

C6611670

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



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

DU PONT

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

MODEL 700TM M24

SERIAL NO.
C6611670

ORDER NO.
5716

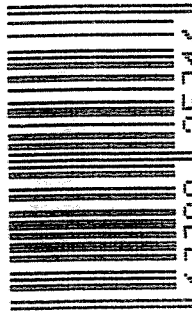
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611670

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611670

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/18/91	KS.
600	Proof		3/18/91	KS.
607	Check Headspace		3/18/91	KS.
610	Dis-assemble Gun		3/18/91	KS.
612	Magnaflux Barrel Action		3/28/91	KB
	Magnaflux Bolt		"	"
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WLB
620	Apply Coatings (Barrel Action)		4-19-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/91	

Op. #		READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	7	7	7			5/1/91	DH
	G) Safety Off Force	4	4	4			5/1/91	DH
	H) Trigger Pull Test & Retainability						4/30/91	DH
	I) Firing Pin Indent	.0225	.0235	.0235			5/1/91	DH
	J) Assemble Stock						5/2/91	KS
	K) Assemble Swivel Studs						5-10-91	DH
	L) Attach Front and Rear Sight Assemblies						5/2/91	KS
	M) Iron Sight Alignment						5/2/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/2/91	KS
	O) Attach Scope to Rifle						5/2/91	KS
	P) Detach & Attach Scope 20 Times						5/2/91	KS
640	Gallery Target & Test						5-3-91	DH
	A) Time						5-3-91	DH
	B) Malfunctions						5-3-91	DH
	C) Pierced Primers						5-3-91	DH
	D) Optical Clarity of Scope						5-3-91	DH
645	Inspect for Live Ammo						5-3-91	DH
655	Final Inspection							
	A) Headspace						5-10-91	DH
	B) Trigger Pull	2.37	2.32	2.39	2.36	2.42	5/9/91	DH
	C) Function						5-10-91	DH
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6611670DATE 4/30/91TESTER- JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.46	2.55	2.37	MIN. SETTING,
PULL #2	2.48	2.48	2.45	2.32	NO AVG. OF 5
PULL #3	2.49	2.45	2.50	2.39	READINGS ACCEPT-
PULL #4	2.43	2.49	2.51	2.36	ABLE LESS THAN 2#
PULL #5	2.48	2.53	2.51	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.29	3.45			
PULL #2	3.32	3.26			
PULL #3	3.31	3.34			
PULL #4	3.28	3.31			
PULL #5	3.26	3.33			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.36		4.39
PULL #2	4.22	4.39		4.43
PULL #3	4.39	4.40		4.23
PULL #4	4.39	4.41		4.43
PULL #5	4.43	4.41		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611670
3 May 1991

CENTROIDAL DISTANCES

0 TO 1	.277483
1 TO 2	.304646
1 TO 3	.0762365
1 TO 4	.287005
1 TO 5	.219347

SP <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS:
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS:
THE RESULTING AVERAGE POI RADIUS FOR THE

THE AMR FOR THIS RIFLE IS: .924

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611670

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.565

VS= 1.950

GS= 2.565

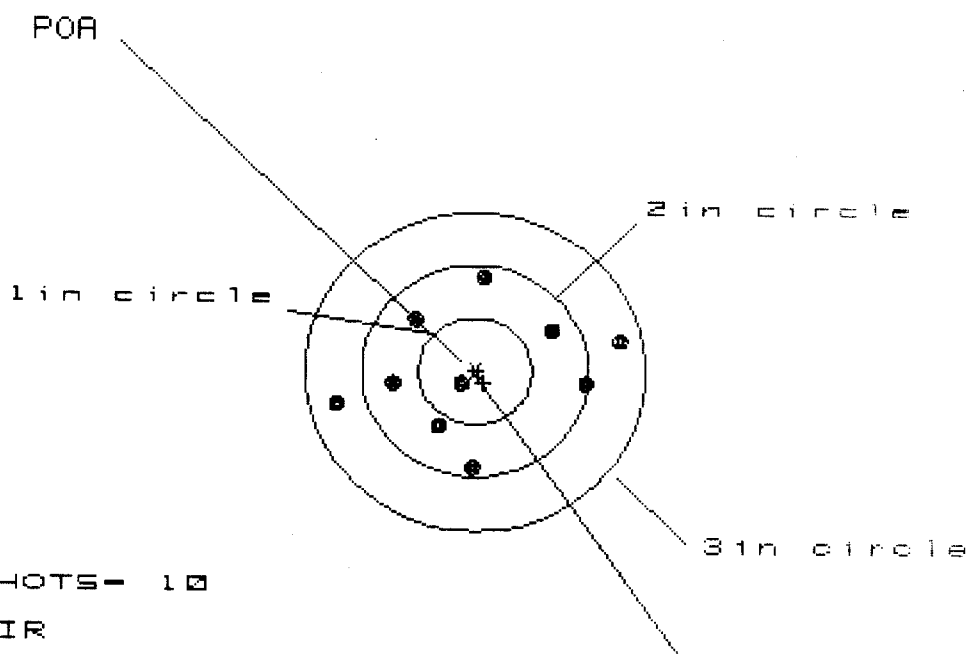
CENTROID *

PATTERN #	:	1	9	9
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.085	.920	.998
MINIMUM X	:	-1.480	-.969	-1.091
MAXIMUM Y	:	.999	.967	1.044
MINIMUM Y	:	-.951	-.983	-1.089
CENTROID X	:	.226	.391	.313
CENTROID Y	:	.161	.193	.116
POA TO CENTROID in.	:	.278	.436	.415
MIN RADIUS	:	.343	.193	.325
MEAN RADIUS	:	.977	.883	.852
MAX RADIUS	:	1.507	1.239	1.158
HORIZONTAL SPREAD	:	2.565	1.889	1.740
VERTICAL SPREAD	:	1.950	1.950	1.775
EXTREME SPREAD	:	2.565	2.399	2.175
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611670

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 2.487

VS= 1.811

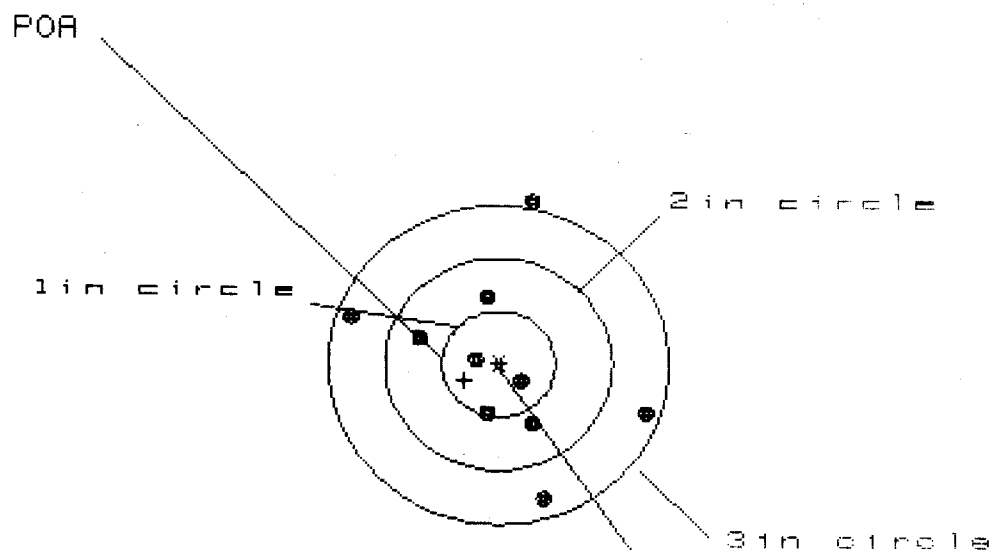
GS= 2.580

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.287	1.080	.948
MINIMUM X	:	-1.200	-1.057	-.753
MAXIMUM Y	:	.884	.921	.883
MINIMUM Y	:	-.927	-.890	-.928
CENTROID X	:	-.074	-.217	-.085
CENTROID Y	:	.108	.071	.109
POA TO CENTROID in.	:	.131	.228	.138
MIN RADIUS	:	.172	.059	.164
MEAN RADIUS	:	.841	.757	.727
MAX RADIUS	:	1.331	1.102	.952
HORIZONTAL SPREAD	:	2.487	2.137	1.701
VERTICAL SPREAD	:	1.811	1.811	1.811
EXTREME SPREAD	:	2.580	2.153	1.815
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

3 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 3

2in - 6

3in - 9

HS- 2.652

VS- 2.747

GS- 2.815

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.356	.549
MINIMUM X	:	-1.328	-1.296	-1.127
MAXIMUM Y	:	1.511	.796	.754
MINIMUM Y	:	-1.236	-1.068	-1.110
CENTROID X	:	.302	.270	.101
CENTROID Y	:	.155	-.013	.029
POA TO CENTROID in.	:	.339	.270	.105
MIN RADIUS	:	.250	.226	.212
MEAN RADIUS	:	.859	.764	.682
MAX RADIUS	:	1.538	1.431	1.261
HORIZONTAL SPREAD	:	2.652	2.652	1.676
VERTICAL SPREAD	:	2.747	1.864	1.864
EXTREME SPREAD	:	2.815	2.815	2.370
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611670

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.747

VS= 2.970

GS= 3.085

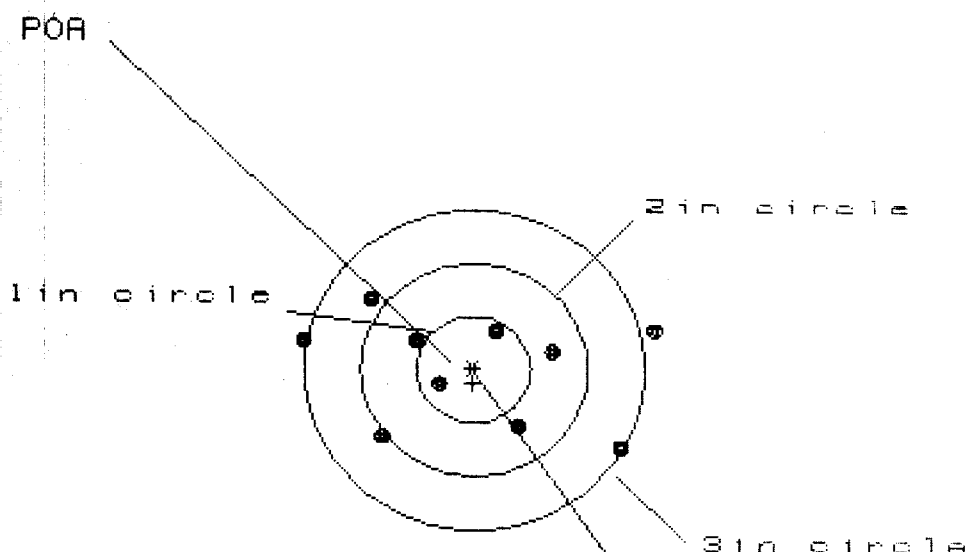
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.760	.743	.618
MINIMUM X	:	-.987	-1.004	-.757
MAXIMUM Y	:	1.076	.866	.965
MINIMUM Y	:	-1.894	-1.568	-1.460
CENTROID X	:	.202	.219	.344
CENTROID Y	:	-.125	.085	-.023
POA TO CENTROID in.	:	.238	.235	.345
MIN RADIUS	:	.302	.358	.193
MEAN RADIUS	:	1.003	.869	.783
MAX RADIUS	:	1.900	1.603	1.474
HORIZONTAL SPREAD	:	1.747	1.747	1.375
VERTICAL SPREAD	:	2.970	2.434	2.425
EXTREME SPREAD	:	3.085	2.777	2.590
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

3 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.026

VS = 1.395

GS = 3.027

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.548	1.422	1.258
MINIMUM X	:	-1.478	-1.305	-1.860
MAXIMUM Y	:	.643	.680	.718
MINIMUM Y	:	-.752	-.715	-.677
CENTROID X	:	.009	-.163	.001
CENTROID Y	:	.129	.092	.054
POA TO CENTROID in.	:	.129	.187	.054
MIN RADIUS	:	.387	.221	.357
MEAN RADIUS	:	.940	.848	.791
MAX RADIUS	:	1.583	1.591	1.429
HORIZONTAL SPREAD	:	3.026	2.727	2.118
VERTICAL SPREAD	:	1.395	1.395	1.395
EXTREME SPREAD	:	3.027	2.911	2.536
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		