

C6636172

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

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

MODEL 700TM H24

SERIAL NO.
C6636172

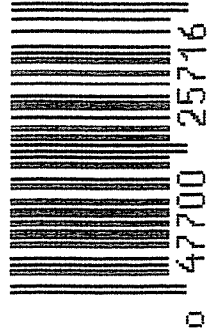
ORDER NO.
5716

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

5716 C6636172

05

UPC



Stock
Required

GUN SERIAL #

C6634172

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	JS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/24/91	KS
	C) Inspect Ejector Hole for Chamfer		5/24/91	KS
	D) Oil Firing Pin Ass'y		5/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/28/91	JS

op. #	BARBER - M24 0038542 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/28/91	JP
	G) Safety Off Force	3	3	3			5/28/91	JP
	H) Trigger Pull Test & Retainability						5/28/91	JP
	I) Firing Pin Indent	1.0225	1.0225	1.0225			5/28/91	JP
	J) Assemble Stock						5/28/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/28/91	KS
	M) Iron Sight Alignment						5/28/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	KS
	O) Attach Scope to Rifle						5/28/91	KS
	P) Detach & Attach Scope 20 Times						5/28/91	KS
640	Gallery Target & Test						5/28/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/29/91	KE
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.25	2.19	2.33	2.35	2.31	6/1/91	JP
	C) Function						6-1-91	D/H
660	Pack						6-20-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 1663172

DATE 5-28-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.20	2.35	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.34	2.35	2.19	
PULL #3	2.25	2.31	2.29	2.33	
PULL #4	2.34	2.32	2.31	2.35	
PULL #5	2.38	2.31	2.33	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.36		
PULL #2	3.34	3.34		
PULL #3	3.37	3.36		
PULL #4	3.35	3.20		
PULL #5	3.35	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.37		4.48
PULL #2	4.52	4.20		4.50
PULL #3	4.51	4.40		4.48
PULL #4	4.38	4.42		4.51
PULL #5	4.33	4.47		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636172
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.186904
1 TO	2	.292099
1 TO	3	.357405
1 TO	4	.283387
1 TO	5	.301505

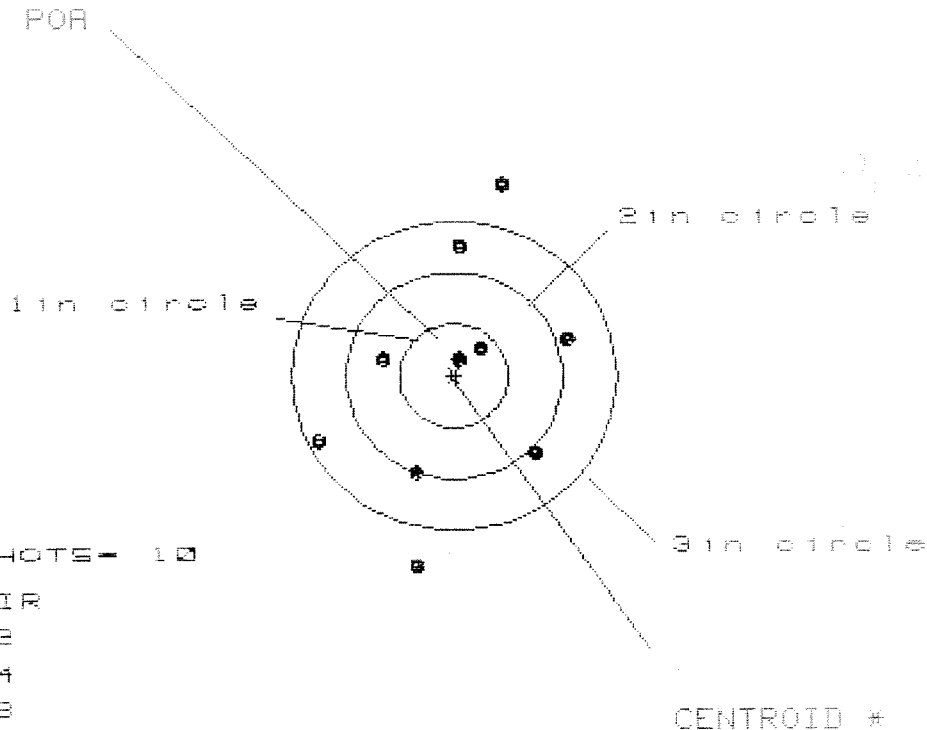
PP <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0426
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .125522
THE AMR FOR THIS RIFLE IS: .9638

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636172

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.311

VS= 3.660

GS= 3.746

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.075	1.118	1.073
MINIMUM X	:	-1.236	-1.193	-1.238
MAXIMUM Y	:	1.833	1.445	1.242
MINIMUM Y	:	-1.827	-1.624	-0.893
CENTROID X	:	-0.044	-0.087	-0.043
CENTROID Y	:	-0.161	-0.364	-0.161
POA TO CENTROID in.	:	.167	.375	.167
MIN RADIUS	:	.197	.402	.197
MEAN RADIUS	:	1.069	.994	.868
MAX RADIUS	:	1.875	1.663	1.374
HORIZONTAL SPREAD	:	2.311	2.311	2.311
VERTICAL SPREAD	:	3.660	3.069	2.135
EXTREME SPREAD	:	3.746	3.106	2.503
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

28 May 1991

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CENTERFIRE PATTERNS

2

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 3.973

VS = 2.530

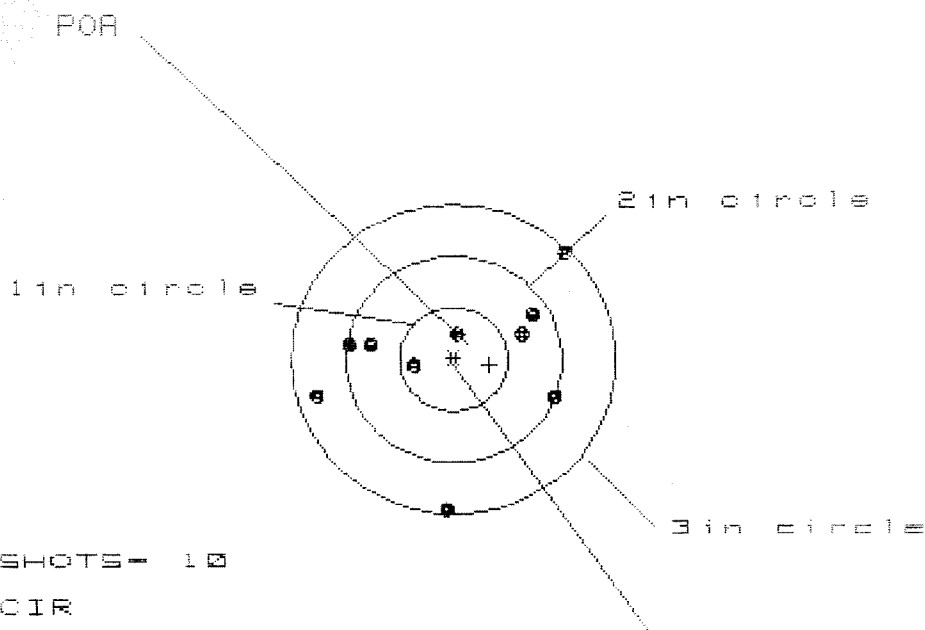
GS = 4.105

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.877	1.123	1.026
MINIMUM X	:	-1.095	-0.776	-0.807
MAXIMUM Y	:	1.138	1.116	0.959
MINIMUM Y	:	-1.392	-1.414	-1.571
CENTROID X	:	.065	-.254	-.157
CENTROID Y	:	.110	.132	.289
POR TO CENTROID in.	:	.128	.287	.329
MIN RADIUS	:	.366	.146	.102
MEAN RADIUS	:	1.242	.990	.892
MAX RADIUS	:	2.885	1.479	1.596
HORIZONTAL SPREAD	:	3.973	1.899	1.833
VERTICAL SPREAD	:	2.530	2.530	2.530
EXTREME SPREAD	:	4.105	2.794	2.678
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.217

VS = 2.437

GS = 2.653

CENTROID #

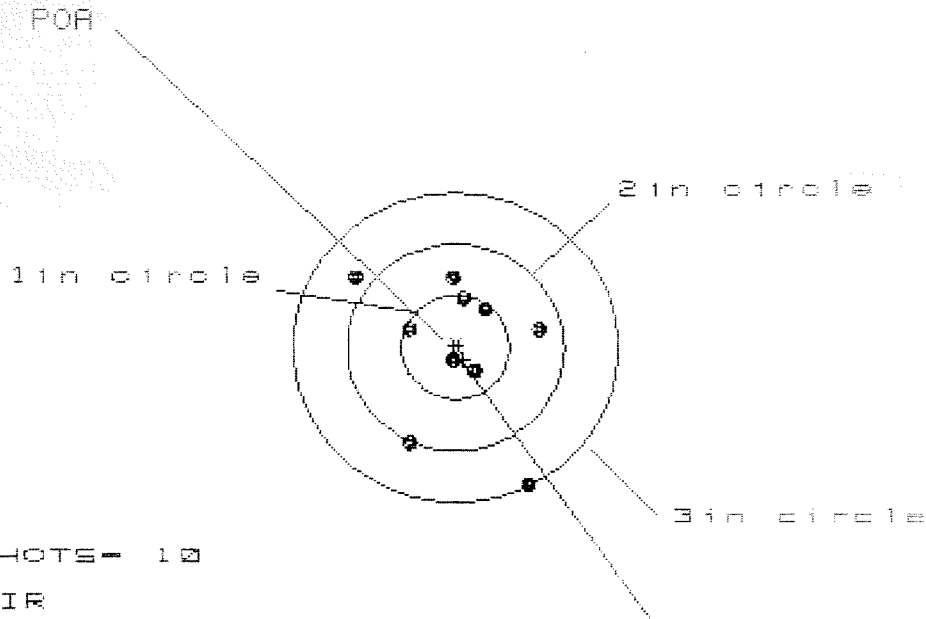
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.981	.974	1.035
MINIMUM X	:	-1.236	-1.243	-1.122
MAXIMUM Y	:	1.017	.859	.381
MINIMUM Y	:	-1.420	-.552	-.445
CENTROID X	:	-.331	-.324	-.445
CENTROID Y	:	.052	.210	.103
POA TO CENTROID in.	:	.335	.386	.457
MIN RADIUS	:	.296	.140	.227
MEAN RADIUS	:	.906	.826	.762
MAX RADIUS	:	1.422	1.360	1.207
HORIZONTAL SPREAD	:	2.217	2.217	2.157
VERTICAL SPREAD	:	2.437	1.411	.826
EXTREME SPREAD	:	2.653	2.628	2.163
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.672

VS= 2.047

CS= 2.592

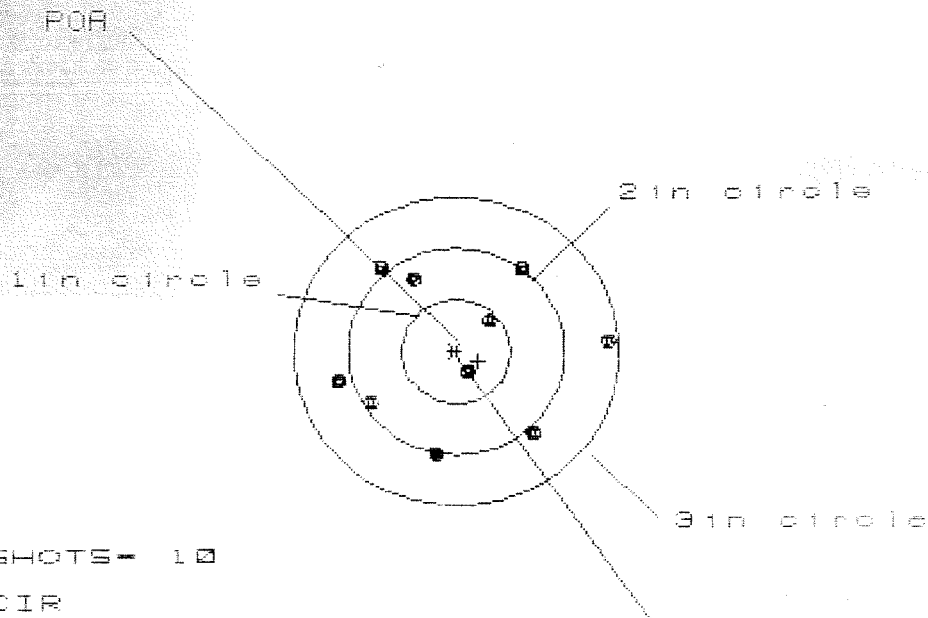
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.725	.797	.688
MINIMUM X	:	-.947	-.875	-.510
MAXIMUM Y	:	.722	.574	.628
MINIMUM Y	:	-1.325	-1.103	-1.031
CENTROID X	:	-.072	-.144	-.035
CENTROID Y	:	.121	.269	.197
POA TO CENTROID in.	:	.141	.305	.200
MIN RADIUS	:	.147	.278	.231
MEAN RADIUS	:	.695	.596	.527
MAX RADIUS	:	1.473	1.173	1.150
HORIZONTAL SPREAD	:	1.672	1.672	1.197
VERTICAL SPREAD	:	2.047	1.677	1.659
EXTREME SPREAD	:	2.592	1.748	1.716
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.535

VS= 1.801

GS= 2.558

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.429	.838	.720
MINIMUM X	-1.106	-.948	-.755
MAXIMUM Y	.823	.834	.805
MINIMUM Y	-.978	-.967	-.996
CENTROID X	-.208	-.366	-.248
CENTROID Y	.092	.081	.110
POA TO CENTROID in.	.227	.375	.271
MIN RADIUS	.246	.331	.279
MEAN RADIUS	.907	.847	.816
MAX RADIUS	1.432	1.122	1.056
HORIZONTAL SPREAD	2.535	1.786	1.475
VERTICAL SPREAD	1.801	1.801	1.801
EXTREME SPREAD	2.558	2.080	2.080
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	