Smead®

FORM

UPC

0 47700 25716 7

C6665743

ORDER NO. 516

BARREL LENGTH

CAPACITY*

MODEL 700 TH M24

Remington

DUPONT

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

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

MODEL 700 TM M24

SERIAL NO. C6665743

ORDER NO. 5716

20

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

5716 C6665743

ORDER 5716
MODEL 700 TM M24
UPC

0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665743

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/26/91	KA
600	Proof		9/26/91	KA
607	Check Headspace		9/26/91	KA
610	Dis-assemble Gun		9/26/91	KA
612	Magnaflux Barrel Action	OCT	4 1991	KCA
	Magnaflux Bolt	OCT	4 1991	KCA
615	Rollmark Caliber	OCT	4 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	EB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-8-91	TA
	Apply Coating (Bolt)			TA
625	Final Assembly A) Clean inside of Bolt Assembly		11/1/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/1/91	KA
	C) Inspect Ejector Hole for Chamfer		11/1/91	KA
	D) Oil Firing Pin Ass'y		11/1/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-4-91	KA

QUALITY AUDIT

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	4			11-4-91	
	G) Safety Off Force	4	4	4			11-4-91	
	H) Trigger Pull Test & Retainability						11-4-91	
	I) Firing Pin Indent	.020	.020	.020			11-4-91	
	J) Assemble Stock						11/4/91	
	K) Assemble Swivel Studs						11-13-91	AC
	L) Attach Front and Rear Sight Assemblies						11/4/91	
	M) Iron Sight Alignment						11/4/91	
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	
	O) Attach Scope to Rifle						11/4/91	
	P) Detach & Attach Scope 20 Times						11/4/91	
640	Gallery Target & Test						11-5-91	
	A) Time						"	
	B) Malfunctions						"	
	C) Pierced Primers						"	
	D) Optical Clearity of Scope						"	
645	Inspect for Live Ammo						11-5-91	
655	Final Inspection A) Headspace						11-13-91	AC
	B) Trigger Pull	247	249	246	253	252	11-6-91	
	C) Function						11-13-91	AC
660	Pack						12-10-91	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6665743

DATE 11-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.35	2.38	2.47	MIN. SETTING,
PULL #2	2.26	2.34	2.36	2.49	NO AVG. OF 5
PULL #3	2.26	2.33	2.35	2.46	READINGS ACCEPT-
PULL #4	2.18	2.33	2.30	2.53	ABLE LESS THAN 2#
PULL #5	2.33	2.35	2.35	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.32		
PULL #2	3.42	3.40		
PULL #3	3.41	3.38		
PULL #4	3.39	3.37		
PULL #5	3.37	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	4.21	4.24		4.41
PULL #2	4.25	4.37		4.40
PULL #3	4.25	4.37		4.46
PULL #4	4.28	4.36		4.48
PULL #5	4.30	4.34		4.40
TOTAL				
AVG.				

CONTROL DISTANCE CALCULATIONS
[illegible] RIFLE # 26665743
[illegible] No. 1391

CONTROL DISTANCES

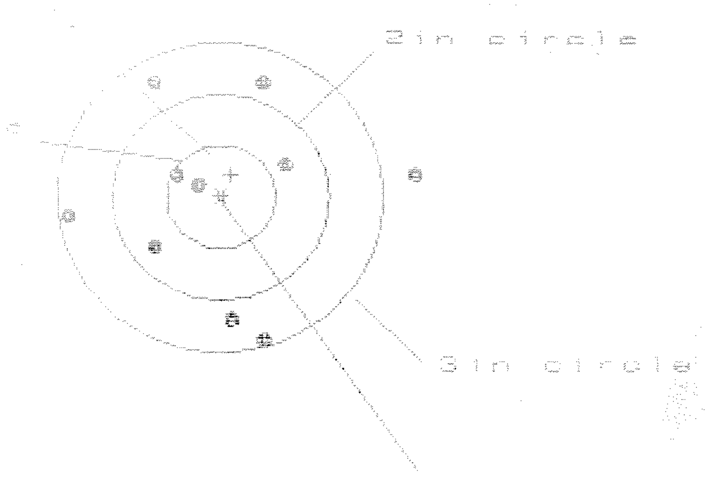
0	TO 1	.234386
1	TO 2	.382001
1	TO 3	.198323
1	TO 4	.152738
1	TO 5	.296096

THE AVERAGE [illegible] ORDINATE FOR THIS RIFLE IS: .0328
THE AVERAGE [illegible] ORDINATE FOR THIS RIFLE IS: -.0636
THE RESULTANT [illegible] VERTICAL FOR THIS RIFLE IS: .0715598

THE [illegible] FOR THIS RIFLE IS: [illegible]

CENTERFIRE PATT/C6685743.1

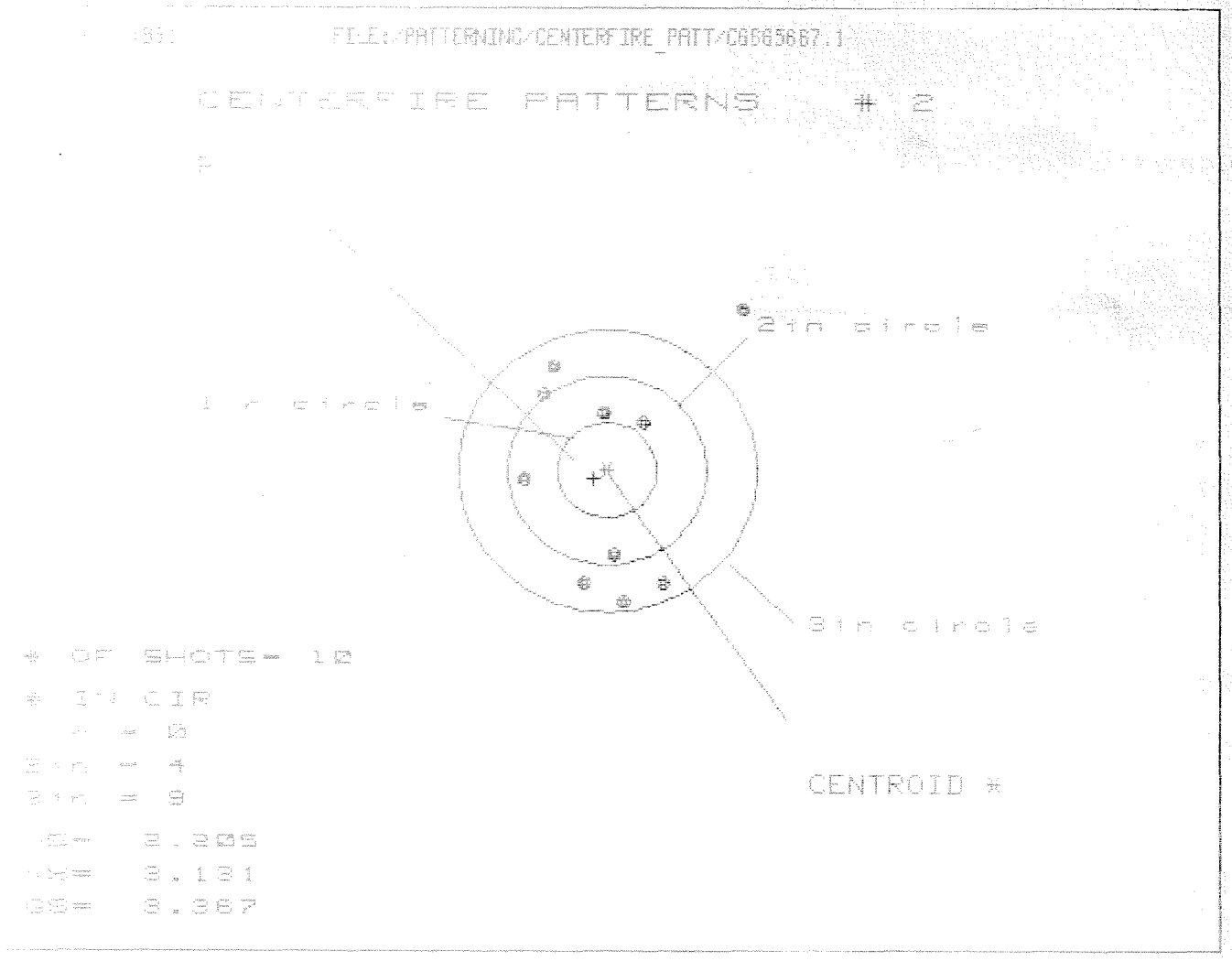
PATTERNS # 1



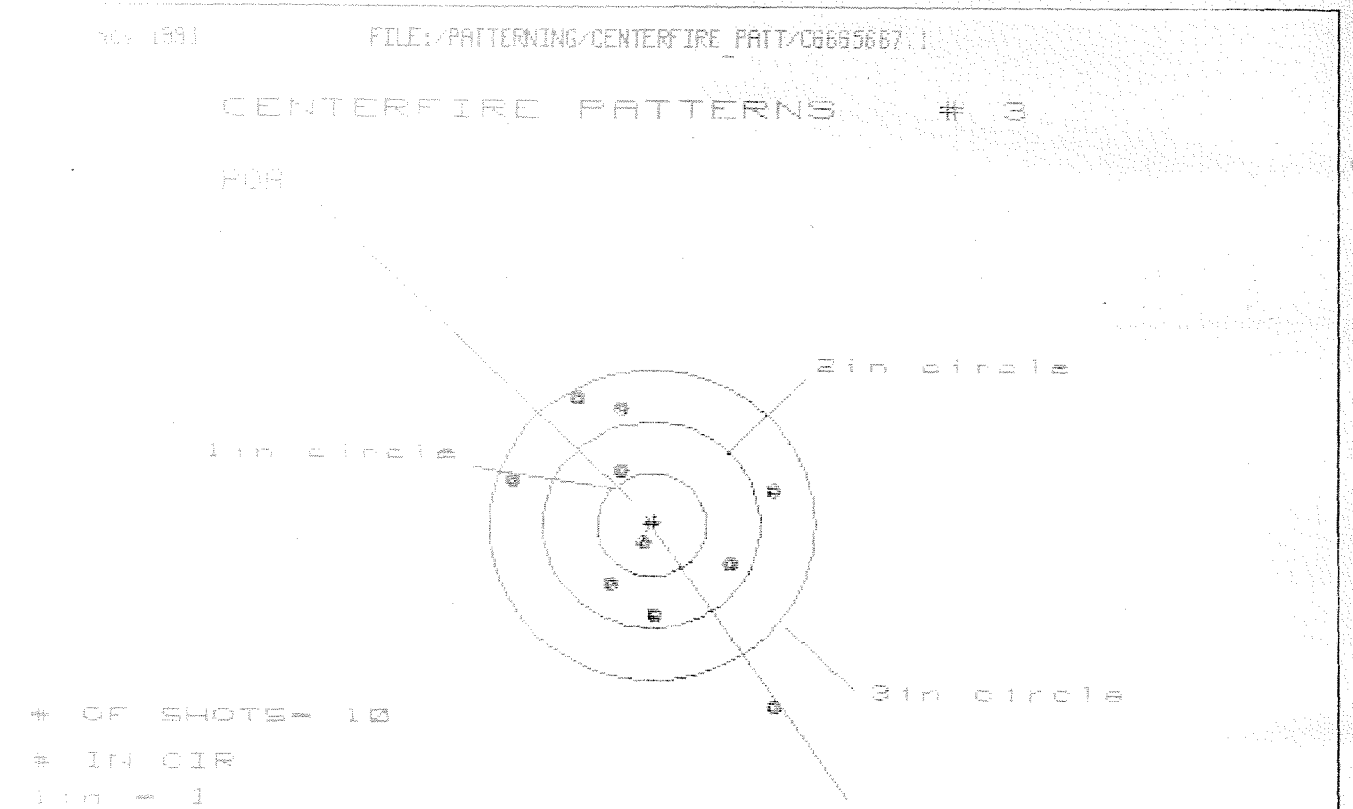
SHOTS = 10
= 4
= 3
3.228
2.530
3.242

#	:	[redacted]		
(BEST OF)	:	10	9	8
MAXIMUM X	:	1.832	.756	.832
[illegible]	:	-1.363	-1.184	-1.108
[illegible]	:	1.155	1.177	1.008
[illegible]	:	-1.377	-1.353	-1.231
[illegible]	:	[illegible]	-.295	-.371
[illegible]	:	[illegible]	-.238	-.069
[illegible]	:	.2?4	.379	.378
[illegible]	:	.21?	.135	.105
[illegible]	:	1.34?	.922	.824
[illegible]	:	1.544	1.484	1.327
SPREAD	:	3.228	1.940	1.940
SPREAD	:	2.530	2.530	2.289
SPREAD	:	3.242	1.725	2.385

INCH CIRCLE = 2
INCH CIRCLE = 4
INCH CIRCLE = 5



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	.751	.785
MINIMUM X	:	-.970	-.722	-.680
MAXIMUM Y	:	1.724	1.284	1.132
MINIMUM Y	:	-1.407	-1.216	-1.191
CENTROID X	:	.139	-.009	-.043
CENTROID Y	:	.089	-.102	.050
AVG TO CENTROID in.	:	.165	.103	.066
AVG RADIUS	:	.612	.730	.677
MAX RADIUS	:	1.149	1.018	.972
SD RADIUS	:	2.180	1.356	1.352
HORIZONTAL SPREAD	:	2.205	1.473	1.473
VERTICAL SPREAD	:	3.131	2.500	2.323
EXTREME SPREAD	:	3.367	2.598	2.529
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.166	1.287	1.214
MINIMUM X	:	-1.317	-1.196	-1.269
MAXIMUM Y	:	1.238	1.044	1.109
MINIMUM Y	:	-1.725	-1.054	-.924
CENTROID X	:	-.017	-.138	-.065
CENTROID Y	:	-.032	.160	.030
POA TO CENTROID in.	:	.036	.211	.071
MIN RADIUS	:	.152	.318	.190
MEAN RADIUS	:	1.041	.924	.871
MAX RADIUS	:	2.041	1.297	1.322
HORIZONTAL SPREAD	:	2.483	2.483	2.483
VERTICAL SPREAD	:	2.961	2.098	2.033
EXTREME SPREAD	:	3.464	2.484	2.484
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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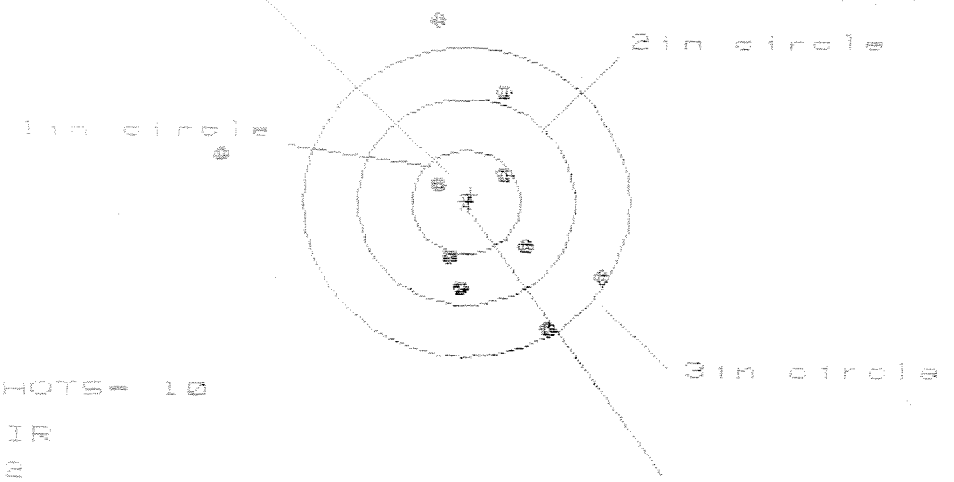
CENTERFIRE PATTERNS # 4

POA

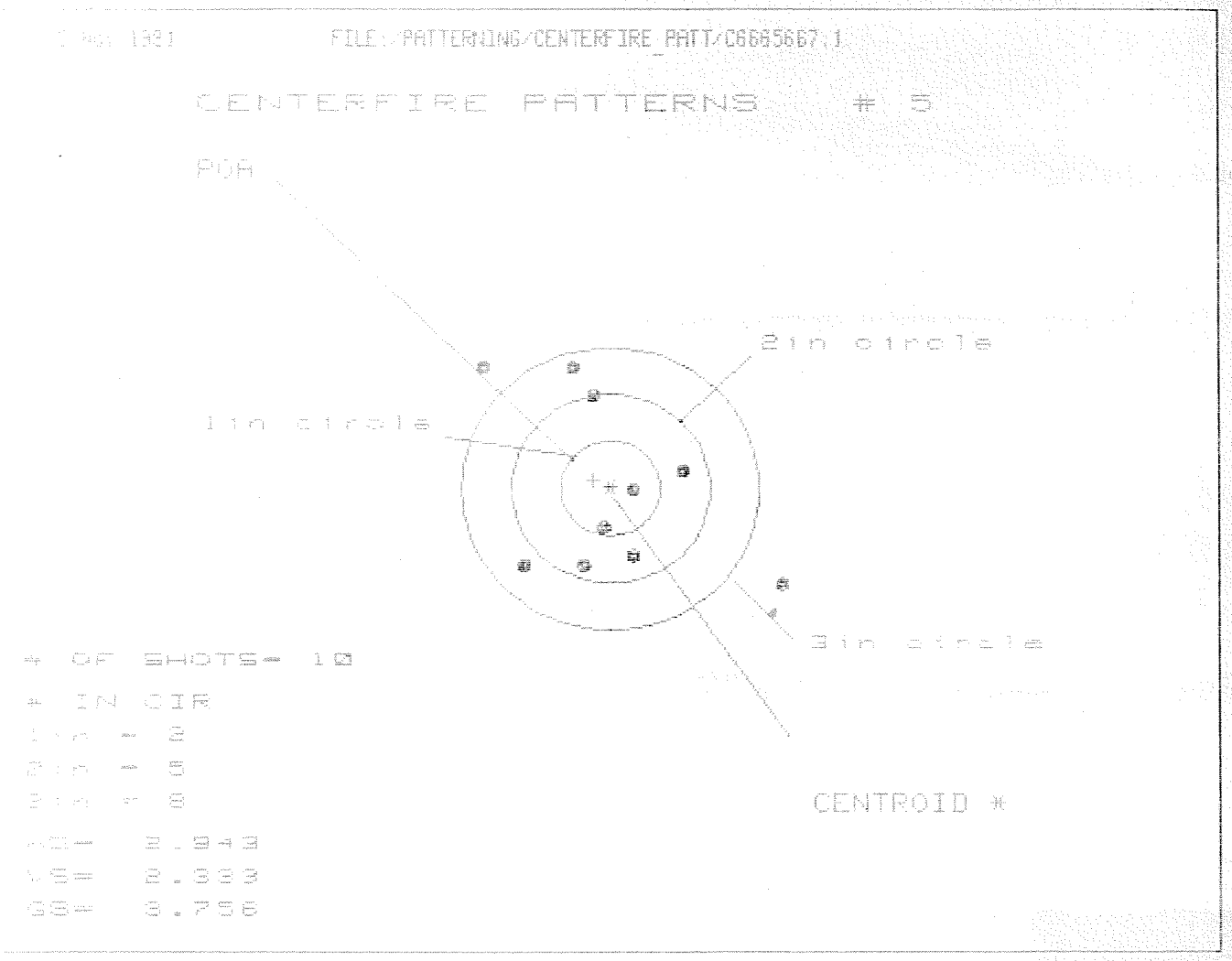


OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 8

ME= 3.522
MS= 2.872
GS= 3.707

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	.970	.900
MINIMUM X	:	-2.297	-.556	-.600
MAXIMUM Y	:	1.783	1.884	1.327
MINIMUM Y	:	-1.189	-1.138	-.900
CENTROID X	:	-.043	.212	.202
CENTROID Y	:	-.071	-.122	-.352
POA TO CENTROID in.	:	.083	.245	.451
MIN RADIUS	:	.320	.307	.221
MEAN RADIUS	:	1.087	.918	.759
MAX RADIUS	:	2.343	1.917	1.327
HORIZONTAL SPREAD	:	3.522	1.526	1.500
VERTICAL SPREAD	:	2.972	2.972	2.235
EXTREME SPREAD	:	3.707	3.151	2.276
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.702	.917	-.785
MINIMUM X	:	-1.241	-1.052	-.772
MAXIMUM Y	:	1.296	1.181	1.320
MINIMUM Y	:	-1.037	-.972	-.825
CENTROID X	:	.178	-.013	.119
CENTROID Y	:	-.088	.027	-.120
POA TO CENTROID in.	:	.197	.030	.169
MIN RADIUS	:	.272	.469	.333
MEAN RADIUS	:	1.039	.957	.826
MAX RADIUS	:	1.993	1.581	1.350
HORIZONTAL SPREAD	:	2.941	1.969	1.557
VERTICAL SPREAD	:	2.333	2.153	2.145
EXTREME SPREAD	:	3.756	2.468	2.164
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	