

C6636031

MODEL 700™ M24

Model SMS™

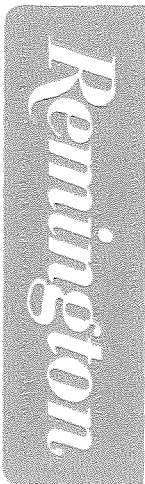
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

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

MODEL 700™ H24

SERIAL NO.
C6636031

ORDER NO.
5716

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

05

UPC

0 47700 25716 7

5716 C6636031

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL #

C6636031

REPAIR
6/27/91

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8	9 1	Kcd
	Magnaflux Bolt	5 8	9 1	Kcd
615	Rollmark Caliber		9 1	CS.
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-21-91	AA
	Apply Coating (Bolt)		5-21-91	AA
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/12/91	K.S.
	D) Oil Firing Pin Ass'y		4/12/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	PH

Op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	3	3	3			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.021	.021	.021			6-13-91	DH
	J) Assemble Stock						6-13-91	KS
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-13-91	KS
	M) Iron Sight Alignment						6-13-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	KS
	O) Attach Scope to Rifle						6-13-91	KS
	P) Detach & Attach Scope 20 Times						6-13-91	KS
640	Gallery Target & Test						6-14-91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						6-14-91	KS
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.51	2.55	2.58	2.48	2.54	6-15-91	DH
	C) Function						6-15-91	DH
660	Pack						6-20-91	KS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C66360 ³¹DATE 6-12-91TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.52	2.50	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.55	2.50	2.55	
PULL #3	2.52	2.62	2.56	2.58	
PULL #4	2.44	2.57	2.58	2.48	
PULL #5	2.52	2.58	2.55	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.79	3.19		
PULL #2	3.27	3.20		
PULL #3	3.37	3.59		
PULL #4	3.40	3.63		
PULL #5	3.20	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.50		4.61
PULL #2	4.44	4.59		4.62
PULL #3	4.46	4.59		4.65
PULL #4	4.52	4.49		4.62
PULL #5	4.38	4.61		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636031
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0890056
1 TO	2	.3178
1 TO	3	.192167
1 TO	4	.171304
1 TO	5	.292385

43 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0596
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0596969

THE AMR FOR THIS RIFLE IS: 1.116

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636031

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 1.640

VS = 2.954

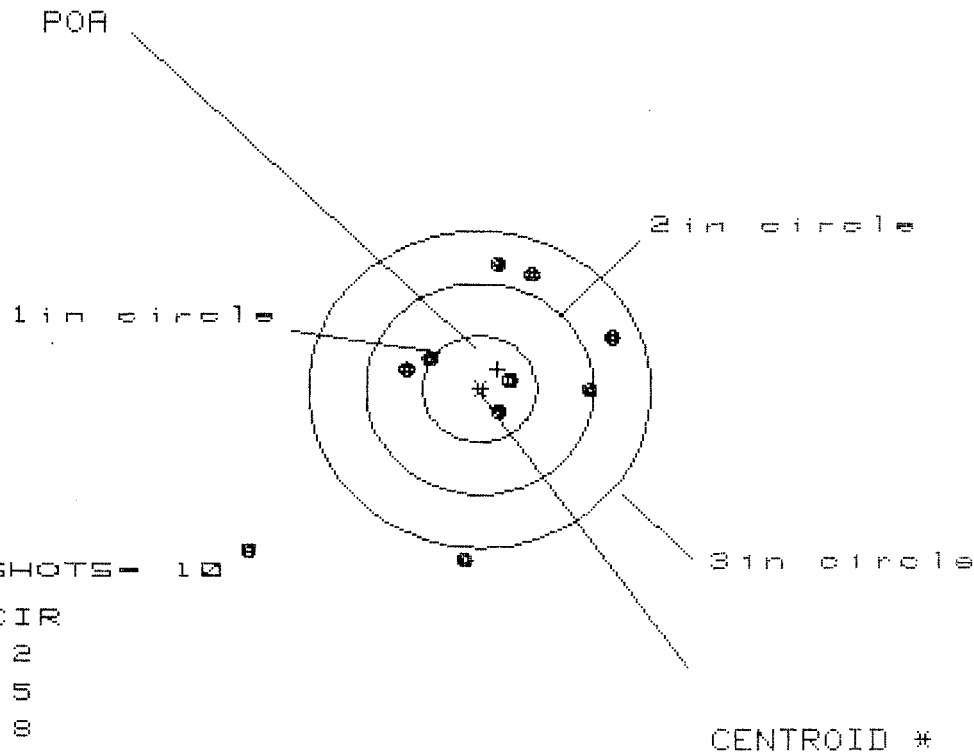
GS = 3.151

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.582	.465	.455
MINIMUM X	:	-1.058	-.738	-.748
MAXIMUM Y	:	1.507	1.346	.989
MINIMUM Y	:	-1.447	-1.393	-1.225
CENTROID X	:	-.001	.116	.126
CENTROID Y	:	.089	.250	.082
POA TO CENTROID in.	:	.089	.276	.150
MIN RADIUS	:	.568	.372	.494
MEAN RADIUS	:	.999	.869	.823
MAX RADIUS	:	1.793	1.418	1.251
HORIZONTAL SPREAD	:	1.640	1.203	1.203
VERTICAL SPREAD	:	2.954	2.739	2.214
EXTREME SPREAD	:	3.151	2.760	2.221
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

14 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.175

VS = 2.793

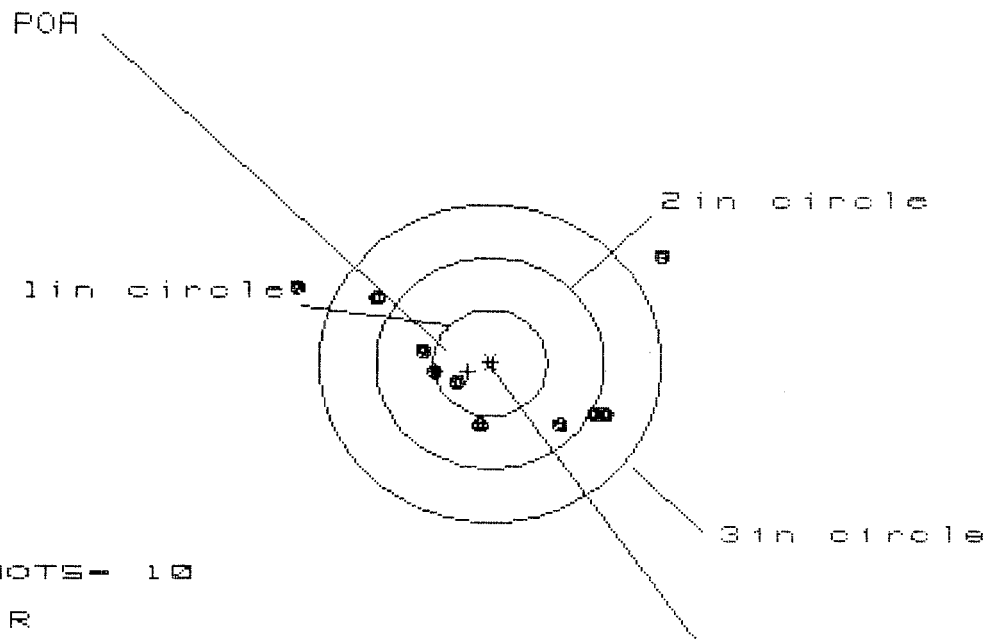
GS = 3.773

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.175	.953	.907
MINIMUM X	:	-2.000	-.843	-.889
MAXIMUM Y	:	1.205	1.034	.814
MINIMUM Y	:	-1.588	-1.759	-.565
CENTROID X	:	-.162	.060	.106
CENTROID Y	:	-.185	-.014	.206
POA TO CENTROID in.	:	.246	.062	.232
MIN RADIUS	:	.249	.094	.296
MEAN RADIUS	:	1.048	.836	.723
MAX RADIUS	:	2.526	1.796	.919
HORIZONTAL SPREAD	:	3.175	1.796	1.796
VERTICAL SPREAD	:	2.793	2.793	1.379
EXTREME SPREAD	:	3.773	2.807	1.828
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.255

VS= 1.597

GS= 3.267

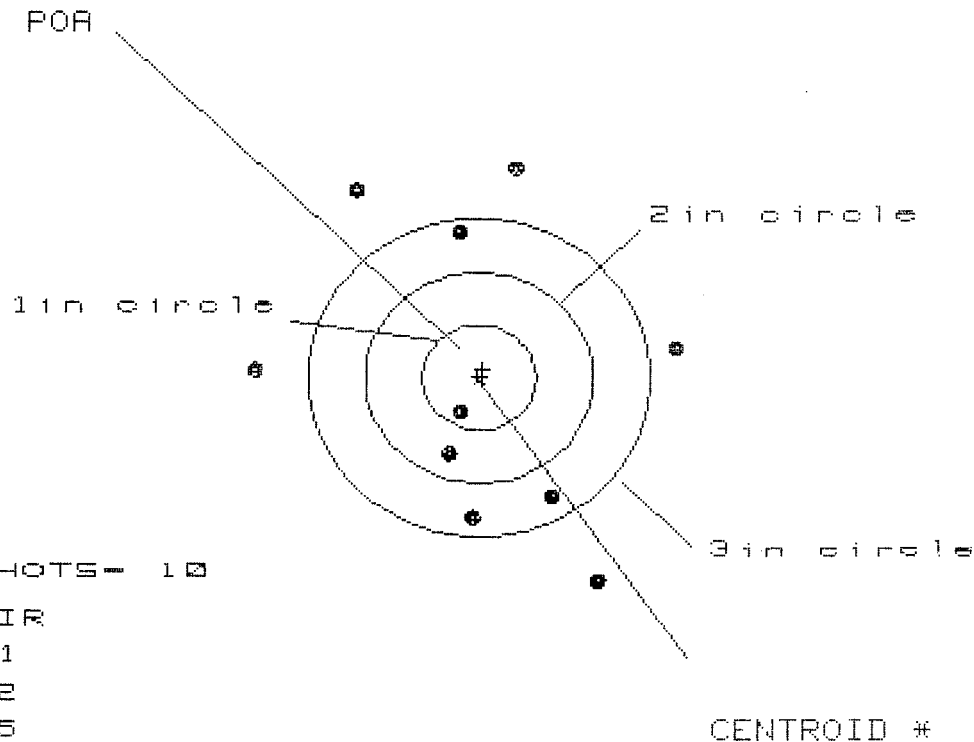
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.554	1.365	.988
MINIMUM X	:	-1.701	-1.157	-.987
MAXIMUM Y	:	.974	1.051	.845
MINIMUM Y	:	-.623	-.546	-.414
CENTROID X	:	.191	.380	.210
CENTROID Y	:	.081	.004	-.128
POA TO CENTROID in.	:	.208	.380	.246
MIN RADIUS	:	.320	.476	.305
MEAN RADIUS	:	.992	.900	.744
MAX RADIUS	:	1.840	1.723	1.299
HORIZONTAL SPREAD	:	3.255	2.522	1.975
VERTICAL SPREAD	:	1.597	1.597	1.259
EXTREME SPREAD	:	3.267	2.545	2.259
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 2

3 in = 5

HS= 3.641

VS= 3.941

GS= 4.269

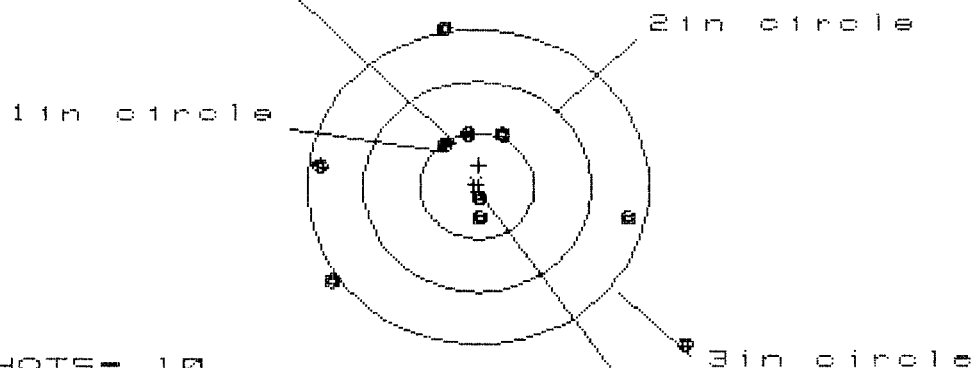
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	1.793	1.678
MINIMUM X	:	-1.962	-1.848	-1.963
MAXIMUM Y	:	1.980	1.762	1.957
MINIMUM Y	:	-1.961	-1.575	-1.380
CENTROID X	:	-.029	-.143	-.028
CENTROID Y	:	-.080	.138	-.057
POA TO CENTROID in.	:	.085	.199	.063
MIN RADIUS	:	.370	.555	.392
MEAN RADIUS	:	1.515	1.453	1.364
MAX RADIUS	:	2.214	1.855	1.977
HORIZONTAL SPREAD	:	3.641	3.641	3.641
VERTICAL SPREAD	:	3.941	3.337	3.337
EXTREME SPREAD	:	4.269	3.646	3.646
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	5		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 7

HS = 3.255

VS = 3.036

GS = 3.702

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.822	1.479	1.340
MINIMUM X	-1.433	-1.230	-1.369
MAXIMUM Y	1.499	1.329	1.192
MINIMUM Y	-1.537	-1.097	-.610
CENTROID X	-.016	-.219	-.080
CENTROID Y	-.203	-.033	.105
POA TO CENTROID in.	.204	.221	.132
MIN RADIUS	.114	.228	.210
MEAN RADIUS	1.025	.856	.736
MAX RADIUS	2.384	1.559	1.460
HORIZONTAL SPREAD	3.255	2.709	2.709
VERTICAL SPREAD	3.036	2.426	1.801
EXTREME SPREAD	3.702	2.754	2.754
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		