

C6611487

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

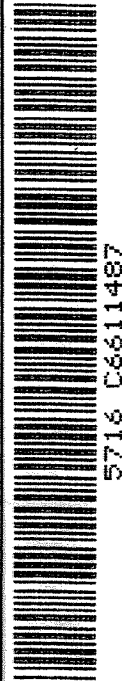
VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

SERIAL NO.
C6611487

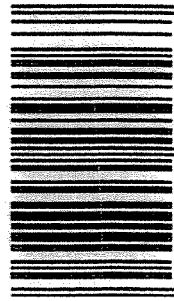
ORDER NO.
5716

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



5716 C6611487

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6611487**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		- 11	KR
615	Rollmark Caliber		3/27/91	JS
617	Drill and Tap Sight Holes	APR	3 1991	WB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/2/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	KS
	C) Inspect Ejector Hole for Chamfer		5/2/91	KS
	D) Oil Firing Pin Ass'y		5/2/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/2/91	JS

op.	BARBER - M24 0077702	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/8/91	OK
	G) Safety Off Force	4	4	4			5/8/91	OK
	H) Trigger Pull Test & Retainability						5/8/91	OK
	I) Firing Pin Indent	.0205	.0205	.0205			5/8/91	OK
	J) Assemble Stock						5/8/91	KS
	K) Assemble Swivel Studs						5-17-91	K
	L) Attach Front and Rear Sight Assemblies						5/8/91	KS
	M) Iron Sight Alignment						5/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/8/91	KS
	O) Attach Scope to Rifle						5/8/91	KS
	P) Detach & Attach Scope 20 Times						5/8/91	KS
640	Gallery Target & Test						5/10/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/10/91	KT
655	Final Inspection							
	A) Headspace						5-17-91	K
	B) Trigger Pull	222	226	226	228	226	5/13/91	OK
	C) Function						5-17-91	K
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO.

C6611487

DATE

5/8/91

TESTER

J. B. T. (H)

V. B. T. (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.48	2.22	MIN. SETTING,
PULL #2	2.36	2.32	2.42	2.26	NO AVG. OF 5
PULL #3	2.31	2.43	2.39	2.26	READINGS ACCEPT-
PULL #4	2.41	2.36	2.42	2.28	ABLE LESS THAN 2#
PULL #5	2.38	2.44	2.42	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.27	3.39			
PULL #2	3.23	3.22			
PULL #3	3.19	3.30			
PULL #4	3.33	3.42			
PULL #5	3.37	3.34			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.40		4.40
PULL #2	4.49	4.46		4.35
PULL #3	4.43	4.42		4.39
PULL #4	4.36	4.30		4.45
PULL #5	4.49	4.43		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611487
10 May 1991

CENTROIDAL DISTANCES

0 TO	1	.434775
1 TO	2	.25948
1 TO	3	.522231
1 TO	4	.413473
1 TO	5	.607007

1215 <----POA

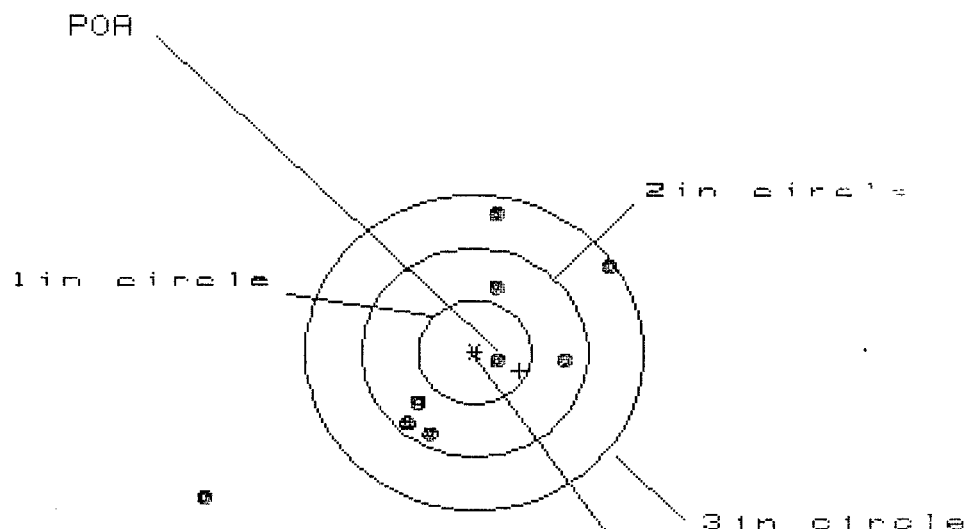
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0°
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE

THE AMR FOR THIS RIFLE IS: 1.14

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611487

CENTERFIRE PATTERNS



OF SHOTS - 10

IN CIR

1in - 1

2in - 5

3in - 9

HS - 3.584

VS - 2.649

GS - 4.197

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.227	.965	1.015
MINIMUM X	:	-2.357	-.849	-.727
MAXIMUM Y	:	1.275	1.122	1.105
MINIMUM Y	:	-1.374	-.885	-.712
CENTROID X	:	-.398	-.136	-.151
CENTROID Y	:	.175	.328	.345
POA TO CENTROID in.	:	.435	.355	.375
MIN RADIUS	:	.208	.287	.307
MEAN RADIUS	:	1.105	.901	.871
MAX RADIUS	:	2.728	1.212	1.256
HORIZONTAL SPREAD	:	3.584	1.814	1.814
VERTICAL SPREAD	:	2.649	2.007	2.007
EXTREME SPREAD	:	4.197	2.369	2.248
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

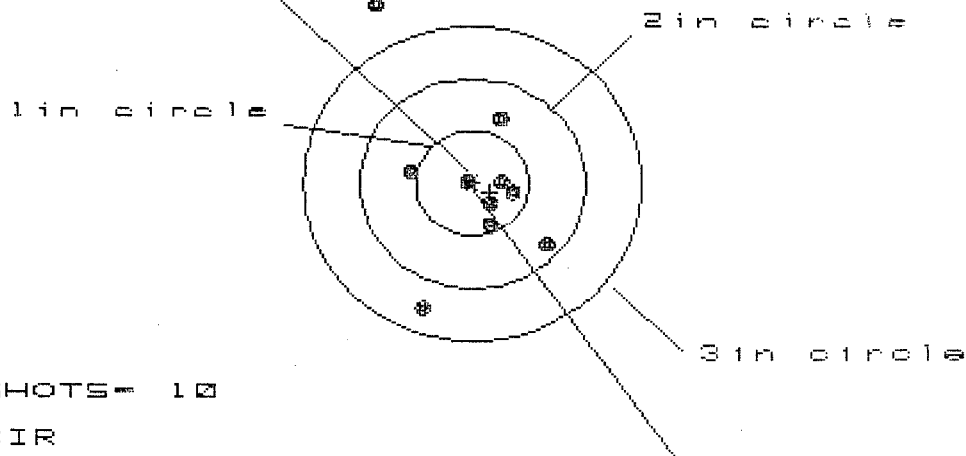
18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66114B7

CENTERFIRE PATTERNS

12

POA



OF SHOTS = 10

IN CIR

1in = 5

2in = 8

3in = 9

HS = 1.512

VS = 2.966

GS = 2.983

CENTROID #

PATTERN #	:	12		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.704	.614	.541
MINIMUM X	:	-.808	-.611	-.684
MAXIMUM Y	:	1.742	.780	.651
MINIMUM Y	:	-1.224	-1.030	-.496
CENTROID X	:	-.155	-.065	.008
CENTROID Y	:	.084	-.110	.013
POA TO CENTROID in.	:	.176	.128	.020
MIN RADIUS	:	.044	.046	.125
MEAN RADIUS	:	.661	.492	.385
MAX RADIUS	:	1.921	1.183	.734
HORIZONTAL SPREAD	:	1.512	1.225	1.225
VERTICAL SPREAD	:	2.966	1.810	1.147
EXTREME SPREAD	:	2.983	1.964	1.382
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 3.317

VS= 2.827

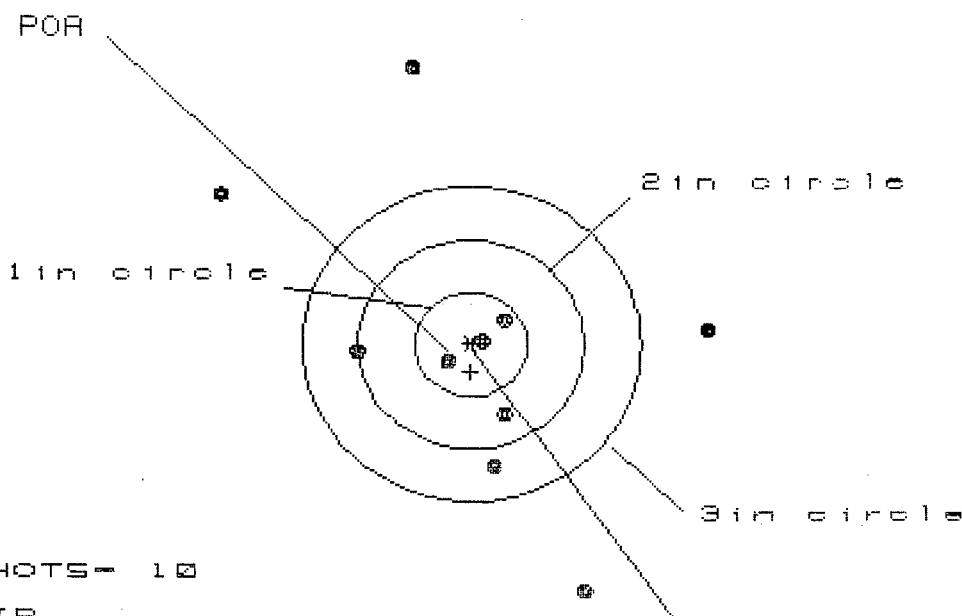
GS= 3.349

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.343	1.123	1.132
MINIMUM X	:	-1.974	-1.379	-1.370
MAXIMUM Y	:	1.262	1.311	1.121
MINIMUM Y	:	-1.565	-1.516	-1.545
CENTROID X	:	.052	.272	.263
CENTROID Y	:	-.090	-.139	.051
POA TO CENTROID in.	:	.104	.305	.268
MIN RADIUS	:	.455	.374	.233
MEAN RADIUS	:	1.137	1.027	.939
MAX RADIUS	:	2.023	1.518	1.444
HORIZONTAL SPREAD	:	3.317	2.502	2.502
VERTICAL SPREAD	:	2.827	2.827	1.666
EXTREME SPREAD	:	3.349	2.841	2.519
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

1in - 3

2in - 4

3in = 6

HS= 4.219

VS= 4.982

GS= 5.209

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.055	1.996	1.718
MINIMUM X	:	-2.164	-2.223	-1.351
MAXIMUM Y	:	2.631	1.746	.728
MINIMUM Y	:	-2.351	-2.059	-1.841
CENTROID X	:	.006	.065	.343
CENTROID Y	:	.263	-.029	-.247
POA TO CENTROID in.	:	.263	.071	.423
MIN RADIUS	:	.054	.301	.173
MEAN RADIUS	:	1.363	1.202	1.011
MAX RADIUS	:	2.685	2.827	1.952
HORIZONTAL SPREAD	:	4.219	4.219	3.069
VERTICAL SPREAD	:	4.982	3.805	2.569
EXTREME SPREAD	:	5.209	4.939	3.079
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 3.597

VS = 3.998

GS = 4.530

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.417	1.541	1.288
MINIMUM X	:	-2.180	-2.022	-1.310
MAXIMUM Y	:	2.646	1.390	1.140
MINIMUM Y	:	-1.352	-1.058	-.884
CENTROID X	:	.209	.051	.304
CENTROID Y	:	.172	-.122	-.295
POA TO CENTROID in.	:	.270	.132	.424
MIN RADIUS	:	.495	.401	.273
MEAN RADIUS	:	1.433	1.225	1.079
MAX RADIUS	:	3.002	2.454	1.514
HORIZONTAL SPREAD	:	3.597	3.563	2.598
VERTICAL SPREAD	:	3.998	2.448	2.024
EXTREME SPREAD	:	4.530	4.234	2.992
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		