

C6649301

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **Model 700™ H24**

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

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

SERIAL NO.
C6649301

ORDER NO.
5716

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

06

UPC



0 47700 25716 7



5716 C6649301

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	failed	
TEST		
TGT		
PROOF	Needs New Bit	
TEST		
TGT		
PROOF	100 R.I. Test OK 9-13-91 D.H.	
TEST		
TGT		
PROOF		
TEST		
TGT		

MOD.		GA. CAL. 1702	GUN # 6649301
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaver loose check head	RW
	2nd	check head Polish face of Boit 100 Rd Test	RW
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649301

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	AW
600	Proof	6 27	9 1	AW
607	Check Headspace	6 27	9 1	AW
610	Dis-assemble Gun	6 27	9 1	AW
612	Magnaflux Barrel Action		JUL 2 1991	K.R.
	Magnaflux Bolt		JUL 2 1991	K.R.
615	Rollmark Caliber		JUL 2 1991	GS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 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		8-8-91	JH

BARBER - M24 0067506		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	6	6	6			8-8-91	YH
	G) Safety Off Force	3	3	3			8-8-91	YH
	H) Trigger Pull Test & Retainability						8-8-91	YH
	I) Firing Pin Indent	.0215	.021	.021			8-8-91	YH
	J) Assemble Stock						8/9/91	RW
	K) Assemble Swivel Studs						7-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/9/91	RW
	M) Iron Sight Alignment						8/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	RW
	O) Attach Scope to Rifle						8/9/91	RW
	P) Detach & Attach Scope 20 Times						8/9/91	RW
640	Gallery Target & Test						8-9-91	AC
	A) Time						8-9-91	AC
	B) Malfunctions						8-9-91	AC
	C) Pierced Primers						8-9-91	AC
	D) Optical Clarity of Scope						8-9-91	AC
645	Inspect for Live Ammo						8-9-91	AC
655	Final Inspection							
	A) Headspace						7-13-91	AC
	B) Trigger Pull	258	231	239	263	260	9/13/91	YH
	C) Function						7-13-91	AC
660	Pack						9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6649301DATE 8-8-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.38	2.35	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.39	2.40	2.51	
PULL #3	2.40	2.31	2.43	2.59	
PULL #4	2.35	2.40	2.40	2.63	
PULL #5	2.27	2.39	2.44	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.34		
PULL #2	3.51	3.46		
PULL #3	3.50	3.50		
PULL #4	3.46	3.46		
PULL #5	3.56	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.33		4.22
PULL #2	4.35	4.36		4.44
PULL #3	4.34	4.45		4.29
PULL #4	4.40	4.41		4.48
PULL #5	4.24	4.34		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649301
9 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.557807
1 TO	2	.065
1 TO	3	.546125
1 TO	4	.62404
1 TO	5	.554294

5
4 + <----POA
43

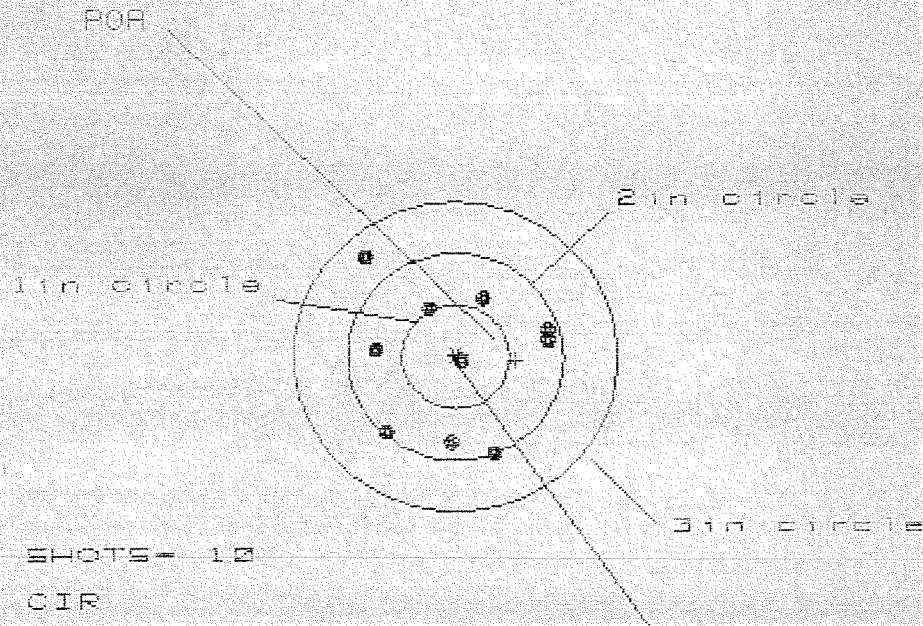
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4862
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1392
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .505734
THE AMR FOR THIS RIFLE IS: .9216

9 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649301

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 1

2in = 9

3in = 10

HS = 1.719

VS = 1.922

GS = 2.279

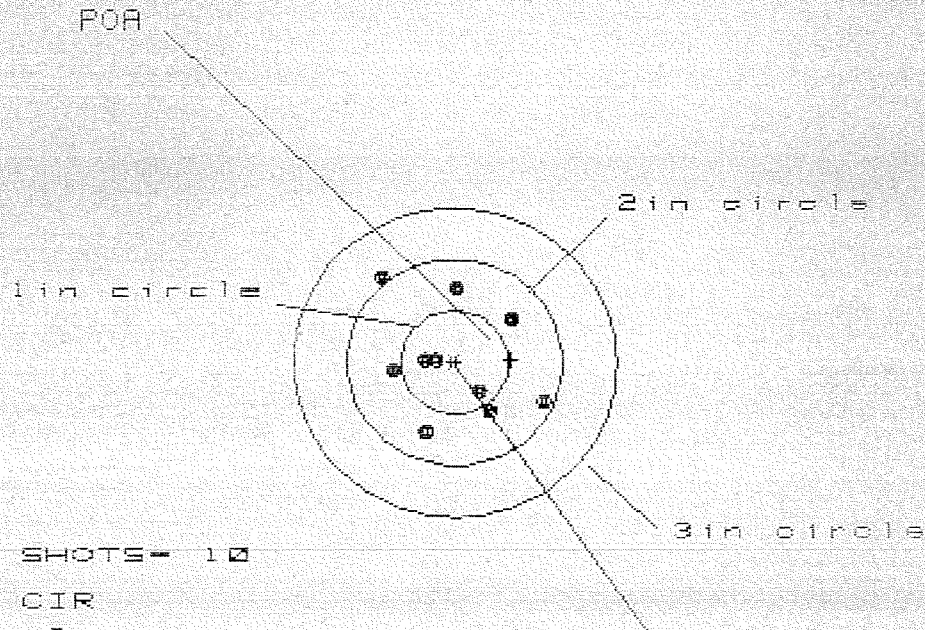
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.895	.804	.842
MINIMUM X	-.824	-.806	-.768
MAXIMUM Y	1.009	.683	.583
MINIMUM Y	-.913	-.801	-.863
CENTROID X	-.557	-.466	-.504
CENTROID Y	.030	-.082	.018
POA TO CENTROID in.	.558	.473	.505
MIN RADIUS	.062	.096	.065
MEAN RADIUS	.794	.738	.706
MAX RADIUS	1.303	.960	1.005
HORIZONTAL SPREAD	1.719	1.610	1.610
VERTICAL SPREAD	1.922	1.484	1.446
EXTREME SPREAD	2.279	1.802	1.882
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.455

VS= 1.499

GS= 1.862

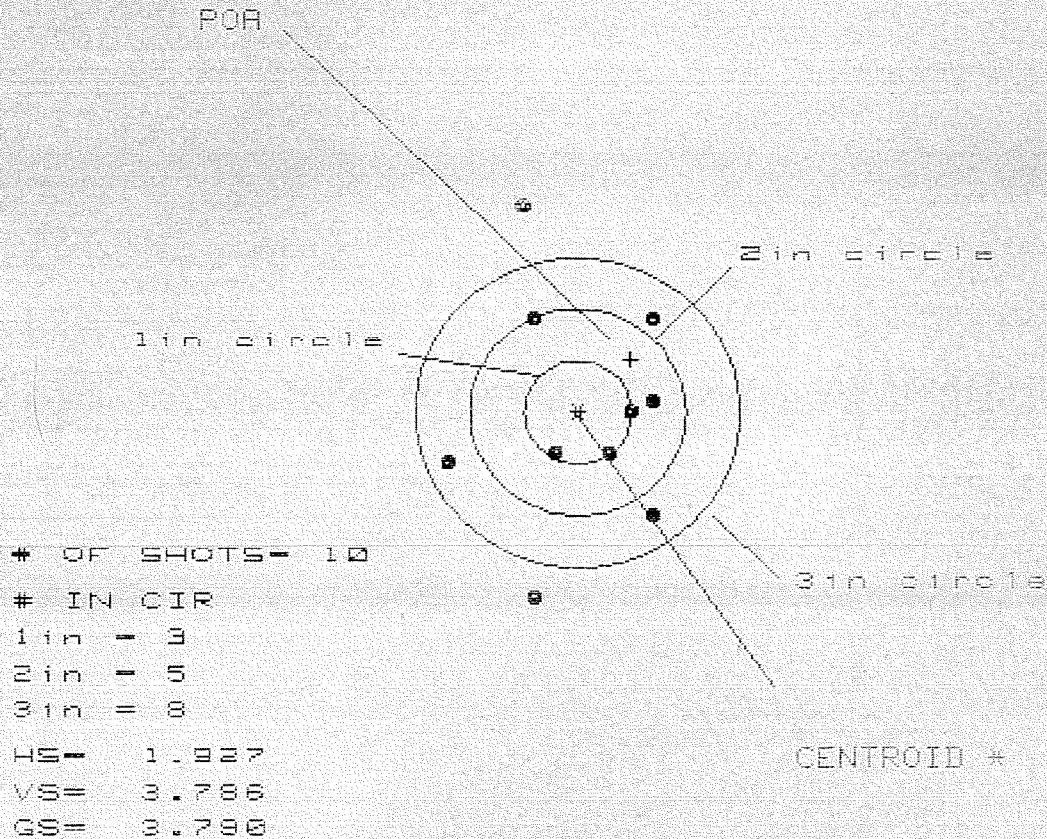
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.799	.726	.567
MINIMUM X	:	-.657	-.667	-.577
MAXIMUM Y	:	.792	.823	.787
MINIMUM Y	:	-.787	-.619	-.654
CENTROID X	:	-.524	-.451	-.542
CENTROID Y	:	-.826	-.114	-.079
POA TO CENTROID in.	:	.524	.465	.547
MIN RADIUS	:	.215	.251	.288
MEAN RADIUS	:	.614	.562	.521
MAX RADIUS	:	1.829	.823	.798
HORIZONTAL SPREAD	:	1.456	1.393	1.143
VERTICAL SPREAD	:	1.499	1.442	1.442
EXTREME SPREAD	:	1.862	1.478	1.478
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

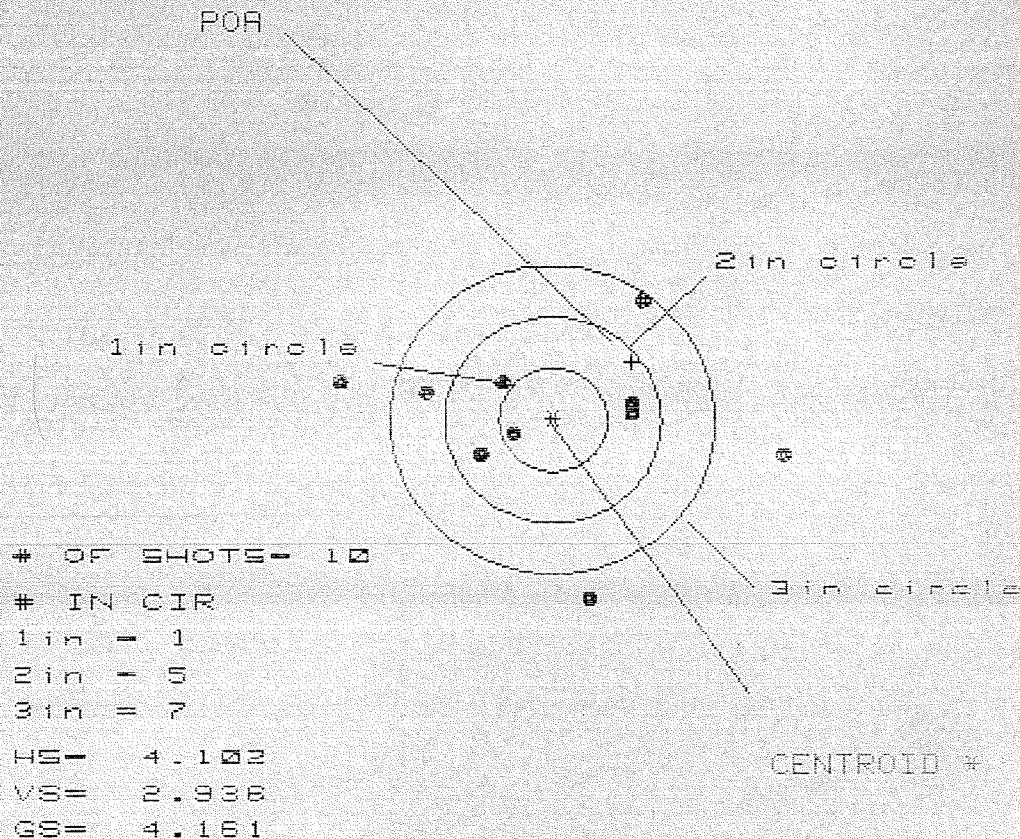


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.702
MINIMUM X	-1.225
MAXIMUM Y	2.035
MINIMUM Y	-1.751
CENTROID X	-.490
CENTROID Y	-.512
POA TO CENTROID in.	.709
MIN RADIUS	.479
MEAN RADIUS	1.076
MAX RADIUS	2.109
HORIZONTAL SPREAD	1.927
VERTICAL SPREAD	3.786
EXTREME SPREAD	3.790
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

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CENTERFIRE PATTERNS # 4

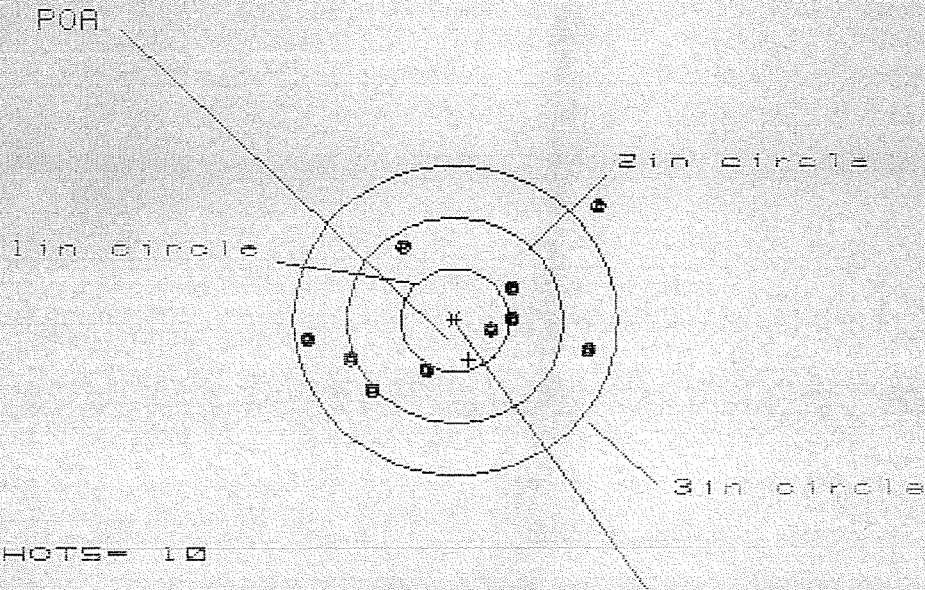


PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	2.109
MINIMUM X	-1.993
MAXIMUM Y	1.168
MINIMUM Y	-1.768
CENTROID X	-0.732
CENTROID Y	-0.569
POA TO CENTROID in.	.927
MIN RADIUS	.369
MEAN RADIUS	1.193
MAX RADIUS	2.132
HORIZONTAL SPREAD	4.102
VERTICAL SPREAD	2.936
EXTREME SPREAD	4.161
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	7

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.721

VS= 1.800

GS= 2.998

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.328
MINIMUM X	-1.393
MAXIMUM Y	1.078
MINIMUM Y	-0.722
CENTROID X	-0.128
CENTROID Y	0.381
POA TO CENTROID in.	0.402
MIN RADIUS	0.295
MEAN RADIUS	0.931
MAX RADIUS	1.711
HORIZONTAL SPREAD	2.721
VERTICAL SPREAD	1.800
EXTREME SPREAD	2.998
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9