

C6349067

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349067

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		GB
617	Drill and Tap Sight Holes	1-19-90		EB
618	Polish Barrel RB	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-28-90	TJA
	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		2/4/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4			2-2-90	JU
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2-2-90	JU
	H) Trigger Pull Test & Retainability						9/4/90	CSB
	I) Firing Pin Indent	.022	.022	.022			2-2-90	JU
	J) Assemble Stock						9/6/90	RW
	K) Assemble Swivel Studs						9/9/90	JDS
	L) Attach Front and Rear Sight Assemblies						9/6/90	RW
	M) Iron Sight Alignment						9/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/90	RW
	O) Attach Scope to Rifle						9/6/90	RW
	P) Detach & Attach Scope 20 Times						9/6/90	RW
640	Gallery Target & Test						7-8-90	J
	A) Time						"	J
	B) Malfunctions						"	J
	C) Pierced Primers						"	J
	D) Optical Clarity of Scope						"	J
645	Inspect for Live Ammo						7-8-90	J
655	Final Inspection							
	A) Headspace						9/9/90	JDS
	B) Trigger Pull	275	265	264	263	275	9/9/90	JDS
	C) Function						9/9/90	JDS
660	Pack						9-18-90	JU

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349067

DATE 9/4/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.37	2.41	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.39	2.32	2.65	
PULL #3	2.50	2.25	2.38	2.64	
PULL #4	2.59	2.40	2.38	2.63	
PULL #5	2.51	2.49	2.35	2.75	
TOTAL	12.80	11.90	11.84		
AVG.	2.56	2.38	2.37		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.00		
PULL #2	3.25	3.13		
PULL #3	3.22	3.14		
PULL #4	3.11	3.19		
PULL #5	3.17	3.20		
TOTAL	15.93	15.66		
AVG.	3.18	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.01		4.00
PULL #2	4.09	4.01		4.06
PULL #3	4.05	4.04		4.04
PULL #4	4.00	4.06		4.07
PULL #5	4.00	4.07		4.07
TOTAL	20.28	20.19		20.24
AVG.	4.05	4.04		4.05

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349067
8 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	.0338378
1 TO 2	.400292
1 TO 3	.298617
1 TO 4	.431668
1 TO 5	.30181

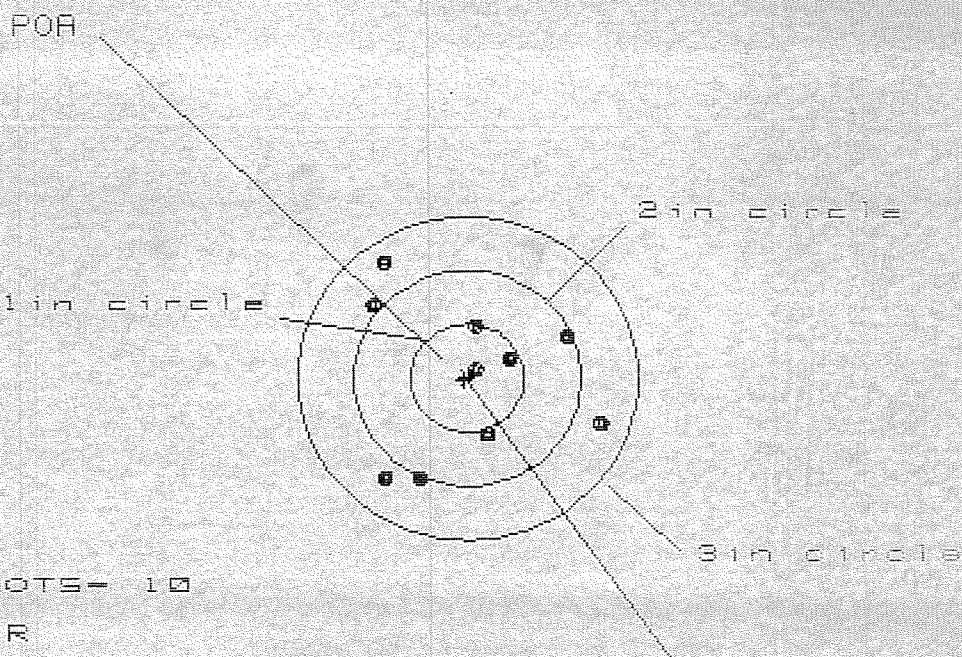
13 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .276339
THE AMR FOR THIS RIFLE IS: .8412

8 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349067

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.998

VS= 1.978

GS= 2.430

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.187	1.103	.891
MINIMUM X	:	-.811	-.895	-.757
MAXIMUM Y	:	1.034	.796	.756
MINIMUM Y	:	-.944	-.829	-.869
CENTROID X	:	.028	.112	-.026
CENTROID Y	:	.019	-.096	-.056
POA TO CENTROID in.	:	.034	.147	.062
MIN RADIUS	:	.050	.168	.143
MEAN RADIUS	:	.818	.766	.719
MAX RADIUS	:	1.279	1.197	1.070
HORIZONTAL SPREAD	:	1.998	1.998	1.648
VERTICAL SPREAD	:	1.978	1.625	1.625
EXTREME SPREAD	:	2.430	2.286	2.021
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8349067

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.597

VS= 1.596

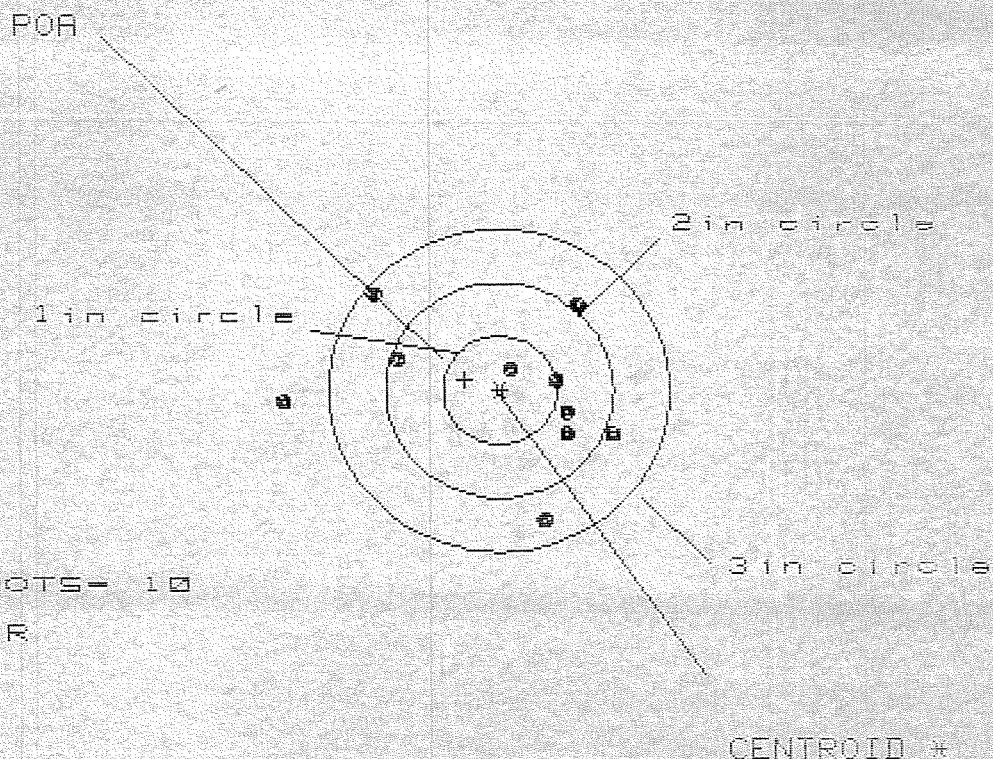
GS= 2.665

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.567	1.408	1.076
MINIMUM X	:	-1.030	-.856	-.680
MAXIMUM Y	:	.788	.757	.777
MINIMUM Y	:	-.808	-.839	-.819
CENTROID X	:	.373	.199	.023
CENTROID Y	:	-.184	-.153	-.173
POA TO CENTROID in.	:	.416	.252	.175
MIN RADIUS	:	.148	.324	.493
MEAN RADIUS	:	.902	.816	.731
MAX RADIUS	:	1.590	1.417	1.100
HORIZONTAL SPREAD	:	2.597	2.264	1.756
VERTICAL SPREAD	:	1.596	1.596	1.596
EXTREME SPREAD	:	2.665	2.303	1.850
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.908

VS= 2.130

GS= 2.917

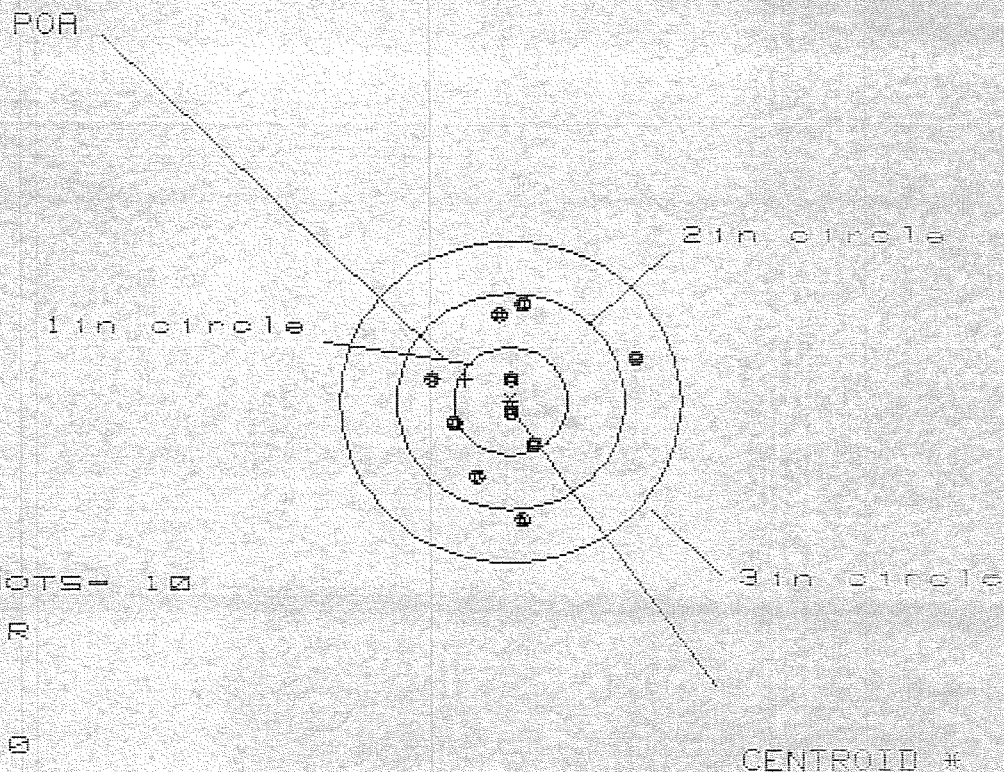
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.993	.780	.620
MINIMUM X	-1.915	-1.282	-1.231
MAXIMUM Y	.912	.897	.911
MINIMUM Y	-1.218	-1.233	-1.120
CENTROID X	.304	.517	.677
CENTROID Y	-.095	-.080	-.193
POA TO CENTROID in.	.318	.523	.704
MIN RADIUS	.248	.255	.225
MEAN RADIUS	.975	.810	.669
MAX RADIUS	1.919	1.565	1.290
HORIZONTAL SPREAD	2.908	2.062	1.851
VERTICAL SPREAD	2.130	2.130	2.032
EXTREME SPREAD	2.917	2.571	2.057
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.805

VS= 1.927

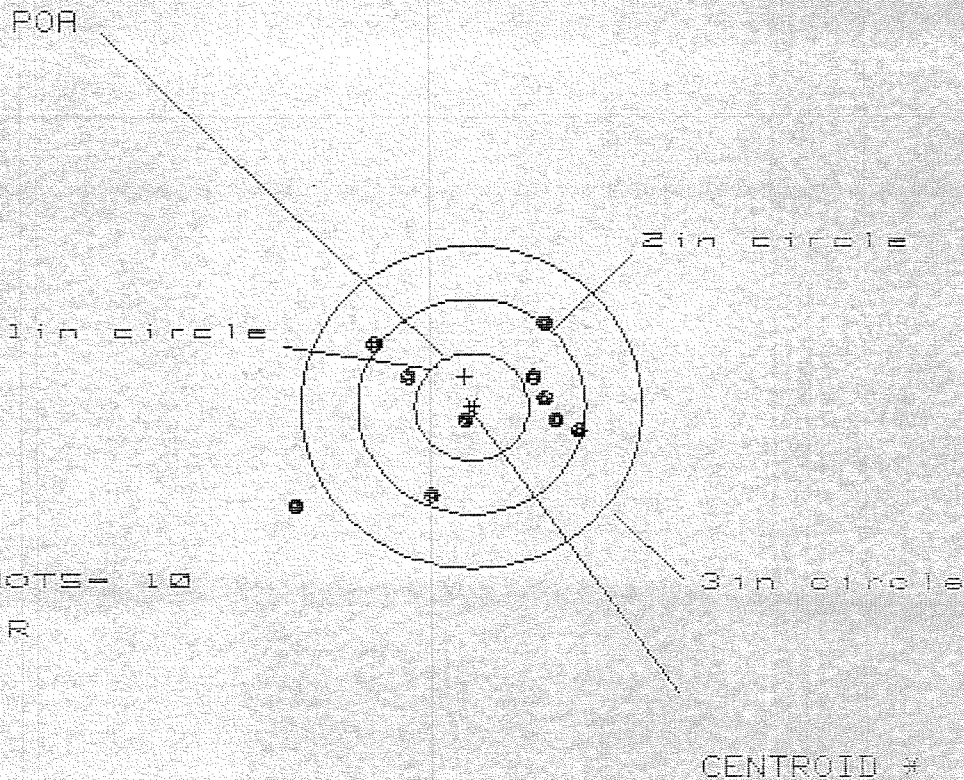
GS= 1.927

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.106	.316	.346
MINIMUM X	-.699	-.576	-.546
MAXIMUM Y	.855	.895	.766
MINIMUM Y	-1.072	-1.032	-.739
CENTROID X	.397	.274	.244
CENTROID Y	-.205	-.245	-.116
POA TO CENTROID in.	.447	.368	.270
MIN RADIUS	.107	.129	.200
MEAN RADIUS	.664	.599	.540
MAX RADIUS	1.163	1.060	.819
HORIZONTAL SPREAD	1.805	.892	.892
VERTICAL SPREAD	1.927	1.927	1.505
EXTREME SPREAD	1.927	1.927	1.557
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.459

VS= 1.776

GS= 2.812

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.921	.750	.620
MINIMUM X	:	-1.538	-1.042	-.877
MAXIMUM Y	:	.811	.704	.767
MINIMUM Y	:	-.965	-.886	-.823
CENTROID X	:	.061	.232	.362
CENTROID Y	:	-.281	-.174	-.237
POA TO CENTROID in.	:	.288	.290	.432
MIN RADIUS	:	.131	.309	.330
MEAN RADIUS	:	.847	.709	.623
MAX RADIUS	:	1.815	1.156	1.087
HORIZONTAL SPREAD	:	2.459	1.792	1.497
VERTICAL SPREAD	:	1.776	1.590	1.590
EXTREME SPREAD	:	2.812	1.965	1.906
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®

MODEL 700™ H24

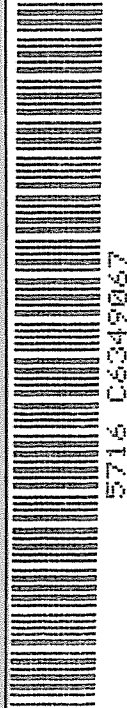
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
06349067

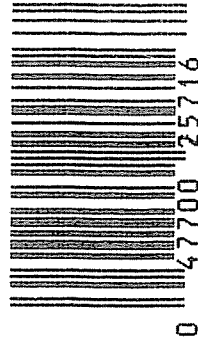
ORDER NO.
5716

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LPC



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