

C6498877

MODEL 700™ M24

Model **SMS**™

Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498877

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	KP
	Magnaflux Bolt		7-17-90	KP
615	Rollmark Caliber		7-17-90	G.S.
617	Drill and Tap Sight Holes		7/23/90	KB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-16-90	AS
	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		8/24/90	AS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			8/29/90	WLB
	G) Safety Off Force	3	3	3			8/29/90	WLB
	H) Trigger Pull Test & Retainability						8/29/90	HL
	I) Firing Pin Indent	.0225	.0225	.0225			8/29/90	WLB
	J) Assemble Stock						8/30/90	RW
	K) Assemble Swivel Studs						9/5/90	JD
	L) Attach Front and Rear Sight Assemblies						8/30/90	RW
	M) Iron Sight Alignment						8/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/30/90	RW
	O) Attach Scope to Rifle						8/30/90	RW
	P) Detach & Attach Scope 20 Times						8/30/90	RW
640	Gallery Target & Test						8-31-90	DH
	A) Time						8-31-90	DH
	B) Malfunctions						8-31-90	DH
	C) Pierced Primers						8-31-90	DH
	D) Optical Clarity of Scope						8-31-90	DH
645	Inspect for Live Ammo						8-31-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	JD
	B) Trigger Pull	2.28	2.24	2.29	2.42	2.36	9-4-90	JD
	C) Function						9/5/90	JD
660	Pack						9-18-90	JD

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498877

DATE 8/29/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.19	2.25	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.16	2.31	2.24	
PULL #3	2.28	2.21	2.24	2.29	
PULL #4	2.31	2.24	2.20	2.42	
PULL #5	2.23	2.24	2.20	2.36	
TOTAL	11.57	11.04	11.20	11.59	
AVG.	2.314	2.208	2.24	2.318	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.18		
PULL #2	3.24	3.19		
PULL #3	3.21	3.17		
PULL #4	3.20	3.23		
PULL #5	3.16	3.13		
TOTAL	16.04	15.90		
AVG.	3.208	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.16		4.24
PULL #2	4.22	4.18		4.27
PULL #3	4.21	4.22		4.24
PULL #4	4.20	4.24		4.20
PULL #5	4.21	4.20		4.25
TOTAL	20.99	21.00		21.20
AVG.	4.198	4.2		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498877
31 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.979547
1 TO	2	.531373
1 TO	3	.313198
1 TO	4	.924035
1 TO	5	.974708

132 $\frac{1}{2}$ <----POA

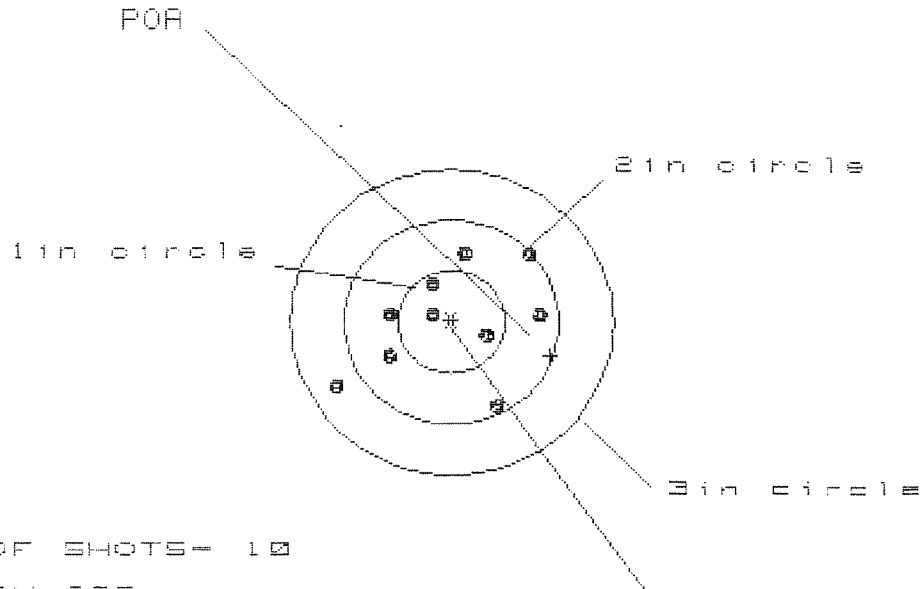
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3798
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2652
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .463227
THE AMR FOR THIS RIFLE IS: .8556

31 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498877

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.947

VS= 1.553

GS= 2.326

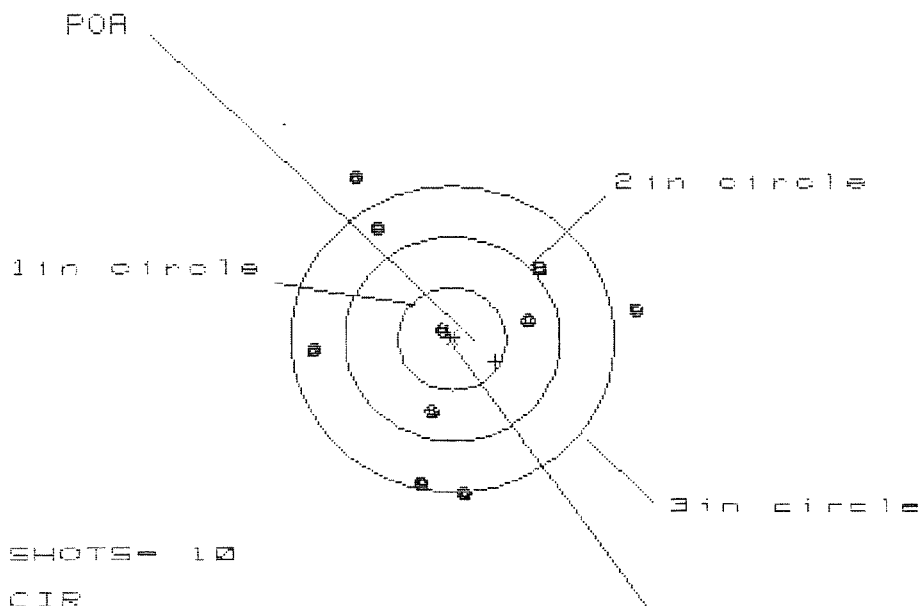
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.826	.702	.780
MINIMUM X	-1.121	-.688	-.610
MAXIMUM Y	.710	.635	.626
MINIMUM Y	-.843	-.918	-.839
CENTROID X	-.923	-.799	-.877
CENTROID Y	.328	.403	.324
POR TO CENTROID in.	.980	.895	.935
MIN RADIUS	.134	.257	.180
MEAN RADIUS	.689	.618	.574
MAX RADIUS	1.308	.980	.939
HORIZONTAL SPREAD	1.947	1.390	1.390
VERTICAL SPREAD	1.553	1.553	1.465
EXTREME SPREAD	2.326	1.646	1.503
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

IS= 3.005

VS= 3.129

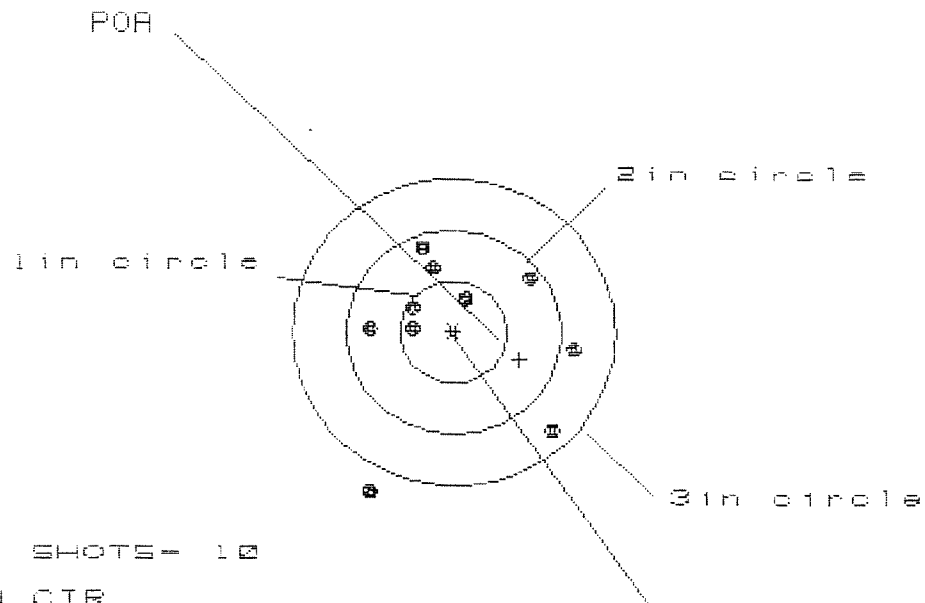
GS= 3.306

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.726	1.623	.944
MINIMUM X	:	-1.279	-1.382	-1.179
MAXIMUM Y	:	1.595	1.248	1.303
MINIMUM Y	:	-1.534	-1.357	-1.302
CENTROID X	:	-.404	-.301	-.504
CENTROID Y	:	.214	.037	-.018
POA TO CENTROID in.	:	.457	.304	.505
MIN RADIUS	:	.147	.352	.358
MEAN RADIUS	:	1.190	1.117	1.033
MAX RADIUS	:	1.843	1.682	1.423
HORIZONTAL SPREAD	:	3.005	3.005	2.123
VERTICAL SPREAD	:	3.129	2.605	2.605
EXTREME SPREAD	:	3.306	3.035	2.730
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.899

VS= 2.399

GS= 2.583

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.071	.979	1.079
MINIMUM X	:	-.828	-.888	-.788
MAXIMUM Y	:	.864	.694	.548
MINIMUM Y	:	-1.534	-1.165	-.436
CENTROID X	:	-.616	-.524	-.624
CENTROID Y	:	.266	.436	.582
POR TO CENTROID in.	:	.670	.681	.853
MIN RADIUS	:	.318	.125	.141
MEAN RADIUS	:	.861	.724	.595
MAX RADIUS	:	1.744	1.414	1.163
HORIZONTAL SPREAD	:	1.899	1.867	1.867
VERTICAL SPREAD	:	2.399	1.859	.984
EXTREME SPREAD	:	2.583	2.190	1.871
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.694

VS = 2.089

GS = 2.111

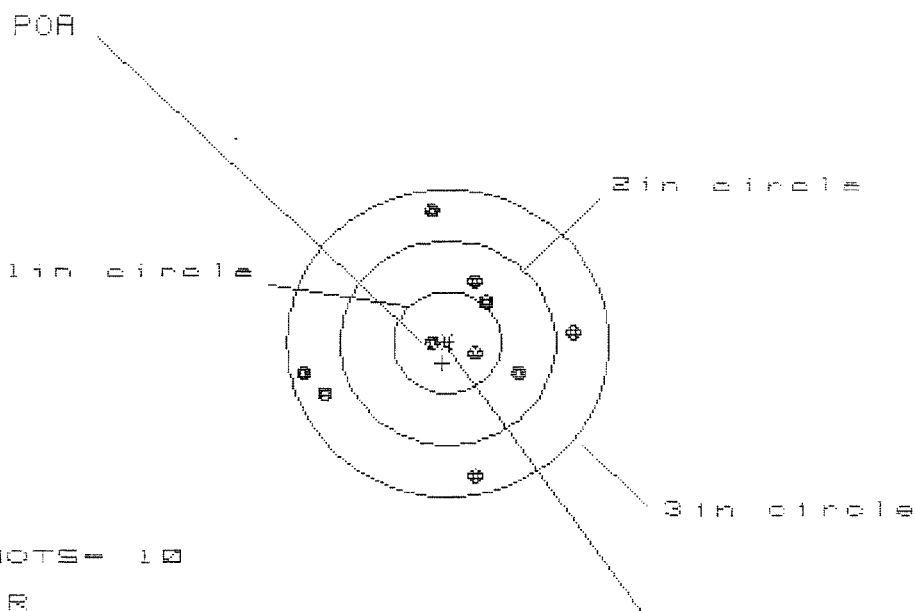
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.910	.935
MINIMUM X	:	-.834	-.784	-.759
MAXIMUM Y	:	1.134	.426	.322
MINIMUM Y	:	-.955	-.829	-.481
CENTROID X	:	.001	-.049	-.074
CENTROID Y	:	.320	.194	.298
POB TO CENTROID in.	:	.320	.200	.307
MIN RADIUS	:	.301	.342	.251
MEAN RADIUS	:	.664	.593	.548
MAX RADIUS	:	1.220	.917	.935
HORIZONTAL SPREAD	:	1.694	1.694	1.694
VERTICAL SPREAD	:	2.089	1.255	.723
EXTREME SPREAD	:	2.111	1.710	1.710
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.526

VS= 2.550

GS= 2.579

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.168	1.017	.978
MINIMUM X	-1.358	-1.312	-1.351
MAXIMUM Y	1.284	1.254	.776
MINIMUM Y	-1.266	-1.296	-1.140
CENTROID X	.043	.194	.233
CENTROID Y	.198	.228	.072
POA TO CENTROID in.	.203	.300	.244
MIN RADIUS	.152	.189	.052
MEAN RADIUS	.874	.793	.720
MAX RADIUS	1.385	1.420	1.405
HORIZONTAL SPREAD	2.526	2.329	2.329
VERTICAL SPREAD	2.550	2.550	1.916
EXTREME SPREAD	2.579	2.579	2.415
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

Remington® **DU PONT**
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. Marque Deposee.

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

SERIAL NO. C6498877	ORDER NO. 5716
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Q1

