

C6636017

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

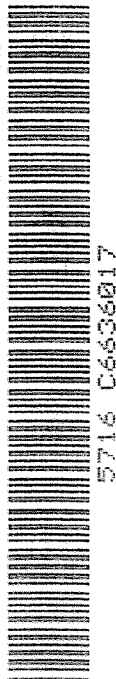
Capacity

Order No. **5716**

*Includes 1 in chamber.

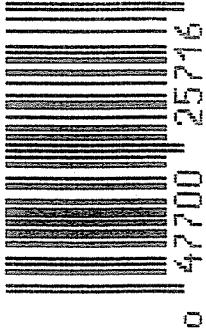


Remington HODEL 700 TH M24		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		SERIAL NO. C6636017	ORDER NO. 5716



5716 C6636017

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636017

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	9 1	RW
600	Proof	4 8	9 1	RW
607	Check Headspace		9 7	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	"
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 19 1991	EB
618	Polish Barrel		APR 19 1991	EB
620	Apply Coatings (Barrel Action)		5-10-91	TSX
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JM

Op. #	BARBER - M24 0036718 OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	5	5	7			6/4/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			6/4/91	WB
	H) Trigger Pull Test & Retainability						6-4-91	JH
	I) Firing Pin Indent	.0215	.022	.0215			6/4/91	WB
	J) Assemble Stock						6/4/91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/4/91	RW
	M) Iron Sight Alignment						6/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	RW
	O) Attach Scope to Rifle						6/4/91	RW
	P) Detach & Attach Scope 20 Times						6/4/91	RW
540	Gallery Target & Test						6-5-91	D/H
	A) Time						6-5-91	D/H
	B) Malfunctions						6-5-91	D/H
	C) Pierced Primers						6-5-91	D/H
	D) Optical Clarity of Scope						6-5-91	D/H
545	Inspect for Live Ammo						6-5-91	D/H
555	Final Inspection						6-8-91	D/H
	A) Headspace							
	B) Trigger Pull	2.27	2.17	2.33	2.33	2.44	6-8-91	JH
	C) Function						6-8-91	D/H
560	Pack						6-20-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6636017

DATE 6-4-91

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.39	2.50	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.56	2.56	2.17	
PULL #3	2.56	2.57	2.55	2.33	
PULL #4	2.57	2.58	2.46	2.33	
PULL #5	2.56	2.46	2.44	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.31		
PULL #2	3.42	3.44		
PULL #3	3.45	3.50		
PULL #4	3.24	3.45		
PULL #5	3.42	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.48		4.59
PULL #2	4.53	4.55		4.36
PULL #3	4.50	4.16		4.34
PULL #4	4.54	4.55		4.55
PULL #5	4.20	4.59		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636017
5 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.164657
1 TO	2	.282843
1 TO	3	.418126
1 TO	4	.135724
1 TO	5	.11136

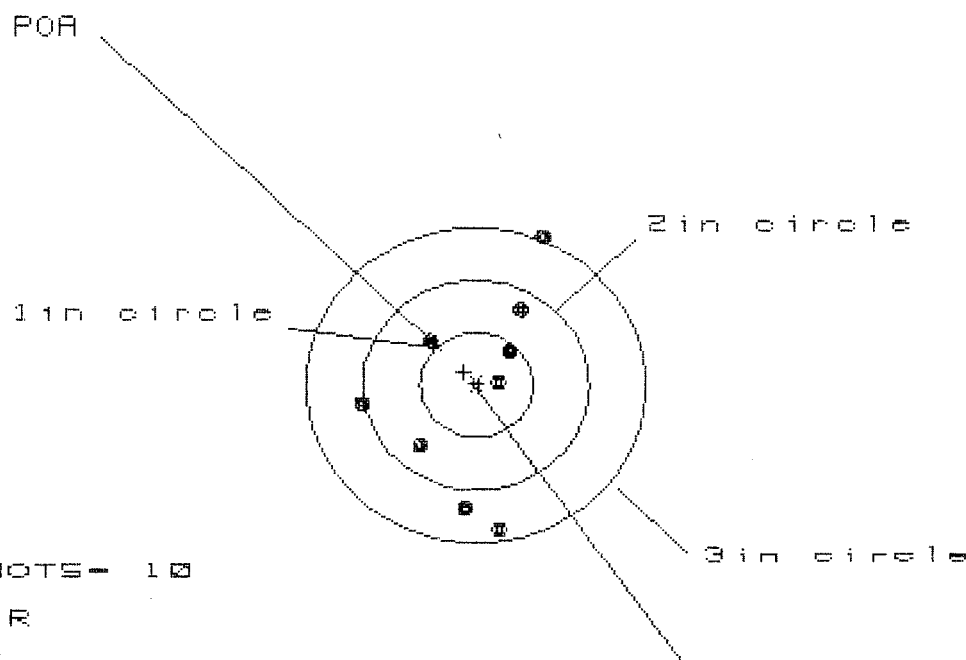
$\frac{3}{16}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1926
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0532
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199812
THE AMR FOR THIS RIFLE IS: .9612

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636017

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.589

VS= 2.780

GS= 2.807

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.578	.485	.517
MINIMUM X	-1.011	-.946	-.914
MAXIMUM Y	1.423	.914	.764
MINIMUM Y	-1.357	-1.199	-1.192
CENTROID X	.106	.041	.009
CENTROID Y	-.126	-.284	-.135
POA TO CENTROID in.	.165	.287	.135
MIN RADIUS	.236	.353	.332
MEAN RADIUS	.849	.790	.708
MAX RADIUS	1.536	1.226	1.192
HORIZONTAL SPREAD	1.589	1.431	1.431
VERTICAL SPREAD	2.780	2.113	1.956
EXTREME SPREAD	2.807	2.125	2.026
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 1.463

VS= 3.936

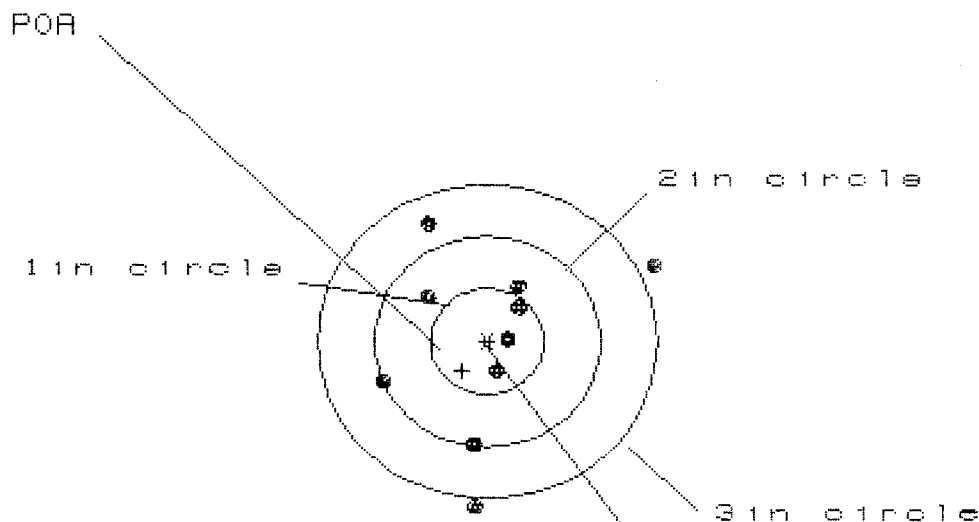
GS= 4.047

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.830	.752
MINIMUM X	:	-.688	-.633	-.711
MAXIMUM Y	:	1.755	1.513	1.694
MINIMUM Y	:	-2.181	-1.614	-1.433
CENTROID X	:	.354	.299	.377
CENTROID Y	:	-.262	-.020	-.201
POA TO CENTROID in.	:	.440	.300	.427
MIN RADIUS	:	.132	.371	.197
MEAN RADIUS	:	1.221	1.117	1.025
MAX RADIUS	:	2.236	1.628	1.705
HORIZONTAL SPREAD	:	1.463	1.463	1.463
VERTICAL SPREAD	:	3.936	3.127	3.127
EXTREME SPREAD	:	4.047	3.128	3.128
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.377

VS= 2.717

GS= 2.798

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.453	.448	.452
MINIMUM X	:	-.924	-.763	-.759
MAXIMUM Y	:	1.139	1.220	1.033
MINIMUM Y	:	-1.578	-1.497	-1.109
CENTROID X	:	.221	.059	.055
CENTROID Y	:	.276	.195	.382
POA TO CENTROID in.	:	.353	.203	.386
MIN RADIUS	:	.157	.310	.322
MEAN RADIUS	:	.855	.787	.675
MAX RADIUS	:	1.627	1.497	1.109
HORIZONTAL SPREAD	:	2.377	1.211	1.211
VERTICAL SPREAD	:	2.717	2.717	2.142
EXTREME SPREAD	:	2.798	2.753	2.181
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

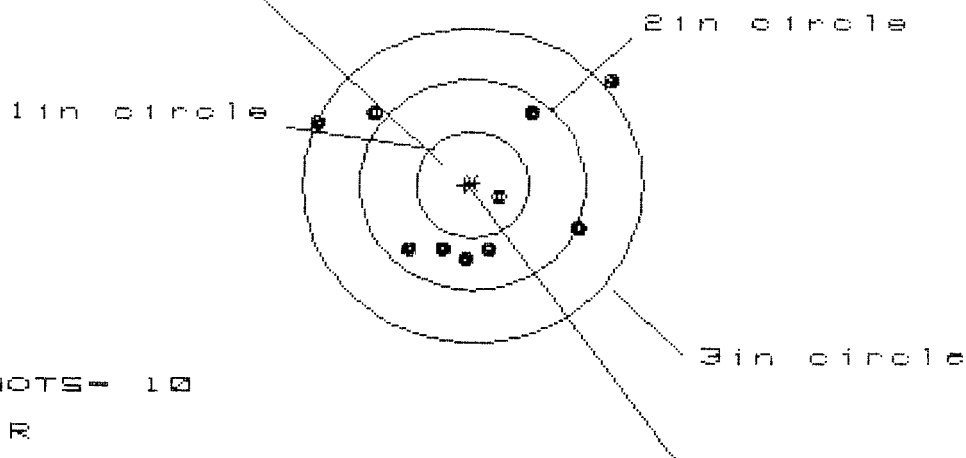
5 Jun 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.641

VS= 1.721

GS= 2.672

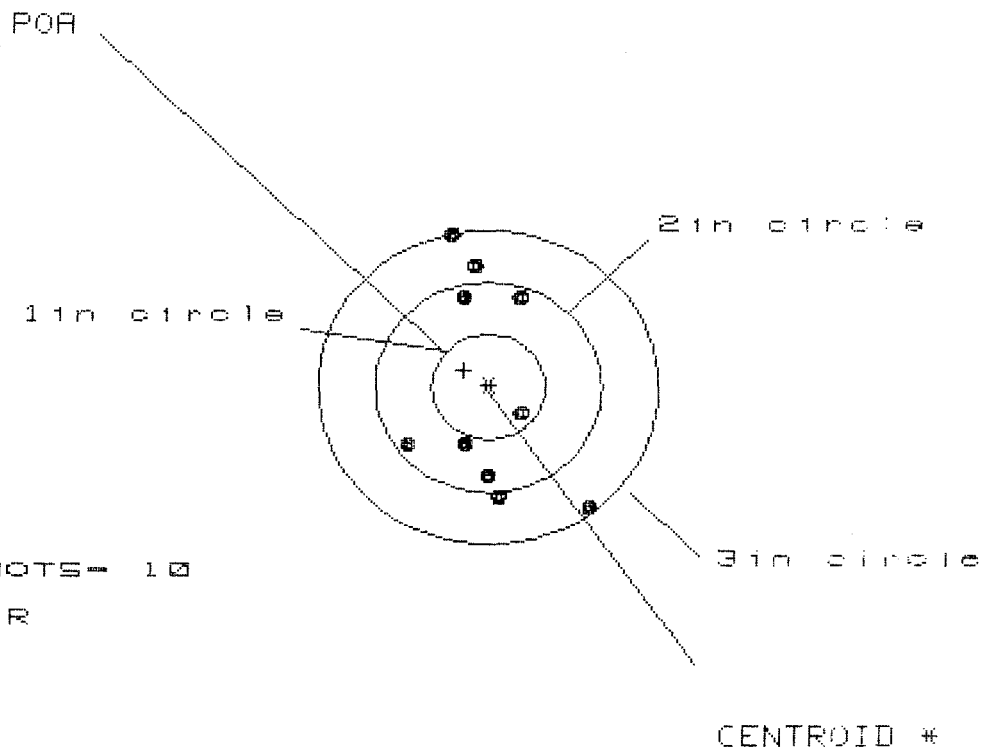
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.268	1.104	.950
MINIMUM X	:	-1.373	-1.232	-.925
MAXIMUM Y	:	1.022	.841	.932
MINIMUM Y	:	-.699	-.585	-.494
CENTROID X	:	.067	-.074	.080
CENTROID Y	:	.084	-.110	-.201
POA TO CENTROID in.	:	.067	.132	.216
MIN RADIUS	:	.273	.374	.227
MEAN RADIUS	:	.936	.835	.713
MAX RADIUS	:	1.629	1.432	1.313
HORIZONTAL SPREAD	:	2.641	2.336	1.875
VERTICAL SPREAD	:	1.721	1.426	1.426
EXTREME SPREAD	:	2.672	2.530	2.165
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.613

VS = 2.645

GS = 2.930

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.928	.891	.351
MINIMUM X	-.685	-.722	-.611
MAXIMUM Y	1.468	1.283	1.156
MINIMUM Y	-1.177	-1.014	-.971
CENTROID X	.215	.252	.141
CENTROID Y	-.158	-.321	-.194
POA TO CENTROID in.	.267	.408	.240
MIN RADIUS	.341	.240	.386
MEAN RADIUS	.945	.853	.800
MAX RADIUS	1.505	1.350	1.156
HORIZONTAL SPREAD	1.613	1.613	.962
VERTICAL SPREAD	2.645	2.297	2.127
EXTREME SPREAD	2.930	2.509	2.135
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		