

06649087

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

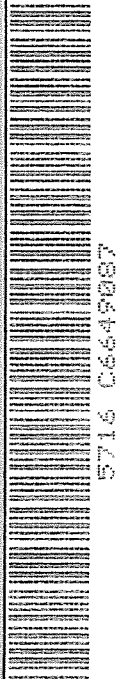
MODEL 700™ N24

SERIAL NO.
 C6649087

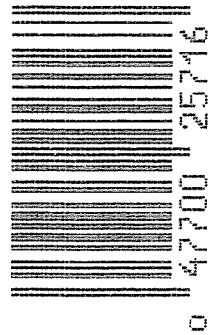
ORDER NO.
 5716

20

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649087

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KS
600	Proof		6/25/91	KS
607	Check Headspace		6/25/91	KS
610	Dis-assemble Gun		6/25/91	KS
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-24-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-24-91	SL
	G) Safety Off Force	5	5	5			7-24-91	SL
	H) Trigger Pull Test & Retainability						7-24-91	SL
	I) Firing Pin Indent	.021	.022	.022			7-24-91	SL
	J) Assemble Stock						7/30/91	KS
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						7/30/91	KS
	M) Iron Sight Alignment						7/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	KS
	O) Attach Scope to Rifle						7/30/91	KS
	P) Detach & Attach Scope 20 Times						7/30/91	KS
640	Gallery Target & Test						7-31-91	SL
	A) Time						"	SL
	B) Malfunctions						"	SL
	C) Pierced Primers						"	SL
	D) Optical Clarity of Scope						"	SL
645	Inspect for Live Ammo						7-31-91	SL
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.53	2.60	2.62	2.62	2.62	8-5-91	SL
	C) Function						8-6-91	AC
660	Pack						7-17-91	SL

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6649087

DATE 7-24-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.46	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.48	2.49	2.60	
PULL #3	2.25	2.47	2.53	2.62	
PULL #4	2.52	2.50	2.55	2.62	
PULL #5	2.60	2.46	2.48	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.38		
PULL #2	3.40	3.40		
PULL #3	3.34	3.52		
PULL #4	3.39	3.38		
PULL #5	3.42	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.36		4.32
PULL #2	4.23	4.35		4.21
PULL #3	4.32	4.36		4.35
PULL #4	4.36	4.35		4.29
PULL #5	4.35	4.33		4.31
TOTAL				
AVG.				

PHYSICAL DISTANCE CALCULATIONS
FOR RIFLE # 06649087
01 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.428121
1 TO 2	.302662
1 TO 3	.216178
1 TO 4	.270296
1 TO 5	.332032

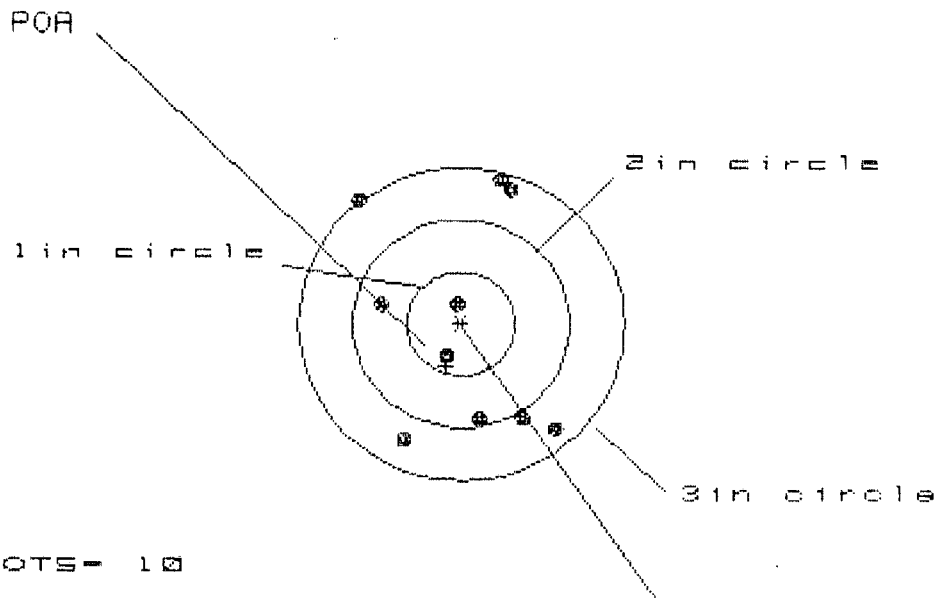
★ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226292
THE AVERAGE POI FOR THIS RIFLE IS: .8158

001

FILE:/PATTERNING/CENTERFIRE_PATT/C8649067

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 1.761

VS= 2.516

GS= 2.784

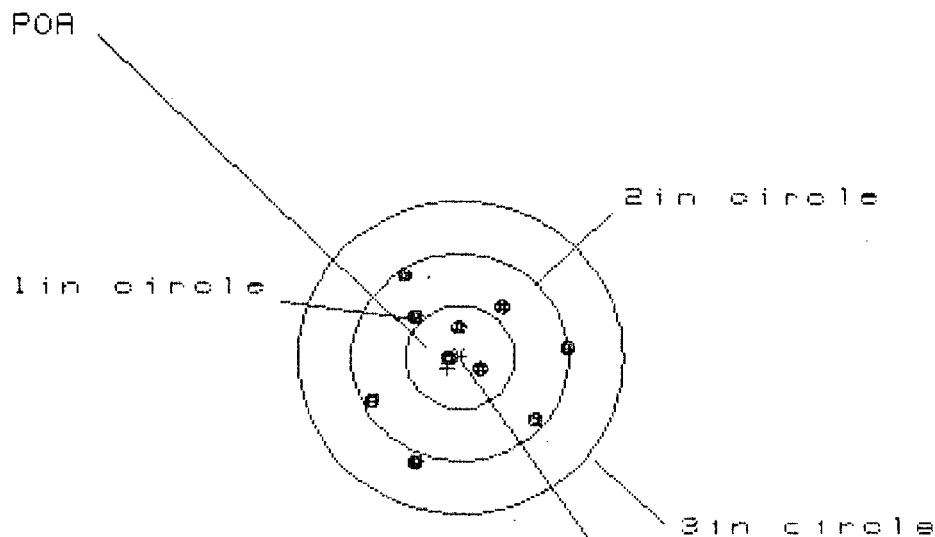
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.827	.723	.750
MINIMUM X	:	-.934	-.888	-.861
MAXIMUM Y	:	1.401	1.529	1.631
MINIMUM Y	:	-1.115	-.987	-.796
CENTROID X	:	.136	.240	.213
CENTROID Y	:	.407	.279	.088
POA TO CENTROID in.	:	.429	.368	.230
MIN RADIUS	:	.162	.275	.165
MEAN RADIUS	:	1.013	.949	.837
MAX RADIUS	:	1.483	1.544	1.682
HORIZONTAL SPREAD	:	1.761	1.611	1.611
VERTICAL SPREAD	:	2.516	2.516	2.427
EXTREME SPREAD	:	2.784	2.656	2.633
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

IS= 1.839

VS= 1.800

GS= 1.893

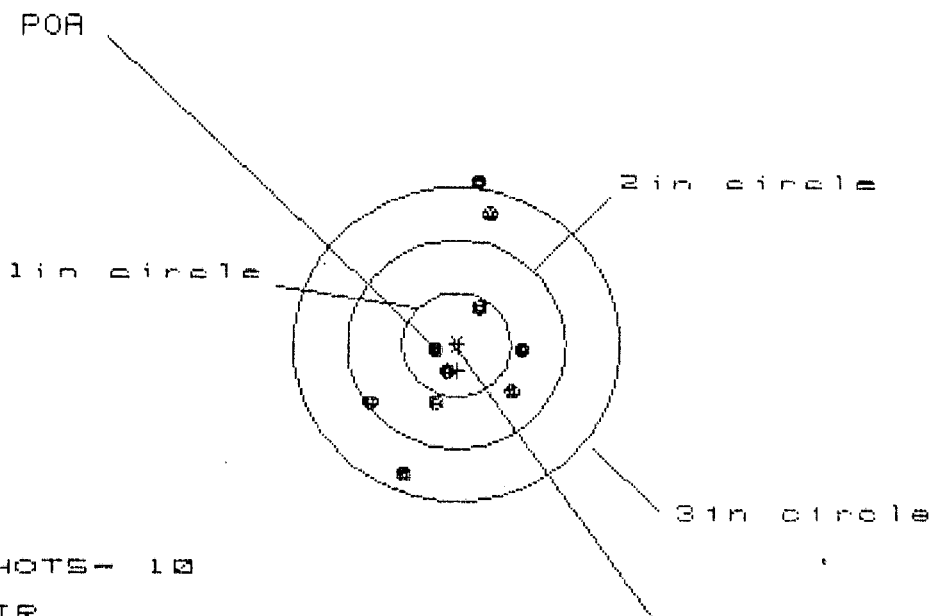
CENTROID #

PATTERN #	:	12	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.032	.985	.741
MINIMUM X	:	-.807	-.854	-.730
MAXIMUM Y	:	.769	.655	.651
MINIMUM Y	:	-1.031	-.681	-.685
CENTROID X	:	.116	.162	.038
CENTROID Y	:	.105	.219	.223
POA TO CENTROID in.	:	.156	.272	.226
MIN RADIUS	:	.086	.159	.096
MEAN RADIUS	:	.663	.603	.545
MAX RADIUS	:	1.111	.986	1.009
HORIZONTAL SPREAD	:	1.839	1.839	1.471
VERTICAL SPREAD	:	1.800	1.336	1.336
EXTREME SPREAD	:	1.893	1.893	1.796
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.307

VS= 2.803

GS= 2.889

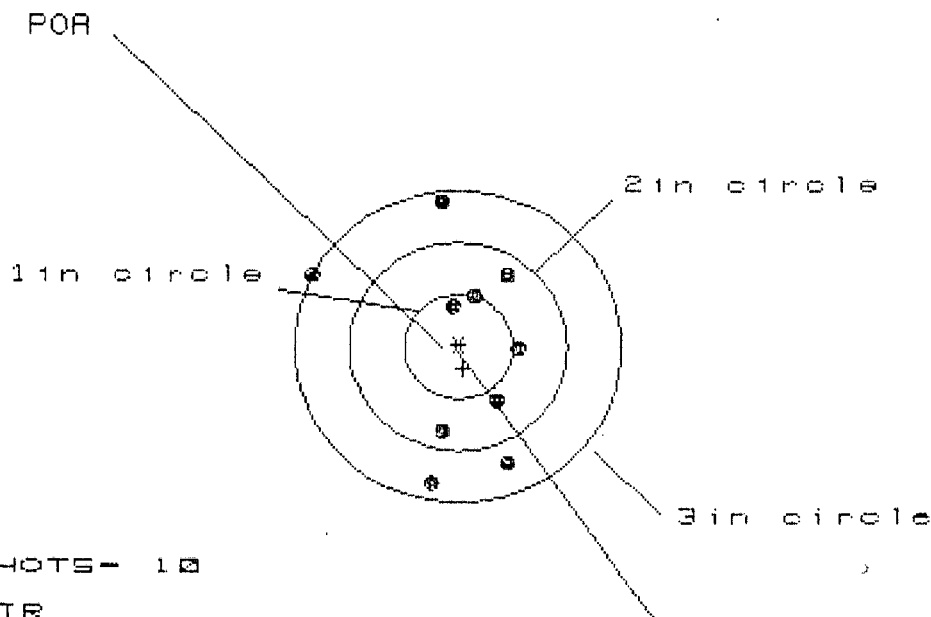
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.563	.586	.529
MINIMUM X	:	-.745	-.721	-.778
MAXIMUM Y	:	1.544	1.383	1.248
MINIMUM Y	:	-1.259	-1.088	-.550
CENTROID X	:	-.006	-.030	.027
CENTROID Y	:	.244	.073	.208
POA TO CENTROID in.	:	.244	.079	.210
MIN RADIUS	:	.153	.108	.188
MEAN RADIUS	:	.773	.658	.600
MAX RADIUS	:	1.559	1.425	1.280
HORIZONTAL SPREAD	:	1.307	1.307	1.307
VERTICAL SPREAD	:	2.803	2.471	1.798
EXTREME SPREAD	:	2.889	2.598	2.089
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



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

IS= 1.865

VS= 2.712

GS= 2.713

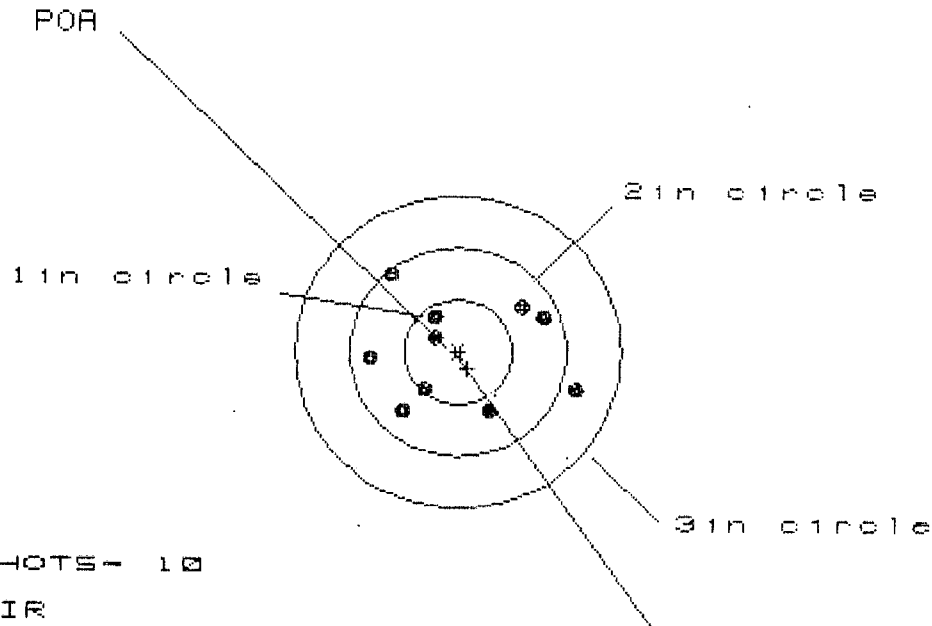
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.557	.412	.373
MINIMUM X	:	-1.308	-.366	-.405
MAXIMUM Y	:	1.379	1.454	.950
MINIMUM Y	:	-1.333	-1.258	-1.077
CENTROID X	:	-.048	.097	.136
CENTROID Y	:	.209	.134	-.047
POA TO CENTROID in.	:	.215	.166	.144
MIN RADIUS	:	.436	.419	.324
MEAN RADIUS	:	.912	.829	.734
MAX RADIUS	:	1.471	1.486	1.150
HORIZONTAL SPREAD	:	1.865	.778	.778
VERTICAL SPREAD	:	2.712	2.712	2.027
EXTREME SPREAD	:	2.713	2.713	2.124
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.952

VS= 1.366

GS= 2.074

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.099	.923	.860
MINIMUM X	:	-.853	-.731	-.794
MAXIMUM Y	:	.766	.722	.477
MINIMUM Y	:	-.600	-.644	-.553
CENTROID X	:	-.087	-.209	-.146
CENTROID Y	:	.161	.205	.114
POA TO CENTROID in.	:	.183	.292	.186
MIN RADIUS	:	.258	.141	.250
MEAN RADIUS	:	.718	.644	.621
MAX RADIUS	:	1.167	.955	.924
HORIZONTAL SPREAD	:	1.952	1.654	1.654
VERTICAL SPREAD	:	1.366	1.366	1.030
EXTREME SPREAD	:	2.074	1.701	1.701
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	