

C6636080

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
MODEL 700TM M24

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

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

SERIAL NO.
C6636080

ORDER NO.
5716

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

20



5716 C6636080

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636 080

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	KR
	Magnaflux Bolt	APR	9 1991	"
615	Rollmark Caliber	APR	9 1991	GL
617	Drill and Tap Sight Holes	APR	19 1991	WB
618	Polish Barrel	APR	19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/3/91	JA

op. #	BARBER - M24 0037470 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			6/4/91	WB
	G) Safety Off Force	2	2	2			6/4/91	WB
	H) Trigger Pull Test & Retainability						6/3/91	JA
	I) Firing Pin Indent	.0215	.0215	.0215			6/4/91	WB
	J) Assemble Stock						6/4/91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/4/91	RW
	M) Iron Sight Alignment						6/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	RW
	O) Attach Scope to Rifle						6/4/91	RW
	P) Detach & Attach Scope 20 Times						6/4/91	RW
640	Gallery Target & Test						6-5-91	AC
	A) Time						6-5-91	AC
	B) Malfunctions						6-5-91	AC
	C) Pierced Primers						6-5-91	AC
	D) Optical Clarity of Scope						6-5-91	AC
645	Inspect for Live Ammo						6-5-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.69	2.21	2.26	2.23	2.26	6-8-91	X/
	C) Function						6-8-91	D/H
660	Pack						6-20-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636080

DATE 6-3-91

TESTER 91

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.48	2.38	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.31	2.41	2.21	
PULL #3	2.52	2.45	2.36	2.26	
PULL #4	2.51	2.35	2.36	2.23	
PULL #5	2.52	2.50	2.49	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.25		
PULL #2	3.51	3.28		
PULL #3	3.39	3.21		
PULL #4	3.30	3.23		
PULL #5	3.39	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.23		4.35
PULL #2	4.34	4.42		4.53
PULL #3	4.29	4.43		4.50
PULL #4	4.33	4.40		4.55
PULL #5	4.45	4.34		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636080

5 Jun 1991

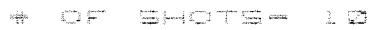
CENTROIDAL DISTANCES

0 TO	1	.283323
1 TO	2	.155322
1 TO	3	.402413
1 TO	4	.335233
1 TO	5	.240651

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .03
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0756066

THE AMP FOR THIS RIFLE IS: .9514



#INCIFF

215

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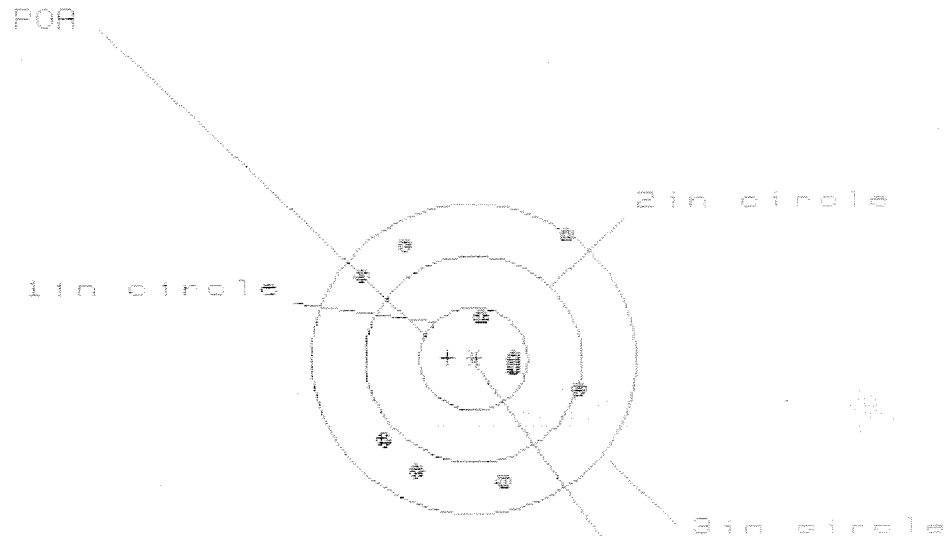
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5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636080

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 3

3 in = 10

HS = 3.029

VS = 2.402

GS = 2.712

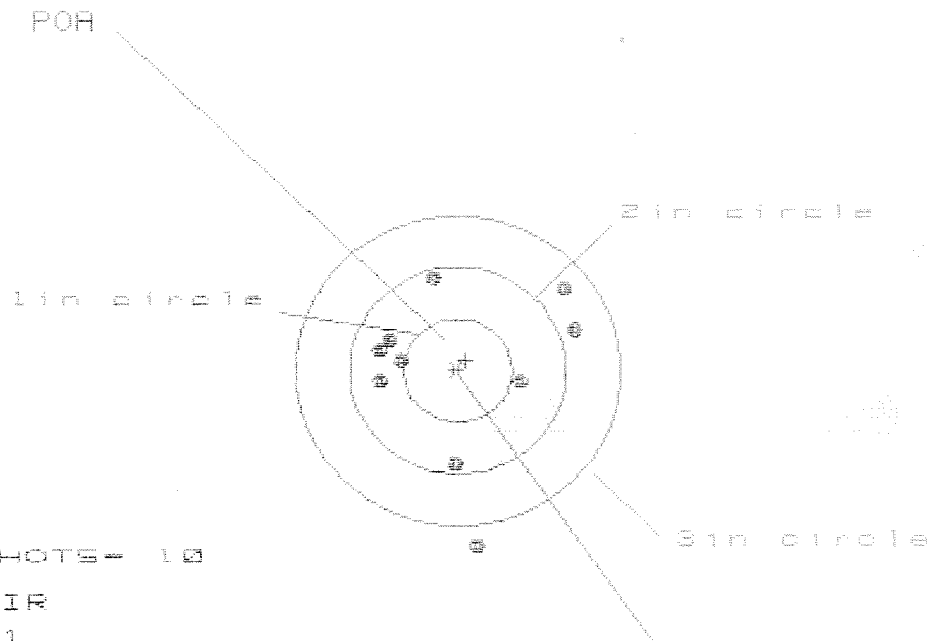
CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	1.100	.984
MINIMUM X	-1.030	-.929	-.857
MAXIMUM Y	1.183	1.205	1.321
MINIMUM Y	-1.220	-1.088	-.972
CENTROID X	.234	.133	.249
CENTROID Y	-.011	-.143	-.259
POA TO CENTROID in.	.234	.195	.359
MIN RADIUS	.407	.506	.425
MEAN RADIUS	.993	.948	.879
MAX RADIUS	1.492	1.314	1.457
HORIZONTAL SPREAD	2.029	2.029	1.841
VERTICAL SPREAD	2.402	2.293	2.293
EXTREME SPREAD	2.712	2.435	2.435
NUMBER IN ONE INCH CIRCLE =	3	3	3
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	10	10	10

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636060

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HE = 1.787

VS = 2.569

GS = 2.601

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.046
MINIMUM X	-.741
MAXIMUM Y	.904
MINIMUM Y	-1.665
CENTROID X	-.076
CENTROID Y	-.100
POA TO CENTROID in.	.125
MIN RADIUS	.486
MEAN RADIUS	.913
MAX RADIUS	1.680
HORIZONTAL SPREAD	1.787
VERTICAL SPREAD	2.569
EXTREME SPREAD	2.601
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	9

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66360B0

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.323

VS= 2.611

GS= 3.161

CENTROID X

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.193
MINIMUM X	-1.130
MAXIMUM Y	1.134
MINIMUM Y	-1.477
CENTROID X	-.086
CENTROID Y	.085
POA TO CENTROID in.	.121
MIN RADIUS	.378
MEAN RADIUS	.951
MAX RADIUS	1.759
HORIZONTAL SPREAD	2.323
VERTICAL SPREAD	2.611
EXTREME SPREAD	3.161
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636000

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.440

VS= 2.715

GS= 2.909

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.210	1.168	1.172
MINIMUM X	-1.227	-1.272	-1.126
MAXIMUM Y	1.483	.957	.861
MINIMUM Y	-1.232	-1.067	-1.163
CENTROID X	.031	.076	-.070
CENTROID Y	.032	-.133	-.037
POA TO CENTROID in.	.044	.153	.079
MIN RADIUS	.442	.457	.325
MEAN RADIUS	1.016	.943	.877
MAX RADIUS	1.537	1.399	1.181
HORIZONTAL SPREAD	2.440	2.440	2.298
VERTICAL SPREAD	2.715	2.024	2.024
EXTREME SPREAD	2.909	2.673	2.299
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		