

C6636189

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

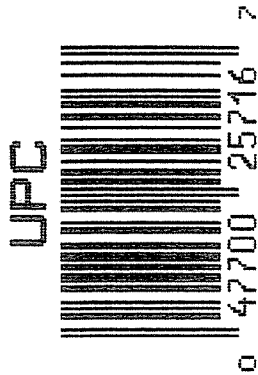
MODEL 700TM M24

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

SERIAL NO.
C6636189

ORDER NO.
5716

20



CONTRACT # DAAA21-87-C-0086

Stock
Repaired

GUN SERIAL #

C6636189

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TJA
	Apply Coating (Bolt)		5-10-91	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	FS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	JG

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	6			5/29/91	SH
	G) Safety Off Force	3	3	3			5/29/91	SH
	H) Trigger Pull Test & Retainability						5/29/91	SH
	I) Firing Pin Indent	.021	.022	.022			5/29/91	SH
	J) Assemble Stock						5/29/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	KS
	M) Iron Sight Alignment						5/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	KS
	O) Attach Scope to Rifle						5/29/91	KS
	P) Detach & Attach Scope 20 Times						5/29/91	KS
640	Gallery Target & Test						6-4-91	AC
	A) Time						6-4-91	AC
	B) Malfunctions						6-4-91	AC
	C) Pierced Primers						6-4-91	AC
	D) Optical Clarity of Scope						6-4-91	AC
645	Inspect for Live Ammo						6-9-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.29	2.27	2.21	2.28	2.27	6-8-91	SH
	C) Function						6-8-91	DH
660	Pack						6-20-91	NE

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636189

DATE 5/29/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.44	2.50	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.22	2.49	2.27	
PULL #3	2.45	2.29	2.47	2.21	
PULL #4	2.39	2.48	2.47	2.28	
PULL #5	2.46	2.47	2.46	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.20		
PULL #2	3.64	3.60		
PULL #3	3.62	3.64		
PULL #4	3.67	3.18		
PULL #5	3.54	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.24		4.17
PULL #2	4.38	4.33		4.38
PULL #3	4.15	4.29		4.41
PULL #4	4.31	4.23		4.29
PULL #5	4.24	4.24		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636189
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.136033
1 TO	2	.452356
1 TO	3	.457542
1 TO	4	.398058
1 TO	5	.206155

371 <----POR

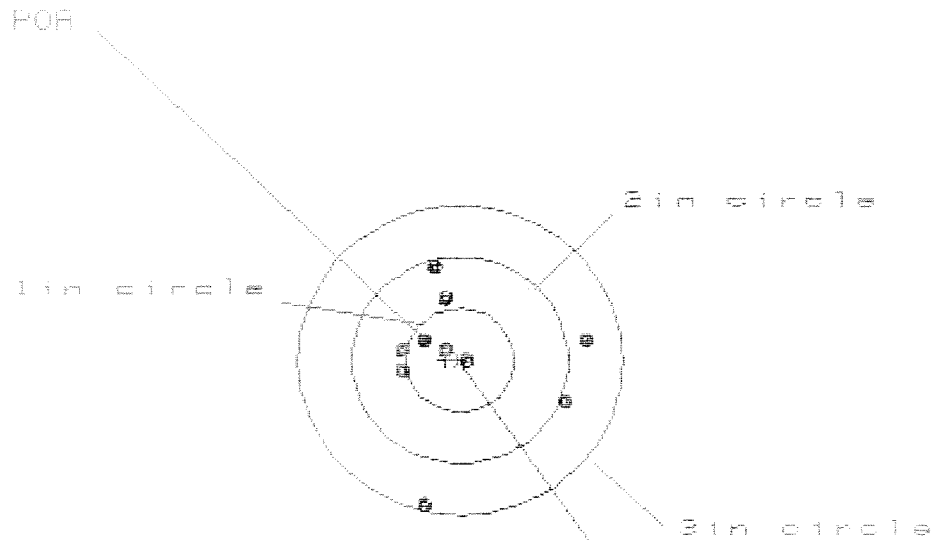
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0408
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148899
THE AMR FOR THIS RIFLE IS: .7992

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636189

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.773

VS= 2.290

GS= 2.290

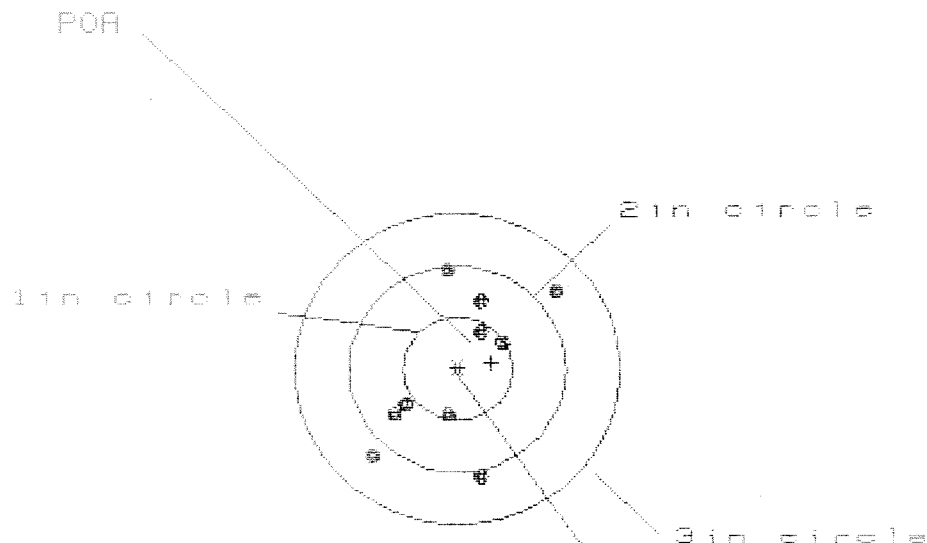
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	1.164	1.107
MINIMUM X	-.577	-.689	-.463
MAXIMUM Y	.867	.709	.714
MINIMUM Y	-1.423	-.599	-.594
CENTROID X	.136	.168	.022
CENTROID Y	-.003	.155	.150
POA TO CENTROID in.	.136	.228	.152
MIN RADIUS	.049	.164	.092
MEAN RADIUS	.690	.604	.485
MAX RADIUS	1.452	1.165	1.256
HORIZONTAL SPREAD	1.773	1.773	1.570
VERTICAL SPREAD	2.290	1.308	1.308
EXTREME SPREAD	2.290	1.815	1.815
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636189

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.681

VS= 1.984

GS= 2.326

CENTROID #

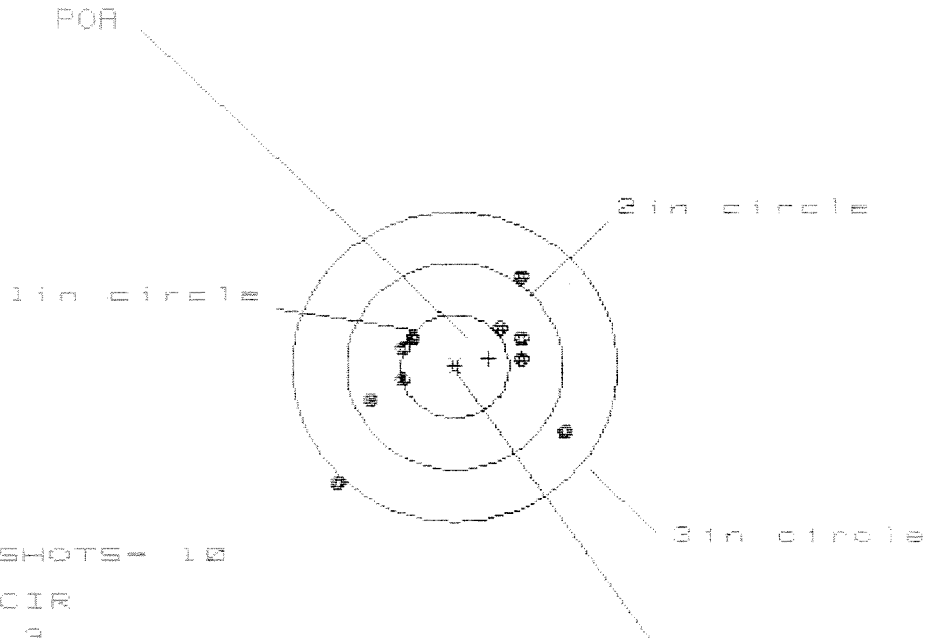
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.933	.517	.436
MINIMUM X	-.748	-.644	-.519
MAXIMUM Y	.970	1.059	.959
MINIMUM Y	-1.014	-.925	-1.015
CENTROID X	-.313	-.417	-.336
CENTROID Y	-.058	-.147	-.057
POA TO CENTROID in.	.319	.442	.341
MIN RADIUS	.373	.322	.383
MEAN RADIUS	.755	.692	.652
MAX RADIUS	1.229	1.061	1.037
HORIZONTAL SPREAD	1.681	1.161	.955
VERTICAL SPREAD	1.984	1.984	1.984
EXTREME SPREAD	2.326	1.998	1.998
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

4 Jun 1991

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CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.150

VS= 1.946

GS= 2.602

CENTROID #

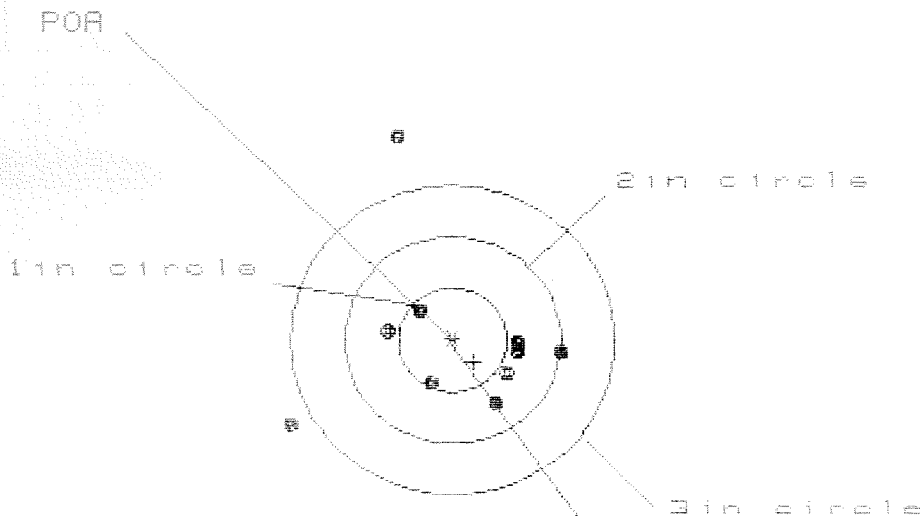
PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.905	.603
MINIMUM X	-1.120	-.925	-.812
MAXIMUM Y	.859	.738	.646
MINIMUM Y	-1.087	-.737	-.502
CENTROID X	-.316	-.191	-.304
CENTROID Y	-.074	.047	.139
POA TO CENTROID in.	.324	.197	.335
MIN RADIUS	.445	.398	.376
MEAN RADIUS	.792	.685	.609
MAX RADIUS	1.561	1.167	.954
HORIZONTAL SPREAD	2.150	1.830	1.415
VERTICAL SPREAD	1.946	1.475	1.148
EXTREME SPREAD	2.602	1.859	1.817
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.506

VS= 2.762

GS= 2.951

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	.953	.759
MINIMUM X	-1.502	-1.553	-.850
MAXIMUM Y	1.962	.476	.403
MINIMUM Y	-.800	-.582	-.430
CENTROID X	-.199	-.148	.046
CENTROID Y	.212	-.006	.067
POA TO CENTROID in.	.291	.148	.082
MIN RADIUS	.415	.276	.272
MEAN RADIUS	.865	.699	.536
MAX RADIUS	2.015	1.659	.871
HORIZONTAL SPREAD	2.506	2.506	1.609
VERTICAL SPREAD	2.762	1.058	.833
EXTREME SPREAD	2.951	2.606	1.614
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

4 Jun 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

* OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.675

VS= 3.518

GS= 3.533

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.539	.561	.630
MINIMUM X	-1.136	-1.114	-1.045
MAXIMUM Y	1.523	1.302	.746
MINIMUM Y	-1.995	-.905	-.743
CENTROID X	-.024	-.046	-.115
CENTROID Y	.127	.348	.185
POA TO CENTROID in.	.129	.351	.218
MIN RADIUS	.113	.272	.102
MEAN RADIUS	.894	.748	.639
MAX RADIUS	2.005	1.431	1.278
HORIZONTAL SPREAD	1.675	1.675	1.675
VERTICAL SPREAD	3.518	2.207	1.488
EXTREME SPREAD	3.533	2.757	2.236
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		