

C6636030

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

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

SERIAL NO.
C6636030

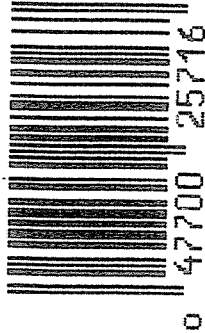
ORDER NO.
5716

20

5716 C6636030



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636030

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR	9 1991	KP
	Magnaflux Bolt	APR	9 1991	Y
615	Rollmark Caliber	APR	9 1991	GS
617	Drill and Tap Sight Holes	APR	9 1991	LB
618	Polish Barrel	APR	19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	PH

op. #	BARBER, M24 0036877 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-21-91	DH
	G) Safety Off Force	2	2	2			5-21-91	DH
	H) Trigger Pull Test & Retainability						5-20-91	DH
	I) Firing Pin Indent	.020	.020	.021			5-21-91	DH
	J) Assemble Stock						5/23/91	Rw
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/23/91	Rw
	M) Iron Sight Alignment						5/23/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	Rw
	O) Attach Scope to Rifle						5/23/91	Rw
	P) Detach & Attach Scope 20 Times						5/23/91	Rw
640	Gallery Target & Test						5/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/23/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.57	2.50	2.49	2.54	2.60	6/1/91	SC
	C) Function						6-1-91	DH
660	Pack						6-20-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636030

DATE 5-20-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.34	2.62	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.33	2.51	2.50	
PULL #3	2.40	2.35	2.17	2.49	
PULL #4	2.34	2.32	2.53	2.54	
PULL #5	2.33	2.36	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.37		
PULL #2	3.44	3.37		
PULL #3	3.20	3.29		
PULL #4	3.31	3.34		
PULL #5	3.37	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.18		4.23
PULL #2	4.28	4.24		4.15
PULL #3	4.15	4.16		4.14
PULL #4	4.23	4.30		4.07
PULL #5	4.20	4.27		3.97
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636030
23 May 1991

CENTROIDAL DISTANCES

0 TO	1	.240832
1 TO	2	.385695
1 TO	3	.145121
1 TO	4	.1364
1 TO	5	.281016

$\frac{3}{6}^2$ <----POA

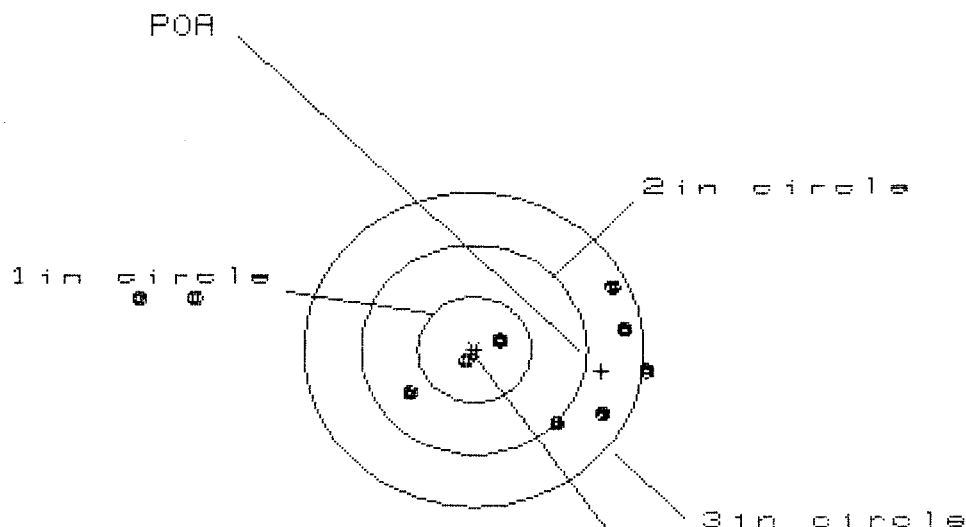
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .174
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1632
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .238559
THE AMR FOR THIS RIFLE IS: 1.092

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636030

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 4.482

VS= 1.279

GS= 4.537

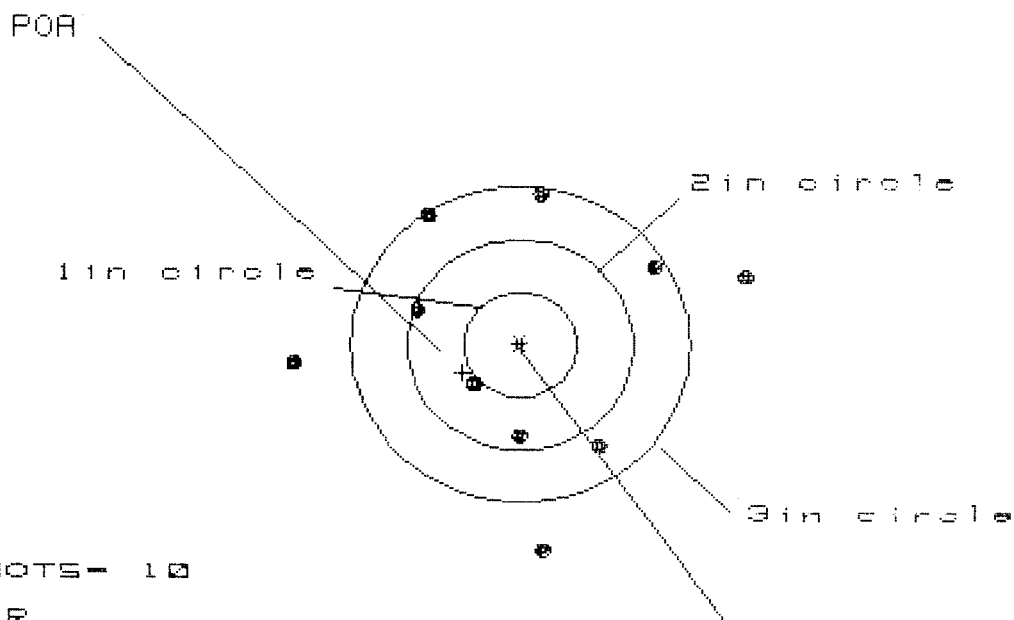
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.218	.870
MINIMUM X	:	-2.938	-2.785	-1.255
MAXIMUM Y	:	.596	.655	.726
MINIMUM Y	:	-.683	-.624	-.553
CENTROID X	:	-1.128	-.802	-.454
CENTROID Y	:	.204	.145	.074
POA TO CENTROID in.	:	1.147	.815	.460
MIN RADIUS	:	.132	.185	.495
MEAN RADIUS	:	1.302	1.045	.774
MAX RADIUS	:	2.985	2.842	1.289
HORIZONTAL SPREAD	:	4.482	4.003	2.125
VERTICAL SPREAD	:	1.279	1.279	1.279
EXTREME SPREAD	:	4.537	4.061	2.139
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 6

HSI = 4.021

VS = 3.381

GS = 4.099

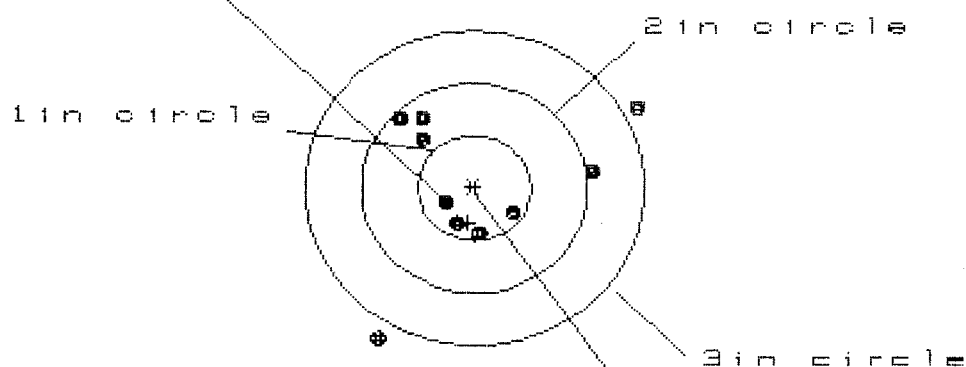
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.969	1.741	1.178
MINIMUM X	:	-2.052	-1.109	-.891
MAXIMUM Y	:	1.442	1.420	1.492
MINIMUM Y	:	-1.939	-1.961	-1.889
CENTROID X	:	.509	.737	.519
CENTROID Y	:	.264	.286	.214
POA TO CENTROID in.	:	.573	.790	.561
MIN RADIUS	:	.590	.787	.566
MEAN RADIUS	:	1.400	1.330	1.231
MAX RADIUS	:	2.061	1.963	1.894
HORIZONTAL SPREAD	:	4.021	2.850	2.069
VERTICAL SPREAD	:	3.381	3.381	3.381
EXTREME SPREAD	:	4.099	3.381	3.381
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

23 May 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 8

HS = 2.389

VS = 2.155

GS = 3.217

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.487	1.224	1.132
MINIMUM X	:	-.902	-.737	-.631
MAXIMUM Y	:	.758	.770	.605
MINIMUM Y	:	-1.397	-1.312	-.541
CENTROID X	:	.056	-.109	-.017
CENTROID Y	:	.330	.245	.409
POA TO CENTROID in.	:	.334	.269	.410
MIN RADIUS	:	.280	.099	.285
MEAN RADIUS	:	.836	.712	.629
MAX RADIUS	:	1.669	1.505	1.133
HORIZONTAL SPREAD	:	2.389	1.961	1.763
VERTICAL SPREAD	:	2.155	2.082	1.147
EXTREME SPREAD	:	3.217	2.485	1.849
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.148

VS= 3.286

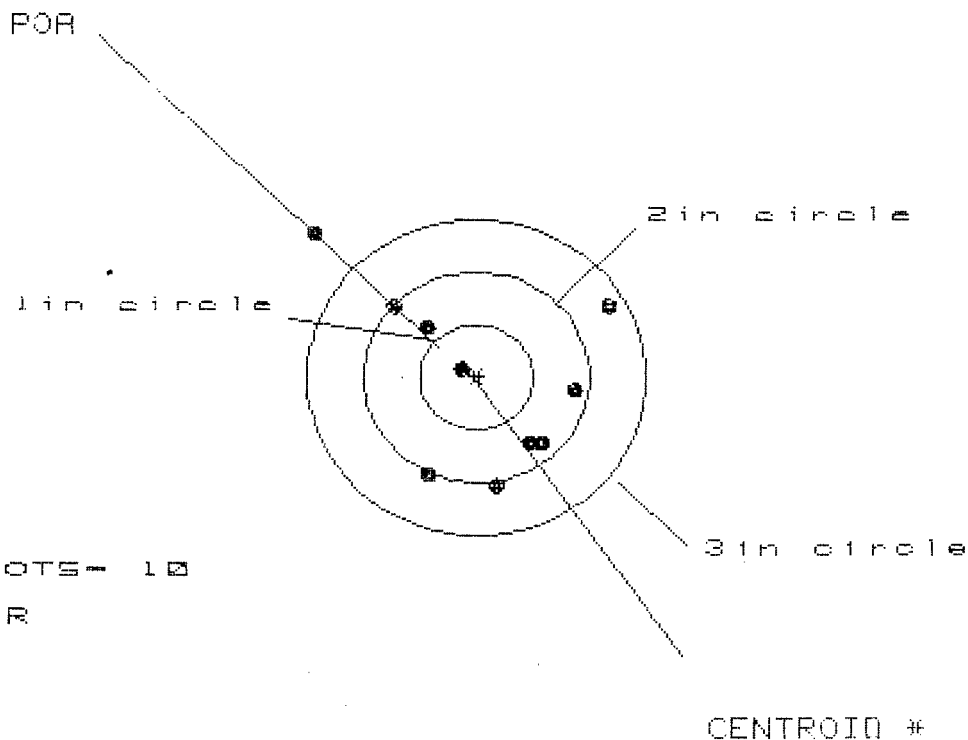
GS= 3.861

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.677	.322	.301
MINIMUM X	:	-.471	-.284	-.305
MAXIMUM Y	:	1.551	1.171	.976
MINIMUM Y	:	-1.734	-1.562	-1.247
CENTROID X	:	.046	-.141	-.120
CENTROID Y	:	.095	-.078	.117
POA TO CENTROID in.	:	.105	.161	.168
MIN RADIUS	:	.044	.174	.125
MEAN RADIUS	:	.961	.822	.684
MAX RADIUS	:	2.285	1.571	1.283
HORIZONTAL SPREAD	:	2.148	.606	.606
VERTICAL SPREAD	:	3.286	2.733	2.223
EXTREME SPREAD	:	3.861	2.734	2.292
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.604

VS= 2.359

GS= 2.873

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.153	.992	.840
MINIMUM X	:	-1.451	-.867	-.743
MAXIMUM Y	:	1.365	.833	.936
MINIMUM Y	:	-.994	-.842	-.739
CENTROID X	:	.131	.292	.168
CENTROID Y	:	-.077	-.229	-.332
POA TO CENTROID in.	:	.152	.371	.372
MIN RADIUS	:	.171	.387	.379
MEAN RADIUS	:	.963	.827	.755
MAX RADIUS	:	1.992	1.291	1.195
HORIZONTAL SPREAD	:	2.604	1.859	1.583
VERTICAL SPREAD	:	2.359	1.675	1.675
EXTREME SPREAD	:	2.873	2.245	1.899
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	