

C6611605

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

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.
C6611605

ORDER NO.
5716

4-6

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



5716 C6611605

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611605

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 91		RW
600	Proof	2 1 91		RW
607	Check Headspace	2 1 91		RW
610	Dis-assemble Gun	2 1 91		RW
612	Magnaflux Barrel Action	2 1 1 91		Kcd
	Magnaflux Bolt	2 1 1 91		Kcd
615	Rollmark Caliber	2 1 1 91		GB
617	Drill and Tap Sight Holes	2 1 3 91		FB
618	Polish Barrel RBB	2 1 3 91		WB
620	Apply Coatings (Barrel Action)		3-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/2/91	JB

op. #	BARBER - M24 0079498 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	3	4			4-4-91	DA
	G) Safety Off Force	2	2	2			4-4-91	DA
	H) Trigger Pull Test & Retainability						4/2/91	JP
	I) Firing Pin Indent	.021	.021	.021			4-4-91	DA
	J) Assemble Stock						4/12/91	RW
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/13/91	RW
	M) Iron Sight Alignment						4/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	RW
	O) Attach Scope to Rifle						4/12/91	RW
	P) Detach & Attach Scope 20 Times						4/12/91	RW
640	Gallery Target & Test						4/12/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/12/91	KS
655	Final Inspection							
	A) Headspace						4-17-91	A
	B) Trigger Pull	2.32	2.39	2.43	2.43	2.43	4/16/91	JP
	C) Function						4-17-91	A
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611605

DATE 4/2/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.48	2.43	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.47	2.45	2.39	
PULL #3	2.38	2.47	2.48	2.43	
PULL #4	2.42	2.46	2.48	2.43	
PULL #5	2.41	2.46	2.47	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.48		
PULL #2	3.49	3.42		
PULL #3	3.47	3.51		
PULL #4	3.47	3.46		
PULL #5	3.33	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.24		4.27
PULL #2	4.21	4.27		4.29
PULL #3	4.26	4.25		4.25
PULL #4	4.23	4.23		4.27
PULL #5	4.27	4.22		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611605
12 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.333017
1 TO	2	.421385
1 TO	3	.407947
1 TO	4	.226497
1 TO	5	.49746

236
145 <----POA

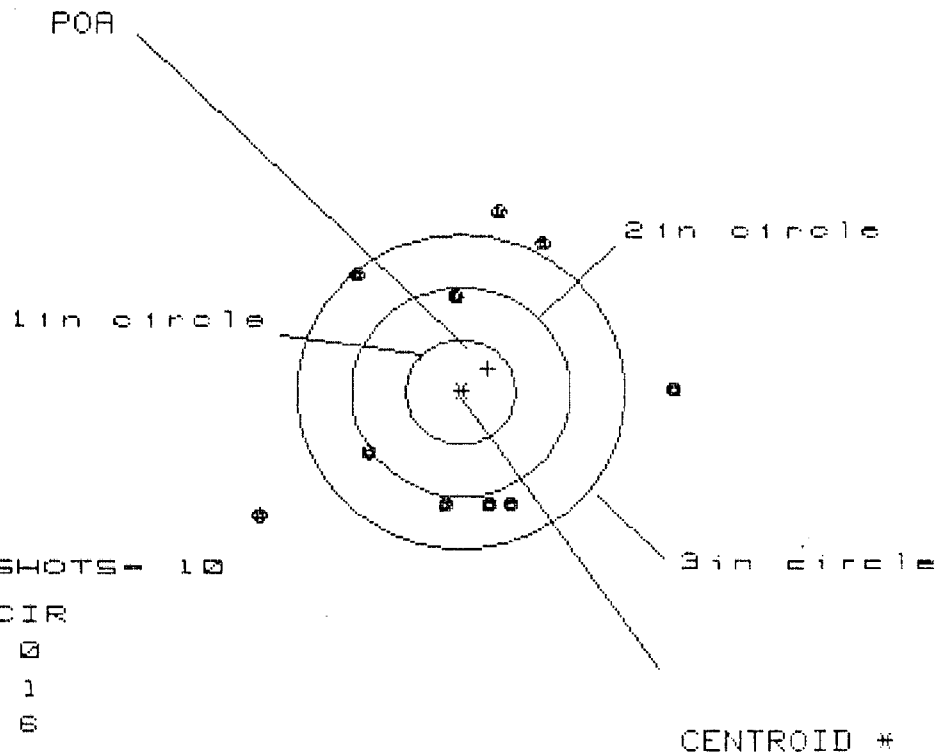
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0894
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0184
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0912739
THE AMR FOR THIS RIFLE IS: .9874

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611685

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 1

3 in = 6

HS= 3.783

VS= 2.857

GS= 3.959

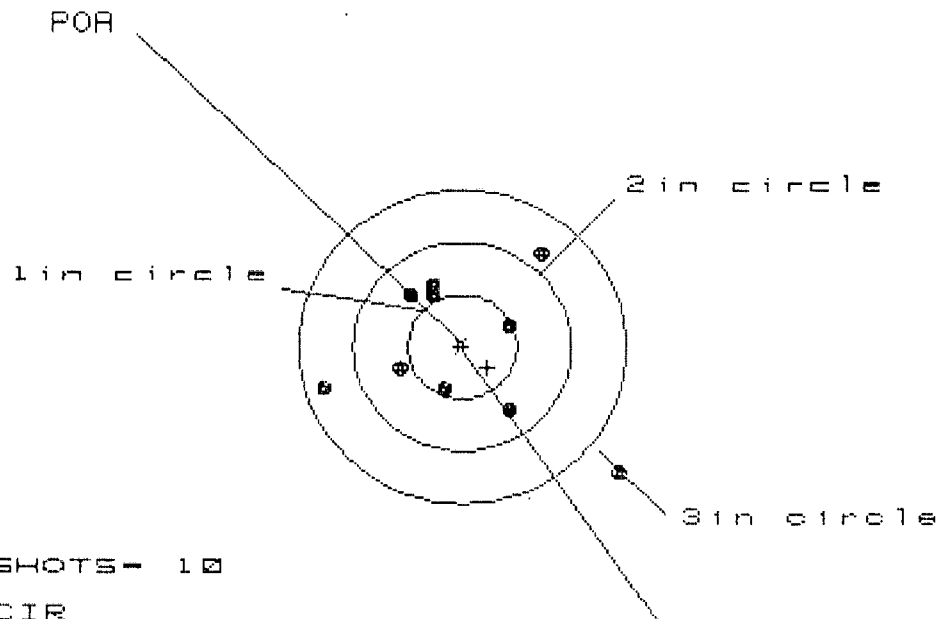
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.948	1.744	.784
MINIMUM X	-1.835	-1.196	-.978
MAXIMUM Y	1.688	1.558	1.541
MINIMUM Y	-1.169	-1.252	-1.269
CENTROID X	-.250	-.046	-.264
CENTROID Y	-.220	-.090	-.073
POA TO CENTROID in.	.333	.101	.274
MIN RADIUS	.919	.815	.772
MEAN RADIUS	1.433	1.346	1.275
MAX RADIUS	2.176	1.749	1.581
HORIZONTAL SPREAD	3.783	2.940	1.762
VERTICAL SPREAD	2.857	2.810	2.810
EXTREME SPREAD	3.959	3.144	2.811
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	6		

12 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.679

VS = 2.056

GS = 2.771

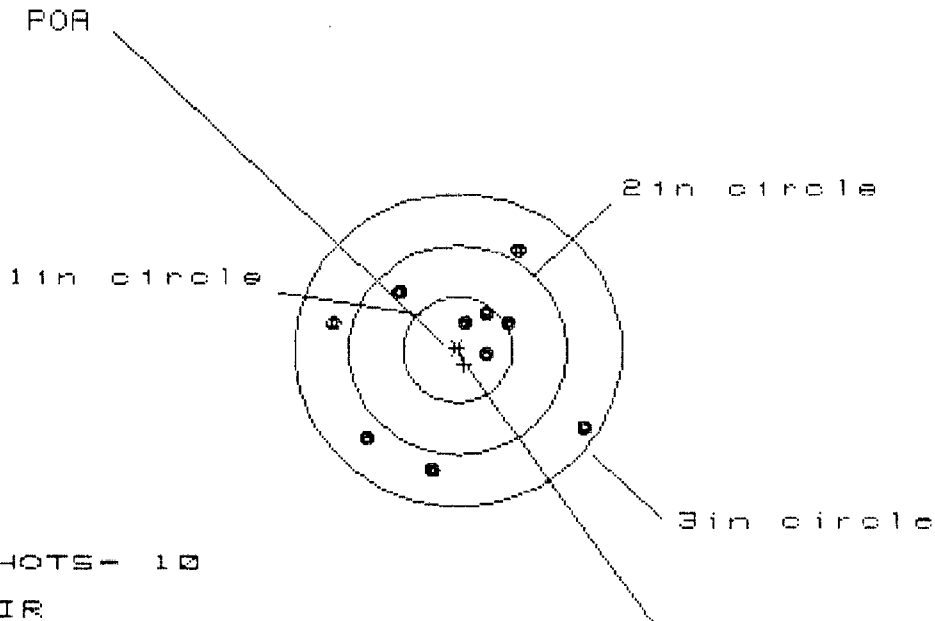
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	.866	.728
MINIMUM X	:	-1.257	-1.099	-.575
MAXIMUM Y	:	.904	.776	.705
MINIMUM Y	:	-1.152	-.700	-.771
CENTROID X	:	-.232	-.390	-.252
CENTROID Y	:	.201	.329	.400
POR TO CENTROID in.	:	.307	.510	.473
MIN RADIUS	:	.430	.437	.440
MEAN RADIUS	:	.856	.717	.647
MAX RADIUS	:	1.830	1.238	1.013
HORIZONTAL SPREAD	:	2.679	1.965	1.303
VERTICAL SPREAD	:	2.056	1.476	1.476
EXTREME SPREAD	:	2.771	2.382	1.714
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS = 2.269

VS = 2.081

GS = 2.489

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.158	.701	.686
MINIMUM X	-1.111	-.983	-.998
MAXIMUM Y	.963	.876	.725
MINIMUM Y	-1.118	-1.205	-1.042
CENTROID X	-.060	-.188	-.173
CENTROID Y	.141	.228	.379
POA TO CENTROID in.	.153	.296	.417
MIN RADIUS	.263	.297	.207
MEAN RADIUS	.832	.768	.681
MAX RADIUS	1.399	1.212	1.258
HORIZONTAL SPREAD	2.269	1.684	1.684
VERTICAL SPREAD	2.081	2.081	1.767
EXTREME SPREAD	2.489	2.248	2.248
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Apr 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.484

VS= 2.234

GS= 3.229

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.175	1.289	1.139
MINIMUM X	:	-1.309	-1.195	-1.198
MAXIMUM Y	:	1.382	.851	.764
MINIMUM Y	:	-.852	-.698	-.784
CENTROID X	:	-.076	-.190	-.040
CENTROID Y	:	-.075	-.229	-.142
POA TO CENTROID in.	:	.107	.297	.147
MIN RADIUS	:	.370	.522	.351
MEAN RADIUS	:	.976	.898	.805
MAX RADIUS	:	1.720	1.384	1.248
HORIZONTAL SPREAD	:	2.484	2.484	2.337
VERTICAL SPREAD	:	2.234	1.549	1.547
EXTREME SPREAD	:	3.229	2.719	2.431
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Apr 1991

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.540

VS= 1.916

GS= 2.977

CENTROID +

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.966	.680	.735
MINIMUM X	:	-1.674	-.850	-.795
MAXIMUM Y	:	1.124	1.040	.600
MINIMUM Y	:	-.792	-.876	-.746
CENTROID X	:	.171	.357	.302
CENTROID Y	:	.045	.129	-.001
POA TO CENTROID in.	:	.177	.380	.302
MIN RADIUS	:	.167	.274	.137
MEAN RADIUS	:	.840	.730	.657
MAX RADIUS	:	1.838	1.132	.915
HORIZONTAL SPREAD	:	2.540	1.530	1.530
VERTICAL SPREAD	:	1.916	1.916	1.346
EXTREME SPREAD	:	2.977	1.991	1.768
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	