

C6636010

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

UPPONT

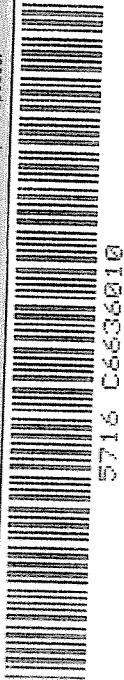
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6636010

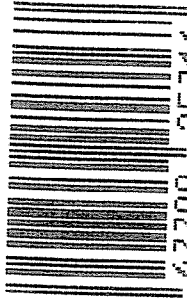
ORDER NO.
5716

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



5716 C6636010

UPC



0 47700 25716 7

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Hard Safe filed stock</i>	
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636010**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS.
617	Drill and Tap Sight Holes	5 15 9 1		KCB
618	Polish Barrel	5 15 9 1		KCB
620	Apply Coatings (Barrel Action)		5-31-91	DA
	Apply Coating (Bolt)		5-31-91	DA
625	Final Assembly A) Clean inside of Bolt Assembly		6/6/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/10/91	KS
	C) Inspect Ejector Hole for Chamfer		6/10/91	KS
	D) Oil Firing Pin Ass'y		6/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	GS

op. #	BARBER - M24 0036633	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-11-91	JH
	G) Safety Off Force	4	4	4			6-11-91	JH
	H) Trigger Pull Test & Retainability						6-11-91	JH
	I) Firing Pin Indent	.0225	.0225	.0225			6-11-91	JH
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-13-91	AF
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6-12-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-12-91	AF
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.60	2.62	2.58	2.33	2.31	6-13-91	JH
	C) Function						6-13-91	AF
660	Pack						6-20-91	AF

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

SERIAL NO. C6636010DATE 6-11-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.62	2.69	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.68	2.55	2.62	
PULL #3	2.55	2.54	2.51	2.58	
PULL #4	2.48	2.58	2.59	2.33	
PULL #5	2.52	2.70	2.59	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.21		
PULL #2	3.24	3.26		
PULL #3	3.42	3.51		
PULL #4	3.27	3.63		
PULL #5	3.57	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.55		4.24
PULL #2	4.26	4.12		4.64
PULL #3	4.57	4.28		4.18
PULL #4	4.31	4.57		4.39
PULL #5	4.42	4.38		
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636010
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.155708
1 TO	2	.276856
1 TO	3	.128725
1 TO	4	.0905539
1 TO	5	.184318

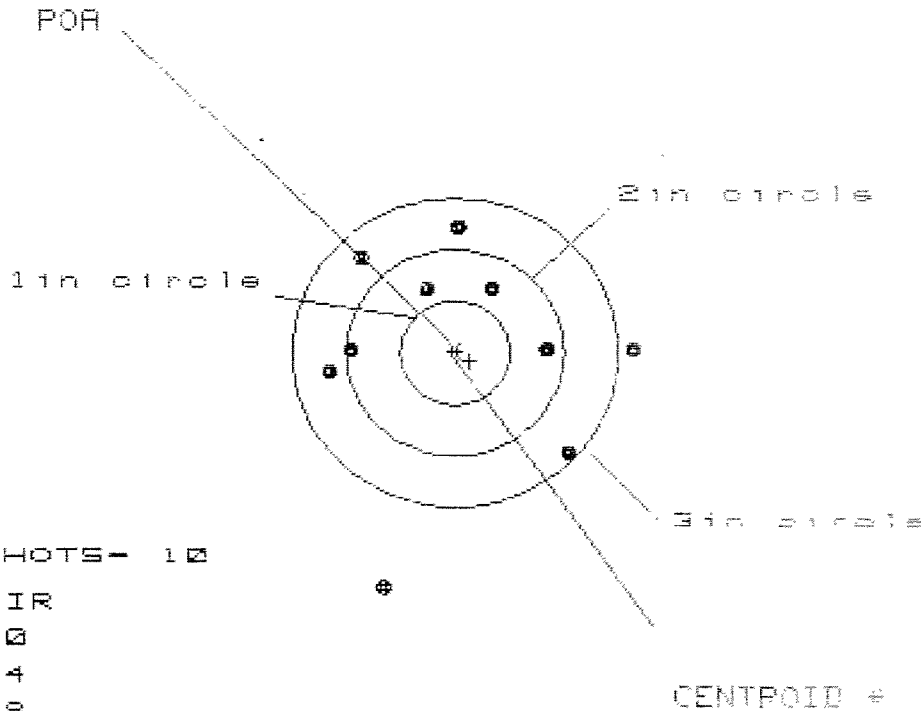
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1384
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141244
THE AMR FOR THIS RIFLE IS: .986

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0036636

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.834

VS= 3.488

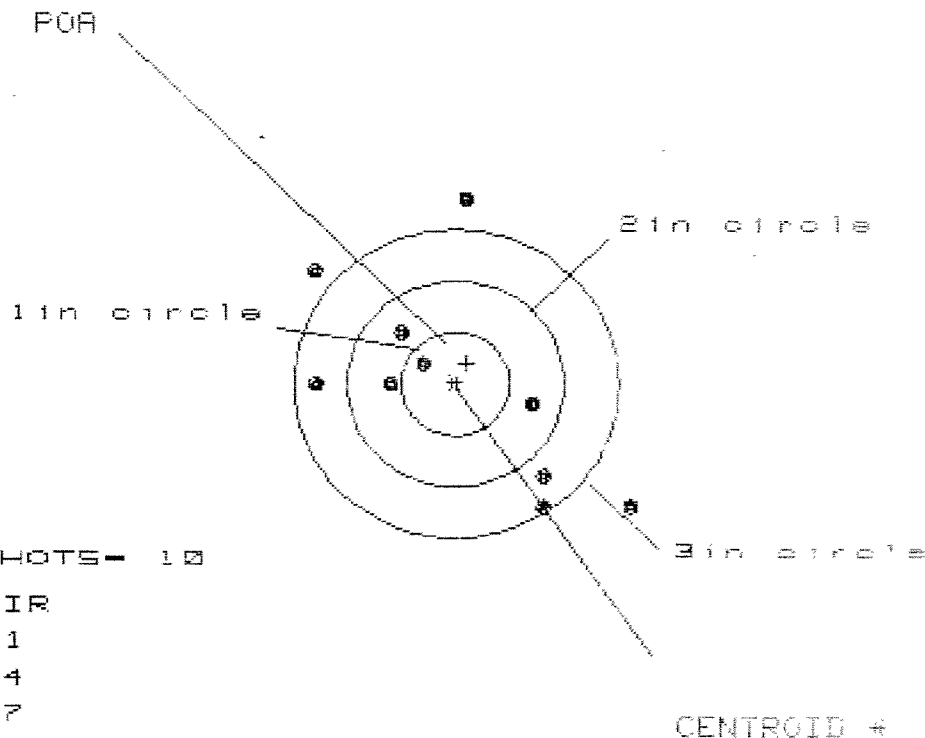
GS= 3.552

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.669	1.598	1.146
MINIMUM X	-1.165	-1.236	-1.826
MAXIMUM Y	1.202	.948	.917
MINIMUM Y	-2.286	-1.180	-1.211
CENTROID X	-.137	-.066	-.266
CENTROID Y	.074	.328	.359
POA TO CENTROID in.	.156	.335	.447
MIN RADIUS	.693	.445	.395
MEAN RADIUS	1.223	1.043	.947
MAX RADIUS	2.373	1.618	1.668
HORIZONTAL SPREAD	2.834	2.834	2.182
VERTICAL SPREAD	3.488	3.128	2.129
EXTREME SPREAD	3.552	2.842	2.522
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

12 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 2.960

VS = 3.045

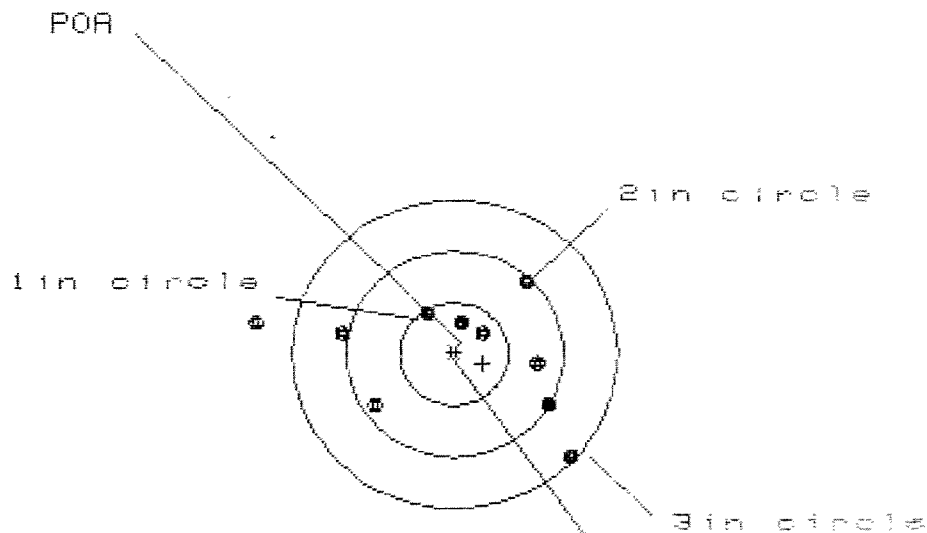
GS = 3.749

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.617	1.015	1.050
MINIMUM X	:	-1.343	-1.163	-1.128
MAXIMUM Y	:	1.805	1.668	1.132
MINIMUM Y	:	-1.240	-1.353	-1.145
CENTROID X	:	-.105	-.285	-.320
CENTROID Y	:	-.201	-.064	-.272
POA TO CENTROID in.	:	.227	.292	.420
MIN RADIUS	:	.403	.177	.319
MEAN RADIUS	:	1.192	1.047	.971
MAX RADIUS	:	2.037	1.692	1.598
HORIZONTAL SPREAD	:	2.960	2.178	2.178
VERTICAL SPREAD	:	3.045	3.021	2.277
EXTREME SPREAD	:	3.749	3.151	3.151
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in - 9

HS- 2.872

VS- 1.695

GS- 3.126

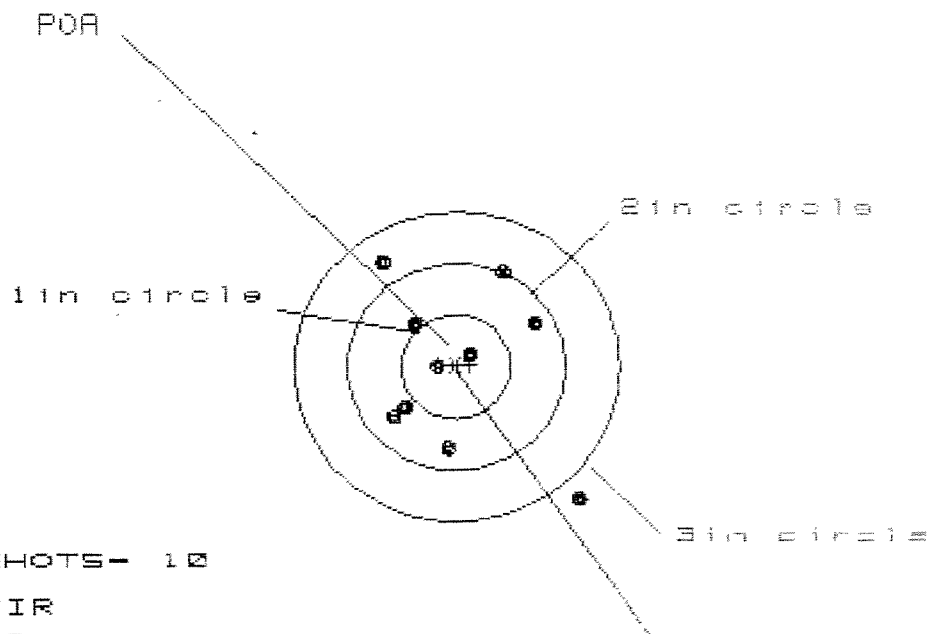
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.056	.854	.765
MINIMUM X	-1.816	-1.203	-1.096
MAXIMUM Y	.718	.746	.627
MINIMUM Y	-.978	-.949	-.616
CENTROID X	-.264	-.062	-.169
CENTROID Y	.095	.066	.103
POA TO CENTROID in.	.280	.090	.250
MIN RADIUS	.320	.216	.215
MEAN RADIUS	.911	.783	.697
MAX RADIUS	1.834	1.277	1.100
HORIZONTAL SPREAD	2.872	2.057	1.661
VERTICAL SPREAD	1.695	1.695	1.243
EXTREME SPREAD	3.126	2.359	1.970
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

12 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 2

2in - 7

3in - 9

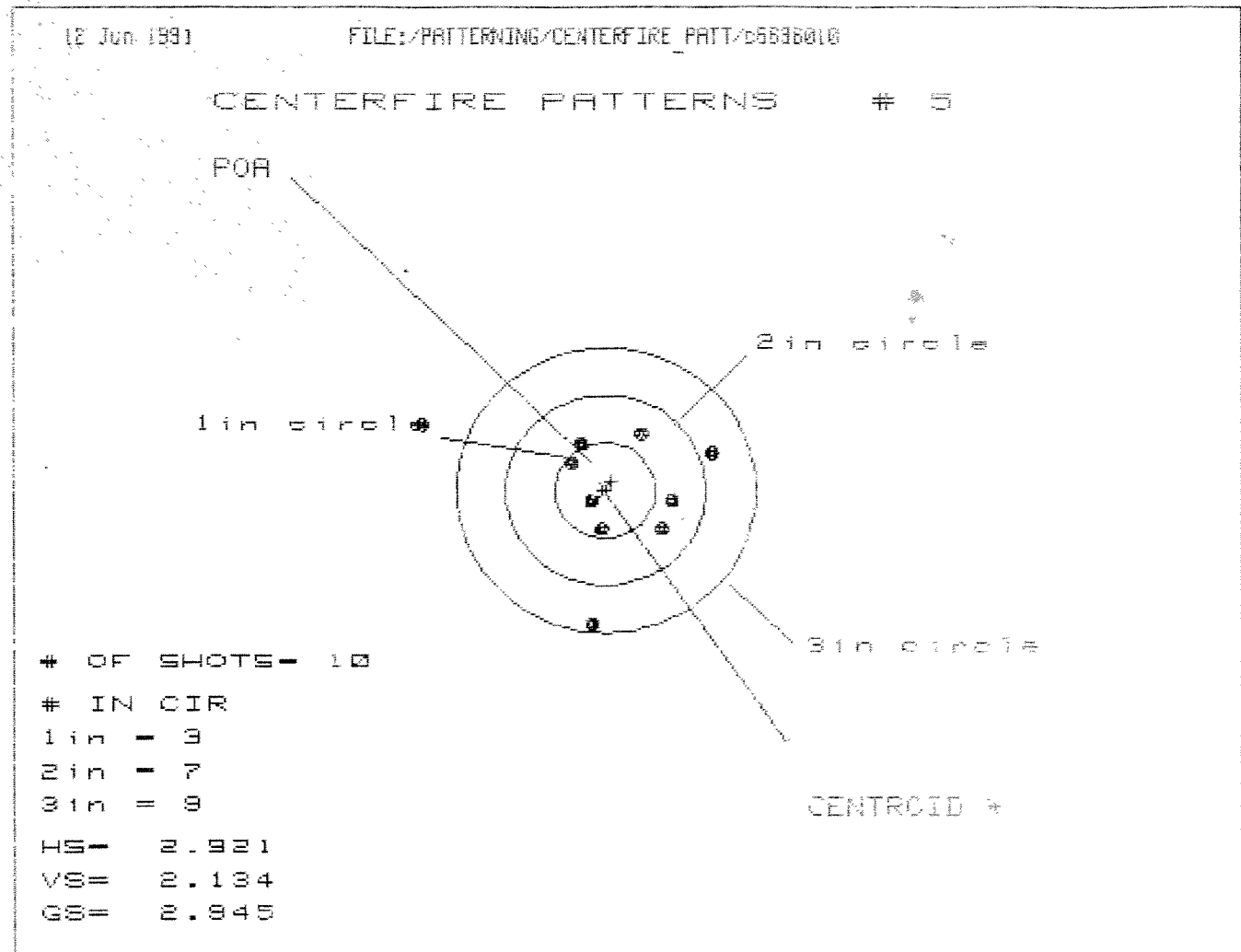
HS- 1.738

VS- 2.279

GS- 2.866

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.077	.826	.758
MINIMUM X	:	-.661	-.542	-.477
MAXIMUM Y	:	.978	.833	.921
MINIMUM Y	:	-1.301	-.882	-.777
CENTROID X	:	-.127	-.246	-.178
CENTROID Y	:	-.016	.129	.024
POA TO CENTROID in.	:	.128	.278	.180
MIN RADIUS	:	.167	.153	.126
MEAN RADIUS	:	.774	.655	.600
MAX RADIUS	:	1.689	.994	1.024
HORIZONTAL SPREAD	:	1.738	1.368	1.235
VERTICAL SPREAD	:	2.279	1.715	1.698
EXTREME SPREAD	:	2.866	1.800	1.774
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.092
MINIMUM X	-1.829
MAXIMUM Y	.740
MINIMUM Y	-1.394
CENTROID X	-.059
CENTROID Y	-.093
POA TO CENTROID in.	.110
MIN RADIUS	.186
MEAN RADIUS	.824
MAX RADIUS	1.973
HORIZONTAL SPREAD	2.921
VERTICAL SPREAD	2.134
EXTREME SPREAD	2.945
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9