

C6349210

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

AMMO BY AR 10

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

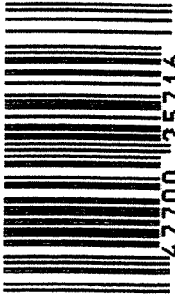
MODEL 700™ M24

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

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

SERIAL NO.
C6349210

ORDER NO.
5716

UPC

 0 47700 25716 7

GUN SERIAL # C6349210

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 12 90	RW
600	Proof		1 12 90	K
607	Check Headspace		1 12 90	K
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	GS
617	Drill and Tap Sight Holes		1-19-90	FB
618	Polish Barrel RB		1-22-90	WB
620	Apply Coatings (Barrel Action)		1-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/24/90 1/24/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/24/90	RW
	C) Inspect Ejector Hole for Chamfer		1/24/90	RW
	D) Oil Firing Pin Ass'y		1/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/1/90	WB

op. #	BARBER M24 0110257	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2-2-90	JH
	G) Safety Off Force	2	2	2			2-2-90	JH
	H) Trigger Pull Test & Retainability						3/1/90	WB
	I) Firing Pin Indent	.0205	.0205	.0205			2-2-90	JH
	J) Assemble Stock						2/28/90	RW
	K) Assemble Swivel Studs						3/16/90	WB
	L) Attach Front and Rear Sight Assemblies						2/28/90	RW
	M) Iron Sight Alignment						2/28/90	RW
	N) Detach Front & Rear Sights & place in numbered container						2/28/90	RW
	O) Attach Scope to Rifle						2/28/90	WB
	P) Detach & Attach Scope 20 Times						2/28/90	WB
640	Gallery Target & Test						3-1-90	AC
	A) Time						3-1-90	AC
	B) Malfunctions						3-1-90	AC
	C) Pierced Primers						3-1-90	AC
	D) Optical Clarity of Scope						3-1-90	AC
645	Inspect for Live Ammo						3-1-90	AC
655	Final Inspection						3/12/90	WB
	A) Headspace							
	B) Trigger Pull	2.64	2.50	2.59	2.57	2.57	3/12/90	6.8
	C) Function						3/12/90	WB
660	Pack							

SWS TRIGGER PULL TEST

BARBER - M24 0110258

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6349210

DATE 31 Jan 90

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.45	2.55	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.35	2.44	2.50	
PULL #3	2.24	2.36	2.35	2.59	
PULL #4	2.19	2.26	2.42	2.57	
PULL #5	2.19	2.25	2.38	2.57	
TOTAL	11.28	11.67	12.14		
AVG.	2.256	2.334	2.428		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.06		
PULL #2	3.34	3.22		
PULL #3	3.28	3.28		
PULL #4	3.30	3.35		
PULL #5	3.35	3.27		
TOTAL	16.62	16.15		
AVG.	3.324	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.17		4.12
PULL #2	4.24	4.22		4.19
PULL #3	4.24	4.28		4.09
PULL #4	4.17	4.12		4.06
PULL #5	4.24	4.21		4.17
TOTAL	21.03	21.00		20.63
AVG.	4.206	4.20		4.126

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6349210
 2 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.405428
1 TO	2	.307747
1 TO	3	.931539
1 TO	4	.771602
1 TO	5	.273543

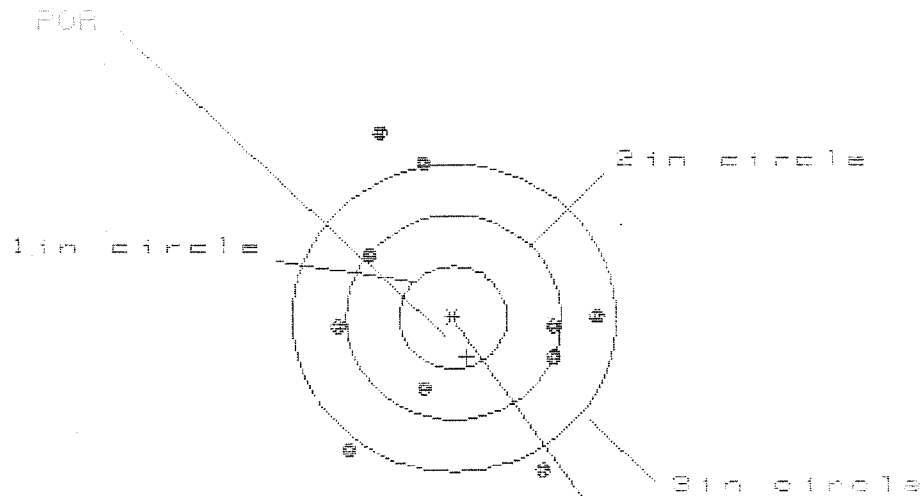
3 4 <----POA

POA X-COORDINATE FOR THIS RIFLE IS: -.2992
 POA Y-COORDINATE FOR THIS RIFLE IS: .0616
 AVERAGE POI RADIUS FOR THIS RIFLE IS: .305475
 POA RADIUS FOR THIS RIFLE IS: 1.088

004

FILE:/PATTERNING/CENTERFIRE_PATT/08349210

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 2.324

VS= 3.251

GS= 3.567

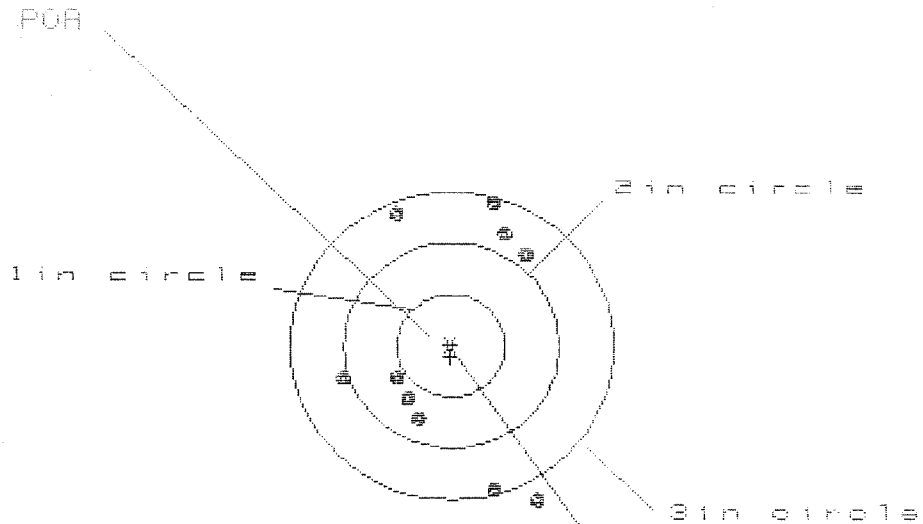
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.281	1.208	1.074
MINIMUM X	-1.043	-1.116	-1.250
MAXIMUM Y	1.807	1.698	1.557
MINIMUM Y	-1.444	-1.243	-1.384
CENTROID X	-.124	-.051	.083
CENTROID Y	.386	.185	.326
CENTROID IN.	.405	.192	.337
SPREAD	.707	.566	.734
SPREAD	1.272	1.174	1.114
SPREAD	1.922	1.731	1.626
SPREAD	2.324	2.324	2.324
SPREAD	3.251	2.941	2.941
SPREAD	3.567	3.133	3.133
ONE INCH CIRCLE	=	0	
TWO INCH CIRCLE	=	4	
THREE INCH CIRCLE	=	6	

1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8349210

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 1.802

VS= 2.839

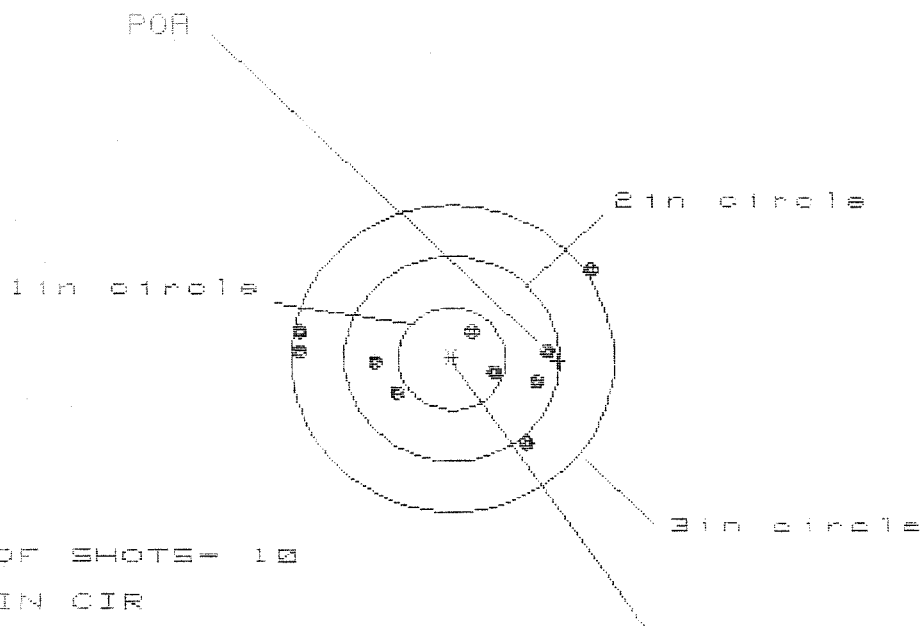
GS= 3.068

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.735	.799
MINIMUM X	:	-.996	-.906	-.842
MAXIMUM Y	:	1.353	1.188	.994
MINIMUM Y	:	-1.486	-1.551	-1.028
CENTROID X	:	.008	-.082	-.146
CENTROID Y	:	.108	.273	.467
MAXIMUM CENTROID Y	:	.108	.285	.489
MINIMUM CENTROID	:	.567	.601	.723
MINIMUM RADIUS	:	1.114	1.042	.964
MAXIMUM RADIUS	:	1.691	1.634	1.127
MINIMUM SPREAD	:	1.882	1.641	1.641
MAXIMUM SPREAD	:	2.839	2.739	2.022
MINIMUM SPREAD	:	3.068	2.826	2.140
MINIMUM ONE INCH CIRCLE	=		0	
MINIMUM TWO INCH CIRCLE	=		3	
MINIMUM THREE INCH CIRCLE	=		9	

MAY 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

CENTROID #

HS= 2.673

VS= 1.724

GS= 2.770

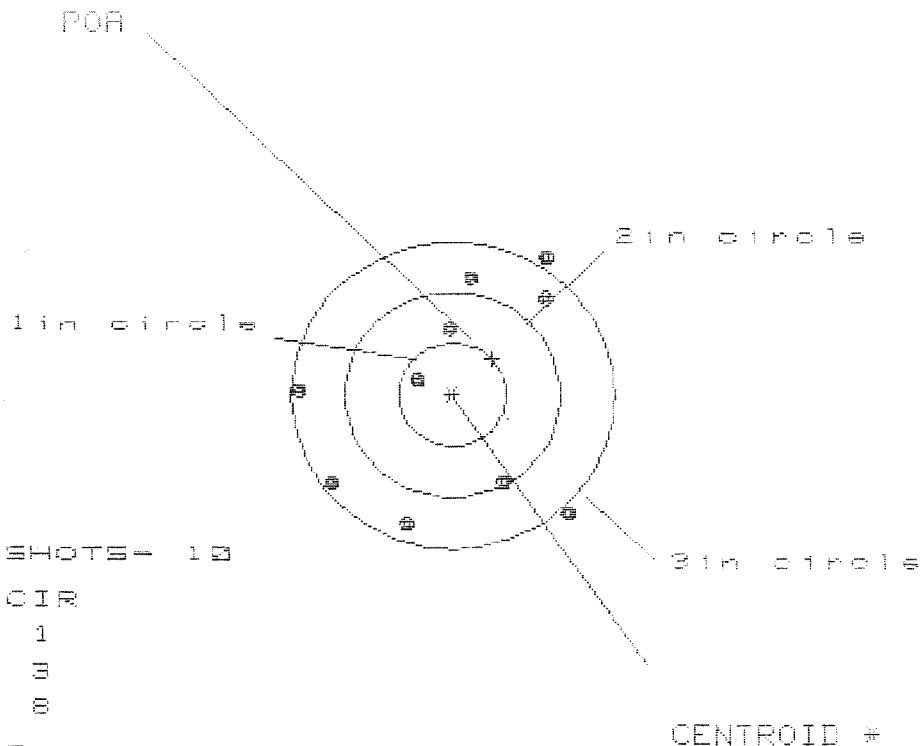
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.238
MINIMUM X	-1.435
MAXIMUM Y	.898
MINIMUM Y	-.826
CENTROID X	-.984
CENTROID Y	.028
POA TO CENTROID in.	.985
MIN RADIUS	.346
MAX RADIUS	.922
AVG RADIUS	1.530
HORIZONTAL SPREAD	2.673
VERTICAL SPREAD	1.724
DIAGONAL SPREAD	2.770
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

1 MAR 1988

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.514

VS= 2.531

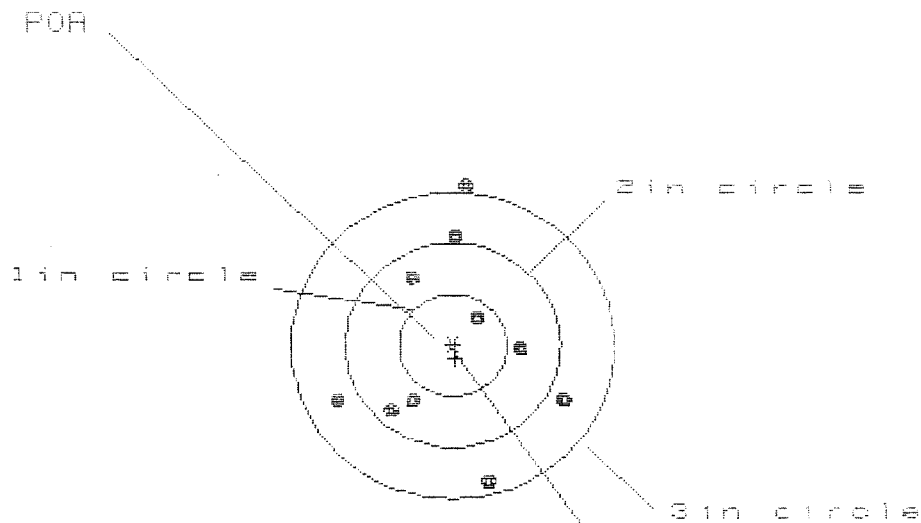
QS= 2.945

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.104	1.030	1.149
MINIMUM X	:	-1.410	-1.288	-1.168
MAXIMUM Y	:	1.295	1.165	1.135
MINIMUM Y	:	-1.236	-1.366	-1.220
CENTROID X	:	-.371	-.493	-.612
CENTROID Y	:	-.345	-.215	-.360
POA TO CENTROID IN.	:	.507	.538	.711
MIN RADIUS	:	.370	.230	.170
MEAN RADIUS	:	1.172	1.094	1.035
MAX RADIUS	:	1.612	1.505	1.477
HORIZONTAL SPREAD	:	2.514	2.318	2.318
VERTICAL SPREAD	:	2.531	2.531	2.355
EXTENS SPREAD	:	2.945	2.945	2.736
SHOTS IN ONE INCH CIRCLE	=		1	
SHOTS IN TWO INCH CIRCLE	=		3	
SHOTS IN THREE INCH CIRCLE	=		8	

1 Mar 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.135

VS = 2.923

GS = 2.926

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.016	1.035	1.074
MINIMUM X	:	-1.119	-1.100	-1.061
MAXIMUM Y	:	1.570	1.286	1.139
MINIMUM Y	:	-1.353	-1.179	-0.622
CENTROID X	:	-0.025	-0.044	-0.083
CENTROID Y	:	.131	-0.043	.104
POA TO CENTROID in.	:	.134	.061	.133
MIN RADIUS	:	.309	.457	.368
MEAN RADIUS	:	.962	.885	.833
MAX RADIUS	:	1.579	1.286	1.190
HORIZONTAL SPREAD	:	2.135	2.135	2.135
VERTICAL SPREAD	:	2.923	2.465	1.761
EXTREME SPREAD	:	2.926	2.484	2.136
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	