

C6522155

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

M2400003833

CONFIDENTIAL SUBJECT TO PROTECTIVE ORDER

Seward®

Remington[®]

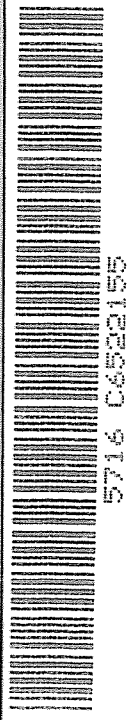
MODEL 700[™] M24

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

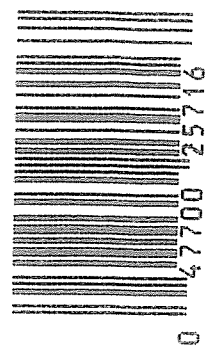
DUPONT
REG. U.S. PAT. & T.M. OFF.

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

SERIAL NO.	C6522155
ORDER NO.	5716



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522155

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12	90	RW
600	Proof	7 12	90	RW
607	Check Headspace	7 12	90	RW
610	Dis-assemble Gun	7 12	90	RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	JS
617	Drill and Tap Sight Holes		7/23/90	RB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-6-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			8/28/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	JM
	I) Firing Pin Indent	.023	.0235	.0235			8/28/90	WB
	J) Assemble Stock						8/28/90	RW
	K) Assemble Swivel Studs						8/31/90	JS
	L) Attach Front and Rear Sight Assemblies						8/28/90	RW
	M) Iron Sight Alignment						8/28/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/90	RW
	O) Attach Scope to Rifle						8/28/90	RW
	P) Detach & Attach Scope 20 Times						8/28/90	RW
640	Gallery Target & Test						8-29-90	DH
	A) Time						8-29-90	DH
	B) Malfunctions						8-29-90	DH
	C) Pierced Primers						8-29-90	DH
	D) Optical Clarity of Scope						8-29-90	DH
645	Inspect for Live Ammo						8-29-90	DH
655	Final Inspection							
	A) Headspace						8/31/90	JS
	B) Trigger Pull	2.20	2.22	2.22	2.22	2.20	8/30/90	JM
	C) Function						8/31/90	JS
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. C6522155

DATE 8/20/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.30	2.42	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.27	2.29	2.22	
PULL #3	2.16	2.29	2.33	2.22	
PULL #4	2.35	2.27	2.34	2.22	
PULL #5	2.39	2.24	2.21	2.20	
TOTAL	11.45	11.37	11.59	11.06	
AVG.	2.29	2.274	2.318	2.212	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.30		
PULL #2	3.31	3.33		
PULL #3	3.26	3.27		
PULL #4	3.29	3.26		
PULL #5	3.32	3.17		
TOTAL	16.61	16.33		
AVG.	3.322	3.266		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.39		4.34
PULL #2	4.34	4.40		4.21
PULL #3	4.34	4.43		4.34
PULL #4	4.36	4.41		4.34
PULL #5	4.34	4.35		4.35
TOTAL	21.75	21.98		21.58
AVG.	4.35	4.396		4.316

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522155
29 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.905884
1 TO	2	.561057
1 TO	3	.935181
1 TO	4	.233034
1 TO	5	.291247

+ 1 2 3
4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0482
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1946
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.06611
THE AMR FOR THIS RIFLE IS: .9692

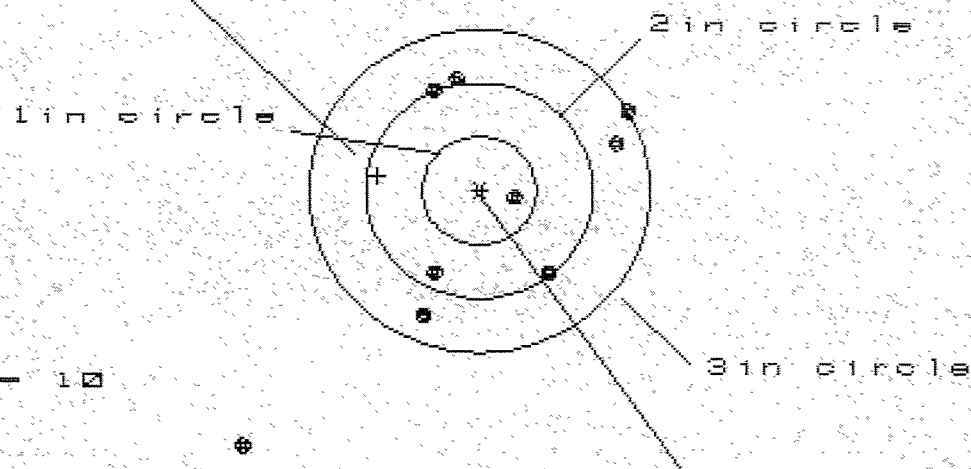
29 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522155

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 3.394

VS= 4.373

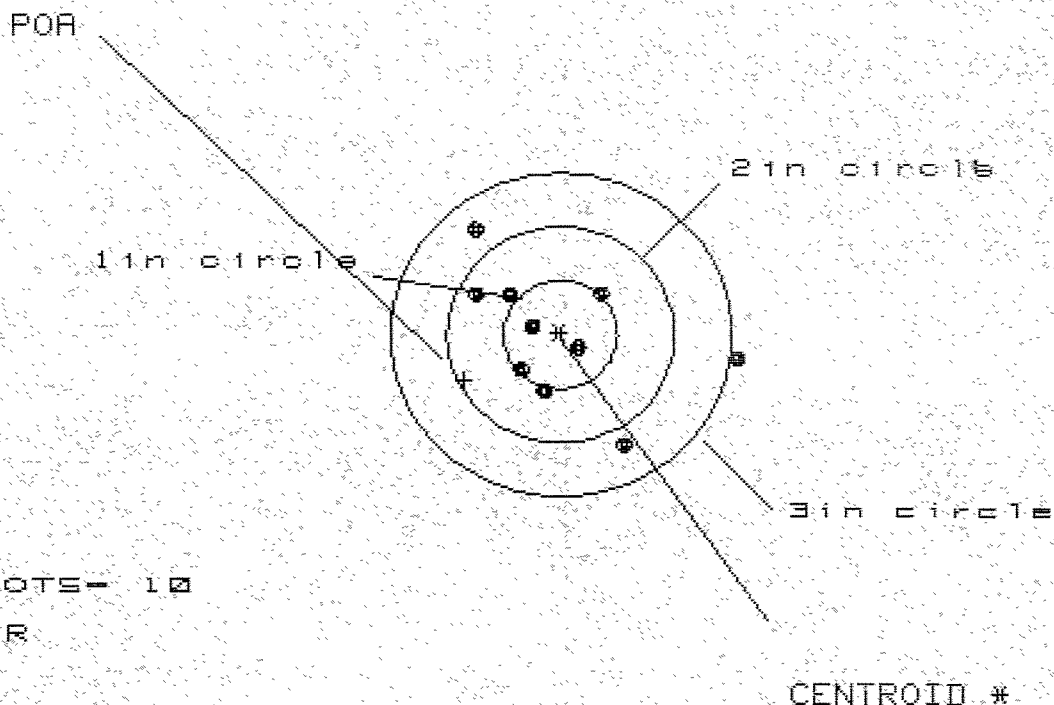
GS= 4.831

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.311	1.080	1.047
MINIMUM X	:	-2.083	-.705	-.738
MAXIMUM Y	:	2.034	1.774	.975
MINIMUM Y	:	-2.339	-1.413	-1.191
CENTROID X	:	.895	1.126	1.159
CENTROID Y	:	-.140	.120	-.102
POA TO CENTROID in.	:	.905	1.132	1.163
MIN RADIUS	:	.349	.339	.126
MEAN RADIUS	:	1.339	1.100	.980
MAX RADIUS	:	3.132	1.793	1.401
HORIZONTAL SPREAD	:	3.394	1.785	1.785
VERTICAL SPREAD	:	4.373	3.187	2.166
EXTREME SPREAD	:	4.831	3.218	2.593
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

29 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.317

VS= 2.016

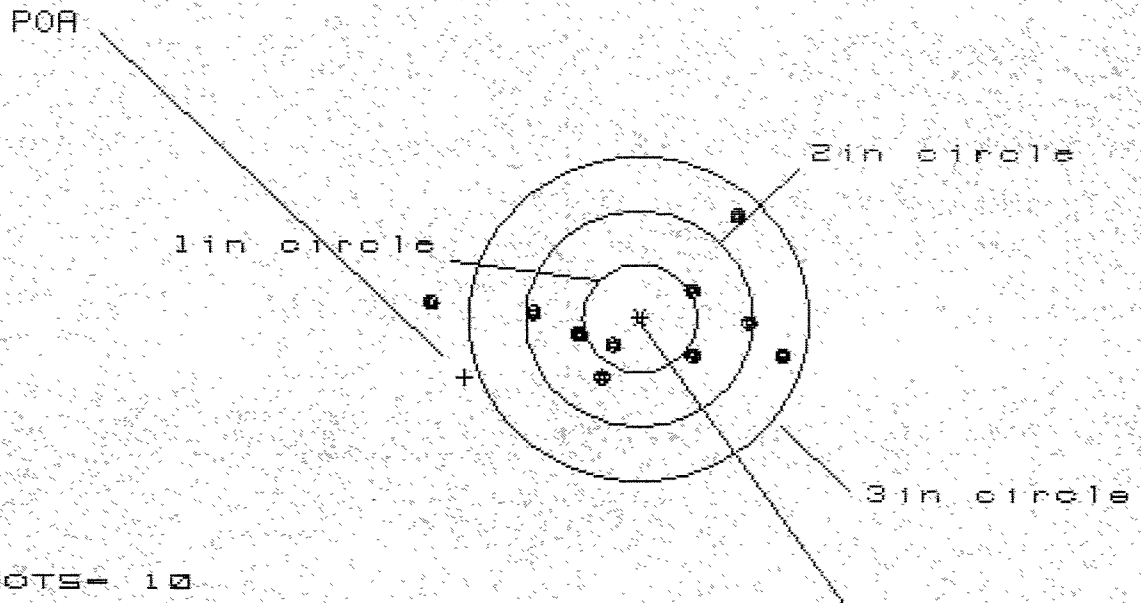
GS= 2.596

PATTERN #	2	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.563	.704	.632	
MINIMUM X	-.754	-.580	-.612	
MAXIMUM Y	.952	.928	.496	
MINIMUM Y	-1.064	-1.088	-.973	
CENTROID X	.847	.673	.745	
CENTROID Y	.419	.443	.328	
POA TO CENTROID in.	.945	.806	.814	
MIN RADIUS	.214	.135	.266	
MEAN RADIUS	.731	.607	.549	
MAX RADIUS	1.579	1.296	1.160	
HORIZONTAL SPREAD	2.317	1.284	1.244	
VERTICAL SPREAD	2.016	2.016	1.469	
EXTREME SPREAD	2.596	2.390	1.889	
NUMBER IN ONE INCH CIRCLE =		3		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		9		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.094

VS= 1.517

GS= 3.133

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.255	1.050	.924
MINIMUM X	-1.839	-1.192	-1.060
MAXIMUM Y	.978	.999	.964
MINIMUM Y	-.539	-.518	-.553
CENTROID X	1.537	1.742	1.610
CENTROID Y	.540	.519	.554
POA TO CENTROID in.	1.629	1.817	1.703
MIN RADIUS	.358	.383	.424
MEAN RADIUS	.902	.782	.738
MAX RADIUS	1.849	1.195	1.220
HORIZONTAL SPREAD	3.094	2.242	1.984
VERTICAL SPREAD	1.517	1.517	1.517
EXTREME SPREAD	3.133	2.272	2.021
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 1.833

VS= 3.693

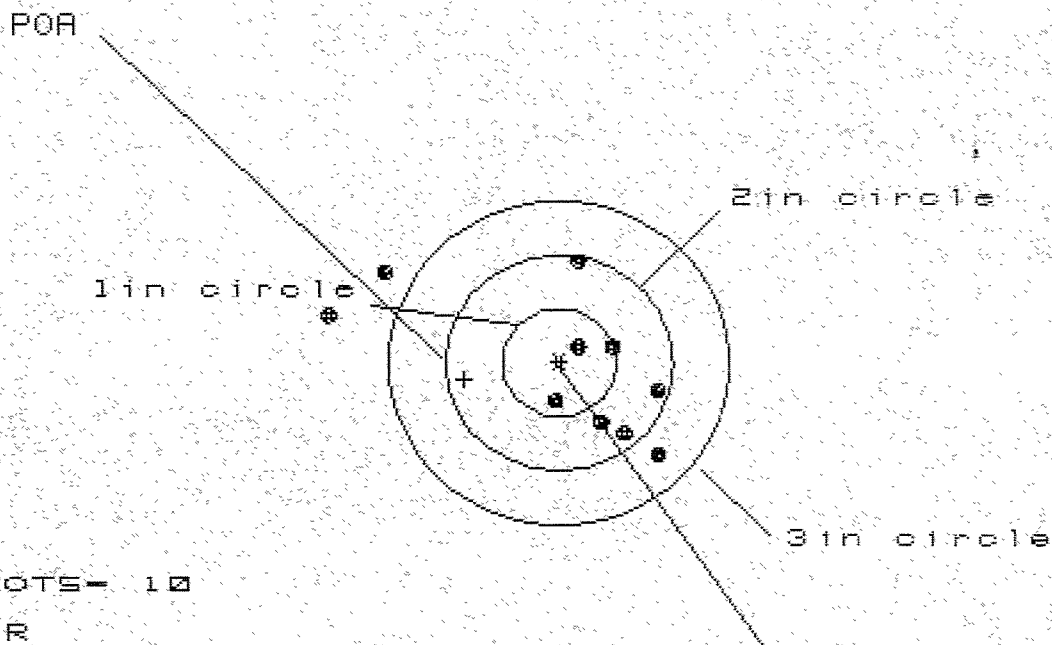
GS= 3.803

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.765	.692	.715
MINIMUM X	-1.068	-1.141	-1.118
MAXIMUM Y	2.343	1.532	1.396
MINIMUM Y	-1.350	-1.090	-.478
CENTROID X	1.079	1.152	1.129
CENTROID Y	.003	-.257	-.121
POA TO CENTROID in.	1.079	1.180	1.136
MIN RADIUS	.063	.057	.177
MEAN RADIUS	.925	.675	.645
MAX RADIUS	2.432	1.551	1.413
HORIZONTAL SPREAD	1.833	1.833	1.833
VERTICAL SPREAD	3.693	2.622	1.874
EXTREME SPREAD	3.803	2.656	2.094
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.882

VS= 1.836

GS= 3.141

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.647	.433
MINIMUM X	:	-2.011	-1.713	-.491
MAXIMUM Y	:	.995	1.042	1.153
MINIMUM Y	:	-.841	-.794	-.683
CENTROID X	:	.833	1.057	1.271
CENTROID Y	:	.151	.104	-.007
POA TO CENTROID in.	:	.847	1.062	1.271
MIN RADIUS	:	.227	.227	.305
MEAN RADIUS	:	.949	.760	.574
MAX RADIUS	:	2.055	1.928	1.177
HORIZONTAL SPREAD	:	2.882	2.360	.924
VERTICAL SPREAD	:	1.836	1.836	1.836
EXTREME SPREAD	:	3.141	2.891	1.952
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	