

C6349088

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M2400107578

POTENTIAL SUBJECT TO PROTECTIVE ORDER




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

MODEL 700™ H24

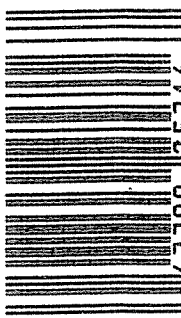
SERIAL NO.
C6349088

ORDER NO.
5716

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



UPC



0 47700 25716 7



5716 C6349088

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349088

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3 31 90	RW
600	Proof		3 31 90	RW
607	Check Headspace		3 31 90	RW
610	Dis-assemble Gun		3 31 90	RW
612	Magnaflux Barrel Action		4-2-90	KCR
	Magnaflux Bolt		4-2-90	KCR
615	Rollmark Caliber		4-2-90	SL
617	Drill and Tap Sight Holes		4/4/90	KCB
618	Polish Barrel RB		4/3/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	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		4/23/90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/23/90	DH
	G) Safety Off Force	2	2	2			4/23/90	JH
	H) Trigger Pull Test & Retainability						4/23/90	JH
	I) Firing Pin Indent	.0215	.0215	.021			4/23/90	JH
	J) Assemble Stock						4/23/90	RW
	K) Assemble Swivel Studs						4/30/90	WB
	L) Attach Front and Rear Sight Assemblies						4/23/90	RW
	M) Iron Sight Alignment						4/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/90	RW
	O) Attach Scope to Rifle						4/23/90	WB
	P) Detach & Attach Scope 20 Times						4/23/90	WB
640	Gallery Target & Test						4-24-90	DH
	A) Time						4-24-90	DH
	B) Malfunctions						4-24-90	DH
	C) Pierced Primers						4-24-90	DH
	D) Optical Clarity of Scope						4-24-90	DH
645	Inspect for Live Ammo						4-24-90	DH
655	Final Inspection						4/26/90	WB
	A) Headspace							
	B) Trigger Pull	2.66	2.62	2.69	2.59	2.70	4/26/90	WB
	C) Function						4/30/90	WB
660	Pack						6/19/90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349088

DATE 4/23/90

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.32	2.46	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.34	2.41	2.62	
PULL #3	2.54	2.36	2.42	2.69	
PULL #4	2.54	2.48	2.42	2.59	
PULL #5	2.51	2.48	2.46	2.70	
TOTAL	12.59	11.98	12.17		
AVG.	2.518	2.396	2.434		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.38		
PULL #2	3.36	3.38		
PULL #3	3.40	3.38		
PULL #4	3.36	3.37		
PULL #5	3.40	3.36		
TOTAL	16.89	16.87		
AVG.	3.378	3.374		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.41		4.22
PULL #2	4.24	4.44		4.24
PULL #3	4.23	4.51		4.21
PULL #4	4.40	4.50		4.20
PULL #5	4.18	4.50		4.20
TOTAL	21.49	22.36		21.07
AVG.	4.298	4.472		4.214

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349088
24 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.36004
1 TO	2	.300661
1 TO	3	.43106
1 TO	4	.703031
1 TO	5	.504822

$\frac{2d^4}{l}$ <----POA

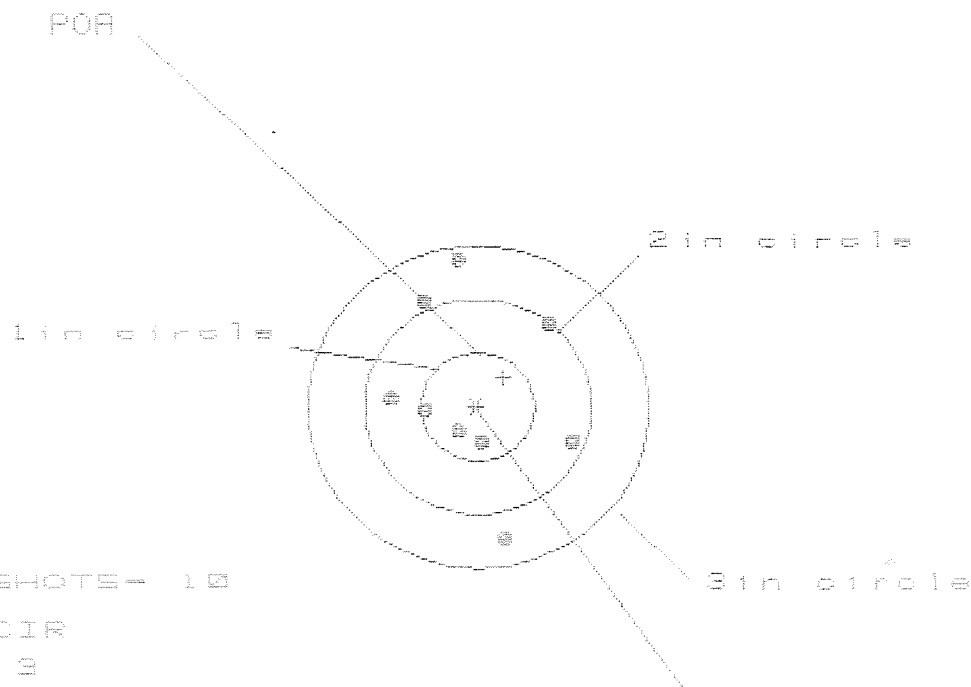
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0612
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212791
THE AMR FOR THIS RIFLE IS: .874

24 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349088

CENTERFIRE PATTERNS

1



* OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.585

VS= 2.590

GS= 2.620

CENTROID *

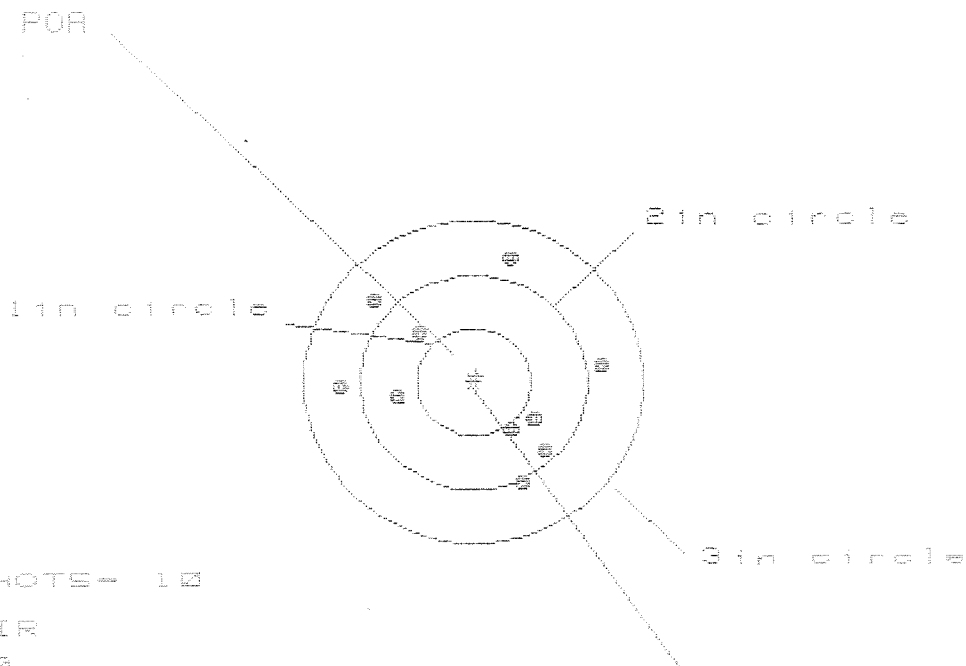
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.837	.818	.845
MINIMUM X	-.748	-.767	-.740
MAXIMUM Y	1.409	1.121	.993
MINIMUM Y	-1.181	-1.024	-1.152
CENTROID X	-.230	-.211	-.238
CENTROID Y	-.277	-.434	-.306
POA TO CENTROID in.	.360	.483	.388
MIN RADIUS	.270	.155	.243
MEAN RADIUS	.852	.761	.732
MAX RADIUS	1.420	1.212	1.174
HORIZONTAL SPREAD	1.585	1.585	1.585
VERTICAL SPREAD	2.590	2.145	2.145
EXTREME SPREAD	2.620	2.247	2.245
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8345088

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.301

VS= 2.064

GS= 2.315

CENTROID #

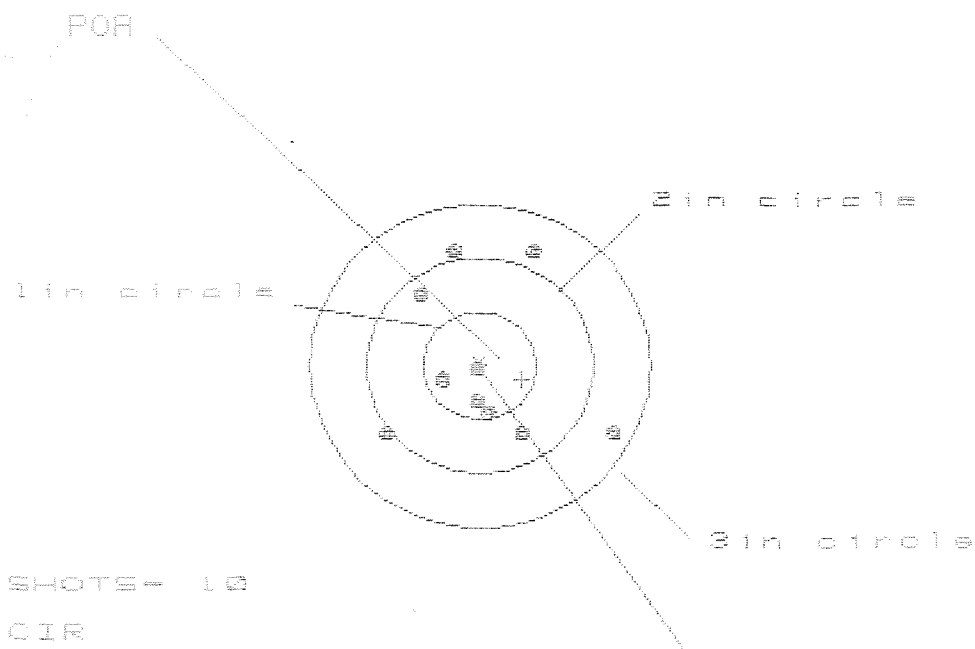
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.119	.988	1.006
MINIMUM X	:	-1.182	-1.011	-.993
MAXIMUM Y	:	1.146	1.139	.858
MINIMUM Y	:	-.918	-.925	-.783
CENTROID X	:	-.024	.107	.088
CENTROID Y	:	-.058	-.051	-.193
POR TO CENTROID in.	:	.063	.118	.212
MIN RADIUS	:	.551	.488	.377
MEAN RADIUS	:	.904	.861	.796
MAX RADIUS	:	1.184	1.239	1.312
HORIZONTAL SPREAD	:	2.301	1.999	1.999
VERTICAL SPREAD	:	2.064	2.064	1.641
EXTREME SPREAD	:	2.315	2.102	2.102
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Apr 1990

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CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS = 2.033

VS = 1.782

GS = 2.285

CENTROID #

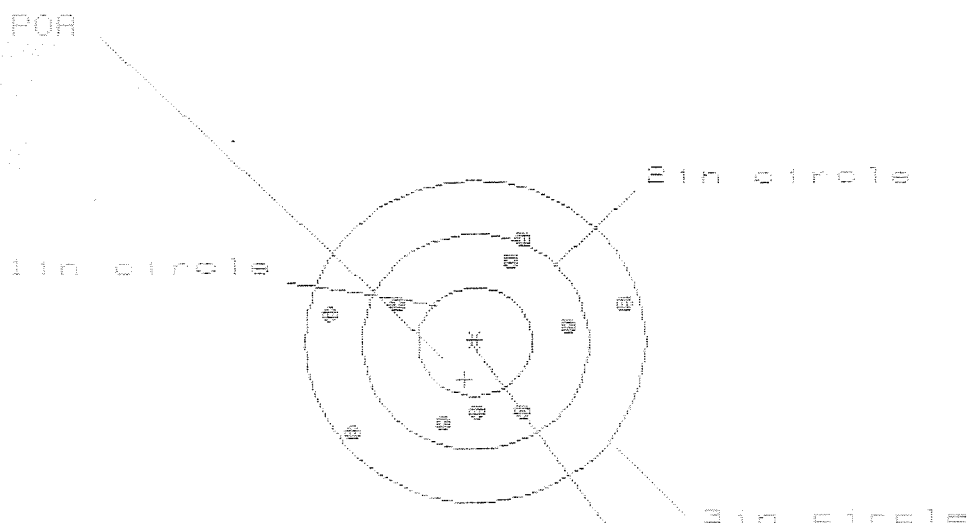
PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	.570	.610
MINIMUM X	-.837	-.704	-.633
MAXIMUM Y	1.111	1.038	1.146
MINIMUM Y	-.671	-.744	-.614
CENTROID X	-.372	-.505	-.576
CENTROID Y	.130	.203	.073
POA TO CENTROID in.	.394	.544	.581
MIN RADIUS	.070	.114	.136
MEAN RADIUS	.759	.691	.594
MAX RADIUS	1.366	1.184	1.148
HORIZONTAL SPREAD	2.033	1.274	1.243
VERTICAL SPREAD	1.782	1.782	1.760
EXTREME SPREAD	2.285	2.191	1.848
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 2.627

VS= 1.827

GS= 2.656

CENTROID *

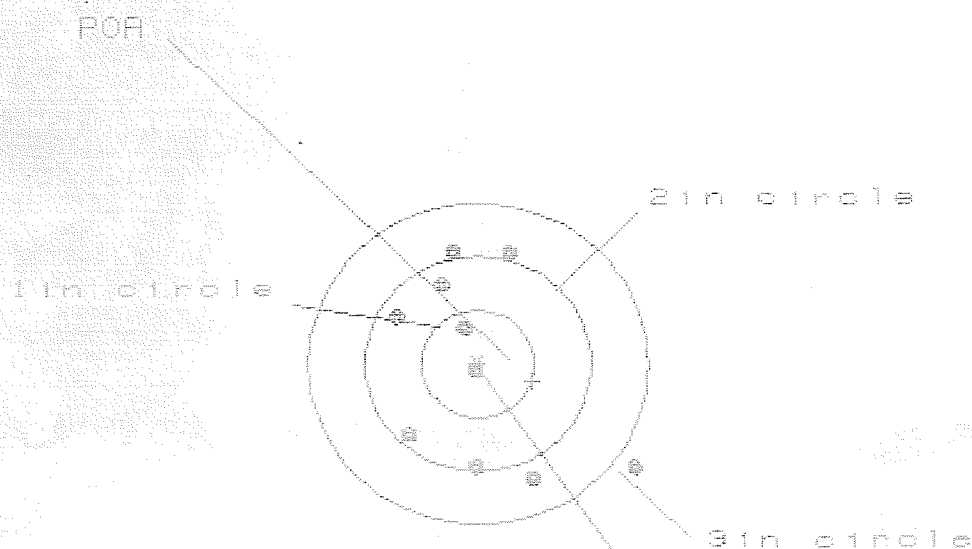
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	1.170	.988
MINIMUM X	:	-1.334	-1.457	-.961
MAXIMUM Y	:	.994	.901	.924
MINIMUM Y	:	-.833	-.862	-.839
CENTROID X	:	.088	.211	.393
CENTROID Y	:	.350	.443	.420
POA TO CENTROID in.	:	.361	.490	.575
MIN RADIUS	:	.609	.685	.554
MEAN RADIUS	:	.976	.919	.829
MAX RADIUS	:	1.382	1.468	1.017
HORIZONTAL SPREAD	:	2.627	2.627	1.949
VERTICAL SPREAD	:	1.827	1.763	1.763
EXTREME SPREAD	:	2.656	2.627	1.949
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
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 = 9

HS= 2.068

VS= 2.117

GS= 2.550

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	.594	.492
MINIMUM X	:	-.686	-.532	-.458
MAXIMUM Y	:	1.065	.962	.818
MINIMUM Y	:	-1.052	-1.155	-1.170
CENTROID X	:	-.481	-.635	-.709
CENTROID Y	:	.161	.264	.408
POA TO CENTROID in.	:	.508	.687	.818
MIN RADIUS	:	.045	.207	.114
MEAN RADIUS	:	.879	.767	.671
MAX RADIUS	:	1.662	1.298	1.184
HORIZONTAL SPREAD	:	2.068	1.126	.950
VERTICAL SPREAD	:	2.117	2.117	1.988
EXTREME SPREAD	:	2.550	2.208	2.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	