

C6649243

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

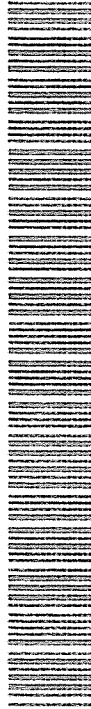
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO. C6649243

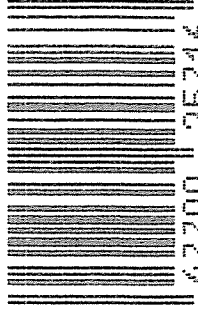
ORDER NO. 5716

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



5716 C6649243

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649243

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	dw
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL 1	7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-29-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6 1/4			8-7-91	DH
	G) Safety Off Force	3	3	3			8-7-91	DH
	H) Trigger Pull Test & Retainability						8-7-91	DH
	I) Firing Pin Indent	.020	.020	.020			8-7-91	DH
	J) Assemble Stock						8/20/91	RW
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	DH
	A) Time						8-12-91	DH
	B) Malfunctions						8-12-91	DH
	C) Pierced Primers						8-12-91	DH
	D) Optical Clarity of Scope						8-12-91	DH
645	Inspect for Live Ammo						8-12-91	DH
655	Final Inspection						8-13-91	DH
	A) Headspace							
	B) Trigger Pull	2-61	2-69	2-70	2-70	2-63	8-13-91	92
	C) Function						8-13-91	DH
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C66 49 243

DATE 8-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.60	2.49	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.67	2.67	2.70	2.69	
PULL #3	2.62	2.53	2.67	2.70	
PULL #4	2.61	2.54	2.70	2.70	
PULL #5	2.62	2.51	2.77	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.27		
PULL #2	3.25	3.28		
PULL #3	3.31	3.28		
PULL #4	3.28	3.23		
PULL #5	3.30	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	4.20	4.61		4.07
PULL #2	4.26	4.25		4.20
PULL #3	4.29	4.17		4.16
PULL #4	4.30	4.25		4.06
PULL #5	4.28	4.25		4.02
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649243
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.195602
1 TO	2	.614539
1 TO	3	.873403
1 TO	4	.424672
1 TO	5	.374995

$\begin{matrix} 2 \\ 4 \\ 3 \end{matrix} \begin{matrix} 1 \\ 2 \\ 3 \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.051
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1174
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127999
THE AMR FOR THIS RIFLE IS: .9674

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649243

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.808

VS= 1.331

GS= 2.889

PATTERN #

:

■

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.240

1.066

.659

MINIMUM X

:

-1.568

-.854

-.721

MAXIMUM Y

:

.853

.875

.818

MINIMUM Y

:

-.478

-.456

-.475

CENTROID X

:

.188

.362

.229

CENTROID Y

:

.054

.032

.089

POA TO CENTROID in.:

:

.195

.363

.245

MIN RADIUS

:

.247

.213

.284

MEAN RADIUS

:

.720

.609

.540

MAX RADIUS

:

1.581

1.159

.836

HORIZONTAL SPREAD

:

2.808

1.920

1.380

VERTICAL SPREAD

:

1.331

1.331

1.293

EXTREME SPREAD

:

2.889

2.040

1.461

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

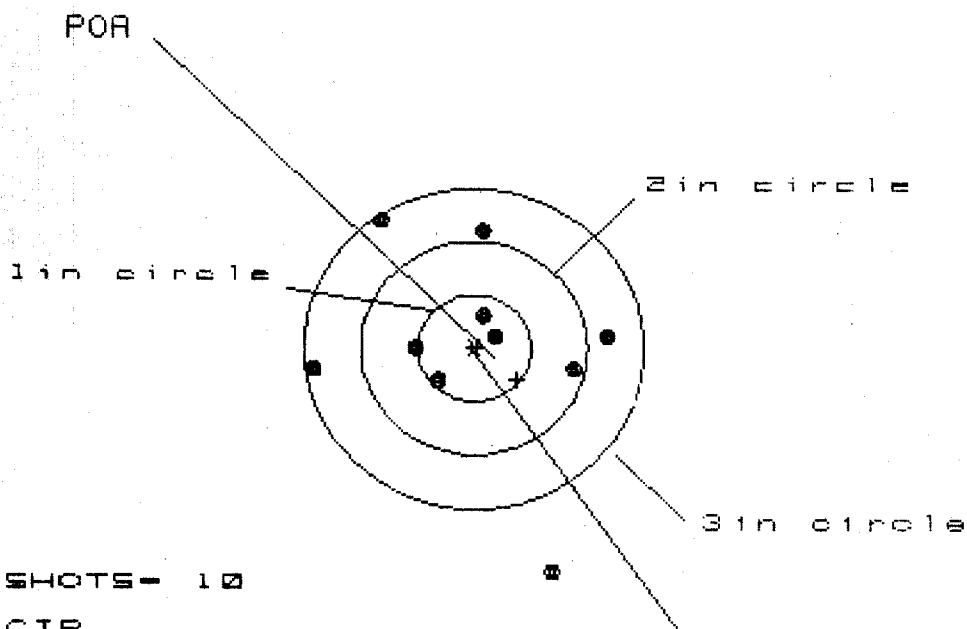
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.663

VS= 3.231

GS= 3.566

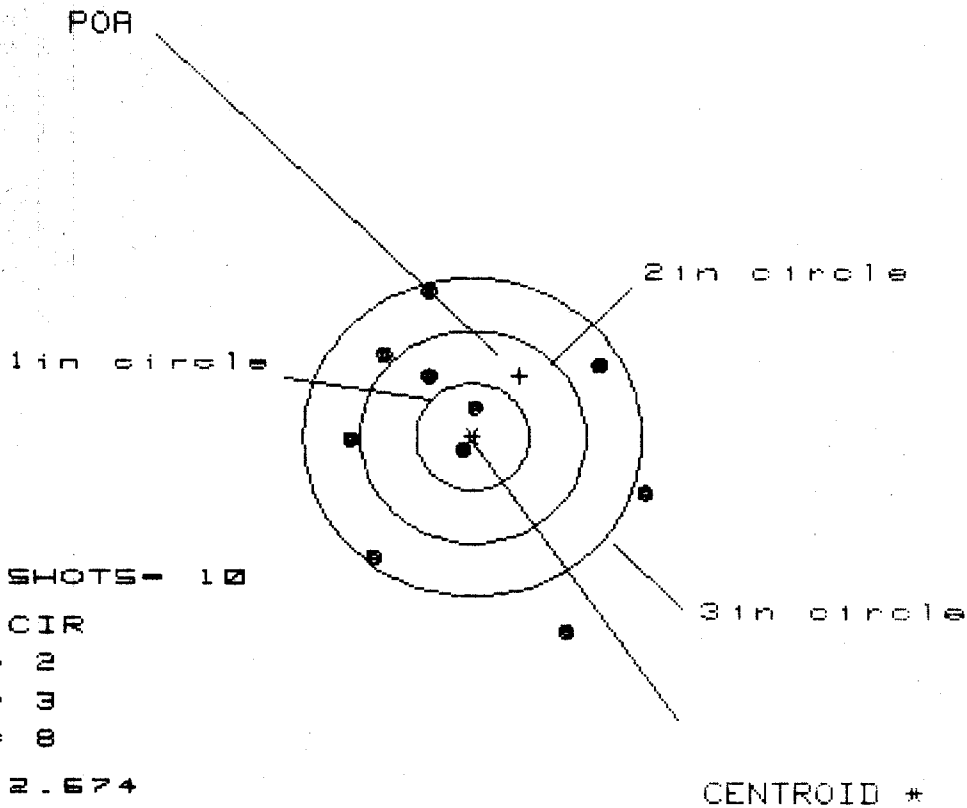
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.222	1.302	1.132
MINIMUM X	:	-1.441	-1.361	-.876
MAXIMUM Y	:	1.186	.958	.906
MINIMUM Y	:	-2.045	-.558	-.610
CENTROID X	:	-.379	-.459	-.289
CENTROID Y	:	.291	.519	.571
POA TO CENTROID in.	:	.478	.693	.640
MIN RADIUS	:	.217	.203	.031
MEAN RADIUS	:	.975	.821	.715
MAX RADIUS	:	2.170	1.423	1.260
HORIZONTAL SPREAD	:	2.663	2.663	2.008
VERTICAL SPREAD	:	3.231	1.516	1.516
EXTREME SPREAD	:	3.566	2.680	2.277
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 2.674

VS = 3.178

GS = 3.407

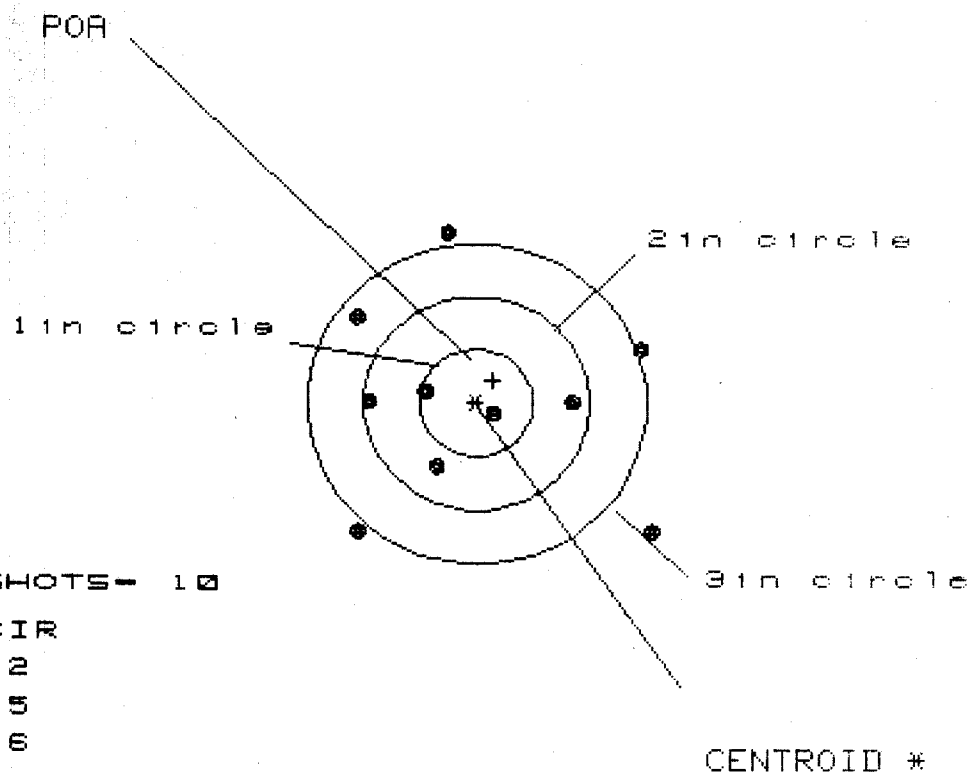
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.555	1.650	1.421
MINIMUM X	:	-1.119	-1.024	-.818
MAXIMUM Y	:	1.359	1.157	1.063
MINIMUM Y	:	-1.819	-1.296	-1.390
CENTROID X	:	-.419	-.514	-.720
CENTROID Y	:	-.574	-.372	-.278
POA TO CENTROID in.	:	.711	.634	.772
MIN RADIUS	:	.121	.133	.237
MEAN RADIUS	:	1.099	.955	.826
MAX RADIUS	:	2.009	1.813	1.514
HORIZONTAL SPREAD	:	2.674	2.674	2.239
VERTICAL SPREAD	:	3.178	2.453	2.453
EXTREME SPREAD	:	3.407	2.725	2.698
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS = 2.552

VS = 2.846

GS = 3.338

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.627	1.617
MINIMUM X	:	-1.053	-0.886	-0.896
MAXIMUM Y	:	1.628	1.492	.825
MINIMUM Y	:	-1.218	-1.349	-1.162
CENTROID X	:	-.147	-.314	-.304
CENTROID Y	:	-.207	-.071	-.258
POA TO CENTROID in.	:	.254	.322	.399
MIN RADIUS	:	.129	.248	.261
MEAN RADIUS	:	1.105	.999	.915
MAX RADIUS	:	1.932	1.678	1.724
HORIZONTAL SPREAD	:	2.552	2.513	2.513
VERTICAL SPREAD	:	2.846	2.841	1.987
EXTREME SPREAD	:	3.338	3.037	3.037
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.396

VS= 2.123

GS= 2.692

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.345	.792	.679
MINIMUM X	:	-1.051	-.901	-.723
MAXIMUM Y	:	1.073	.986	.877
MINIMUM Y	:	-1.050	-1.137	-1.246
CENTROID X	:	.502	.352	.465
CENTROID Y	:	-.151	-.064	.045
POA TO CENTROID in.	:	.524	.358	.467
MIN RADIUS	:	.386	.228	.238
MEAN RADIUS	:	.938	.844	.785
MAX RADIUS	:	1.557	1.252	1.303
HORIZONTAL SPREAD	:	2.396	1.693	1.402
VERTICAL SPREAD	:	2.123	2.123	2.123
EXTREME SPREAD	:	2.692	2.370	2.326
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		