

C6649297

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ H24

SERIAL NO.
C6649297

ORDER NO.
5716

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

20

5716 C6649297

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649297

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action		1 JUL 2 1991	KR
	Magnaflux Bolt		1 JUL 2 1991	KR
615	Rollmark Caliber		1 JUL 2 1991	LS.
617	Drill and Tap Sight Holes		1 JUL 2 1991	LB
618	Polish Barrel		1 JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	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		7-29-91	JA

op. #	BARBER - M24 0067460		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		4	4	6			7-29-91	JP
	G) Safety Off Force		4	4	4			7-29-91	JP
	H) Trigger Pull Test & Retainability							7-29-91	JP
	I) Firing Pin Indent		10205	10205	10205			7-29-91	JP
	J) Assemble Stock							8-1-91	RW
	K) Assemble Swivel Studs							8-6-91	AC
	L) Attach Front and Rear Sight Assemblies							8-1-91	RW
	M) Iron Sight Alignment							8-1-91	RW
	N) Detach Front & Rear Sights & place in numbered container							8-1-91	RW
	O) Attach Scope to Rifle							8-1-91	RW
	P) Detach & Attach Scope 20 Times							8-1-91	RW
640	Gallery Target & Test							8-1-91	NF
	A) Time							"	NF
	B) Malfunctions							"	NF
	C) Pierced Primers							"	NF
	D) Optical Clarity of Scope							"	NF
645	Inspect for Live Ammo							8-1-91	NF
655	Final Inspection								
	A) Headspace							8-6-91	AC
	B) Trigger Pull		2.19	2.35	2.33	2.37	2.40	8-5-91	JP
	C) Function							8-6-91	AC
660	Pack							9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 0-6649297

DATE 7-29-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.50	2.44	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.23	2.50	2.35	
PULL #3	2.49	2.45	2.44	2.33	
PULL #4	2.34	2.47	2.47	2.37	
PULL #5	2.44	2.52	2.51	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.41		
PULL #2	3.44	3.48		
PULL #3	3.32	3.30		
PULL #4	3.38	3.39		
PULL #5	3.32	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.47		4.48
PULL #2	4.48	4.47		4.49
PULL #3	4.47	4.49		4.47
PULL #4	4.39	4.44		4.40
PULL #5	4.39	4.46		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649297
1 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0218403
1 TO	2	.276101
1 TO	3	.0152643
1 TO	4	.159962
1 TO	5	.200212

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0952
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0981299
THE AMR FOR THIS RIFLE IS: .9056

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849287

CENTERFIRE PATTERNS # 1

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.534

VS = 2.437

GS = 2.635

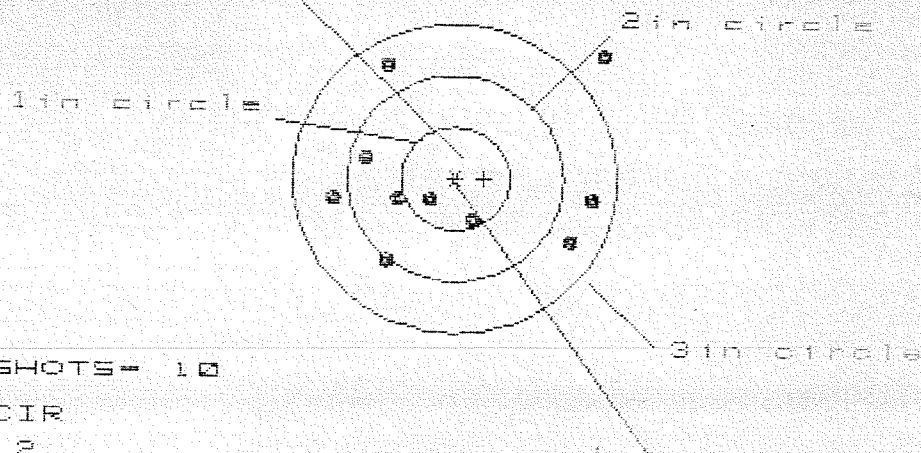
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.023	.855	.938
MINIMUM X	-1.511	-1.500	-1.417
MAXIMUM Y	1.197	1.155	.995
MINIMUM Y	-1.240	-1.282	-1.057
CENTROID X	.006	.174	.091
CENTROID Y	-.021	.021	.101
FOR TO CENTROID in.	.022	.175	.202
MIN RADIUS	.204	.193	.031
MEAN RADIUS	1.014	.928	.842
MAX RADIUS	1.558	1.502	1.434
HORIZONTAL SPREAD	2.534	2.355	2.055
VERTICAL SPREAD	2.437	2.437	2.052
EXTREME SPREAD	2.635	2.635	2.060
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6549297

CENTERFIRE PATTERNS # 2

POB



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.511

VS= 1.987

GS= 2.877

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.374	1.437	1.420
MINIMUM X	-1.137	-0.985	-0.805
MAXIMUM Y	1.198	1.260	1.253
MINIMUM Y	-0.788	-0.655	-0.663
CENTROID X	-0.268	-0.420	-0.600
CENTROID Y	-0.005	-0.138	-0.131
POB TO CENTROID in.	0.268	0.442	0.614
MIN RADIUS	0.279	0.077	0.132
MEAN RADIUS	0.991	0.836	0.727
MAX RADIUS	1.823	1.438	1.482
HORIZONTAL SPREAD	2.511	2.422	2.225
VERTICAL SPREAD	1.987	1.915	1.915
EXTREME SPREAD	2.877	2.422	2.371
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

1 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/06648297

CENTERFIRE PATTERNS # 3

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.072

VS = 2.107

GS = 2.762

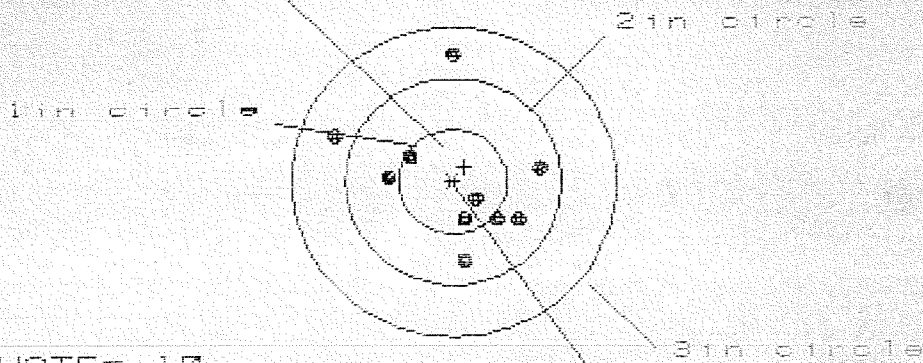
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	.926	1.040
MINIMUM X	:	-1.032	-.735	-.620
MAXIMUM Y	:	1.102	.990	1.080
MINIMUM Y	:	-1.006	-.778	-.689
CENTROID X	:	.019	.133	.018
CENTROID Y	:	-.029	.082	-.007
POB TO CENTROID in.	:	.035	.157	.020
MIN RADIUS	:	.152	.086	.149
MEAN RADIUS	:	.825	.761	.686
MAX RADIUS	:	1.441	1.165	1.190
HORIZONTAL SPREAD	:	2.072	1.661	1.661
VERTICAL SPREAD	:	2.107	1.768	1.768
EXTREME SPREAD	:	2.762	2.169	2.169
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849897

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.863

VS = 2.024

GS = 2.025

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.795	.661
MINIMUM X	-1.068	-1.068	-1.711
MAXIMUM Y	1.240	.558	.449
MINIMUM Y	-.784	-.647	-.577
CENTROID X	-.102	-.102	.031
CENTROID Y	-.139	-.276	-.346
POA TO CENTROID in.	.172	.295	.348
MIN RADIUS	.246	.170	.039
MEAN RADIUS	.678	.582	.454
MAX RADIUS	1.240	1.205	.752
HORIZONTAL SPREAD	1.863	1.963	1.372
VERTICAL SPREAD	2.024	1.205	1.026
EXTREME SPREAD	2.025	1.890	1.373
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849297

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.346

VS = 2.970

GS = 3.258

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.560
MINIMUM X	-1.786
MAXIMUM Y	1.659
MINIMUM Y	-1.311
CENTROID X	-1.131
CENTROID Y	.125
POA TO CENTROID in.	.181
MIN RADIUS	.392
MEAN RADIUS	1.020
MAX RADIUS	1.853
HORIZONTAL SPREAD	2.346
VERTICAL SPREAD	2.970
EXTREME SPREAD	3.258
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8