

C6636140

MODEL 700™ M24

Model **SMS**™

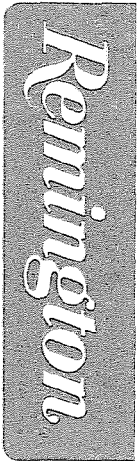
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

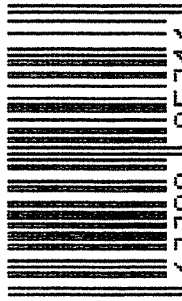


Remington REG. U.S. PAT. & TM. OFF.		DU PONT REG. U.S. PAT. & TM. OFF.	
MODEL 700™ H24		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		SERIAL NO. C6636140	ORDER NO. 5716



5716 C6636140

LPC



0 47700 25716 2

Stock
Repaired

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636140

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1	5-29-91	KCD
	Magnaflux Bolt	5 6 9 1	5-29-91	KCD
615	Rollmark Caliber	5 6 9 1	5-29-91	KCD
617	Drill and Tap Sight Holes	5 15 9 1	5-29-91	KB
618	Polish Barrel	5 15 9 1	5-29-91	KB
620	Apply Coatings (Barrel Action)		5-29-91	KB
	Apply Coating (Bolt)		5-29-91	KB
625	Final Assembly A) Clean inside of Bolt Assembly		4/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KS
	C) Inspect Ejector Hole for Chamfer		4/4/91	KS
	D) Oil Firing Pin Ass'y		4/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	98

op. #	BARBER - M24 0038184	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	6			6/5/91	SP
	G) Safety Off Force	3	3	3			6/5/91	SP
	H) Trigger Pull Test & Retainability						6-5-91	SP
	I) Firing Pin Indent	.021	.021	.021			6-5-91	SP
	J) Assemble Stock						6/5/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/5/91	KS
	M) Iron Sight Alignment						6/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	KS
	O) Attach Scope to Rifle						6/5/91	KS
	P) Detach & Attach Scope 20 Times						6/5/91	KS
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.38	2.42	2.44	2.50	2.55	6-8-91	SP
	C) Function						6-8-91	DH
660	Pack						6-20-91	SP

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-663640

DATE 6-5-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.35	2.43	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.34	2.38	2.42	
PULL #3	2.34	2.34	2.36	2.44	
PULL #4	2.35	2.34	2.39	2.50	
PULL #5	2.33	2.37	2.36	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.47		
PULL #2	3.59	3.52		
PULL #3	3.52	3.64		
PULL #4	3.52	3.55		
PULL #5	3.55	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.57		4.39
PULL #2	4.13	4.39		4.21
PULL #3	4.40	4.36		4.43
PULL #4	4.39	4.41		4.19
PULL #5	4.36	4.49		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636140
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.320807
1 TO	2	.537753
1 TO	3	.525681
1 TO	4	.403517
1 TO	5	.173159

351 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0163169
THE AMR FOR THIS RIFLE IS: .9006

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636140

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.686

VS= 4.109

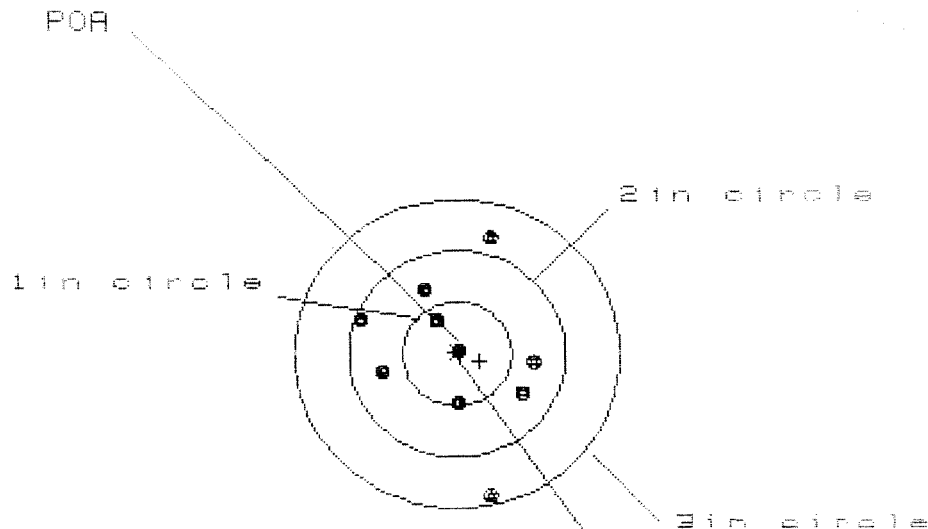
GS= 4.161

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.742	.788	.763
MINIMUM X	-.944	-.898	-.923
MAXIMUM Y	1.986	1.750	1.061
MINIMUM Y	-2.123	-1.088	-.869
CENTROID X	.319	.273	.298
CENTROID Y	-.034	.202	-.017
POR TO CENTROID in.	.321	.340	.298
MIN RADIUS	.372	.162	.358
MEAN RADIUS	1.054	.920	.798
MAX RADIUS	2.163	1.761	1.406
HORIZONTAL SPREAD	1.686	1.686	1.686
VERTICAL SPREAD	4.109	2.838	1.930
EXTREME SPREAD	4.161	2.890	2.298
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

6 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.689

VS= 2.475

GS= 2.475

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.754	.792	.841
MINIMUM X	:	-.935	-.897	-.848
MAXIMUM Y	:	1.084	.930	.561
MINIMUM Y	:	-1.391	-.610	-.494
CENTROID X	:	-.268	-.246	-.295
CENTROID Y	:	.073	.227	.111
POA TO CENTROID in.	:	.221	.335	.315
MIN RADIUS	:	.059	.100	.076
MEAN RADIUS	:	.730	.640	.584
MAX RADIUS	:	1.430	1.010	.906
HORIZONTAL SPREAD	:	1.689	1.689	1.689
VERTICAL SPREAD	:	2.475	1.540	1.055
EXTREME SPREAD	:	2.475	1.745	1.745
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in - 9

HS= 2.292

VS= 2.962

GS= 2.977

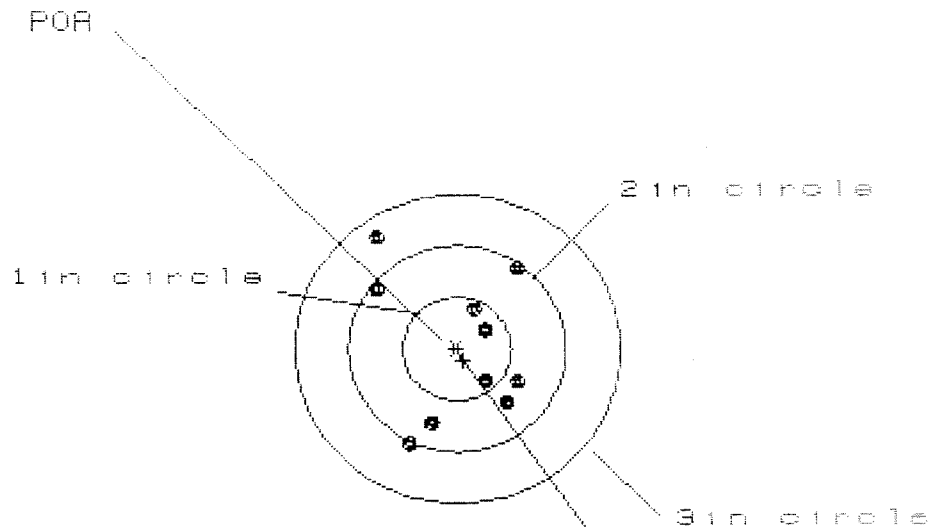
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.018	.984	.979
MINIMUM X	:	-1.274	-1.308	-1.313
MAXIMUM Y	:	1.522	.931	.772
MINIMUM Y	:	-1.440	-1.270	-.908
CENTROID X	:	-.186	-.152	-.147
CENTROID Y	:	-.180	-.349	-.190
POA TO CENTROID in.	:	.258	.380	.240
MIN RADIUS	:	.398	.481	.413
MEAN RADIUS	:	.930	.861	.785
MAX RADIUS	:	1.553	1.316	1.313
HORIZONTAL SPREAD	:	2.292	2.292	2.292
VERTICAL SPREAD	:	2.962	2.201	1.680
EXTREME SPREAD	:	2.977	2.299	2.299
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.293

VS = 1.991

GS = 2.017

CENTROID *

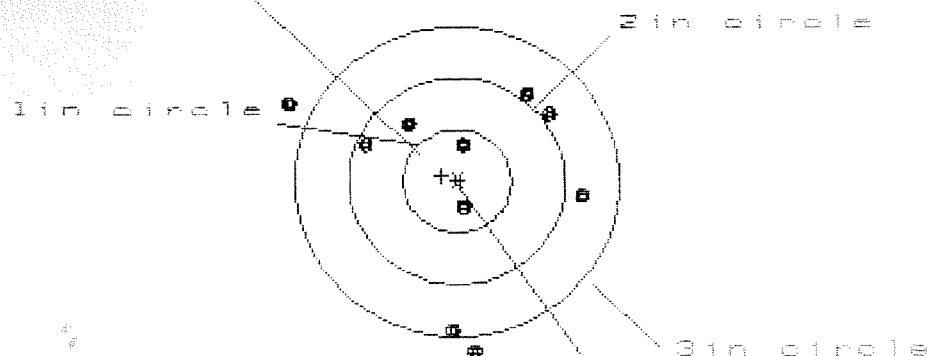
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.524
MINIMUM X	-.769
MAXIMUM Y	1.052
MINIMUM Y	-.939
CENTROID X	-.056
CENTROID Y	.115
POA TO CENTROID in.	.128
MIN RADIUS	.309
MEAN RADIUS	.742
MAX RADIUS	1.303
HORIZONTAL SPREAD	1.293
VERTICAL SPREAD	1.991
EXTREME SPREAD	2.017
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS # 5

POR



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.736

VS = 2.476

GS = 2.984

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.188
MINIMUM X	-1.548
MAXIMUM Y	.828
MINIMUM Y	-1.648
CENTROID X	.147
CENTROID Y	-.054
POR TO CENTROID in.	.156
MIN RADIUS	.271
MEAN RADIUS	1.047
MAX RADIUS	1.732
HORIZONTAL SPREAD	2.736
VERTICAL SPREAD	2.476
EXTREME SPREAD	2.984
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8