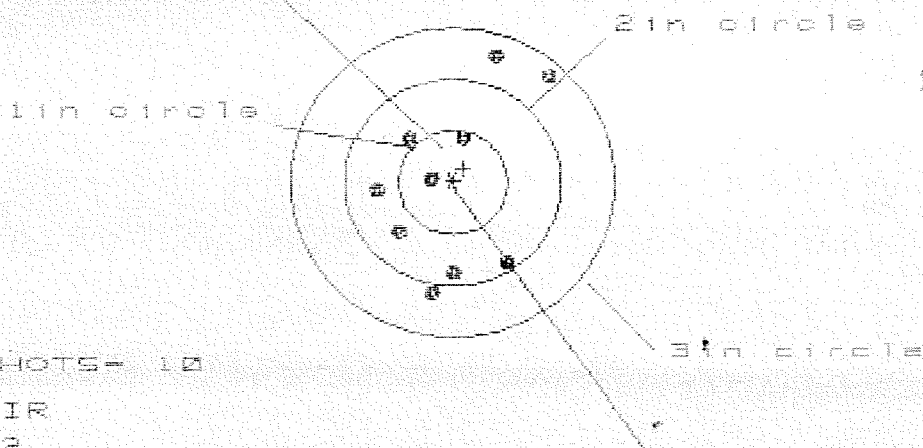
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.009
MINIMUM X	-1.302
MAXIMUM Y	1.786
MINIMUM Y	-1.274
CENTROID X	.169
CENTROID Y	.302
POA TO CENTROID in.	.346
MIN RADIUS	.537
MEAN RADIUS	1.133
MAX RADIUS	1.826
HORIZONTAL SPREAD	2.311
VERTICAL SPREAD	3.060
EXTREME SPREAD	3.180
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649200.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.514

VS= 2.321

GS= 2.393

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.851	.626	.689
MINIMUM X	:	-.663	-.569	-.506
MAXIMUM Y	:	1.256	1.370	.738
MINIMUM Y	:	-1.065	-.951	-.779
CENTROID X	:	-.097	-.191	-.254
CENTROID Y	:	-.131	-.245	-.417
POA TO CENTROID in.	:	.163	.311	.488
MIN RADIUS	:	.204	.210	.360
MEAN RADIUS	:	.811	.734	.633
MAX RADIUS	:	1.337	1.459	.849
HORIZONTAL SPREAD	:	1.514	1.195	1.195
VERTICAL SPREAD	:	2.321	2.321	1.517
EXTREME SPREAD	:	2.393	2.393	1.529
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Sep 1991

FILE:\PATTERNING\CENTERFIRE_PATT\08648208.1

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.536

VS= 2.274

GS= 2.697

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.492	1.495	.728
MINIMUM X	-1.044	-.978	-.691
MAXIMUM Y	1.201	1.247	1.348
MINIMUM Y	-1.073	-1.027	-.926
CENTROID X	.188	.002	-.185
CENTROID Y	-.188	-.234	-.335
POR TO CENTROID in.	.252	.234	.383
MIN RADIUS	.680	.689	.649
MEAN RADIUS	1.090	1.010	.890
MAX RADIUS	1.549	1.701	1.357
HORIZONTAL SPREAD	2.536	2.373	1.419
VERTICAL SPREAD	2.274	2.274	2.274
EXTREME SPREAD	2.697	2.697	2.281
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		