

06636220

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington



VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
item.

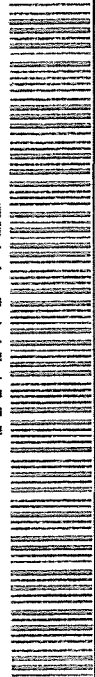
MODEL 700™ M24

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

20

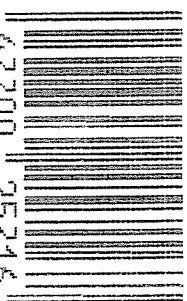
SERIAL NO.
06636220

ORDER NO.
5716



5716 06636220

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636 220

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	9 1	RW
600	Proof	4 30	9 1	RW
607	Check Headspace	4 30	9 1	RW
610	Dis-assemble Gun	4 30	9 1	RW
612	Magnaflux Barrel Action	5 6	9 1	Kcd
	Magnaflux Bolt	5 6	9 1	Kcd
615	Rollmark Caliber	5 6	9 1	GR
617	Drill and Tap Sight Holes	5 10	9 1	FB
618	Polish Barrel	5 10	9 1	WB
620	Apply Coatings (Barrel Action)		5-30-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-22-91	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	6			7-23-91	DH
	G) Safety Off Force	3	3	3			7-23-91	DH
	H) Trigger Pull Test & Retainability						7-22-91	JL
	I) Firing Pin Indent	.022	.020	.021			7-23-91	DH
	J) Assemble Stock						7/25/91	RW
	K) Assemble Swivel Studs						8/6/91	AC
	L) Attach Front and Rear Sight Assemblies						7/25/91	RW
	M) Iron Sight Alignment						7/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/25/91	RW
	O) Attach Scope to Rifle						7/25/91	RW
	P) Detach & Attach Scope 20 Times						7/25/91	RW
640	Gallery Target & Test						7-29-91	AC
	A) Time						7-29-91	AC
	B) Malfunctions						7-29-91	AC
	C) Pierced Primers						7-29-91	AC
	D) Optical Clarity of Scope						7-29-91	AC
645	Inspect for Live Ammo						7-27-91	AC
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.58	2.29	2.34	2.24	2.36	8-5-91	JL
	C) Function						8-5-91	K
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6636220
DATE 7-22-91
TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.54	2.40	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.24	2.44	2.29	
PULL #3	2.54	2.59	2.52	2.34	
PULL #4	2.35	2.48	2.50	2.24	
PULL #5	2.43	2.45	2.40	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.53		
PULL #2	3.64	3.34		
PULL #3	3.37	3.31		
PULL #4	3.36	3.32		
PULL #5	3.46	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.21		4.41
PULL #2	4.23	4.21		4.48
PULL #3	4.36	4.28		4.29
PULL #4	4.31	4.25		4.43
PULL #5	4.19	4.36		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636220
30 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.206073
1 TO	2	.471128
1 TO	3	.480051
1 TO	4	.149496
1 TO	5	.100125

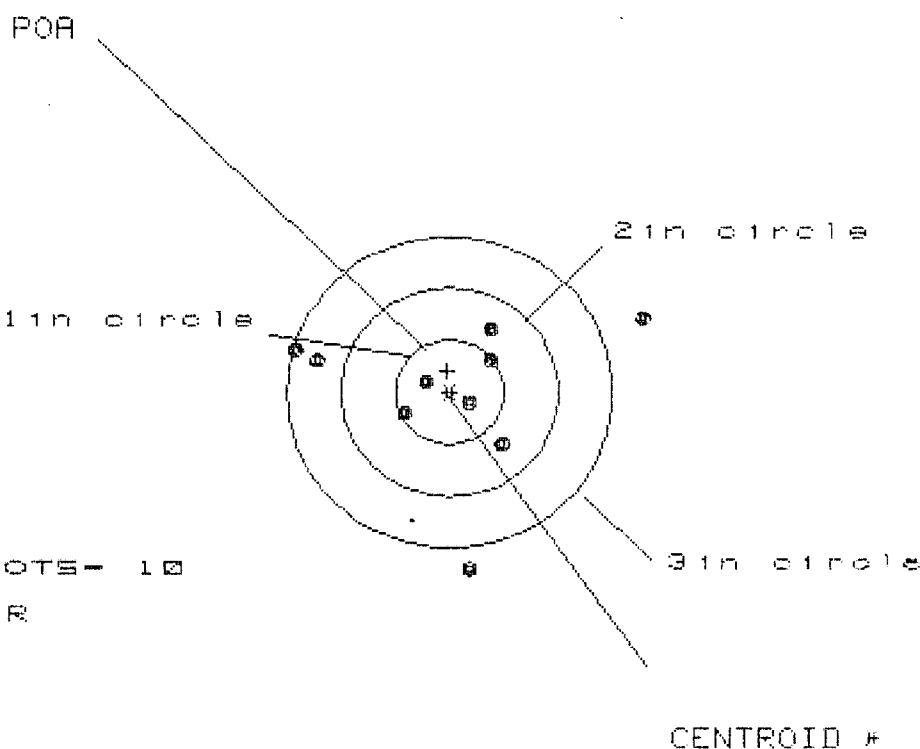
2 4 <----POA
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2756
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .299095
THE AMR FOR THIS RIFLE IS: .905

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836220

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 7

HS = 3.182

VS = 2.330

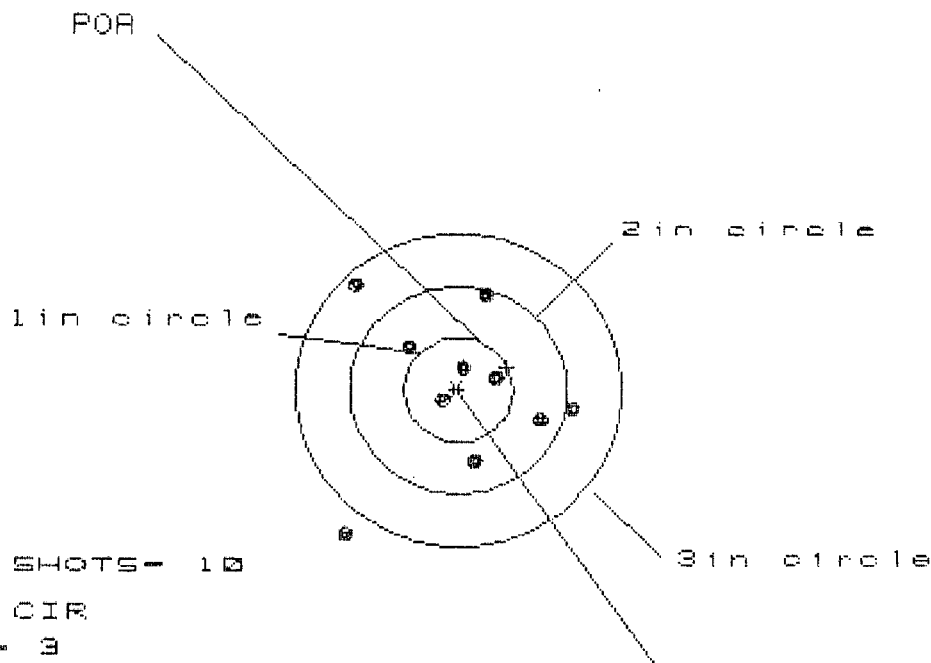
GS = 3.191

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.734	.657	.705
MINIMUM X	-1.448	-1.255	-1.207
MAXIMUM Y	.667	.653	.455
MINIMUM Y	-1.663	-1.589	-1.574
CENTROID X	.021	-.172	-.220
CENTROID Y	-.205	-.279	-.081
POA TO CENTROID in.	.206	.328	.234
MIN RADIUS	.152	.131	.075
MEAN RADIUS	.896	.790	.674
MAX RADIUS	1.858	1.635	1.245
HORIZONTAL SPREAD	3.182	1.912	1.912
VERTICAL SPREAD	2.330	2.242	1.028
EXTREME SPREAD	3.191	2.659	2.104
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.085

VS= 2.409

GS= 2.630

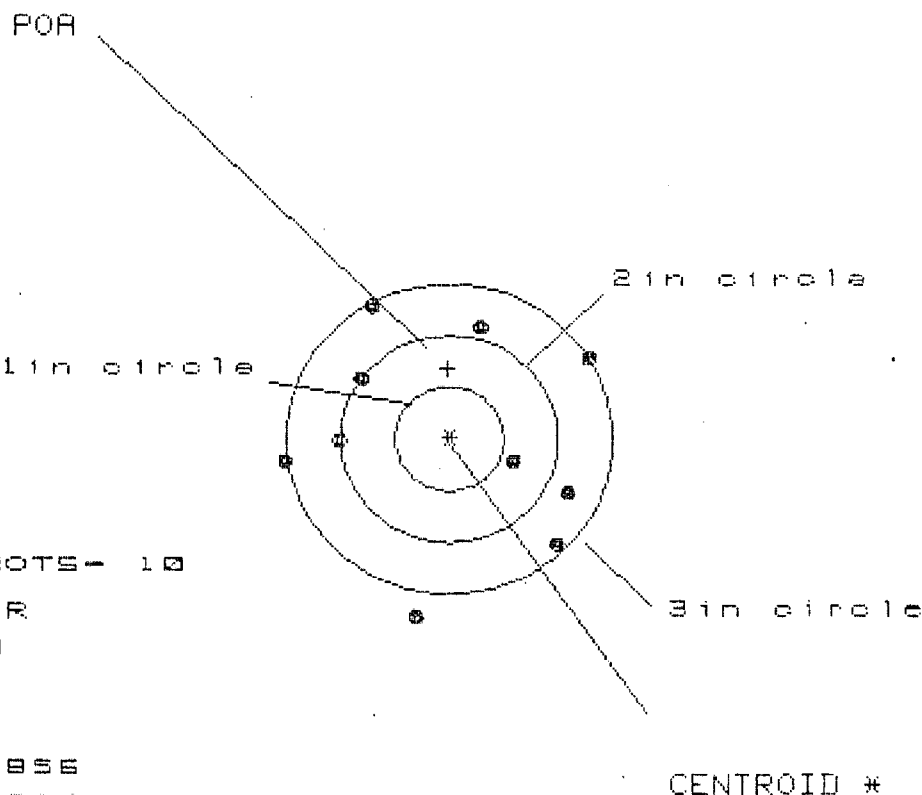
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.065
MINIMUM X	-1.020
MAXIMUM Y	1.015
MINIMUM Y	-1.394
CENTROID X	-.450
CENTROID Y	-.216
POA TO CENTROID in.	.499
MIN RADIUS	.181
MEAN RADIUS	.805
MAX RADIUS	1.727
HORIZONTAL SPREAD	2.085
VERTICAL SPREAD	2.409
EXTREME SPREAD	2.630
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.856

VS= 2.992

GS= 3.015

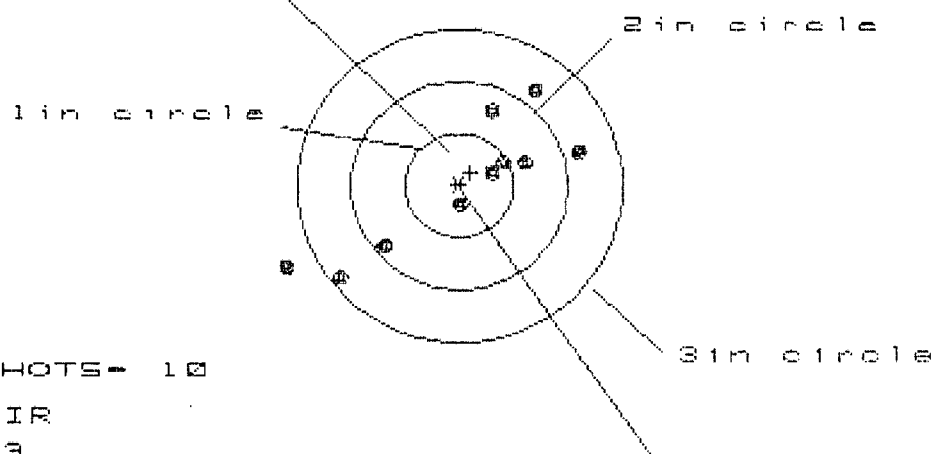
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.333
MINIMUM X	-1.524
MAXIMUM Y	1.257
MINIMUM Y	-1.735
CENTROID X	.014
CENTROID Y	-.685
POA TO CENTROID in.	.685
MIN RADIUS	.664
MEAN RADIUS	1.253
MAX RADIUS	1.766
HORIZONTAL SPREAD	2.856
VERTICAL SPREAD	2.992
EXTREME SPREAD	3.015
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	7

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.754

VS = 1.827

GS = 2.964

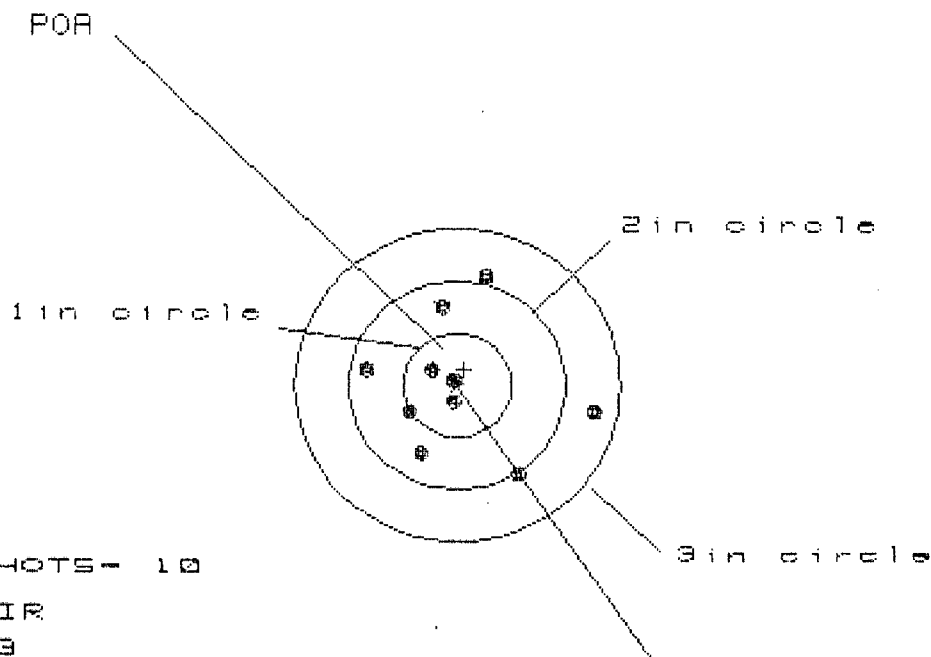
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.133	.952	.787
MINIMUM X	:	-1.621	-1.321	-1.034
MAXIMUM Y	:	.960	.869	.749
MINIMUM Y	:	-.867	-.958	-.814
CENTROID X	:	-.104	.077	.242
CENTROID Y	:	-.123	-.032	.088
POA TO CENTROID in.	:	.161	.083	.257
MIN RADIUS	:	.184	.107	.101
MEAN RADIUS	:	.888	.720	.551
MAX RADIUS	:	1.816	1.631	1.315
HORIZONTAL SPREAD	:	2.754	2.273	1.821
VERTICAL SPREAD	:	1.827	1.827	1.563
EXTREME SPREAD	:	2.964	2.563	2.062
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.120

VS= 1.885

GS= 2.164

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.289	.666	.719
MINIMUM X	:	-.831	-.688	-.635
MAXIMUM Y	:	1.030	.997	.885
MINIMUM Y	:	-.855	-.888	-.763
CENTROID X	:	-.062	-.205	-.258
CENTROID Y	:	-.149	-.116	-.241
POA TO CENTROID in.	:	.161	.236	.353
MIN RADIUS	:	.087	.064	.145
MEAN RADIUS	:	.683	.584	.519
MAX RADIUS	:	1.322	1.110	1.048
HORIZONTAL SPREAD	:	2.120	1.354	1.354
VERTICAL SPREAD	:	1.885	1.885	1.648
EXTREME SPREAD	:	2.164	1.901	1.771
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	