

C6611543

MODEL 700™ M24

Model **SMS**™

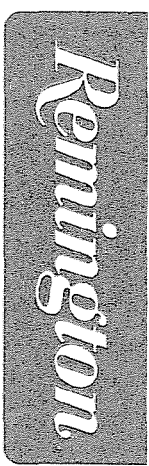
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

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

SERIAL NO.
 C6611543

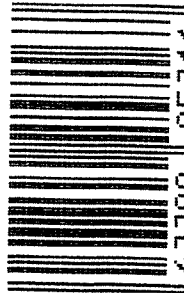
ORDER NO.
 5716

20



5716 C6611543

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611543

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS.
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/19/91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/25/91	JK
	G) Safety Off Force	2	2	2			4/25/91	JK
	H) Trigger Pull Test & Retainability						4/25/91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			4/25/91	JK
	J) Assemble Stock						4/26/91	KX
	K) Assemble Swivel Studs						5-16-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/26/91	KX
	M) Iron Sight Alignment						4/26/91	KX
	N) Detach Front & Rear Sights & place in numbered container						4/26/91	KX
	O) Attach Scope to Rifle						4/26/91	KX
	P) Detach & Attach Scope 20 Times						4/26/91	KX
640	Gallery Target & Test						4-29-91	D/H
	A) Time						4-29-91	D/H
	B) Malfunctions						4-29-91	D/H
	C) Pierced Primers						4-29-91	D/H
	D) Optical Clarity of Scope						4-29-91	D/H
645	Inspect for Live Ammo						4-29-91	D/H
655	Final Inspection							
	A) Headspace						5-16-91	D/H
	B) Trigger Pull	2.19	2.22	2.26	2.26	2.31	5/10/91	JK
	C) Function						5-16-91	D/H
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611543 250DATE 4/25/91 JH00TESTER [Signature] (7)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.33	2.46	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.33	2.40	2.22	
PULL #3	2.23	2.32	2.38	2.26	
PULL #4	2.35	2.41	2.43	2.26	
PULL #5	2.37	2.44	2.44	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.21		
PULL #2	3.15	3.35		
PULL #3	3.18	3.24		
PULL #4	3.24	3.33		
PULL #5	3.20	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.37		4.53
PULL #2	4.38	4.49		4.58
PULL #3	4.20	4.50		4.54
PULL #4	4.43	4.46		4.56
PULL #5	4.46	4.27		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611543
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.195133
1 TO	2	.432558
1 TO	3	.127035
1 TO	4	.337617
1 TO	5	.234361

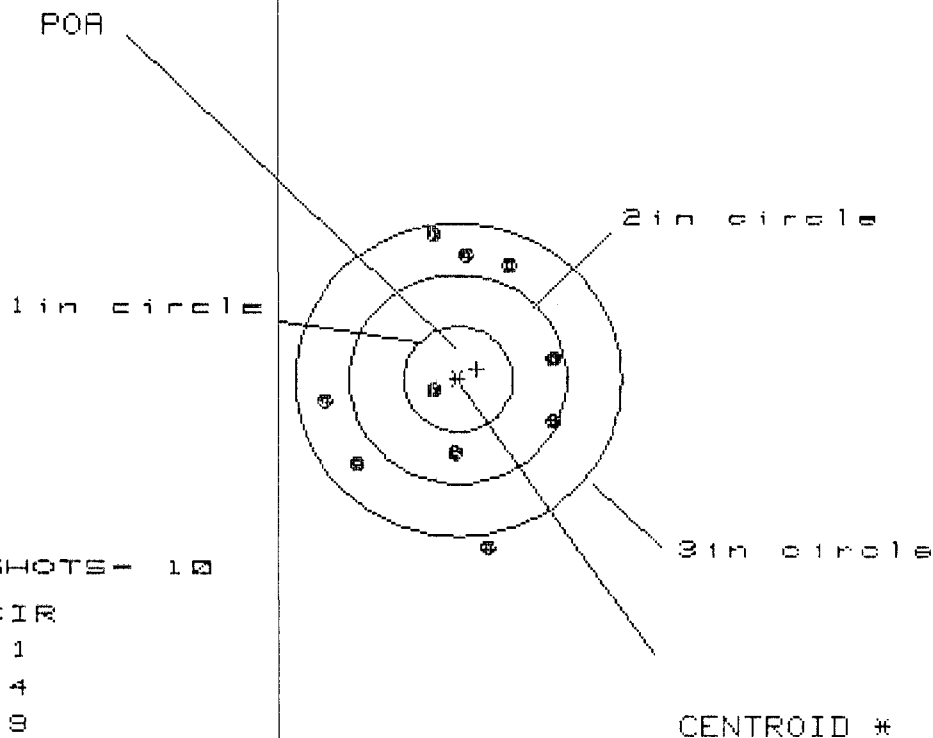
$\frac{2}{54}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0177279
THE AMR FOR THIS RIFLE IS: .8858

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611543

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.175

VS = 2.982

GS = 3.022

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.919	.947	.920
MINIMUM X	-1.256	-1.228	-1.255
MAXIMUM Y	1.396	1.220	1.145
MINIMUM Y	-1.586	-1.019	-.866
CENTROID X	-.171	-.199	-.172
CENTROID Y	-.094	.082	-.071
POA TO CENTROID in.	.196	.215	.186
MIN RADIUS	.208	.314	.219
MEAN RADIUS	1.060	1.003	.950
MAX RADIUS	1.605	1.335	1.272
HORIZONTAL SPREAD	2.175	2.175	2.175
VERTICAL SPREAD	2.982	2.239	2.011
EXTREME SPREAD	3.022	2.331	2.328
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.316

VS= 1.434

GS= 2.535

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.220	1.353	1.233
MINIMUM X	-1.096	-.963	-.977
MAXIMUM Y	.789	.836	.761
MINIMUM Y	-.645	-.598	-.445
CENTROID X	.014	-.119	.001
CENTROID Y	.297	.250	.325
POA TO CENTROID in.	.297	.277	.325
MIN RADIUS	.319	.198	.330
MEAN RADIUS	.964	.883	.886
MAX RADIUS	1.275	1.365	1.259
HORIZONTAL SPREAD	2.316	2.316	2.210
VERTICAL SPREAD	1.434	1.434	1.206
EXTREME SPREAD	2.535	2.461	2.256
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 10		

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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 = 4

2 in = 8

3 in = 10

HS = 2.333

VS = 1.043

GS = 2.334

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.374	.984	.883
MINIMUM X	-.959	-.806	-.739
MAXIMUM Y	.626	.660	.710
MINIMUM Y	-.417	-.383	-.333
CENTROID X	-.044	-.197	-.096
CENTROID Y	-.097	-.131	-.181
POA TO CENTROID in.	.107	.237	.205
MIN RADIUS	.205	.050	.146
MEAN RADIUS	.669	.547	.508
MAX RADIUS	1.407	.998	.909
HORIZONTAL SPREAD	2.333	1.790	1.622
VERTICAL SPREAD	1.043	1.043	1.043
EXTREME SPREAD	2.334	1.805	1.699
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.819

VS= 1.809

GS= 2.353

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.929	.735	.672
MINIMUM X	-.890	-.787	-.850
MAXIMUM Y	.994	.904	1.013
MINIMUM Y	-.815	-.905	-.796
CENTROID X	.141	.038	.101
CENTROID Y	-.223	-.133	-.242
POA TO CENTROID in.	.264	.138	.263
MIN RADIUS	.175	.241	.183
MEAN RADIUS	.791	.742	.688
MAX RADIUS	1.234	1.013	1.015
HORIZONTAL SPREAD	1.819	1.522	1.522
VERTICAL SPREAD	1.809	1.809	1.809
EXTREME SPREAD	2.353	1.864	1.811
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.313

VS = 2.826

GS = 2.883

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.330	1.288	1.322
MINIMUM X	-.983	-1.025	-.864
MAXIMUM Y	1.554	.568	.637
MINIMUM Y	-1.272	-1.099	-1.030
CENTROID X	.024	.066	-.095
CENTROID Y	.036	-.137	-.206
POA TO CENTROID in.	.043	.152	.227
MIN RADIUS	.308	.347	.191
MEAN RADIUS	.945	.869	.760
MAX RADIUS	1.598	1.401	1.328
HORIZONTAL SPREAD	2.313	2.313	2.186
VERTICAL SPREAD	2.826	1.667	1.667
EXTREME SPREAD	2.883	2.326	2.241
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		