

C6349039

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349039

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1-12	90	RW
600	Proof	1 12	90	A
607	Check Headspace	1 12	90	A
610	Dis-assemble Gun	1-12	90	RW
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber		1/17/90	ES
617	Drill and Tap Sight Holes		1/19/90	FB
618	Polish Barrel RB		1/20/90	WB
620	Apply Coatings (Barrel Action)		1/20/90	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/2/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/2/90	RW
	C) Inspect Ejector Hole for Chamfer		2/2/90	RW
	D) Oil Firing Pin Ass'y		2/2/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-6-90	JP

op. #	BARBER - M24 0106379 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/7/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/4			7/7/90	WB
	H) Trigger Pull Test & Retainability						2-6-90	JCL
	I) Firing Pin Indent	.0204	.0204	.021			7/7/90	WB
	J) Assemble Stock						9/4/90	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						9/14/90	RW
	M) Iron Sight Alignment						9/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/14/90	RW
	O) Attach Scope to Rifle						9/14/90	RW
	P) Detach & Attach Scope 20 Times						9/14/90	RW
640	Gallery Target & Test						9/14/90	
	A) Time						9/14/90	
	B) Malfunctions						9/14/90	
	C) Pierced Primers						9/14/90	
	D) Optical Clarity of Scope						9/14/90	
645	Inspect for Live Ammo						9/14/90	
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.52	2.57	2.56	2.53	2.54	9-15-90	JCL
	C) Function							
660	Pack						9/19/90	RF

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

SERIAL NO. C6349039
DATE 9/14/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.38	2.52	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.53	2.48	2.57	
PULL #3	2.50	2.57	2.41	2.56	
PULL #4	2.49	2.55	2.37	2.53	
PULL #5	2.47	2.52	2.35	2.54	
TOTAL	12.26	12.55	12.13	12.76	
AVG.	2.45	2.51	2.42	2.552	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.15		
PULL #2	3.10	3.16		
PULL #3	3.10	3.18		
PULL #4	3.04	3.11		
PULL #5	3.06	3.15		
TOTAL	15.44	15.75		
AVG.	3.09	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.10		3.95
PULL #2	4.19	4.04		3.90
PULL #3	4.10	4.02		3.94
PULL #4	4.10	4.27		3.90
PULL #5	4.08	4.15		3.95
TOTAL	20.66	20.58		19.64
AVG.	4.13	4.12		3.93

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349039
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.298814
1 TO	2	.150987
1 TO	3	.32839
1 TO	4	.272485
1 TO	5	.17254

& <----POA

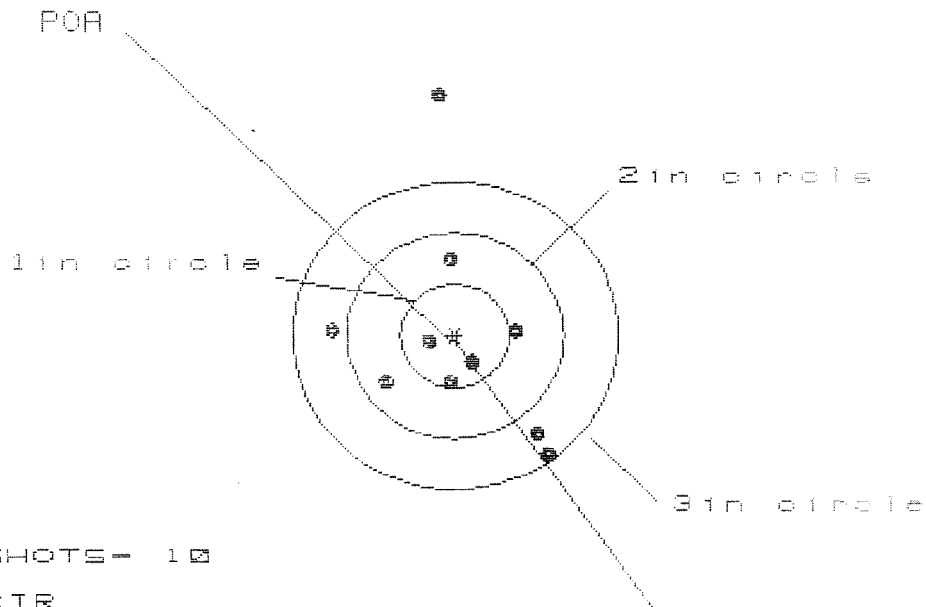
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0328
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1618
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .165091
THE BMR FOR THIS RIFLE IS: 1.071

14 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6349039

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.020

VS= 3.548

GS= 3.696

CENTROID #

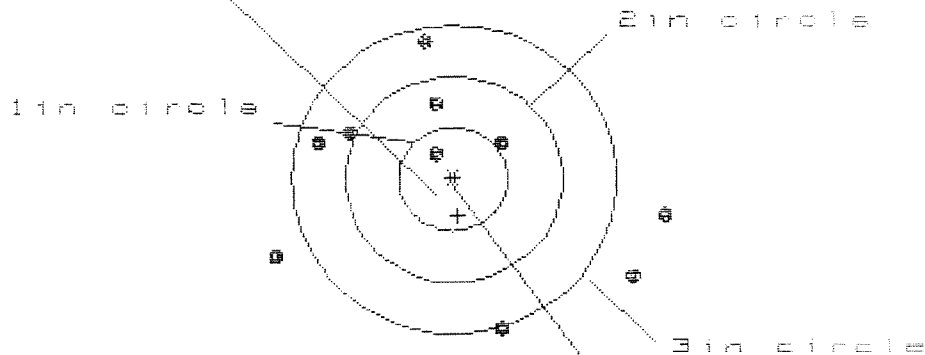
PATTERN #	1	2	3
SHOTS BEST OF	10	9	8
HS	.851	.831	.839
VS	-1.169	-1.189	-1.085
GS	2.367	1.009	.894
HS	-1.181	-.918	-.774
VS	-.159	-.139	-.243
GS	.253	-.010	.105
HS	.299	.139	.265
VS	.146	.199	.649
GS	.717	1.239	1.142
HS	2.020	1.924	1.668
VS	1.927	2.370	2.166
GS	3	5	

14 Sep 1990

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CENTERFIRE PATTERNS # 2

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 3.593

VS = 2.794

GS = 3.815

CENTROID #

PATTERN #	:	2		
SPOTS (BEST OF)	:	10	9	8
MAXIMUM	:	1.938	1.820	.878
MINIMUM	:	-1.655	-1.440	-1.212
AVERAGE	:	1.389	1.346	1.220
STANDARD	:	-1.405	-1.448	-1.575
COEFFICIENT	:	.045	-.260	-.488
COEFFICIENT	:	.352	.395	.522
COEFFICIENT	:	.355	.473	.714
COEFFICIENT	:	.34	.237	.341
COEFFICIENT	:		1.142	.985
COEFFICIENT	:		2.082	1.803
COEFFICIENT	:		3.260	2.890
COEFFICIENT	:		2.794	2.794
COEFFICIENT	:		3.265	2.884
COEFFICIENT	:		1	
COEFFICIENT	:		3	
COEFFICIENT	:		5	

14 Sep 1998

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 4

3in = 6

HS= 1.910

VS= 4.652

GS= 4.771

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.980	1.047	.999
MINIMUM X	:	-.930	-.863	-.911
MAXIMUM Y	:	2.146	1.868	1.164
MINIMUM Y	:	-2.506	-1.882	-1.649
CENTROID X	:	.113	.046	.094
CENTROID Y	:	.069	.347	.114
POA TO CENTROID (in)	:	.132	.350	.147
MAX ERROR	:	.303	.108	.255
MAX FALL	:	.171	.972	.860
MAX RISE	:		1.990	1.754
MAX DOWN	:		1.910	1.910
MAX UP	:		3.750	2.813
MAX STR	:		3.890	2.841
MAX DOWN (in)	:		4	
MAX UP (in)	:		4	
MAX STR (in)	:		6	

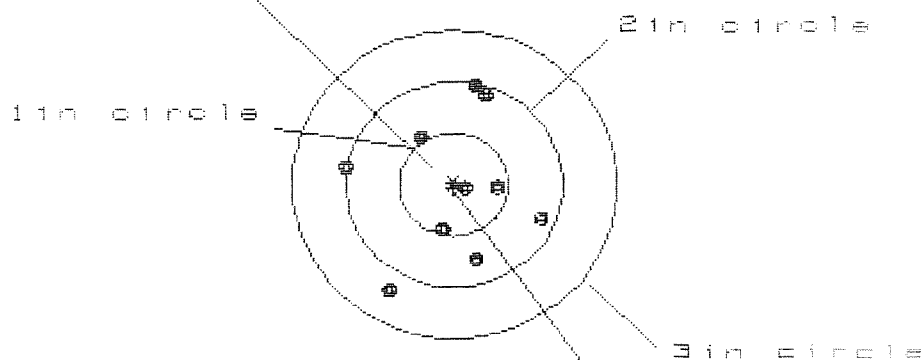
14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349033

CENTERFIRE PATTERNS

4

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.741

VS= 2.039

GS= 2.200

CENTROID #

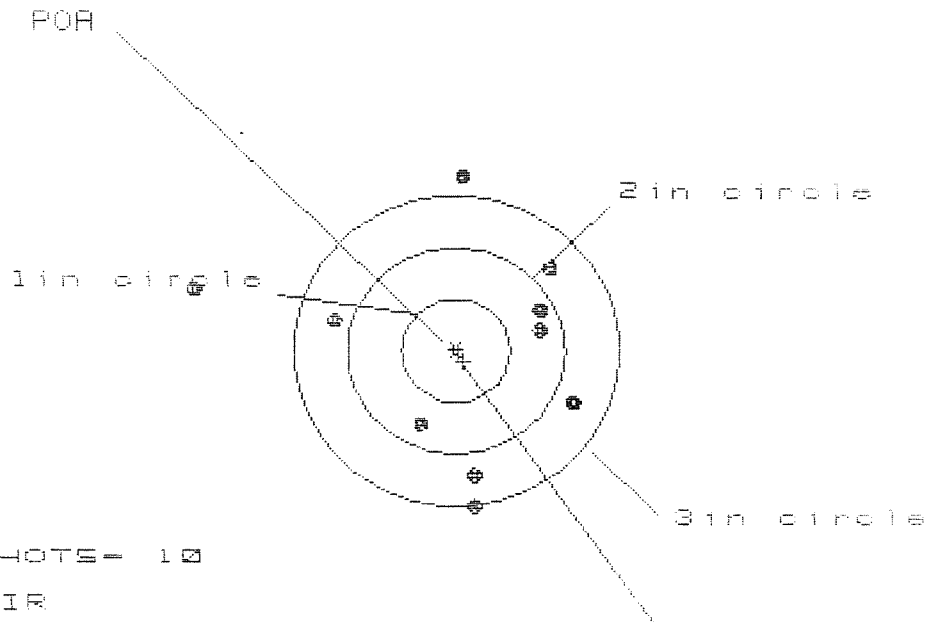
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.753
MINIMUM X	-.988
MAXIMUM Y	1.008
MINIMUM Y	-1.031
CENTROID X	-.001
CENTROID Y	.031
FOR TO CENTROID DIST	.031
MIN RADIUS	.123
MEAN RADIUS	.171
MAX RADIUS	.662
ARC RADIUS	1.059
HORIZONTAL CENTER	1.741
VERTICAL CENTER	1.695
EXTREME SPREAD	1.800
NUMBER IN ONE INCH	3
NUMBER IN TWO INCH	7
NUMBER IN THREE INCH	10

14 Sep 1993

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CENTERFIRE PATTERNS

5



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 7

HS = 3.316

VS = 3.189

GS = 3.686

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.055	.782	.754
MINIMUM X	-2.461	-1.377	-1.405
MAXIMUM Y	1.646	1.712	1.036
MINIMUM Y	-1.543	-1.477	-1.263
CENTROID X	-.072	.201	.229
CENTROID Y	.104	.038	-.176
POA TO CENTROID (in)	.127	.205	.289
MIN RADIUS	.769	.545	.665
MEDIAN RADIUS	1.093	1.093	.999
MAX RADIUS	1.726	1.726	1.527
HORIZONTAL SPREAD (in)	2.159	2.159	2.159
VERTICAL SPREAD (in)	3.189	3.189	2.299
EXTREMES SPREAD (in)	3.193	3.193	2.388
NUMBER IN ONE IN	0	0	0
NUMBER IN TWO IN	3	3	3
NUMBER IN THREE IN	7	7	7

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6349039

ORDER NO.
5716

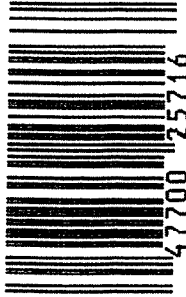
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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5716 C6349039

UPC



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