

C6636306

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

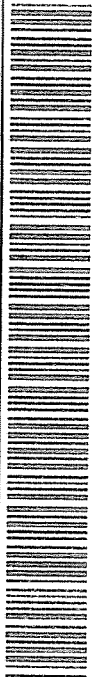
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
D6636306

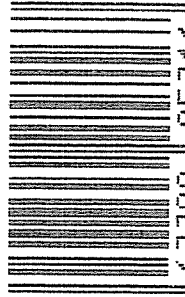
ORDER NO.
5716

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



5716 D6636306

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6636306**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KL
600	Proof		6/25/91	KL
607	Check Headspace		6/25/91	KL
610	Dis-assemble Gun		6/25/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KL
	C) Inspect Ejector Hole for Chamfer		8/8/91	KL
	D) Oil Firing Pin Ass'y		8/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 3/4	5			8-10-91	DH
	G) Safety Off Force	2 1/2	2 1/4	2			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-9-91	SH
	I) Firing Pin Indent	.020	.020	.020			8-10-91	DH
	J) Assemble Stock						8/12/91	KH
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/12/91	KH
	M) Iron Sight Alignment						8/12/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/12/91	KH
	O) Attach Scope to Rifle						8/12/91	KH
	P) Detach & Attach Scope 20 Times						8/12/91	KH
640	Gallery Target & Test						8/14/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						8/14/91	KT
655	Final Inspection						8-15-91	DH
	A) Headspace							
	B) Trigger Pull	2.34	2.37	2.29	2.38	2.23	8-15-91	SH
	C) Function						8-15-91	DH
660	Pack						9-11-91	AF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636306
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.141113
1 TO	2	.267152
1 TO	3	.099925
1 TO	4	.152003
1 TO	5	.0615224

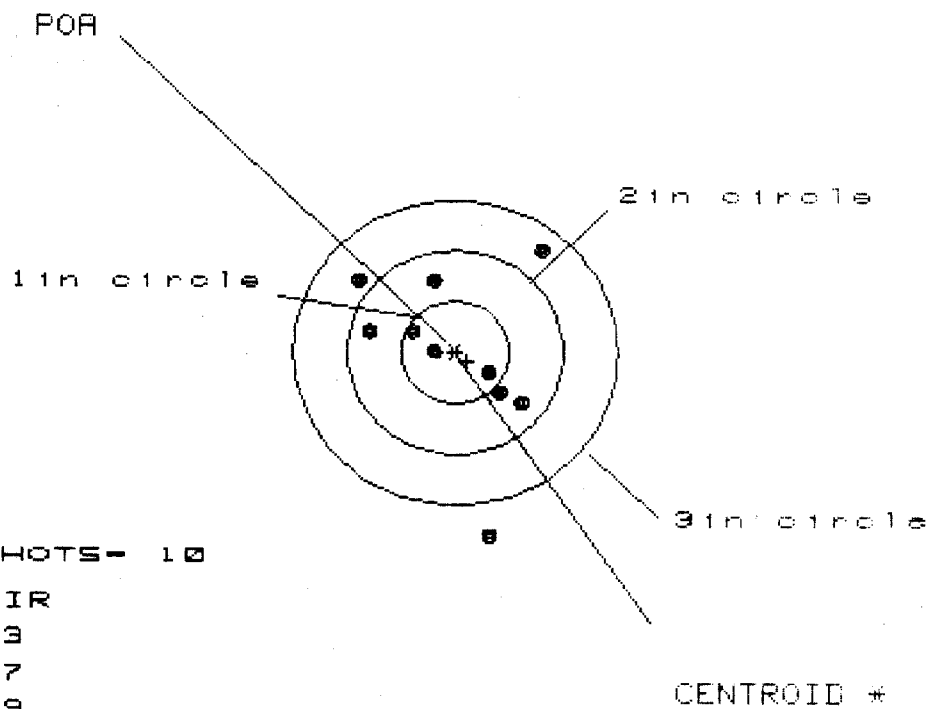
3/2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0946
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .031
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0995493
THE AMR FOR THIS RIFLE IS: .9644

25 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636386

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.696

VS= 2.818

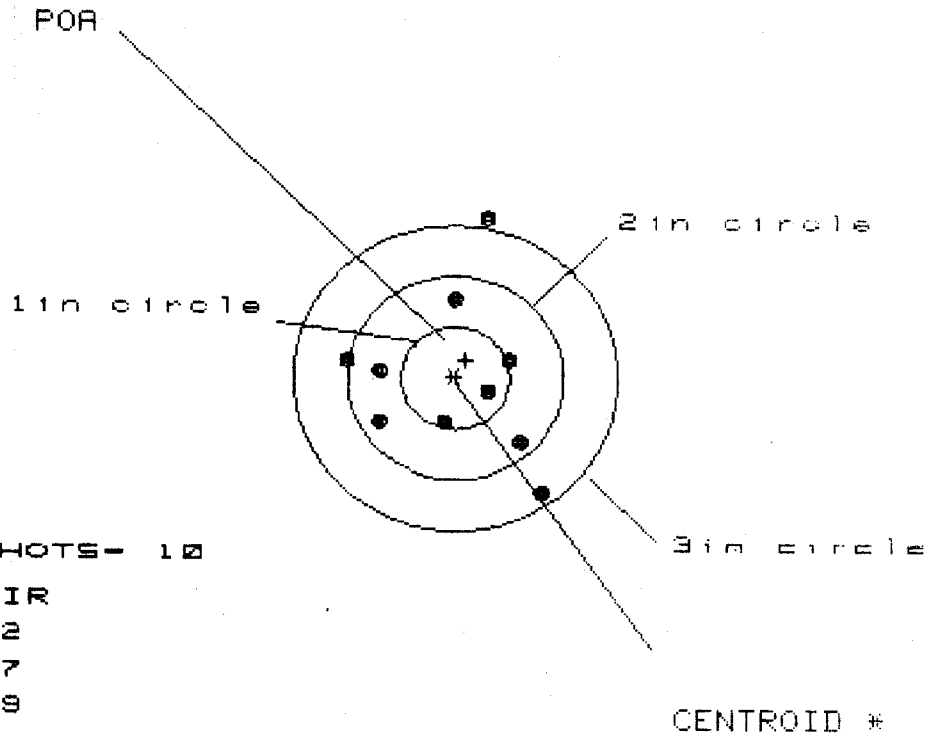
GS= 2.857

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.791	.826	.730
MINIMUM X	-.905	-.870	-.766
MAXIMUM Y	1.029	.830	.639
MINIMUM Y	-1.789	-.676	-.572
CENTROID X	-.107	-.142	-.246
CENTROID Y	.092	.291	.187
FOR TO CENTROID in.	.141	.324	.309
MIN RADIUS	.150	.258	.130
MEAN RADIUS	.806	.690	.601
MAX RADIUS	1.817	1.172	.998
HORIZONTAL SPREAD	1.696	1.696	1.496
VERTICAL SPREAD	2.818	1.506	1.211
EXTREME SPREAD	2.857	1.925	1.925
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.826

VS = 2.657

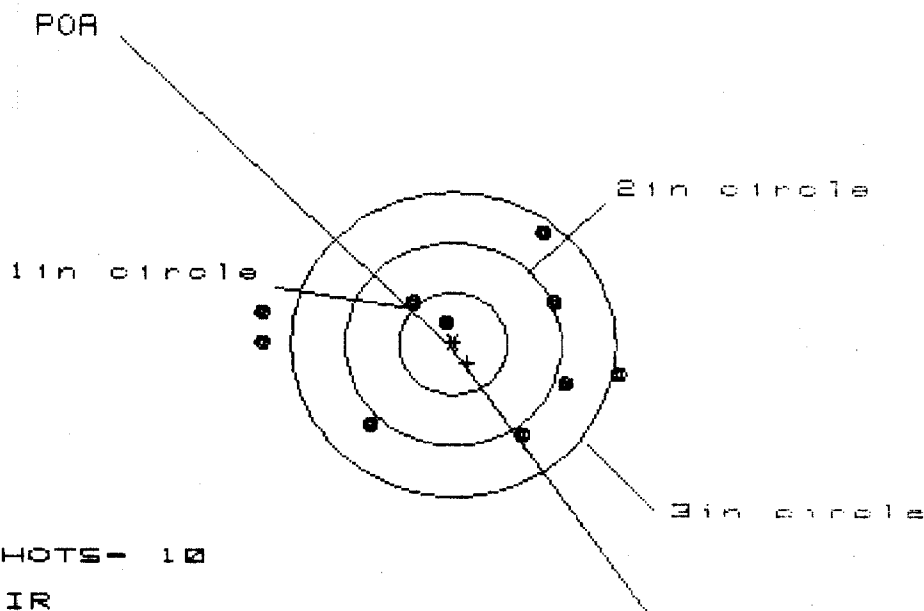
GS = 2.700

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.823	.862	.777
MINIMUM X	-1.003	-.964	-.857
MAXIMUM Y	1.527	.973	.853
MINIMUM Y	-1.130	-.960	-.602
CENTROID X	-.098	-.137	-.244
CENTROID Y	-.175	-.345	-.225
POA TO CENTROID in.	.201	.371	.332
MIN RADIUS	.293	.304	.411
MEAN RADIUS	.856	.761	.693
MAX RADIUS	1.566	1.290	.983
HORIZONTAL SPREAD	1.826	1.826	1.634
VERTICAL SPREAD	2.657	1.933	1.455
EXTREME SPREAD	2.700	2.259	1.843
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 3.286

VS = 1.999

GS = 3.342

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.482	1.281	1.035
MINIMUM X	:	-1.804	-1.969	-1.234
MAXIMUM Y	:	1.117	1.150	1.151
MINIMUM Y	:	-.882	-.849	-.848
CENTROID X	:	-.131	.070	.316
CENTROID Y	:	.189	.156	.155
POA TO CENTROID in.	:	.229	.171	.352
MIN RADIUS	:	.195	.321	.526
MEAN RADIUS	:	1.149	1.059	.920
MAX RADIUS	:	1.828	1.969	1.447
HORIZONTAL SPREAD	:	3.286	3.250	2.269
VERTICAL SPREAD	:	1.999	1.999	1.999
EXTREME SPREAD	:	3.342	3.263	2.471
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 5

3in = 8

HS = 2.980

VS = 1.723

GS = 3.035

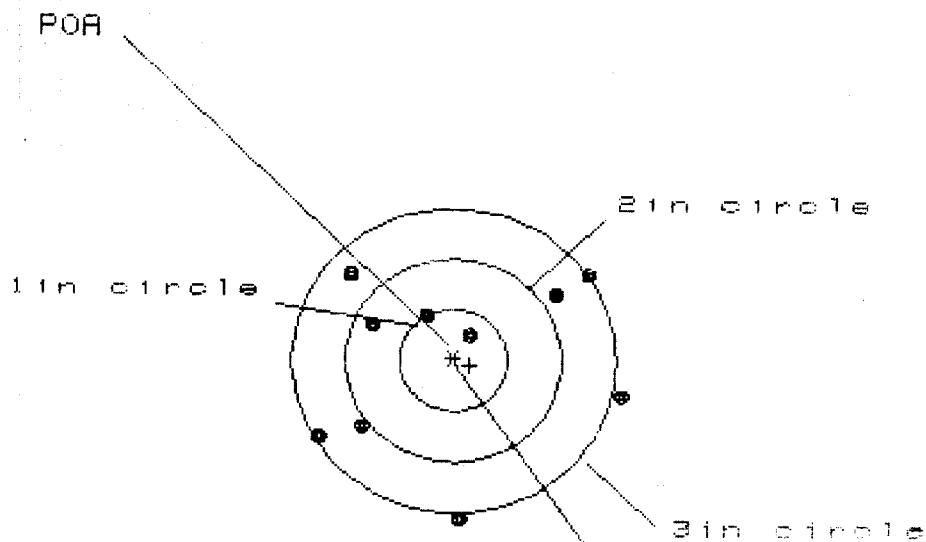
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.126	.895
MINIMUM X	:	-1.692	-1.854	-.614
MAXIMUM Y	:	.602	.477	.411
MINIMUM Y	:	-1.121	-.526	-.458
CENTROID X	:	.014	.176	.408
CENTROID Y	:	.000	.125	.191
POA TO CENTROID in.	:	.014	.216	.450
MIN RADIUS	:	.327	.209	.205
MEAN RADIUS	:	.890	.729	.551
MAX RADIUS	:	1.836	1.927	.982
HORIZONTAL SPREAD	:	2.980	2.980	1.508
VERTICAL SPREAD	:	1.723	1.003	.869
EXTREME SPREAD	:	3.035	2.986	1.620
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.792

VS = 2.445

GS = 2.924

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.583	1.421	1.448
MINIMUM X	-1.210	-1.034	-1.067
MAXIMUM Y	.859	.820	.617
MINIMUM Y	-1.586	-1.625	-1.002
CENTROID X	-.151	-.326	-.353
CENTROID Y	.049	.088	.231
POA TO CENTROID in.	.158	.338	.458
MIN RADIUS	.280	.387	.244
MEAN RADIUS	1.121	1.040	.922
MAX RADIUS	1.621	1.639	1.562
HORIZONTAL SPREAD	2.792	2.455	2.455
VERTICAL SPREAD	2.445	2.445	1.619
EXTREME SPREAD	2.924	2.924	2.924
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06636306DATE 8-9-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.36	2.50	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.44	2.48	2.32	
PULL #3	2.36	2.45	2.48	2.29	
PULL #4	2.42	2.49	2.44	2.38	
PULL #5	2.42	2.46	2.52	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.57		
PULL #2	3.69	3.61		
PULL #3	3.45	3.61		
PULL #4	3.69	3.48		
PULL #5	3.70	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.31		4.30
PULL #2	4.21	4.30		4.37
PULL #3	4.32	4.34		4.38
PULL #4	4.44	4.32		4.36
PULL #5	4.42	4.30		4.15
TOTAL				
AVG.				