

C6649296

MODEL 700™ M24

Model **SMS**™

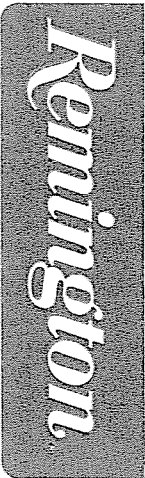
Action

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. C6649296

ORDER NO. 5716

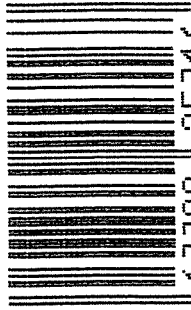
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649296

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649296

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	LS
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	W/B
620	Apply Coatings (Barrel Action)		8-27-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	JH

op. #	BARBER M24 0067449	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9-3-91	SH
	G) Safety Off Force	3	3	3			9-3-91	SH
	H) Trigger Pull Test & Retainability						9-3-91	SH
	I) Firing Pin Indent	1020	1020	1020			9-3-91	SH
	J) Assemble Stock						9/3/91	RW
	K) Assemble Swivel Studs						9-10-91	AC
	L) Attach Front and Rear Sight Assemblies						9/3/91	RW
	M) Iron Sight Alignment						9/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	RW
	O) Attach Scope to Rifle						9/3/91	RW
	P) Detach & Attach Scope 20 Times						9/3/91	RW
640	Gallery Target & Test						9-4-91	AC
	A) Time						9-4-91	AC
	B) Malfunctions						9-4-91	AC
	C) Pierced Primers						9-4-91	AC
	D) Optical Clarity of Scope						9-4-91	AC
645	Inspect for Live Ammo						9-4-91	AC
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	2.51	2.49	2.50	2.50	2.45	9-6-91	SH
	C) Function						9-10-91	AC
660	Pack						9-17-91	DH

BARBER - M24 0067450

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#SERIAL NO. C-6649296DATE 9-3-91TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.51	2.50	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.54	2.55	2.49	
PULL #3	2.33	2.56	2.48	2.50	
PULL #4	2.29	2.56	2.55	2.50	
PULL #5	2.27	2.54	2.50	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.23		
PULL #2	3.46	3.46		
PULL #3	3.42	3.48		
PULL #4	3.44	3.24		
PULL #5	3.44	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	4.40	4.35		4.34
PULL #2	4.38	4.37		4.35
PULL #3	4.29	4.37		4.32
PULL #4	4.34	4.34		4.29
PULL #5	4.37	4.34		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649296
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.0828734
1 TO 2	.281711
1 TO 3	.192094
1 TO 4	.164015
1 TO 5	.38359

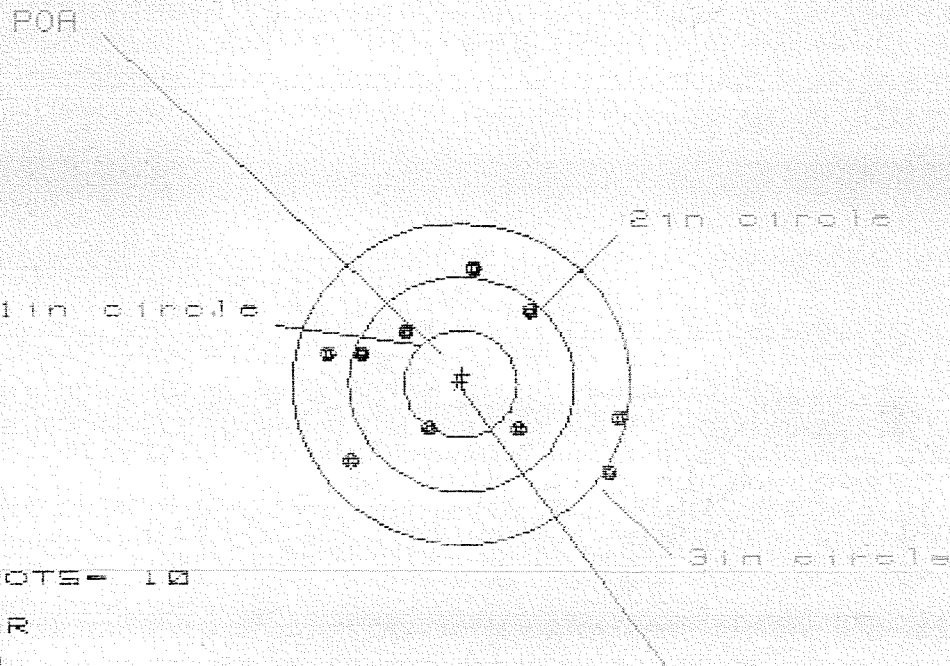
at 5 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0268
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1926
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194456
THE AMR FOR THIS RIFLE IS: 1.023

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649296

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 5

HS= 2.653

VS= 1.876

GS= 2.720

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.436	1.577	.935
MINIMUM X	-1.217	-1.076	-.879
MAXIMUM Y	1.034	.940	.886
MINIMUM Y	-.842	-.811	-.865
CENTROID X	-.012	-.153	-.350
CENTROID Y	-.082	.012	.066
POA TO CENTROID IN.	.083	.153	.356
MIN RADIUS	.501	.493	.351
MEAN RADIUS	1.013	.932	.807
MAX RADIUS	1.519	1.636	1.112
HORIZONTAL SPREAD	2.653	2.653	1.814
VERTICAL SPREAD	1.876	1.751	1.751
EXTREME SPREAD	2.720	2.720	2.144
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

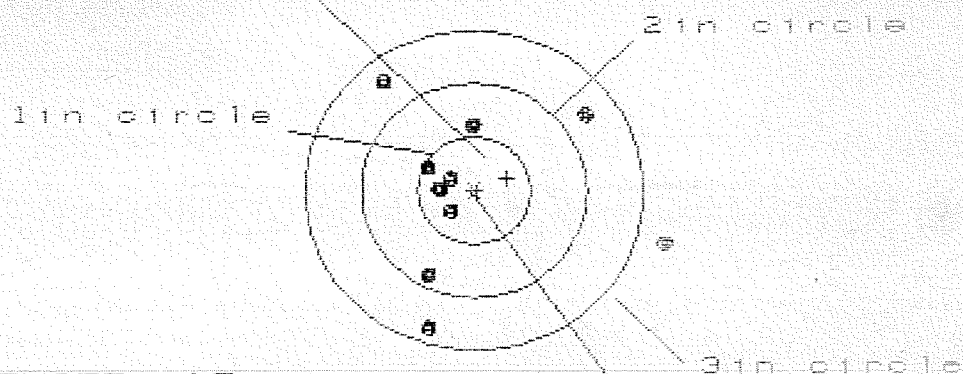
4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8549296

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.462

VS= 2.332

GS= 2.886

CENTROID *

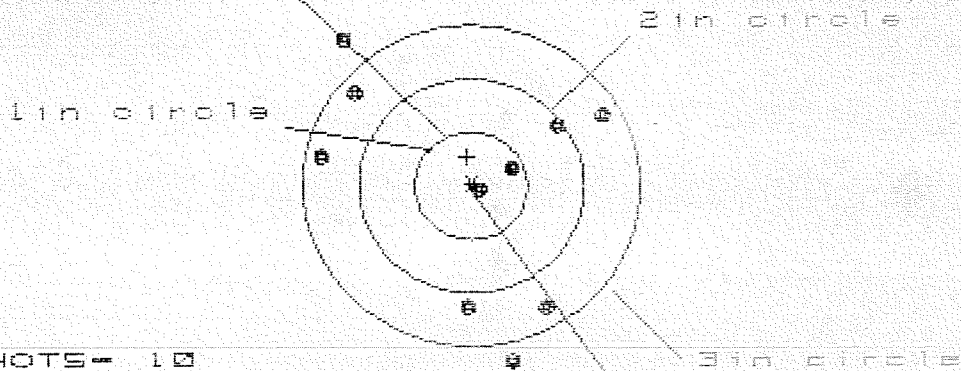
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.649	1.221	1.193
MINIMUM X	:	-0.813	-0.629	-0.657
MAXIMUM Y	:	1.047	0.996	0.829
MINIMUM Y	:	-1.285	-1.336	-1.021
CENTROID X	:	-0.292	-0.476	-0.448
CENTROID Y	:	-0.113	-0.062	0.105
POA TO CENTROID in.	:	0.313	0.480	0.460
MIN RADIUS	:	0.226	0.086	0.065
MEAN RADIUS	:	0.835	0.673	0.593
MAX RADIUS	:	1.712	1.365	1.273
HORIZONTAL SPREAD	:	2.462	1.850	1.850
VERTICAL SPREAD	:	2.332	2.332	1.850
EXTREME SPREAD	:	2.886	2.424	2.050
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.509

VS= 2.956

GS= 3.295

CENTROID *

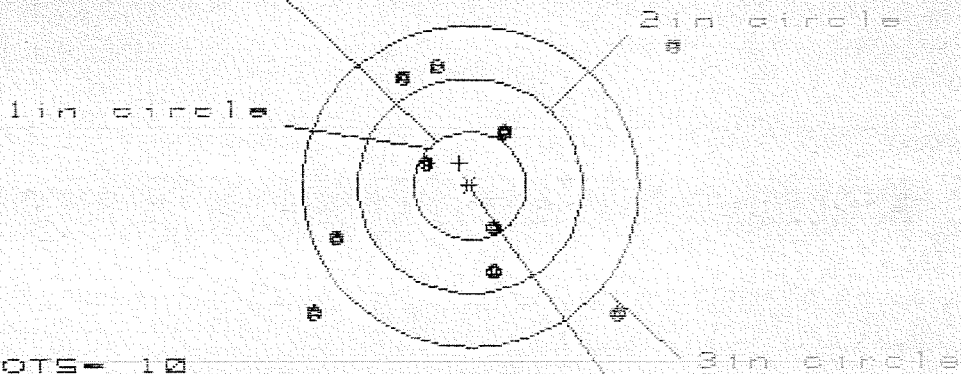
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.197	1.072	1.097
MINIMUM X	-1.312	-1.437	-1.412
MAXIMUM Y	1.341	1.030	.846
MINIMUM Y	-1.615	-1.465	-1.170
CENTROID X	.036	.161	.136
CENTROID Y	-.268	-.418	-.234
POA TO CENTROID in.	.271	.448	.271
MIN RADIUS	.109	.107	.080
MEAN RADIUS	1.137	1.049	.975
MAX RADIUS	1.753	1.518	1.434
HORIZONTAL SPREAD	2.509	2.509	2.509
VERTICAL SPREAD	2.956	2.495	2.016
EXTREME SPREAD	3.295	2.822	2.627
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.158

VS = 2.548

GS = 4.058

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.787	1.516	1.369
MINIMUM X	:	-1.371	-1.173	-1.160
MAXIMUM Y	:	1.308	1.276	1.139
MINIMUM Y	:	-1.240	-1.095	-1.212
CENTROID X	:	.093	-.105	.041
CENTROID Y	:	-.208	-.353	-.216
POA TO CENTROID in.	:	.228	.369	.220
MIN RADIUS	:	.450	.457	.455
MEAN RADIUS	:	1.185	1.060	.971
MAX RADIUS	:	2.214	1.958	1.828
HORIZONTAL SPREAD	:	3.158	2.689	2.529
VERTICAL SPREAD	:	2.548	2.371	2.351
EXTREME SPREAD	:	4.058	2.906	2.906
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID X

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.343

VS = 2.409

GS = 3.138

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.441	.823	.730
MINIMUM X	-.902	-.742	-.596
MAXIMUM Y	1.335	1.251	1.012
MINIMUM Y	-1.074	-1.158	-1.002
CENTROID X	.309	.149	.242
CENTROID Y	-.292	-.208	-.364
POA TO CENTROID in.	.425	.256	.437
MIN RADIUS	.140	.278	.099
MEAN RADIUS	.943	.871	.770
MAX RADIUS	1.626	1.454	1.165
HORIZONTAL SPREAD	2.343	1.565	1.326
VERTICAL SPREAD	2.409	2.409	2.014
EXTREME SPREAD	3.138	2.421	2.258
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		