

C6636172

MODEL 700™ M24

Model **SMS**™

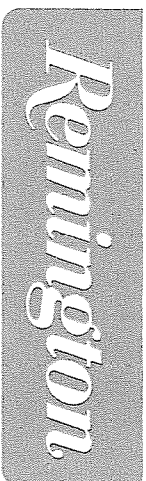
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700TM H24

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

06

SERIAL NO.
C6636172

ORDER NO.
5716



5716 C6636172

UPC



0 47700 25716 7

M-24

Stock
Received

CONTRACT # DAAA21-87-C-0086

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		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/28/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/28/91	JS
	G) Safety Off Force	3	3	3			5/28/91	JS
	H) Trigger Pull Test & Retainability						5/28/91	JS
	I) Firing Pin Indent	1.0225	1.0225	1.0225			5/28/91	JS
	J) Assemble Stock						5/28/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	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	DH
	B) Trigger Pull	2.25	2.19	2.33	2.35	2.31	6/1/91	JS
	C) Function						6-1-91	DH
660	Pack						6-20-91	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 0663172

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 # 06636172
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.166904
1 TO	2	.292099
1 TO	3	.357405
1 TO	4	.283387
1 TO	5	.301505

SP <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .125522
THE AMR FOR THIS RIFLE IS: .9638

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636172

CENTERFIRE PATTERNS

1

POR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.311

VS= 3.660

GS= 3.746

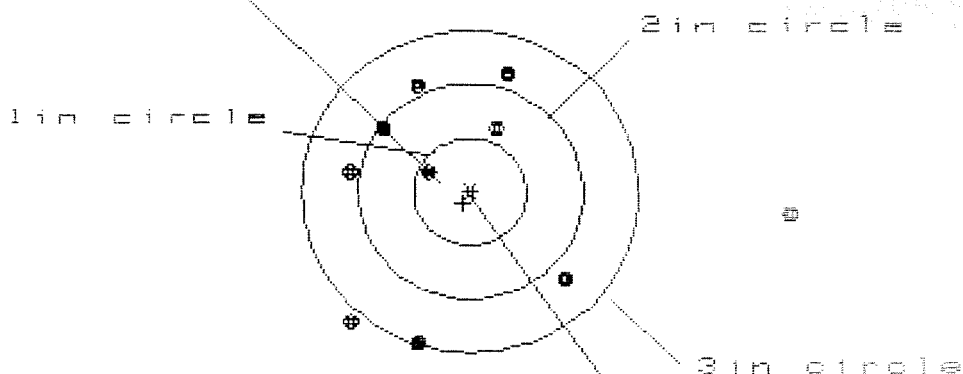
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.075	1.118	1.073
MINIMUM X	:	-1.236	-1.193	-1.238
MAXIMUM Y	:	1.833	1.445	1.242
MINIMUM Y	:	-1.827	-1.624	-0.893
CENTROID X	:	-0.044	-0.087	-0.043
CENTROID Y	:	-0.161	-0.364	-0.161
POR TO CENTROID in.	:	.167	.375	.167
MIN RADIUS	:	.197	.402	.197
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	

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B172

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.973

VS= 2.530

GS= 4.105

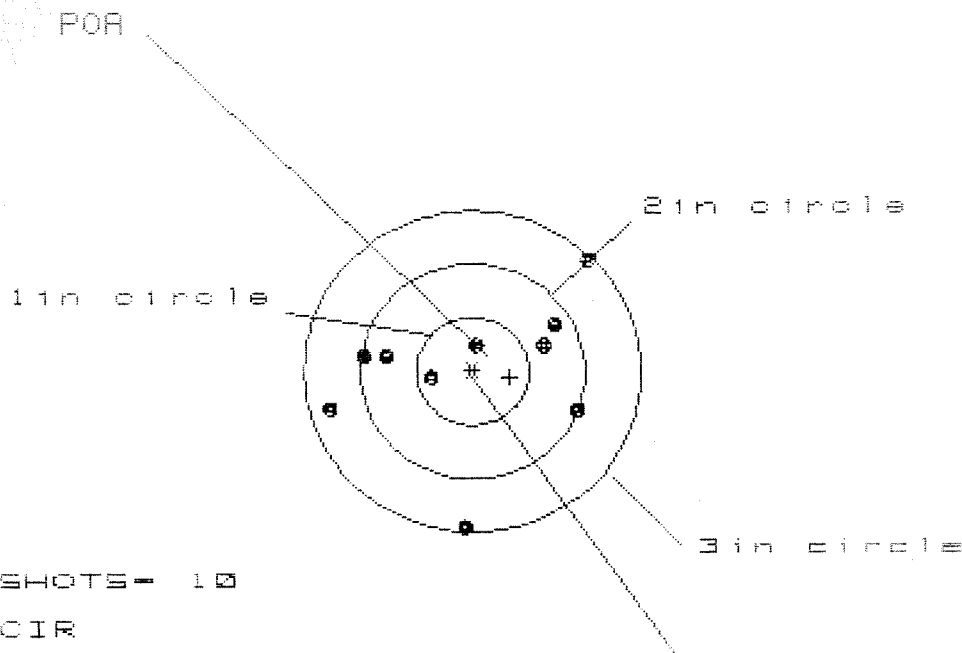
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.877	1.123	1.026
MINIMUM X	:	-1.095	-.776	-.807
MAXIMUM Y	:	1.138	1.116	.959
MINIMUM Y	:	-1.392	-1.414	-1.571
CENTROID X	:	.065	-.254	-.157
CENTROID Y	:	.110	.132	.289
POA 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	=		6	

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636172

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	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B172

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.672

VS= 2.047

GS= 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	

29 May 1981

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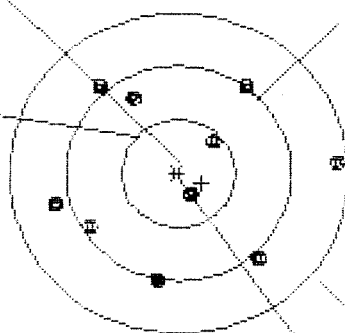
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.535

VS= 1.801

GS= 2.558

CENTROID #

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	