

06523303

MODEL 706™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

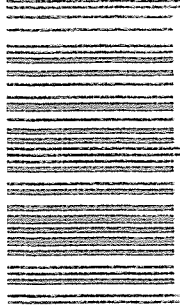
MODEL 700™ H24

SERIAL NO.
C6523303

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 C6523303

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523303

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KA
600	Proof		10/4/90	KA
607	Check Headspace		10/4/90	KA
610	Dis-assemble Gun		10/4/90	KA
612	Magnaflux Barrel Action		10/9/90	KR
	Magnaflux Bolt		10/9/90	KR
615	Rollmark Caliber		10/9/90	DB
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel <i>PB</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/31/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/90	KA
	C) Inspect Ejector Hole for Chamfer		10/31/90	KA
	D) Oil Firing Pin Ass'y		10/31/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11/2/90	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			1/18/91	WLB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			1/18/91	WLB
	H) Trigger Pull Test & Retainability						1-18-91	JD
	I) Firing Pin Indent	.020	.020	.020			1/18/91	WLB
	J) Assemble Stock						1/18/91	KS
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/18/91	KS
	M) Iron Sight Alignment						1/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/18/91	KS
	O) Attach Scope to Rifle						1/18/91	KS
	P) Detach & Attach Scope 20 Times						1/18/91	KS
640	Gallery Target & Test						1-21-91	AC
	A) Time						1-21-91	AC
	B) Malfunctions						1-21-91	AC
	C) Pierced Primers						1-21-91	AC
	D) Optical Clarity of Scope						1-21-91	AC
645	Inspect for Live Ammo						1-21-91	AC
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.19	2.32	2.36	2.41	2.44	2-1-91	JD
	C) Function						2-4-91	AC
660	Pack						3-19-91	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. 06523303

DATE 1-18-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.31	2.42	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.35	2.43	2.32	
PULL #3	2.36	2.33	2.31	2.36	
PULL #4	2.37	2.38	2.50	2.41	
PULL #5	2.31	2.31	2.38	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.50		
PULL #2	3.43	3.47		
PULL #3	3.44	3.45		
PULL #4	3.47	3.50		
PULL #5	3.44	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.29		4.32
PULL #2	4.26	4.16		4.30
PULL #3	4.29	4.29		4.27
PULL #4	4.28	4.18		4.33
PULL #5	4.26	4.28		4.37
TOTAL				
AVG.				

MOD.		GA. CAL.	GUN #
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Slides brass won't eject.	KS
	2nd	POLISHED EJECTOR Repol.	KS. 1/21/91
	3rd	shot OK 1-29-91	
	4th		

FUNCTION RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rds shot OK 1-79-91 DH	K5
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

M2400005875

SUBJECT TO PROTECTIVE ORDER

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523303
21 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.132883
1 TO	2	.182439
1 TO	3	.0672086
1 TO	4	.279045
1 TO	5	.27225

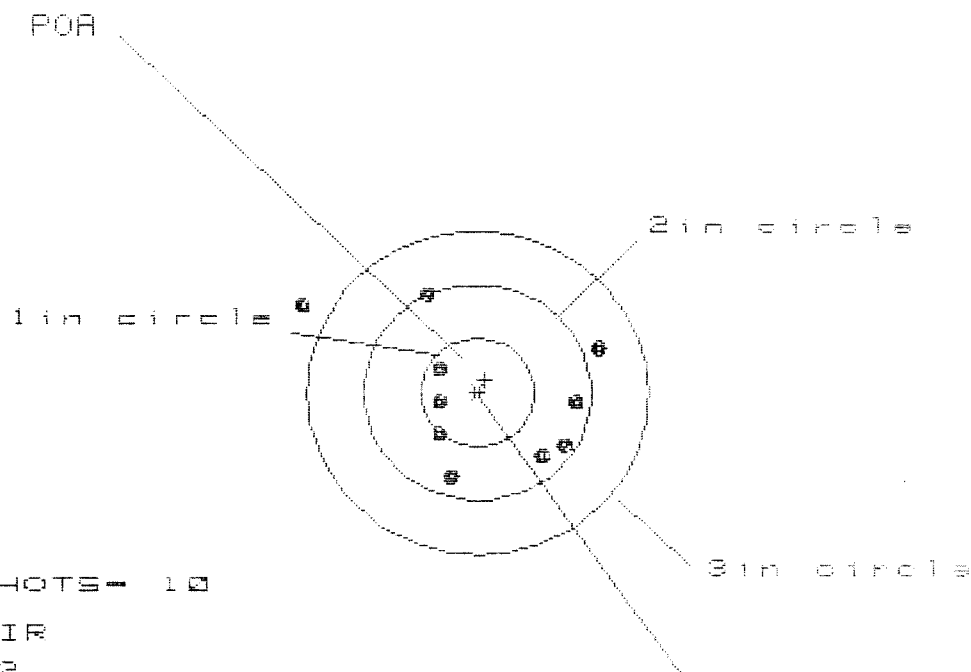
36 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0082
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00833464
THE AMR FOR THIS RIFLE IS: .9914

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06523303

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.570

VS= 1.663

GS= 2.611

CENTROID #

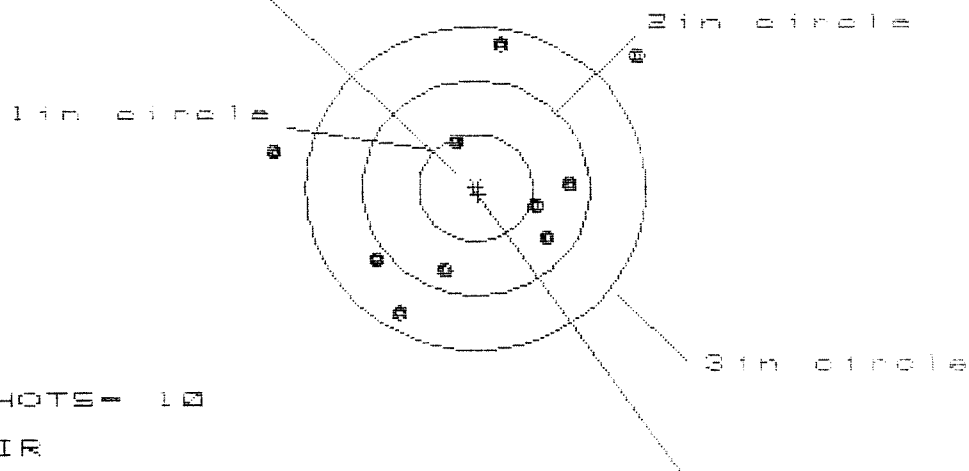
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.069	.902	.831
MINIMUM X	-1.501	-.646	-.533
MAXIMUM Y	.905	.997	1.061
MINIMUM Y	-.758	-.666	-.602
CENTROID X	-.063	.104	-.009
CENTROID Y	-.117	-.209	-.273
POA TO CENTROID in.	.133	.233	.273
MIN RADIUS	.335	.487	.378
MEAN RADIUS	.859	.755	.695
MAX RADIUS	1.711	1.188	1.187
HORIZONTAL SPREAD	2.570	1.548	1.364
VERTICAL SPREAD	1.663	1.663	1.663
EXTREME SPREAD	2.611	1.844	1.844
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

21 Jan 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.174

VS= 2.473

GS= 3.295

CENTROID *

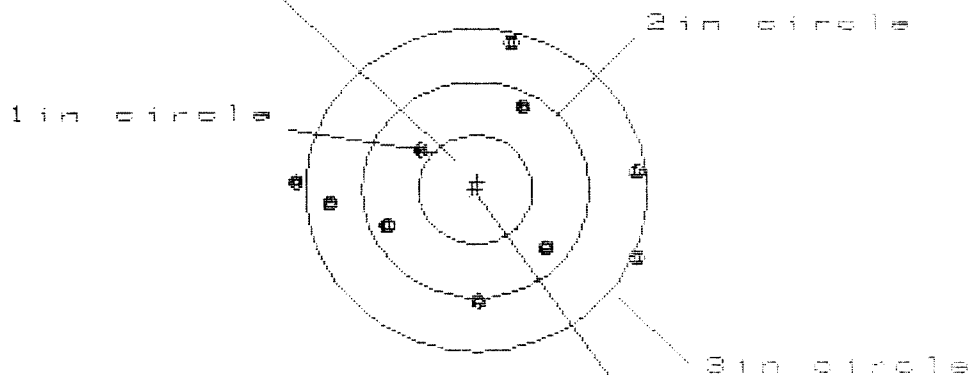
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.028	.832
MINIMUM X	:	-1.728	-1.567	-.880
MAXIMUM Y	:	1.300	1.439	1.502
MINIMUM Y	:	-1.173	-1.034	-.971
CENTROID X	:	-.023	-.184	.012
CENTROID Y	:	.061	-.078	-.141
POA TO CENTROID in.	:	.065	.200	.142
MIN RADIUS	:	.427	.537	.470
MEAN RADIUS	:	1.091	.993	.876
MAX RADIUS	:	1.912	1.646	1.519
HORIZONTAL SPREAD	:	3.174	2.595	1.712
VERTICAL SPREAD	:	2.473	2.473	2.473
EXTREME SPREAD	:	3.295	2.645	2.645
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Jan 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.024

VS= 2.401

GS= 3.102

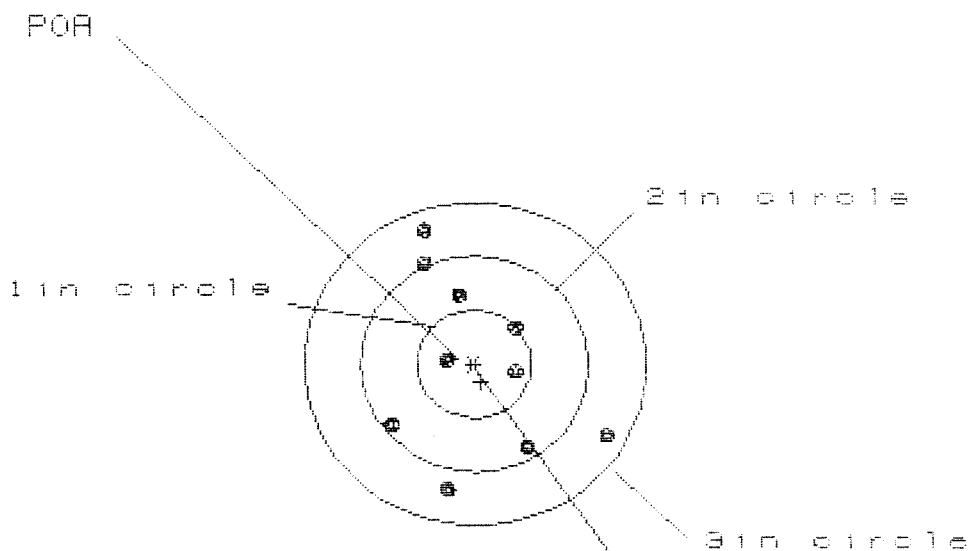
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.454	1.563	1.387
MINIMUM X	:	-1.570	-1.409	-1.290
MAXIMUM Y	:	1.326	1.258	1.261
MINIMUM Y	:	-1.075	-1.143	-1.140
CENTROID X	:	-.014	-.175	.001
CENTROID Y	:	-.071	-.003	-.006
POA TO CENTROID in.	:	.072	.175	.006
MIN RADIUS	:	.585	.418	.559
MEAN RADIUS	:	1.146	1.078	1.038
MAX RADIUS	:	1.575	1.565	1.389
HORIZONTAL SPREAD	:	3.024	2.972	2.677
VERTICAL SPREAD	:	2.401	2.401	2.401
EXTREME SPREAD	:	3.102	2.972	2.687
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.934

VS= 2.393

GS= 2.494

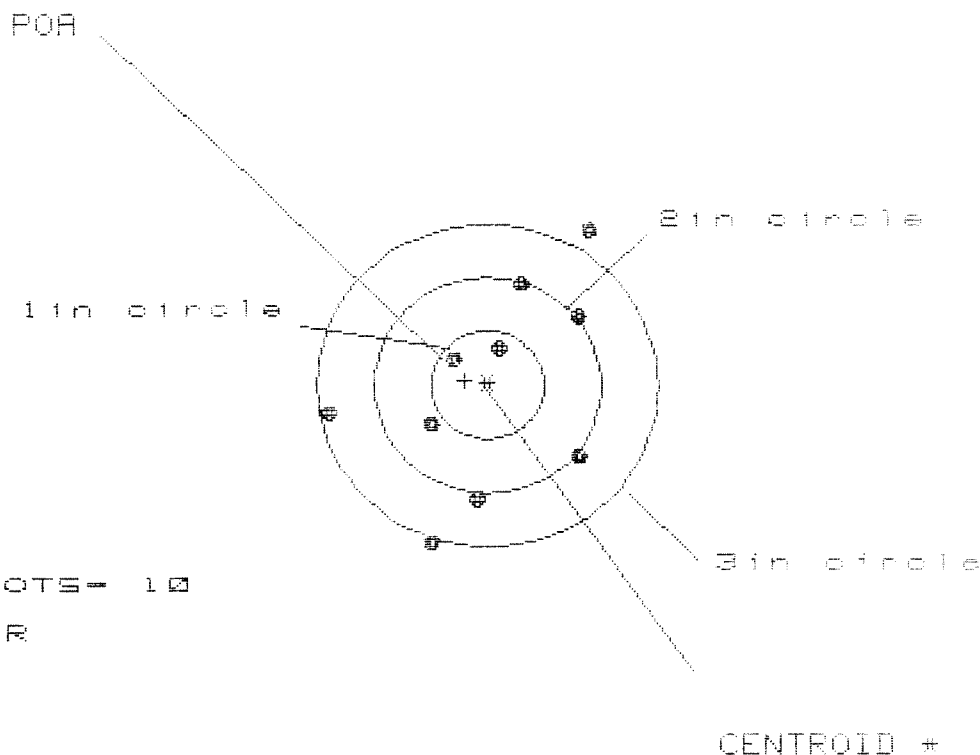
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.175	.589	.547
MINIMUM X	:	-.759	-.629	-.671
MAXIMUM Y	:	1.219	1.146	1.056
MINIMUM Y	:	-1.174	-1.247	-1.104
CENTROID X	:	-.058	-.189	-.147
CENTROID Y	:	.162	.235	.092
POA TO CENTROID in.	:	.172	.302	.173
MIN RADIUS	:	.237	.102	.189
MEAN RADIUS	:	.858	.790	.744
MAX RADIUS	:	1.346	1.257	1.122
HORIZONTAL SPREAD	:	1.934	1.218	1.218
VERTICAL SPREAD	:	2.393	2.393	2.160
EXTREME SPREAD	:	2.494	2.400	2.163
NUMBER IN ONE INCH CIRCLE	=		3	
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 = 3

HS= 2.231

VS= 2.929

GS= 3.226

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.867	.917
MINIMUM X	:	-1.374	-1.279	-1.329
MAXIMUM Y	:	1.488	1.062	.903
MINIMUM Y	:	-1.441	-1.276	-1.004
CENTROID X	:	.199	.104	.154
CENTROID Y	:	-.043	-.208	-.049
POA TO CENTROID in.	:	.204	.233	.161
MIN RADIUS	:	.367	.450	.385
MEAN RADIUS	:	1.003	.922	.847
MAX RADIUS	:	1.717	1.337	1.361
HORIZONTAL SPREAD	:	2.231	2.146	2.146
VERTICAL SPREAD	:	2.929	2.338	1.907
EXTREME SPREAD	:	3.226	2.475	2.350
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	