

C6636185

MODEL 700™ M24

Model SMS™

Action

Barrel Length

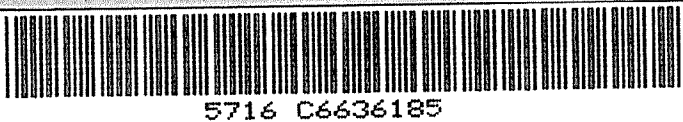
Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6636185
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636185

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	U
615	Rollmark Caliber		APR 9 1991	YB
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	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		5/28/91	YB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/28/91	JH
	G) Safety Off Force	3	3	3			5/28/91	JH
	H) Trigger Pull Test & Retainability						5/28/91	JH
	I) Firing Pin Indent	.0205	.0205	.020			5/28/91	JH
	J) Assemble Stock						5/28/91	RW
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/28/91	RW
	M) Iron Sight Alignment						5/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	RW
	O) Attach Scope to Rifle						5/28/91	RW
	P) Detach & Attach Scope 20 Times						5/28/91	RW
640	Gallery Target & Test						5-31-91	D/H
	A) Time						5-31-91	D/H
	B) Malfunctions						5-31-91	D/H
	C) Pierced Primers						5-31-91	D/H
	D) Optical Clarity of Scope						5-31-91	D/H
645	Inspect for Live Ammo						5-31-91	D/H
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.25	2.28	2.22	2.30	2.34	6-1-91	JH
	C) Function						6-1-91	D/H
660	Pack						6-19-91	RE

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

SERIAL NO C6636185DATE 5/28/91TESTER JCP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.18	2.49	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.42	2.36	2.28	
PULL #3	2.55	2.36	3.44	2.22	
PULL #4	2.59	2.38	2.39	2.30	
PULL #5	2.58	2.47	2.46	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.66		
PULL #2	3.57	3.26		
PULL #3	3.57	3.28		
PULL #4	3.65	3.55		
PULL #5	3.65	3.70		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.62		4.62
PULL #2	4.27	4.59		4.62
PULL #3	4.54	4.66		4.66
PULL #4	4.52	4.42		4.55
PULL #5	4.59	4.55		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636185
31 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.428964
1 TO	2	.567088
1 TO	3	.393487
1 TO	4	.513425
1 TO	5	.515982

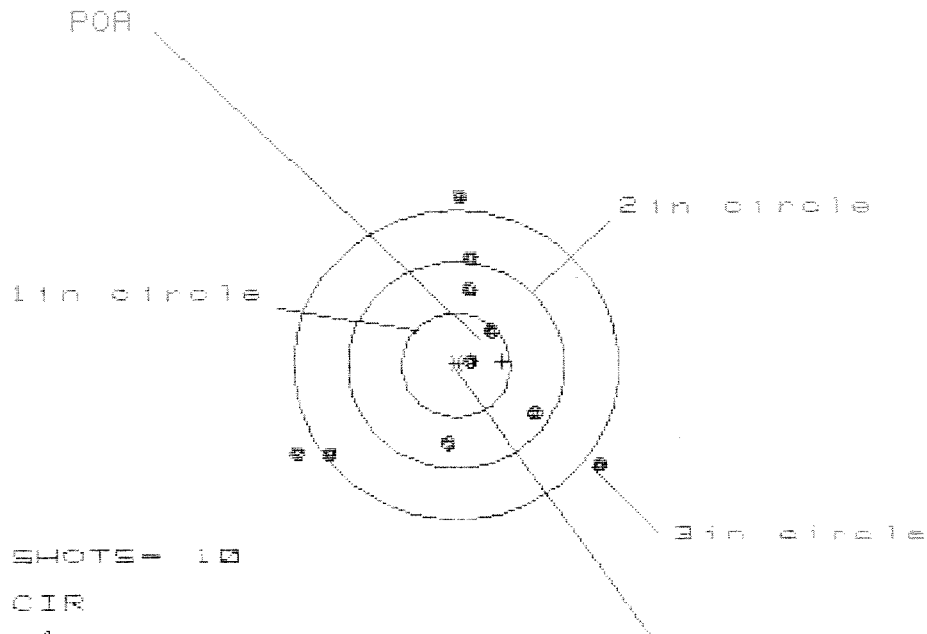
1  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0384
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0314
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0496036
THE AMR FOR THIS RIFLE IS: .9284

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636185

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.796

VS= 2.580

GS= 2.905

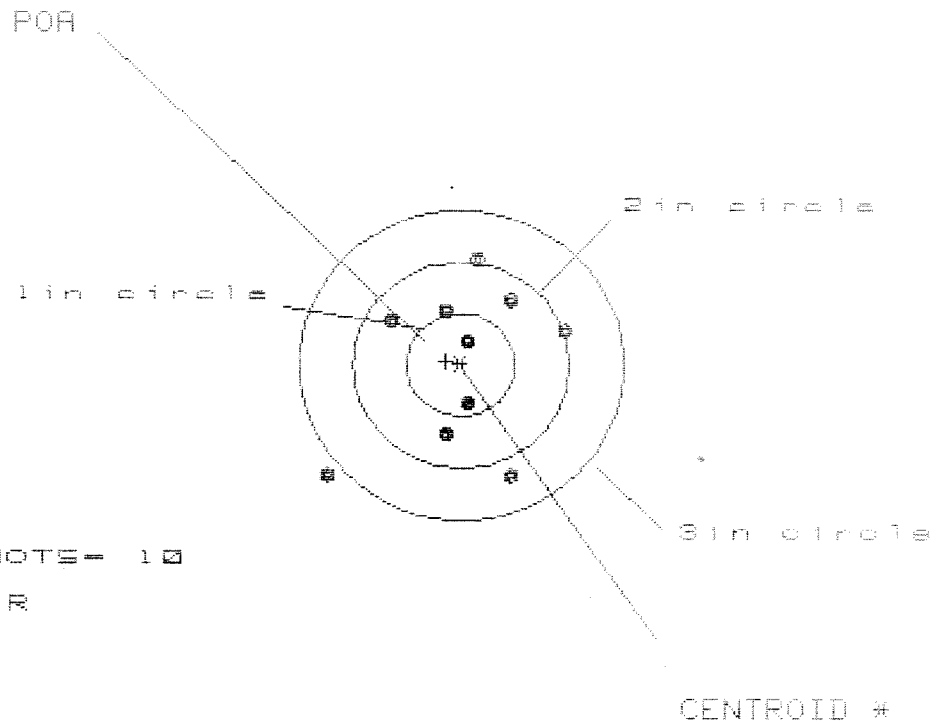
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.324	1.160	.678
MINIMUM X	-1.472	-1.372	-1.227
MAXIMUM Y	1.603	1.504	1.370
MINIMUM Y	-.977	-1.076	-1.048
CENTROID X	-.427	-.263	-.408
CENTROID Y	-.041	.058	.192
POA TO CENTROID in.	.429	.269	.451
MIN RADIUS	.151	.041	.186
MEAN RADIUS	1.048	.928	.855
MAX RADIUS	1.718	1.648	1.614
HORIZONTAL SPREAD	2.796	2.532	1.905
VERTICAL SPREAD	2.580	2.580	2.418
EXTREME SPREAD	2.905	2.905	2.698
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.195

VS = 2.077

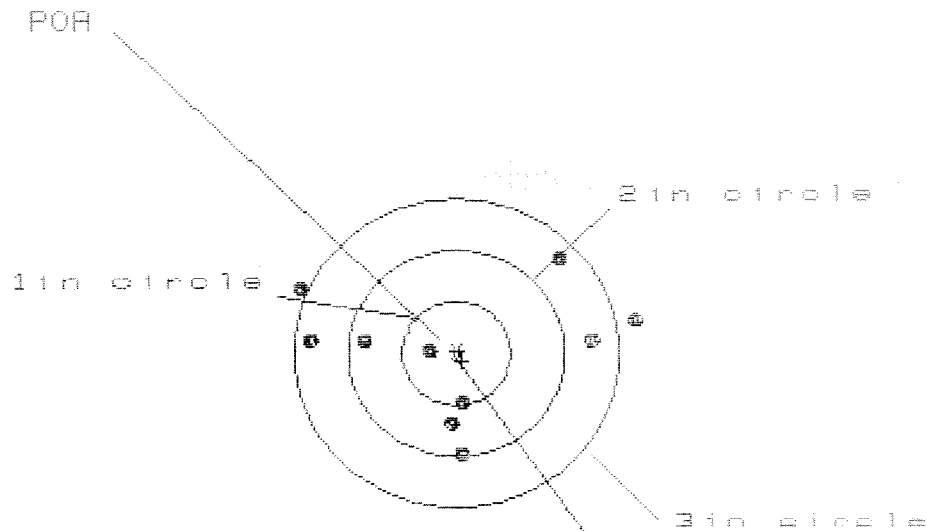
GS = 2.613

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.932	.791	.832
MINIMUM X	:	-1.264	-.785	-.744
MAXIMUM Y	:	1.024	.907	.762
MINIMUM Y	:	-1.053	-1.159	-.954
CENTROID X	:	.140	.281	.240
CENTROID Y	:	-.031	.086	.231
POA TO CENTROID in.	:	.144	.294	.333
MIN RADIUS	:	.260	.157	.039
MEAN RADIUS	:	.814	.699	.602
MAX RADIUS	:	1.645	1.204	.978
HORIZONTAL SPREAD	:	2.195	1.576	1.576
VERTICAL SPREAD	:	2.077	2.066	1.716
EXTREME SPREAD	:	2.613	2.082	1.745
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.013

VS= 1.851

GS= 3.034

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.604
MINIMUM X	-1.409
MAXIMUM Y	.883
MINIMUM Y	-.968
CENTROID X	-.051
CENTROID Y	.075
POA TO CENTROID in.	.091
MIN RADIUS	.286
MEAN RADIUS	1.037
MAX RADIUS	1.628
HORIZONTAL SPREAD	3.013
VERTICAL SPREAD	1.851
EXTREME SPREAD	3.034
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

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FILE:/PATTERNING/CENTERFIRE_PATT/08686185

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.392

VS= 2.103

GS= 2.575

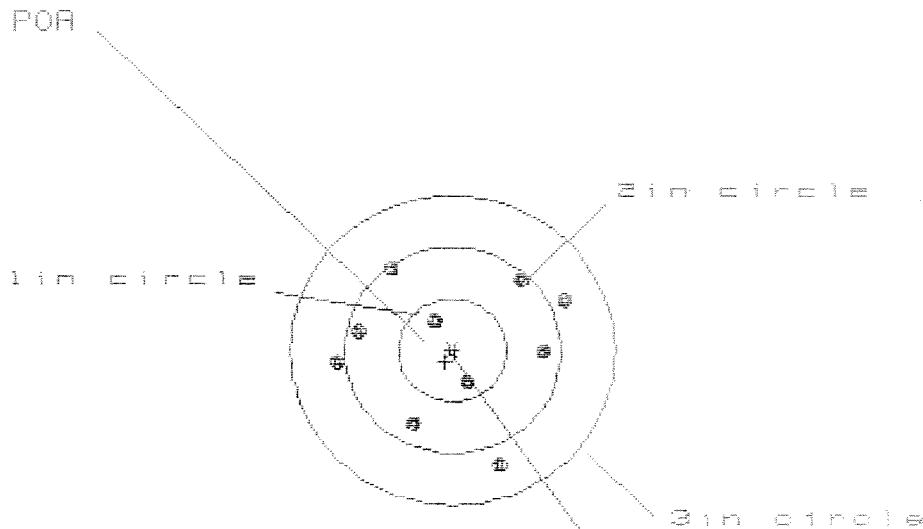
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.375	1.063	.955
MINIMUM X	-1.017	-.865	-.941
MAXIMUM Y	1.091	1.073	1.171
MINIMUM Y	-1.012	-1.030	-.932
CENTROID X	.079	-.073	.035
CENTROID Y	.046	.064	-.034
POA TO CENTROID in.	.092	.097	.048
MIN RADIUS	.317	.183	.262
MEAN RADIUS	.891	.826	.767
MAX RADIUS	1.383	1.164	1.252
HORIZONTAL SPREAD	2.392	1.928	1.896
VERTICAL SPREAD	2.103	2.103	2.103
EXTREME SPREAD	2.575	2.245	2.245
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.052

VS= 1.908

GS= 2.193

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	1.057	.992
MINIMUM X	-1.048	-.995	-.862
MAXIMUM Y	.773	.647	.692
MINIMUM Y	-1.135	-.884	-.840
CENTROID X	.067	.014	-.119
CENTROID Y	.108	.235	.191
POA TO CENTROID in.	.128	.235	.224
MIN RADIUS	.363	.230	.217
MEAN RADIUS	.852	.797	.745
MAX RADIUS	1.233	1.115	.998
HORIZONTAL SPREAD	2.052	2.052	1.854
VERTICAL SPREAD	1.908	1.531	1.531
EXTREME SPREAD	2.193	2.126	1.855
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	