

C6349043

MODEL 700™ M24

Model **SMS**™

Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700TM M24

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

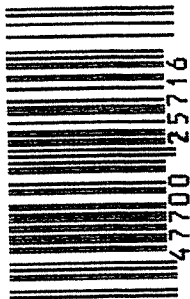
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6349043	Ø1
ORDER NO. 5716	



5716 C6349043

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349043

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 30 90	RW
600	Proof		1 30 90	K
607	Check Headspace		1 30 90	K
610	Dis-assemble Gun		1 30 90	RW
612	Magnaflux Barrel Action		2-5-90	KER
	Magnaflux Bolt		2-5-90	
615	Rollmark Caliber		2-5-90	CS
617	Drill and Tap Sight Holes		2-5-90	FB
618	Polish Barrel RB		2-5-90	WB
620	Apply Coatings (Barrel Action)		2-17-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/19/90	WB
	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		4/18/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/19/90	RL
	G) Safety Off Force	3	3	3			4/19/90	RL
	H) Trigger Pull Test & Retainability						4/19/90	RL
	I) Firing Pin Indent	1021	1022	10225			4/19/90	RL
	J) Assemble Stock						4/19/90	RL
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/19/90	RL
	M) Iron Sight Alignment						4/19/90	RL
	N) Detach Front & Rear Sights & place in numbered container						4/19/90	RL
	O) Attach Scope to Rifle						4/20/90	RL
	P) Detach & Attach Scope 20 Times						4/20/90	RL
640	Gallery Target & Test						4-20-90	AC
	A) Time						4-20-90	AC
	B) Malfunctions						4-20-90	AC
	C) Pierced Primers						4-20-90	AC
	D) Optical Clarity of Scope						4-20-90	AC
645	Inspect for Live Ammo						4-20-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace							
	B) Trigger Pull	2.33	2.30	2.29	2.31	2.32	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6-19-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. CL349043

DATE 4/18/90

TESTER gll

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.48	2.50	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.46	2.45	2.30	
PULL #3	2.54	2.51	2.43	2.29	
PULL #4	2.52	2.47	2.31	2.31	
PULL #5	2.52	2.55	2.40	2.32	
TOTAL	12.57	12.47	12.09		
AVG.	2.514	2.494	2.418		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.49		
PULL #2	3.49	3.50		
PULL #3	3.46	3.46		
PULL #4	3.34	3.33		
PULL #5	3.47	3.50		
TOTAL	17.20	17.25		
AVG.	3.44	3.45		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.13		4.41
PULL #2	4.28	4.21		4.43
PULL #3	4.21	4.15		4.43
PULL #4	4.21	4.19		4.38
PULL #5	4.20	4.18		4.43
TOTAL	21.21	20.86		22.08
AVG.	4.242	4.172		4.416

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349043
20 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.0465298
1 TO	2	.469013
1 TO	3	.428551
1 TO	4	.460196
1 TO	5	.200125

30
400 <----PDR

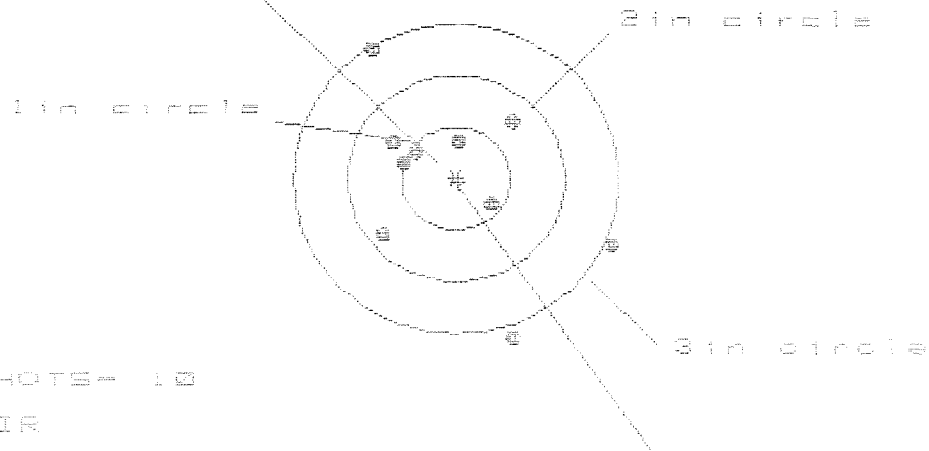
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0124
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3312
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .331432
THE AMP FOR THIS RIFLE IS: .8384

28 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349043

CENTERFIRE PATTERNS # 1

FOR



→ OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

MEAN = 2.131

SE = 3.625

CS = 3.098

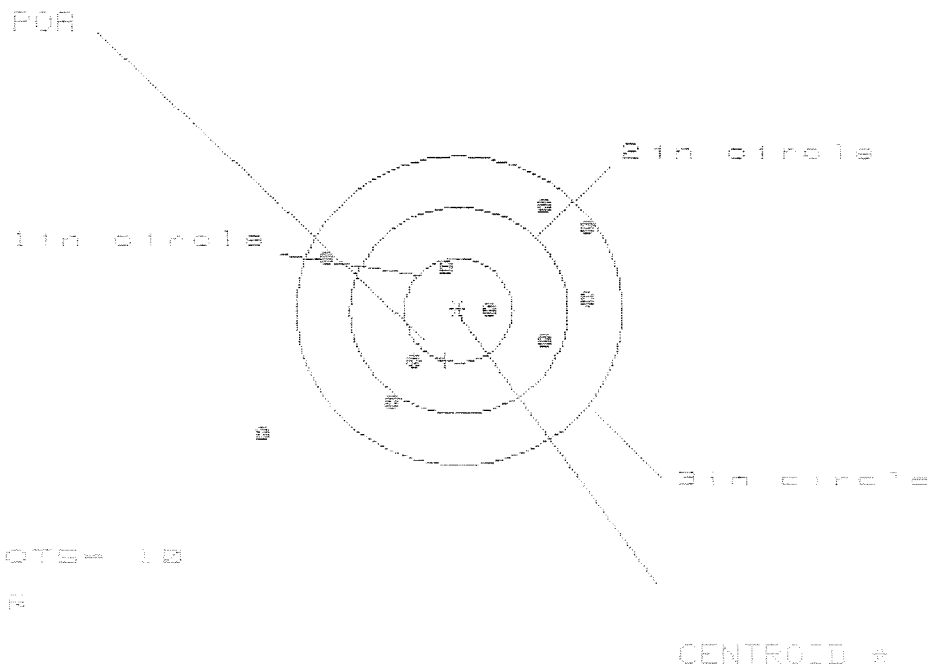
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.398	1.458	.792
MINIMUM X	:	-.733	-.673	-.491
MAXIMUM Y	:	1.306	1.138	1.036
MINIMUM Y	:	-1.519	-.817	-.849
CENTROID X	:	-.022	-.082	-.264
CENTROID Y	:	.041	.209	.311
FOR TO CENTROID in:	:	.046	.225	.408
MIN RADIUS	:	.338	.198	.169
MEAN RADIUS	:	.867	.745	.587
MAX RADIUS	:	1.611	1.671	1.146
HORIZONTAL SPREAD	:	2.131	2.131	1.283
VERTICAL SPREAD	:	2.025	1.955	1.084
EXTREME SPREAD	:	3.098	2.892	1.884
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

28 Apr 1998

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CENTERFIRE PATTERNS # 2



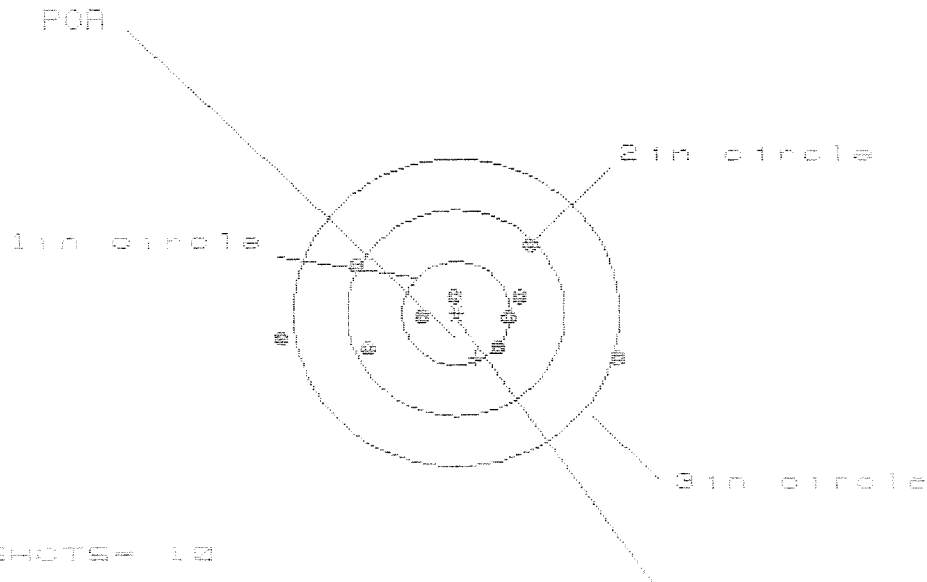
OF SHOTS = 10
 # IN 1IN
 1IN = 2
 2IN = 4
 3IN = 8
 MEAN = 2.046
 MS = 2.196
 SS = 3.683

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	.989	1.071
MINIMUM X	-1.852	-1.414	-1.291
MAXIMUM Y	.980	.845	.935
MINIMUM Y	-1.216	-1.069	-1.979
CENTROID X	.120	.325	.282
CENTROID Y	.488	.623	.532
POR TO CENTROID in.	.502	.703	.570
MIN RADIUS	.317	.146	.232
MEAN RADIUS	1.069	.900	.863
MAX RADIUS	2.215	1.470	1.381
HORIZONTAL SPREAD	3.046	2.403	2.362
VERTICAL SPREAD	2.196	1.914	1.914
EXTREME SPREAD	3.683	2.533	2.395
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

28 Apr 1998

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CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

* IN CIR

1in = 4

2in = 7

3in = 8

HE = 2.061

VE = 1.140

CE = 2.067

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.467	1.290	.696
MINIMUM X	:	-1.594	-1.134	-.973
MAXIMUM Y	:	.664	.634	.571
MINIMUM Y	:	-.475	-.506	-.421
CENTROID X	:	-.183	-.006	-.167
CENTROID Y	:	.436	.467	.636
POA TO CENTROID IN.	:	.473	.467	.556
DIP RADIUS	:	.203	.249	.118
MEAN RADIUS	:	.813	.704	.614
MAX RADIUS	:	1.618	1.386	1.034
HORIZONTAL SPREAD	:	3.061	2.424	1.669
VERTICAL SPREAD	:	1.140	1.140	.992
EXTREME SPREAD	:	3.067	2.592	1.778
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

MEAN = 1.780

SD = 2.493

SE = 3.588

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.973

1.030

.626

MINIMUM X

:

-.813

-.766

-.639

MAXIMUM Y

:

.971

.801

.709

MINIMUM Y

:

-1.522

-.743

-.678

CENTROID X

:

.040

-.007

-.134

CENTROID Y

:

.497

.667

.759

POR TO CENTROID in.

:

.499

.667

.771

MIN RADIUS

:

.275

.206

.072

MEAN RADIUS

:

.745

.686

.502

MAX RADIUS

:

1.580

1.261

.759

HORIZONTAL SPREAD

:

1.786

1.786

1.265

VERTICAL SPREAD

:

2.493

1.544

1.387

EXTREME SPREAD

:

2.588

1.983

1.388

NUMBER IN ONE INCH CIRCLE =

:

2

7

9

NUMBER IN TWO INCH CIRCLE =

:

7

9

NUMBER IN THREE INCH CIRCLE =

:

9

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FILE:/PATTERNING/CENTERFIRE_PATT/C8349043

CENTERFIRE PATTERNS

5

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

CS= 2.327

VS= 1.074

GS= 2.383

CENTROID *

PATTERN #	1	5	9	8
SHOTS (BEST OF)	10		9	8
MAXIMUM X	1.076		.937	.768
MINIMUM X	-1.251		-.641	-.524
MAXIMUM Y	.551		.574	.537
MINIMUM Y	-.523		-.500	-.537
CENTROID X	.107		.246	.129
CENTROID Y	.194		.171	.200
POB TO CENTROID in.	.221		.300	.245
MIN RADIUS	.199		.249	.220
MEAN RADIUS	.658		.585	.525
MAX RADIUS	1.267		.982	.937
HORIZONTAL SPREAD	2.327		1.578	1.292
VERTICAL SPREAD	1.074		1.074	1.074
EXTREME SPREAD	2.383		1.702	1.560
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	