

C6636145

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

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

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

SERIAL NO.
 C6636145

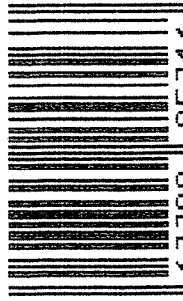
ORDER NO.
5716

20



5716 C6636145

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636145

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	5 8 9 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		W/B
620	Apply Coatings (Barrel Action)		5-31-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	FS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	FS
	C) Inspect Ejector Hole for Chamfer		6-6-91	FS
	D) Oil Firing Pin Ass'y		6-6-91	FS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	FS

op. #	BARBERAM24 0038239	READINGS				DATE	INIT
625 cont.	F) Safety On Force	6	6	6		6-7-91	JK
	G) Safety Off Force	4	4	4		6-7-91	JK
	H) Trigger Pull Test & Retainability					6-7-91	JK
	I) Firing Pin Indent	.0215	.023	.023		6-7-91	JK
	J) Assemble Stock					6-7-91	KS
	K) Assemble Swivel Studs					6-13-91	A
	L) Attach Front and Rear Sight Assemblies					6-7-91	KS
	M) Iron Sight Alignment					6-7-91	KS
	N) Detach Front & Rear Sights & place in numbered container					6-7-91	KS
	O) Attach Scope to Rifle					6-7-91	KS
	P) Detach & Attach Scope 20 Times					6-7-91	KS
640	Gallery Target & Test					6/10/91	KT
	A) Time					6/10/91	KT
	B) Malfunctions					6/10/91	KT
	C) Pierced Primers					6/10/91	KT
	D) Optical Clarity of Scope					6/10/91	KT
645	Inspect for Live Ammo					6/10/91	KT
655	Final Inspection						
	A) Headspace					6-13-91	A
	B) Trigger Pull	2.70	2.67	2.72	2.71	2.74	6-13-91
	C) Function					6-13-91	A
660	Pack					6-19-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636145
DATE 6-7-91
TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.45	2.48	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.45	2.40	2.67	
PULL #3	2.48	2.41	2.42	2.72	
PULL #4	2.46	2.51	2.44	2.71	
PULL #5	2.50	2.46	2.44	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.53		
PULL #2	3.48	3.39		
PULL #3	3.47	3.52		
PULL #4	3.42	3.54		
PULL #5	3.42	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.41		4.44
PULL #2	4.30	4.37		4.44
PULL #3	4.30	4.34		4.38
PULL #4	4.33	4.39		4.50
PULL #5	4.35	4.38		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636145
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.110277
1 TO	2	.0952575
1 TO	3	.262406
1 TO	4	.29484
1 TO	5	.278657

4 (----FOR

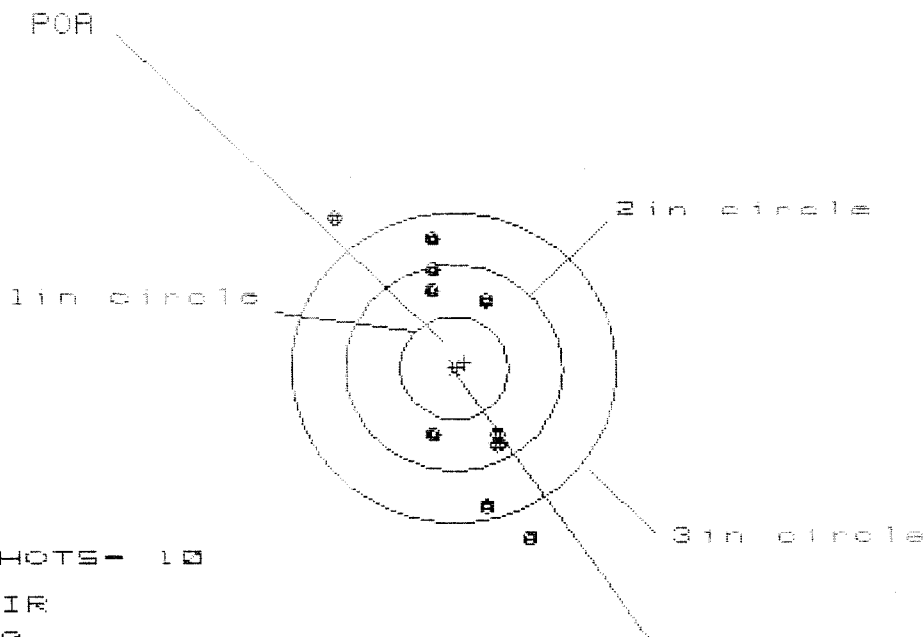
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .049
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .161989
THE AMR FOR THIS RIFLE IS: .9804

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636145

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 1.771

VS= 3.057

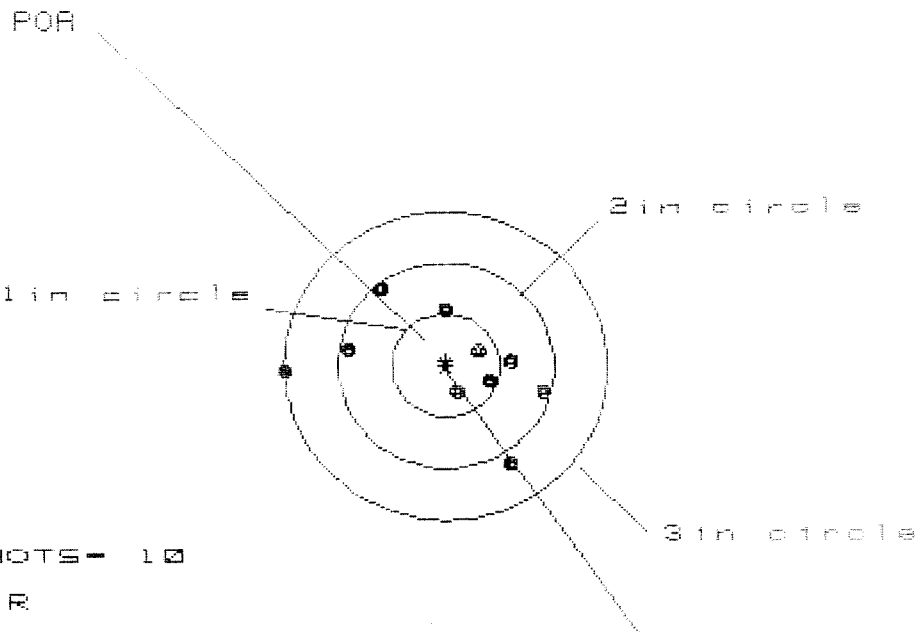
GS= 3.533

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.668	.545	.305
MINIMUM X	-1.103	-.376	-.308
MAXIMUM Y	1.431	1.391	1.207
MINIMUM Y	-1.626	-1.467	-1.370
CENTROID X	-.095	.028	-.040
CENTROID Y	-.056	-.215	-.031
POA TO CENTROID in.	.110	.217	.051
MIN RADIUS	.677	.534	.633
MEAN RADIUS	1.086	.985	.909
MAX RADIUS	1.807	1.565	1.391
HORIZONTAL SPREAD	1.771	.921	.613
VERTICAL SPREAD	3.057	2.858	2.577
EXTREME SPREAD	3.533	2.983	2.621
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.393

VS= 1.649

GS= 2.404

CENTROID #

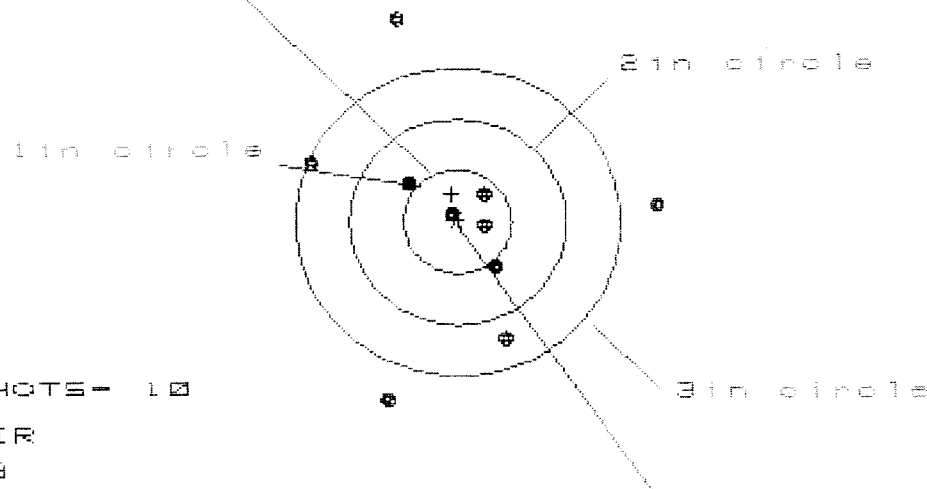
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.935	.774	.833
MINIMUM X	:	-1.458	-1.030	-.971
MAXIMUM Y	:	.707	.704	.586
MINIMUM Y	:	-.942	-.945	-.375
CENTROID X	:	-.000	.161	.102
CENTROID Y	:	-.049	-.046	.072
POA TO CENTROID in.	:	.049	.168	.125
MIN RADIUS	:	.246	.146	.109
MEAN RADIUS	:	.755	.635	.590
MAX RADIUS	:	1.458	1.058	.972
HORIZONTAL SPREAD	:	2.393	1.804	1.804
VERTICAL SPREAD	:	1.649	1.649	.961
EXTREME SPREAD	:	2.404	2.061	1.853
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 3.198

VS= 3.745

GS= 3.746

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.871	1.806	1.713
MINIMUM X	-1.327	-1.392	-1.485
MAXIMUM Y	1.968	.769	.574
MINIMUM Y	-1.777	-1.559	-1.118
CENTROID X	.054	.119	.212
CENTROID Y	-.272	-.490	-.295
POA TO CENTROID in.	.277	.505	.364
MIN RADIUS	.073	.266	.100
MEAN RADIUS	1.037	.933	.792
MAX RADIUS	2.054	1.847	1.724
HORIZONTAL SPREAD	3.198	3.198	3.198
VERTICAL SPREAD	3.745	2.328	1.692
EXTREME SPREAD	3.746	3.221	3.221
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.297

VS = 2.753

GS = 2.835

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	1.069	.916
MINIMUM X	:	-1.334	-1.228	-.567
MAXIMUM Y	:	1.075	.889	.783
MINIMUM Y	:	-1.678	-.899	-1.005
CENTROID X	:	.188	.082	.235
CENTROID Y	:	-.138	.048	.154
POA TO CENTROID in.	:	.233	.095	.281
MIN RADIUS	:	.281	.109	.293
MEAN RADIUS	:	.868	.682	.597
MAX RADIUS	:	1.932	1.493	1.008
HORIZONTAL SPREAD	:	2.297	2.297	1.483
VERTICAL SPREAD	:	2.753	1.788	1.788
EXTREME SPREAD	:	2.835	2.474	1.796
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 3.190

VS = 2.938

GS = 3.653

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.181
MINIMUM X	-2.009
MAXIMUM Y	1.078
MINIMUM Y	-1.860
CENTROID X	.098
CENTROID Y	-.257
POA TO CENTROID in.	.275
MIN RADIUS	.418
MEAN RADIUS	1.153
MAX RADIUS	2.262
HORIZONTAL SPREAD	3.190
VERTICAL SPREAD	2.938
EXTREME SPREAD	3.653
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8