

C6636149

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]


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

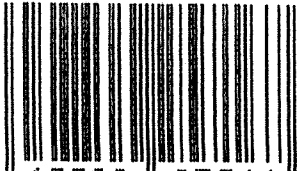
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700 TM H24	SERIAL NO. C6636149
	ORDER NO. 5716

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


5716 C6636149

UPC


0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636149

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	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		CS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	KS
	C) Inspect Ejector Hole for Chamfer		4/12/91	KS
	D) Oil Firing Pin Ass'y		4/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/13/91	D/H

op. #	BARBER - M24 0038272	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	2	2	2			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	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6-14-91	KT
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.59	2.57	2.58	2.59	2.56	6-15-91	JK
	C) Function						6-15-91	DH
660	Pack						6-19-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636149DATE 6-13-91TESTER PH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.59	2.61	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	2.52	2.63	2.57	
PULL #3	2.24	2.52	2.64	2.58	
PULL #4	2.17	2.51	2.61	2.59	
PULL #5	2.20	2.52	2.70	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.30		
PULL #2	3.00	3.34		
PULL #3	3.11	3.29		
PULL #4	2.99	3.19		
PULL #5	3.18	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.16		4.28
PULL #2	4.42	4.13		4.24
PULL #3	4.01	4.16		4.27
PULL #4	3.96	4.16		4.02
PULL #5	4.02	4.17		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636149
14 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.541901
1 TO	2	.661069
1 TO	3	.853029
1 TO	4	.666888
1 TO	5	.847917

1
54 <----POA

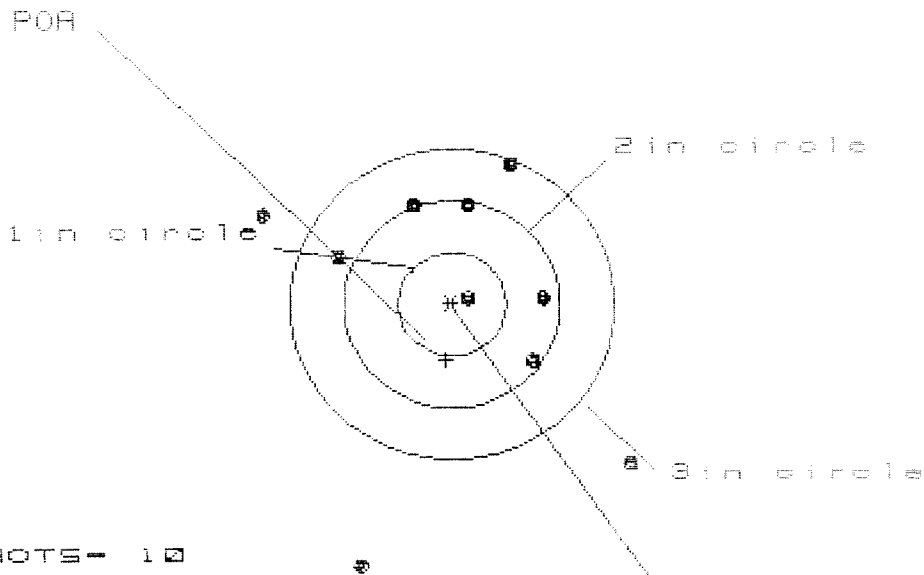
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0766
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0416
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0871672

THE AMR FOR THIS RIFLE IS: 1.234

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636149

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 3.366

VS = 3.864

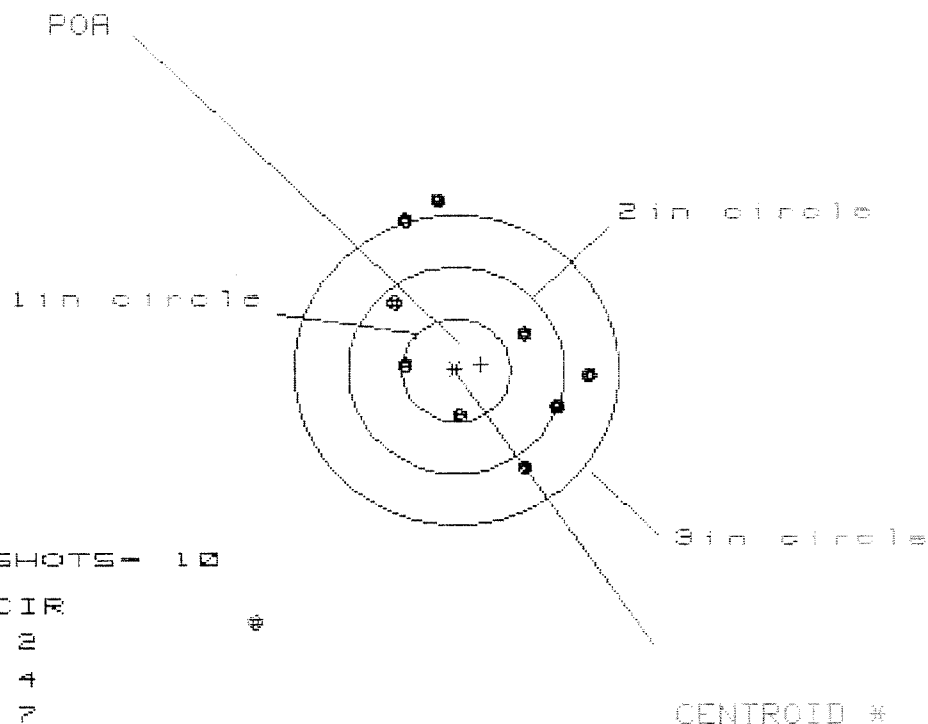
GS = 4.154

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.621	1.536	.962
MINIMUM X	-1.745	-1.836	-1.644
MAXIMUM Y	1.320	1.037	.807
MINIMUM Y	-2.544	-1.841	-1.068
CENTROID X	.056	.147	-.045
CENTROID Y	.539	.822	1.052
POA TO CENTROID in.	.542	.835	1.053
MIN RADIUS	.104	.253	.523
MEAN RADIUS	1.334	1.138	.960
MAX RADIUS	2.672	2.394	1.684
HORIZONTAL SPREAD	3.366	3.366	2.606
VERTICAL SPREAD	3.864	2.878	1.875
EXTREME SPREAD	4.154	4.154	2.828
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

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FILE:/PATTERNING/CENTERFIRE_PATT/06636149

CENTERFIRE PATTERNS # 2



HS = 3.138

VS = 4.099

GS = 4.441

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.260	1.052	1.005
MINIMUM X	:	-1.078	-0.769	-0.816
MAXIMUM Y	:	1.659	1.388	1.391
MINIMUM Y	:	-2.440	-1.177	-1.003
CENTROID X	:	-0.230	-0.022	.025
CENTROID Y	:	-0.057	.214	.040
POA TO CENTROID in.	:	.237	.215	.048
MIN RADIUS	:	.435	.406	.454
MEAN RADIUS	:	1.211	.979	.896
MAX RADIUS	:	3.079	1.438	1.547
HORIZONTAL SPREAD	:	3.138	1.821	1.821
VERTICAL SPREAD	:	4.099	2.565	2.394
EXTREME SPREAD	:	4.441	2.677	2.602
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8836149

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 5

HS= 2.324

VS= 3.394

GS= 3.813

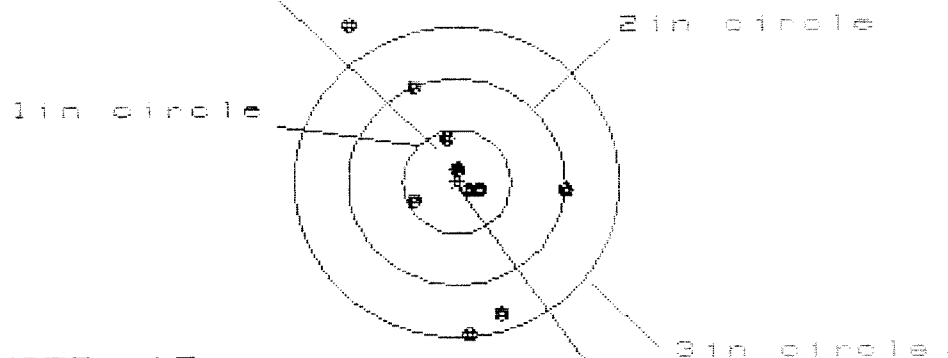
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	.961	.873
MINIMUM X	:	-1.285	-1.363	-1.243
MAXIMUM Y	:	1.906	1.893	1.734
MINIMUM Y	:	-1.488	-1.276	-1.329
CENTROID X	:	.049	.127	.087
CENTROID Y	:	-.314	-.526	-.367
POA TO CENTROID in.	:	.318	.541	.367
MIN RADIUS	:	.037	.221	.098
MEAN RADIUS	:	1.149	1.081	.970
MAX RADIUS	:	2.030	1.894	1.743
HORIZONTAL SPREAD	:	2.324	2.324	2.116
VERTICAL SPREAD	:	3.394	3.169	3.062
EXTREME SPREAD	:	3.813	3.294	3.234
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 4

POR



OF SHOTS- 10

IN CIR

1in = 5

2in = 5

3in = 9

HS= 2.050

VS= 3.016

GS= 3.210

CENTROID #

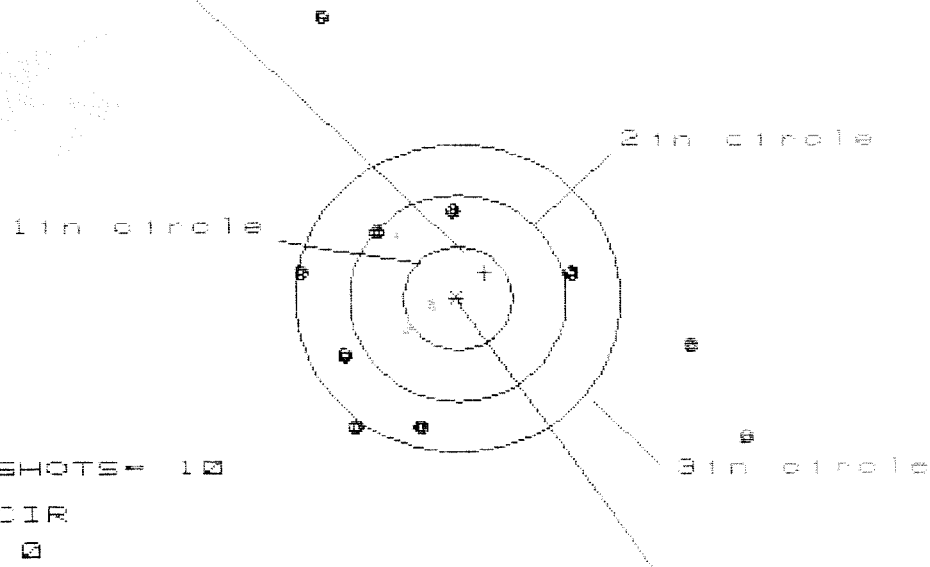
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	.938	.936
MINIMUM X	:	-1.001	-.536	-.537
MAXIMUM Y	:	1.520	1.079	.913
MINIMUM Y	:	-1.496	-1.327	-1.228
CENTROID X	:	-.006	.105	.106
CENTROID Y	:	-.125	-.294	-.128
POR TO CENTROID in.	:	.125	.312	.167
MIN RADIUS	:	.121	.140	.026
MEAN RADIUS	:	.808	.708	.583
MAX RADIUS	:	1.820	1.327	1.259
HORIZONTAL SPREAD	:	2.050	1.474	1.474
VERTICAL SPREAD	:	3.016	2.406	2.141
EXTREME SPREAD	:	3.210	2.459	2.286
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 1

3in = 6

HS = 4.129

VS = 4.102

GS = 5.678

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.690
MINIMUM X	-1.439
MAXIMUM Y	2.799
MINIMUM Y	-1.304
CENTROID X	-0.252
CENTROID Y	-0.251
POA TO CENTROID in.	0.356
MIN RADIUS	0.862
MEAN RADIUS	1.660
MAX RADIUS	3.059
HORIZONTAL SPREAD	4.129
VERTICAL SPREAD	4.102
EXTREME SPREAD	5.678
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	1
NUMBER IN THREE INCH CIRCLE	6