

C6349214

CHINE
-177

MODEL 700TM M24

Model **SMS**

TM

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 700™ H24		SERIAL NO. C6349214	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349214

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3 31 90	RW
600	Proof		3 31 90	RW
607	Check Headspace		3 31 90	RW
610	Dis-assemble Gun		3 31 90	RW
612	Magnaflux Barrel Action		4-2-90	KCR
	Magnaflux Bolt		4-2-90	KCR
615	Rollmark Caliber		4-2-90	SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel AB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/20/90	SL

BARBER - M24 0110311

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/27/90	JK
	G) Safety Off Force	3	3	3			4/27/90	JK
	H) Trigger Pull Test & Retainability						4/26/90	JK
	I) Firing Pin Indent	.0215	.021	.0215			4/27/90	JK
	J) Assemble Stock						4/30/90	RW
	K) Assemble Swivel Studs						5/1/90	WB
	L) Attach Front and Rear Sight Assemblies						4/30/90	RW
	M) Iron Sight Alignment						4/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/90	RW
	O) Attach Scope to Rifle						4/30/90	JK
	P) Detach & Attach Scope 20 Times						4/30/90	JK
640	Gallery Target & Test						4-30-90	AC
	A) Time						4-30-90	AC
	B) Malfunctions						4-30-90	AC
	C) Pierced Primers						4-30-90	AC
	D) Optical Clarity of Scope						4-30-90	AC
645	Inspect for Live Ammo						4-30-90	AC
655	Final Inspection						5/1/90	WB
	A) Headspace						5/1/90	WB
	B) Trigger Pull	2.38	2.36	2.32	2.35	2.36	5/1/90	WB
	C) Function						5/1/90	WB
660	Pack						6-9-90	D/H

TIME

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349214DATE 4/26/90TESTER J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.25	2.30	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.20	2.18	2.36	
PULL #3	2.34	2.23	2.24	2.32	
PULL #4	2.29	2.19	2.25	2.35	
PULL #5	2.29	2.29	2.24	2.36	
TOTAL	11.84	11.16	11.21		
AVG.	2.368	2.232	2.242		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.27		
PULL #2	3.48	3.29		
PULL #3	3.43	3.30		
PULL #4	3.53	3.43		
PULL #5	3.25	3.41		
TOTAL	17.16	16.70		
AVG.	3.432	3.34		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.34		4.27
PULL #2	4.30	4.30		4.28
PULL #3	4.38	4.35		4.21
PULL #4	4.30	4.40		4.33
PULL #5	4.35	4.28		4.34
TOTAL	21.68	21.67		21.43
AVG.	4.336	4.334		4.286

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349214
1 May 1998

CENTROIDAL DISTANCES

0 TO 1	.23658
1 TO 2	.293557
1 TO 3	.516637
1 TO 4	.47308
1 TO 5	.454458

$\bar{x}_p$ <----POA

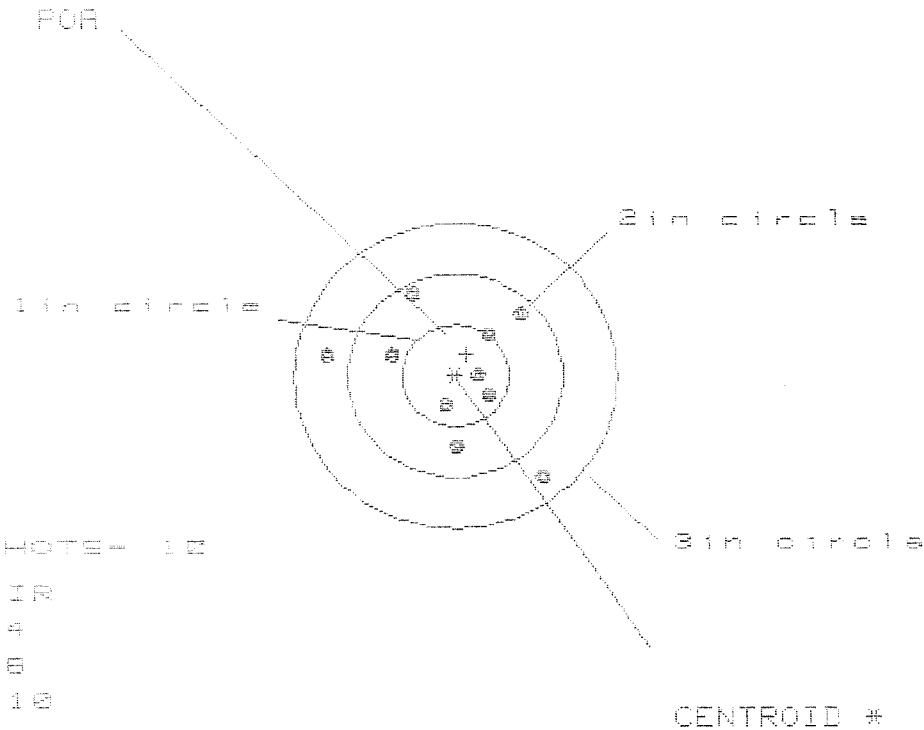
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240648
THE RMR FOR THIS RIFLE IS: .7786

1 May 1998

FILE/PATTERNING/CENTERFIRE_PATT/09349214

CENTERFIRE PATTERNS

1



+ OF SHOTS = 12

IN CIR

1 in = 4

2 in = 8

3 in = 10

HRT = 2.007

VSH = 1.839

GSH = 2.351

CENTROID #

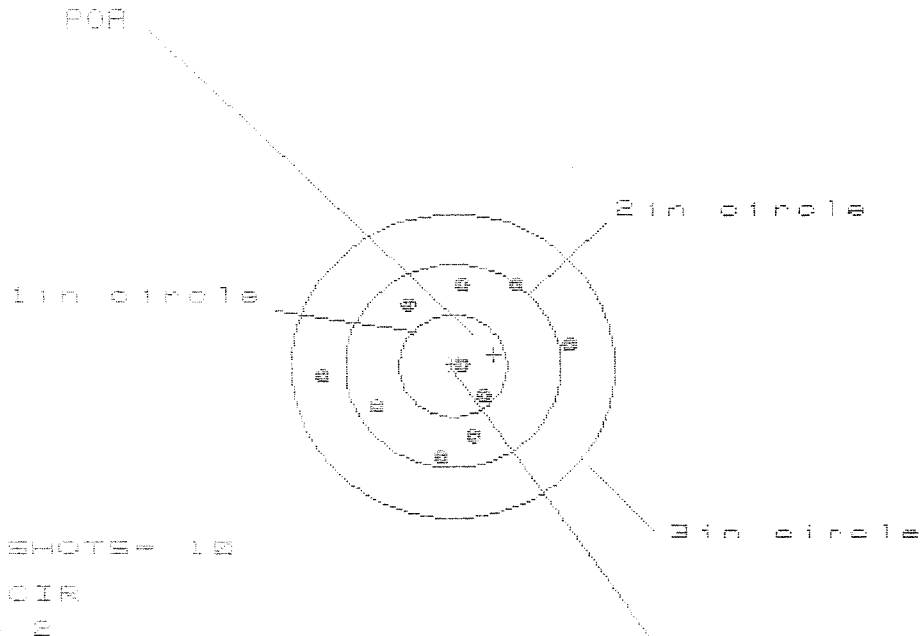
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.828	.741	.605
MINIMUM X	-1.179	-1.087	-.610
MAXIMUM Y	.833	.721	.734
MINIMUM Y	-1.006	-.848	-.835
CENTROID X	-.107	-.199	-.063
CENTROID Y	-.211	-.099	-.112
FOR TO CENTROID (in)	.237	.222	.129
MIN RADIUS	.242	.353	.223
MEAN RADIUS	.698	.640	.557
MAX RADIUS	1.303	1.092	.877
HORIZONTAL SPREAD	2.007	1.828	1.215
VERTICAL SPREAD	1.839	1.569	1.569
EXTREME SPREAD	2.351	1.871	1.643
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

1 May 1998

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CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 IN = 2

2 IN = 7

3 IN = 10

MEAN = 0.000

X = 1.741

Y = 0.000

CENTROID #

PATTERN #

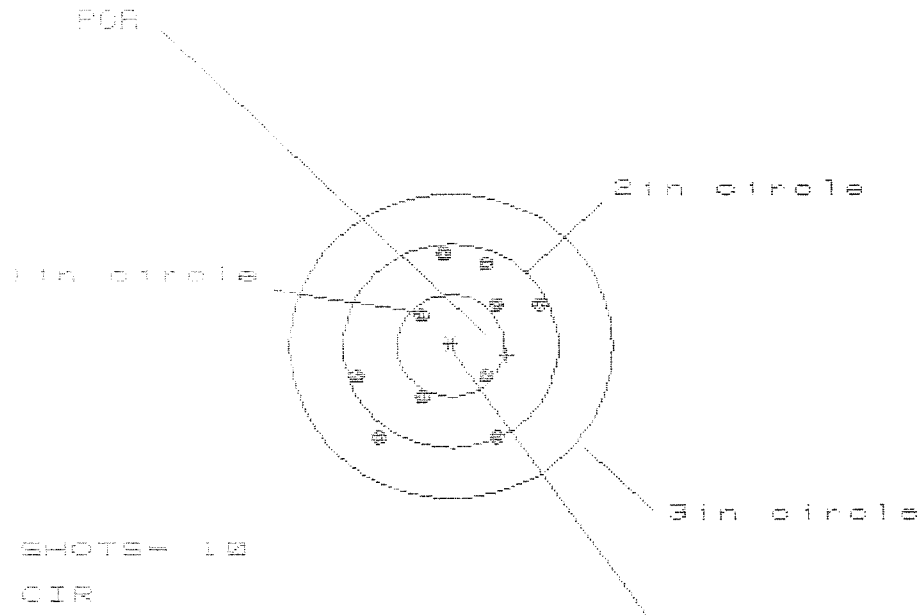
2

SHOTS (BEST OF)	1	2	3
MAXIMUM X	1.095	.960	.601
MINIMUM X	-1.209	-.840	-.720
MAXIMUM Y	.810	.799	.824
MINIMUM Y	-.930	-.942	-.917
CENTROID X	-.383	-.248	-.368
CENTROID Y	-.111	-.099	-.124
POB TO CENTROID IN.	.398	.267	.389
MIN RADIUS	.095	.052	.088
MEAN RADIUS	.779	.715	.688
MAX RADIUS	1.214	.981	1.020
HORIZONTAL SPREAD	2.304	1.800	1.920
VERTICAL SPREAD	1.741	1.741	1.741
EXTREME SPREAD	2.325	1.899	1.876
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

1 May 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

CIR 1 = 2

CIR 2 = 8

CIR 3 = 10

HSE = 1.715

VSE = 1.836

ESE = 1.836

PATTERN #

3

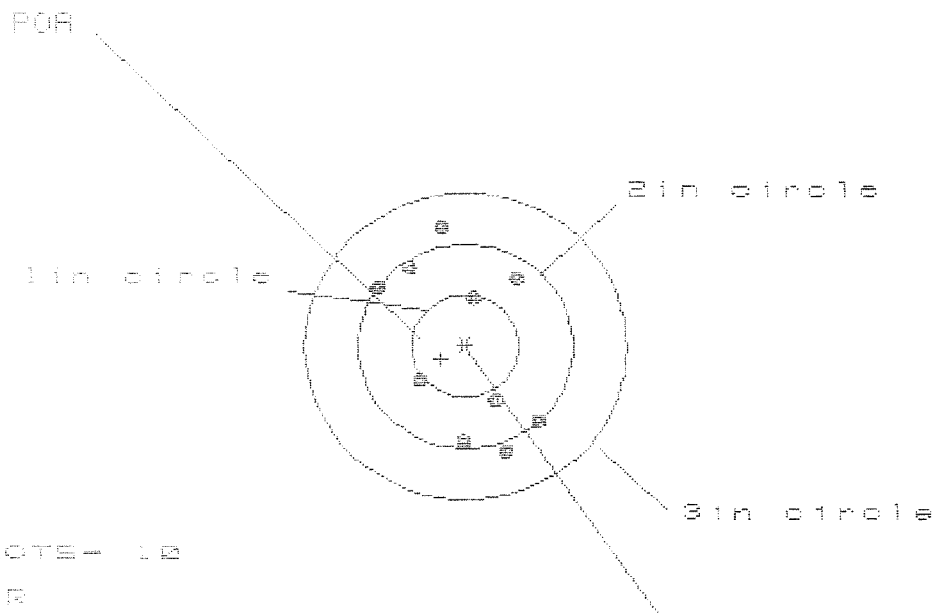
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.816	.737	.782
MINIMUM X	-.899	-.978	-.933
MAXIMUM Y	.943	.843	.725
MINIMUM Y	-.893	-.951	-.748
CENTROID X	-.524	-.445	-.490
CENTROID Y	.094	.194	.312
POB TO CENTROID IN.	.533	.485	.581
MIN RADIUS	.387	.415	.359
MEAN RADIUS	.781	.727	.679
MAX RADIUS	1.142	1.063	1.077
HORIZONTAL SPREAD	1.715	1.715	1.715
VERTICAL SPREAD	1.836	1.794	1.473
EXTREME SPREAD	1.996	1.870	1.856
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

1 May 1990

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CENTERFIRE PATTERNS

4



+ OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 10

HS = 1.457

VS = 2.184

GS = 2.280

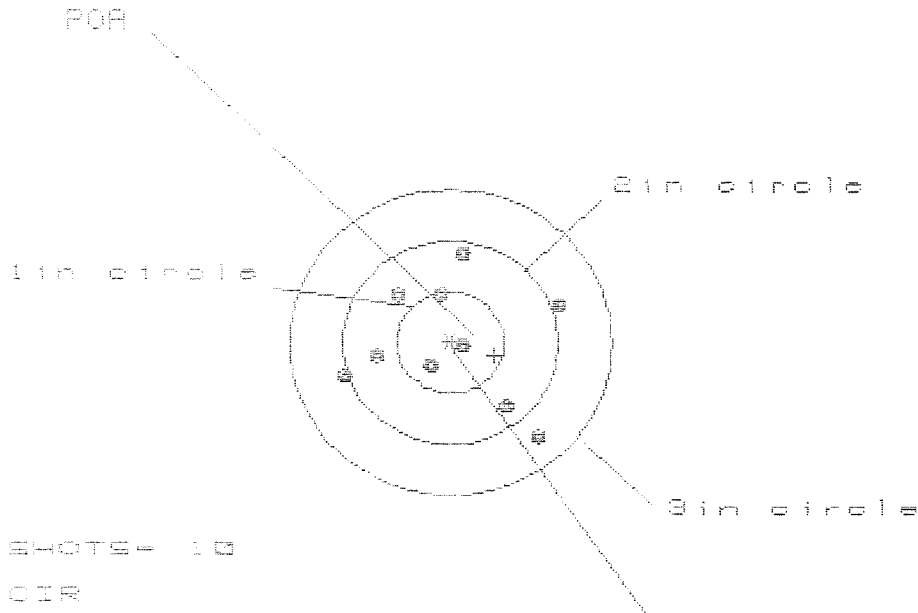
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.683	.659	.707
MINIMUM X	-.774	-.798	-.750
MAXIMUM Y	1.132	.923	.806
MINIMUM Y	-1.062	-.936	-.959
CENTROID X	.224	.248	.200
CENTROID Y	.127	.001	.118
POR TO CENTROID (in)	.257	.248	.232
MIN RADIUS	.460	.487	.482
MEAN RADIUS	.860	.817	.788
MAX RADIUS	1.153	1.073	.984
HORIZONTAL SPREAD	1.457	1.457	1.457
VERTICAL SPREAD	2.194	1.859	1.765
EXTREME SPREAD	2.280	2.079	1.929
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.898

VS= 1.782

ES= 2.898

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.001	1.092	.713
MINIMUM X	-.998	-.907	-.770
MAXIMUM Y	.880	.780	.808
MINIMUM Y	-.962	-.725	-.697
CENTROID X	-.413	-.504	-.641
CENTROID Y	.125	.225	.197
POR TO CENTROID in.	.432	.552	.670
MIN RADIUS	.114	.231	.308
MEAN RADIUS	.735	.672	.606
MAX RADIUS	1.220	1.115	.997
HORIZONTAL SPREAD	1.999	1.999	1.483
VERTICAL SPREAD	1.782	1.505	1.505
EXTREME SPREAD	2.898	2.898	1.617
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	