

C6649279

MODEL 700™ M24

Model **SMS**™

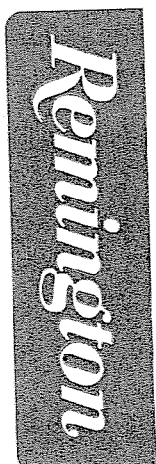
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Still
mead

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.
C6649279

ORDER NO.
5716

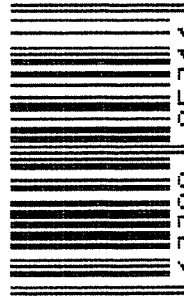
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649279

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649279

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		dw
600	Proof	6 27 91		dw
607	Check Headspace	6 27 91		RW
610	Dis-assemble Gun	6 27 91		dw
612	Magnaflux Barrel Action		1 JUL 2 1991	KR
	Magnaflux Bolt		1 JUL 2 1991	KR
615	Rollmark Caliber		1 JUL 2 1991	LS
617	Drill and Tap Sight Holes		1 JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-8-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-8-91	DH
	G) Safety Off Force	3	3	3 1/2			8-8-91	DH
	H) Trigger Pull Test & Retainability						8-8-91	DH
	I) Firing Pin Indent	.020	.020	.021			8-8-91	DH
	J) Assemble Stock						8/10/91	RW
	K) Assemble Swivel Studs						8/13/91	DH
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	DH
	A) Time						8-12-91	DH
	B) Malfunctions						8-12-91	DH
	C) Pierced Primers						8-12-91	DH
	D) Optical Clarity of Scope						8-12-91	DH
645	Inspect for Live Ammo						8-12-91	DH
655	Final Inspection							
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.67	2.65	2.63	2.64	2.63	8-13-91	DH
	C) Function						8-13-91	DH
660	Pack						9-19-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649279

DATE 8-8-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.60	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.37	2.63	2.65	
PULL #3	2.41	2.36	2.63	2.63	
PULL #4	2.40	2.38	2.59	2.64	
PULL #5	2.41	2.35	2.62	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.38		
PULL #2	3.04	3.35		
PULL #3	3.35	3.34		
PULL #4	3.36	3.31		
PULL #5	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	4.45	4.53		4.17
PULL #2	4.44	4.46		4.18
PULL #3	4.44	4.48		4.23
PULL #4	4.43	4.44		4.23
PULL #5	4.41	4.46		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649279
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.482872
1 TO	2	.212953
1 TO	3	.579884
1 TO	4	.720285
1 TO	5	.432034

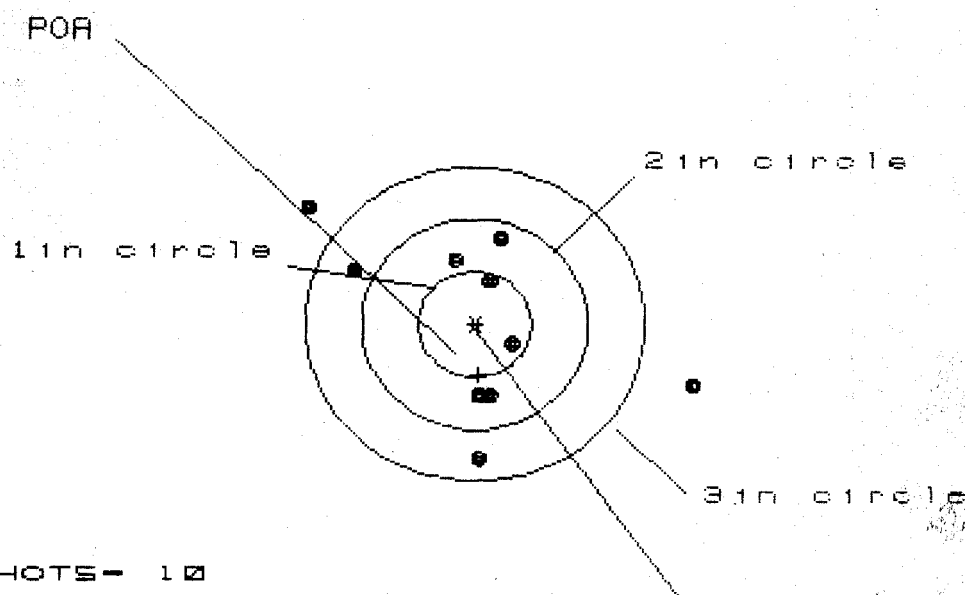
$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.249
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .169
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .300935
THE AMR FOR THIS RIFLE IS: .9828

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649279

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.461

VS= 2.365

GS= 3.856

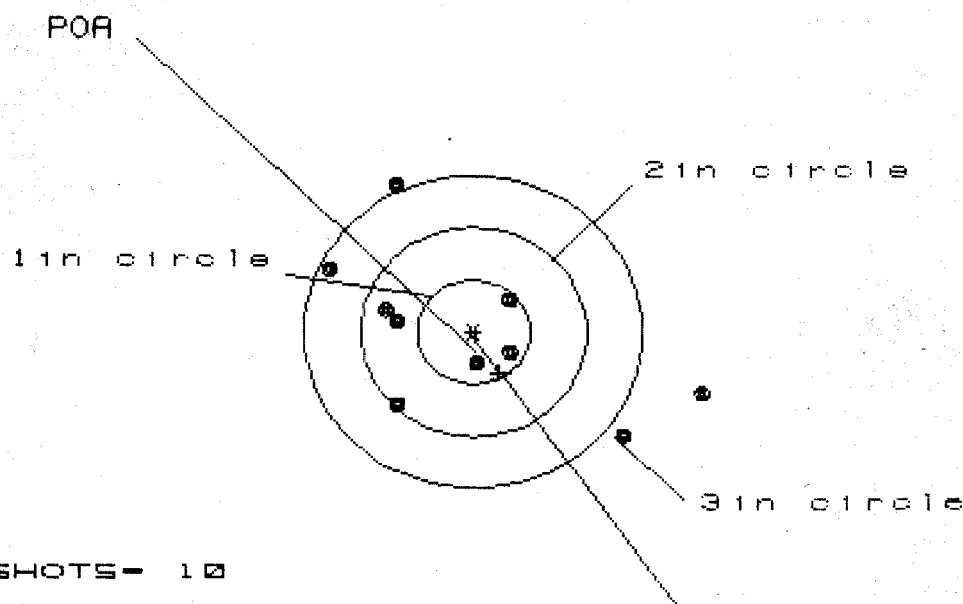
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.962	.501	.341
MINIMUM X	:	-1.499	-1.281	-1.028
MAXIMUM Y	:	1.106	1.040	.841
MINIMUM Y	:	-1.259	-1.325	-1.195
CENTROID X	:	-.029	-.247	-.087
CENTROID Y	:	.482	.548	.418
POA TO CENTROID in.	:	.483	.601	.427
MIN RADIUS	:	.316	.505	.349
MEAN RADIUS	:	1.000	.893	.767
MAX RADIUS	:	2.050	1.650	1.202
HORIZONTAL SPREAD	:	3.461	1.782	1.369
VERTICAL SPREAD	:	2.365	2.365	2.036
EXTREME SPREAD	:	3.856	2.840	2.121
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 3.253

VS= 2.443

GS= 3.473

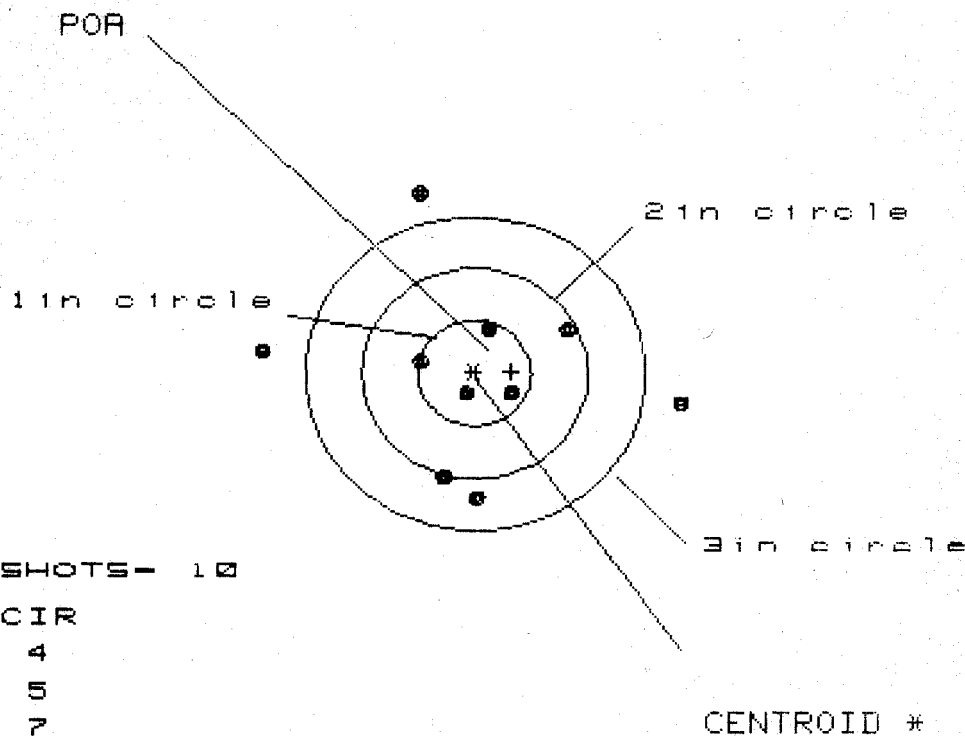
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.031	1.592	.742
MINIMUM X	:	-1.232	-1.006	-.807
MAXIMUM Y	:	1.407	1.345	1.208
MINIMUM Y	:	-1.036	-1.098	-.870
CENTROID X	:	-.222	-.448	-.647
CENTROID Y	:	.392	.454	.591
POA TO CENTROID in.	:	.450	.638	.876
MIN RADIUS	:	.244	.386	.291
MEAN RADIUS	:	1.023	.881	.729
MAX RADIUS	:	2.108	1.934	1.229
HORIZONTAL SPREAD	:	3.263	2.598	1.549
VERTICAL SPREAD	:	2.443	2.443	2.078
EXTREME SPREAD	:	3.473	3.169	2.079
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 3.670

VS= 2.850

GS= 3.710

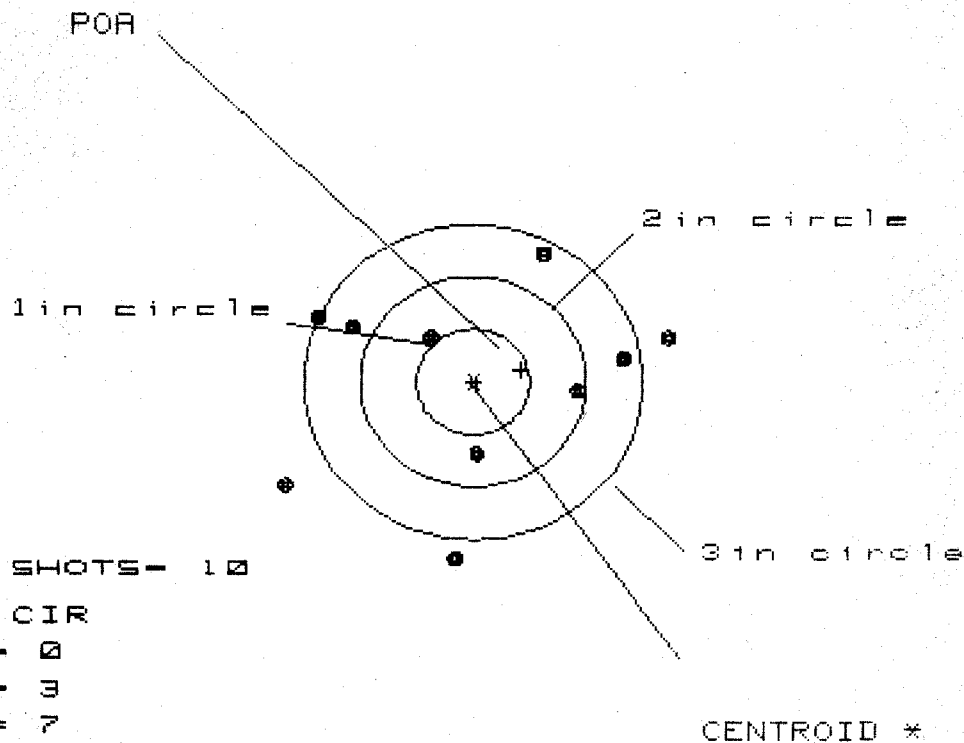
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.827	1.623	.833
MINIMUM X	:	-1.843	-.693	-.491
MAXIMUM Y	:	1.670	1.697	1.663
MINIMUM Y	:	-1.180	-1.153	-1.187
CENTROID X	:	-.321	-.117	-.319
CENTROID Y	:	-.019	-.046	-.012
POA TO CENTROID in.	:	.322	.125	.320
MIN RADIUS	:	.219	.200	.226
MEAN RADIUS	:	1.018	.914	.810
MAX RADIUS	:	1.859	1.834	1.734
HORIZONTAL SPREAD	:	3.670	2.316	1.324
VERTICAL SPREAD	:	2.850	2.850	2.850
EXTREME SPREAD	:	3.710	3.040	2.892
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.361

VS = 2.858

GS = 3.629

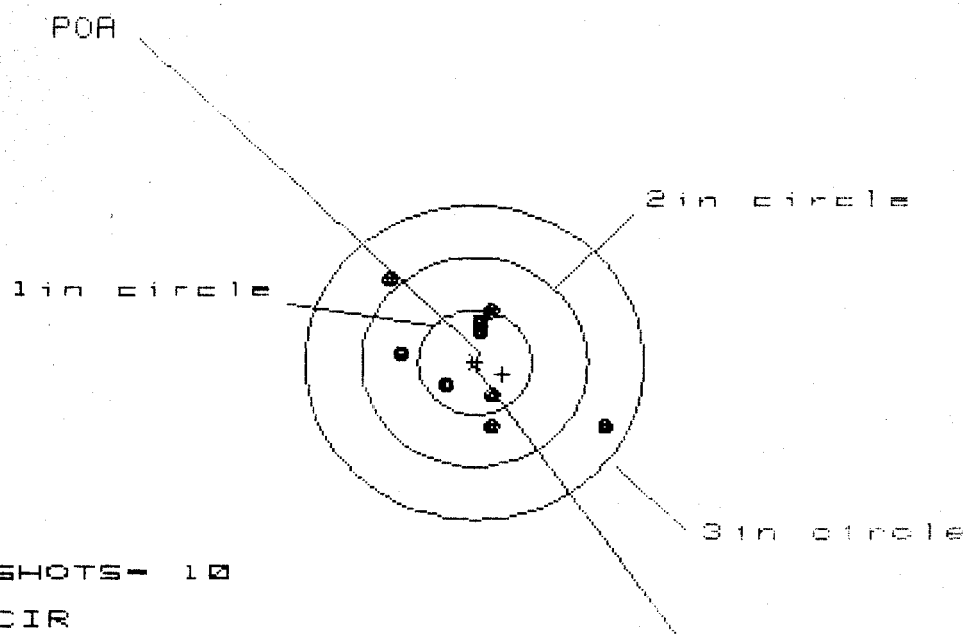
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.686	1.499	1.315
MINIMUM X	:	-1.675	-1.531	-1.343
MAXIMUM Y	:	1.174	1.070	1.111
MINIMUM Y	:	-1.684	-1.788	-1.747
CENTROID X	:	-.426	-.239	-.427
CENTROID Y	:	-.119	-.015	-.056
POA TO CENTROID in.	:	.442	.240	.431
MIN RADIUS	:	.513	.597	.467
MEAN RADIUS	:	1.284	1.197	1.144
MAX RADIUS	:	1.919	1.821	1.754
HORIZONTAL SPREAD	:	3.361	3.030	2.658
VERTICAL SPREAD	:	2.858	2.858	2.858
EXTREME SPREAD	:	3.629	3.038	2.966
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 10

HS= 1.897

VS= 1.382

GS= 2.347

PATTERN #	:	5	9	2
SHOTS (BEST OF)	:	10	9	2
MAXIMUM X	:	1.104	.280	.196
MINIMUM X	:	-.793	-.670	-.645
MAXIMUM Y	:	.771	.703	.507
MINIMUM Y	:	-.611	-.642	-.554
CENTROID X	:	-.247	-.370	-.286
CENTROID Y	:	.109	.177	.089
POA TO CENTROID in.	:	.270	.410	.299
MIN RADIUS	:	.263	.280	.297
MEAN RADIUS	:	.589	.515	.440
MAX RADIUS	:	1.262	.971	.663
HORIZONTAL SPREAD	:	1.897	.950	.841
VERTICAL SPREAD	:	1.382	1.345	1.061
EXTREME SPREAD	:	2.347	1.639	1.089
NUMBER IN ONE INCH CIRCLE =	:	6		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		