

C6611588

MODEL 700™ M24

Model **SMS**™

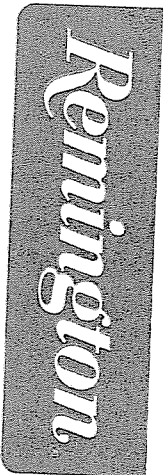
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

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

MODEL 700™ H24

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

SERIAL NO.
C6611588

ORDER NO.
5716

20

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611588

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/24/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	"
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	W.B.
620	Apply Coatings (Barrel Action)		4-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 3/4	4 3/4			4/12/91	WLB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			4/12/91	WLB
	H) Trigger Pull Test & Retainability						4/12/91	OK
	I) Firing Pin Indent	.0205	.021	.021			4/12/91	WLB
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/24/91	KS
	O) Attach Scope to Rifle						4/24/91	KS
	P) Detach & Attach Scope 20 Times						4/24/91	KS
640	Gallery Target & Test						4-25-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-25-91	NF
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.24	2.20	2.26	2.33	2.37	5-20-91	OK
	C) Function						5-21-91	D/H
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611588

DATE 4/12/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.31	2.38	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.38	2.36	2.20	
PULL #3	2.43	2.35	2.32	2.26	
PULL #4	2.41	2.37	2.35	2.33	
PULL #5	2.43	2.36	2.35	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.42		
PULL #2	3.38	3.45		
PULL #3	3.51	3.44		
PULL #4	3.42	3.33		
PULL #5	3.39	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.18		4.17
PULL #2	4.39	4.22		4.36
PULL #3	4.37	4.23		4.43
PULL #4	4.16	4.25		4.42
PULL #5	4.21	4.16		4.51
TOTAL				
AVG.				

MOD.		GA. CAL.	GUN #
			1588
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
KT	4/26	Ejector Sticks (Replace Bolt) (#2)	KS
	2nd		
		100 Rd OK AC	
	3rd		
		5-2-91	
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6611588
24 May 1991

CENTROIDAL DISTANCES

0 TO 1	.174003
1 TO 2	.27751
1 TO 3	.0952103
1 TO 4	.392604
1 TO 5	.138708

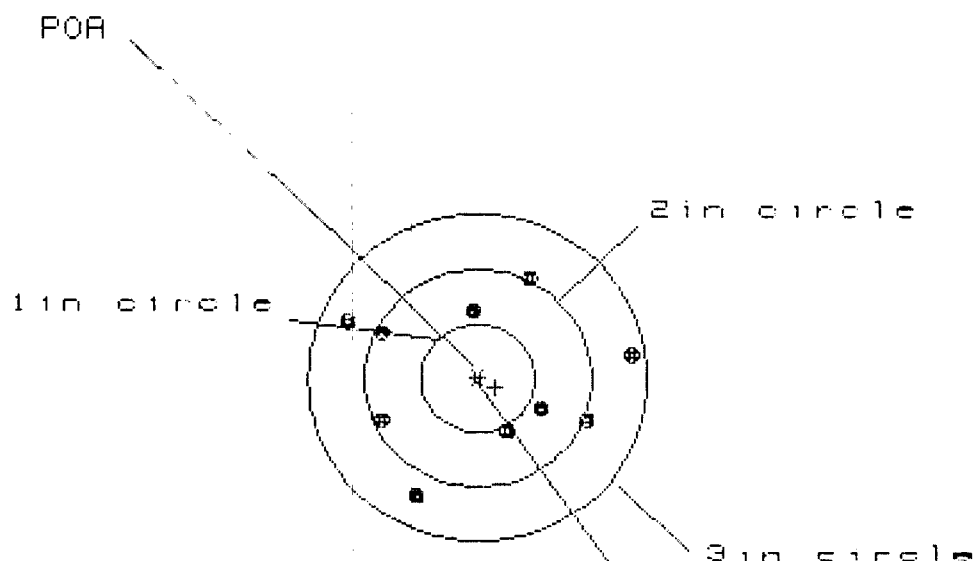
$\bar{y}_R$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0454
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0146
THE RESULTING AVERAGE POB RADIUS FOR THIS RIFLE IS: .0476879
THE AMR FOR THIS RIFLE IS: 1.009

24 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6611588 1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 10

HS- 2.477

VS= 1.973

GS= 2.493

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.360	1.087	1.031
MINIMUM X	:	-1.117	-.965	-1.021
MAXIMUM Y	:	.882	.911	.778
MINIMUM Y	:	-1.091	-1.062	-.603
CENTROID X	:	-.154	-.306	-.250
CENTROID Y	:	.081	.052	.185
POA TO CENTROID in.	:	.174	.310	.311
MIN RADIUS	:	.553	.607	.469
MEAN RADIUS	:	.952	.900	.857
MAX RADIUS	:	1.385	1.150	1.134
HORIZONTAL SPREAD	:	2.477	2.052	2.052
VERTICAL SPREAD	:	1.973	1.973	1.381
EXTREME SPREAD	:	2.493	2.245	2.245
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B115B3.1

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.226

VS= 2.023

GS= 2.641

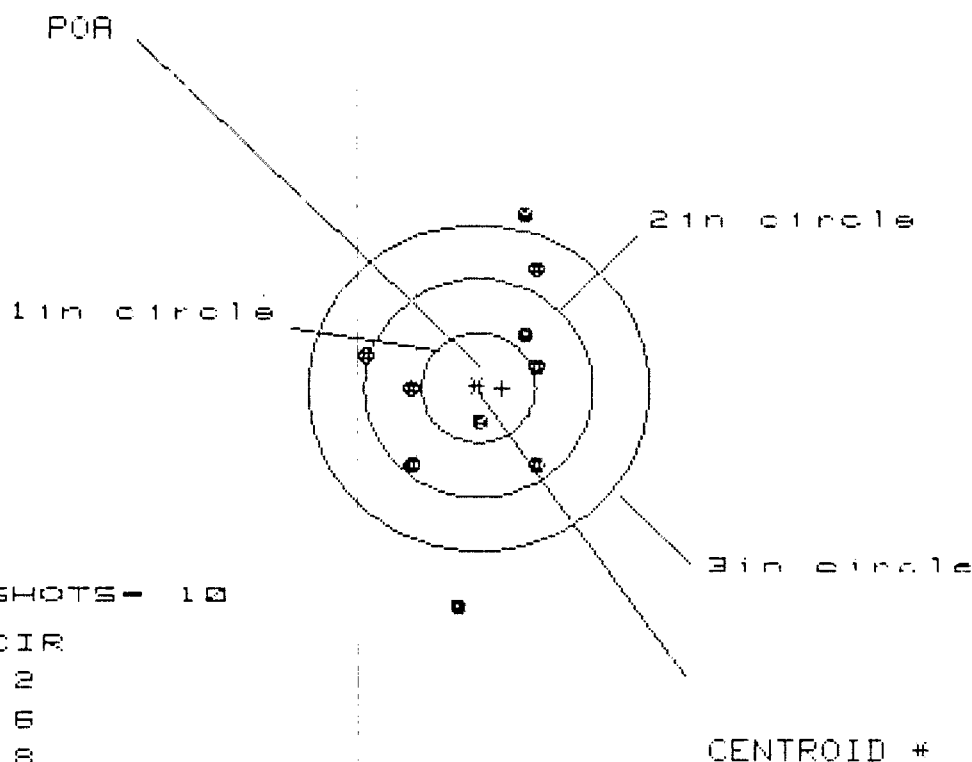
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.104	1.193	1.139
MINIMUM X	:	-1.122	-1.033	-.883
MAXIMUM Y	:	1.287	1.080	1.018
MINIMUM Y	:	-.736	-.593	-.655
CENTROID X	:	.082	-.007	-.157
CENTROID Y	:	-.065	-.208	-.146
POA TO CENTROID in.	:	.105	.208	.214
MIN RADIUS	:	.331	.286	.199
MEAN RADIUS	:	.965	.884	.813
MAX RADIUS	:	1.518	1.294	1.260
HORIZONTAL SPREAD	:	2.226	2.226	2.022
VERTICAL SPREAD	:	2.023	1.673	1.673
EXTREME SPREAD	:	2.641	2.515	2.325
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

24 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.493

VS= 3.620

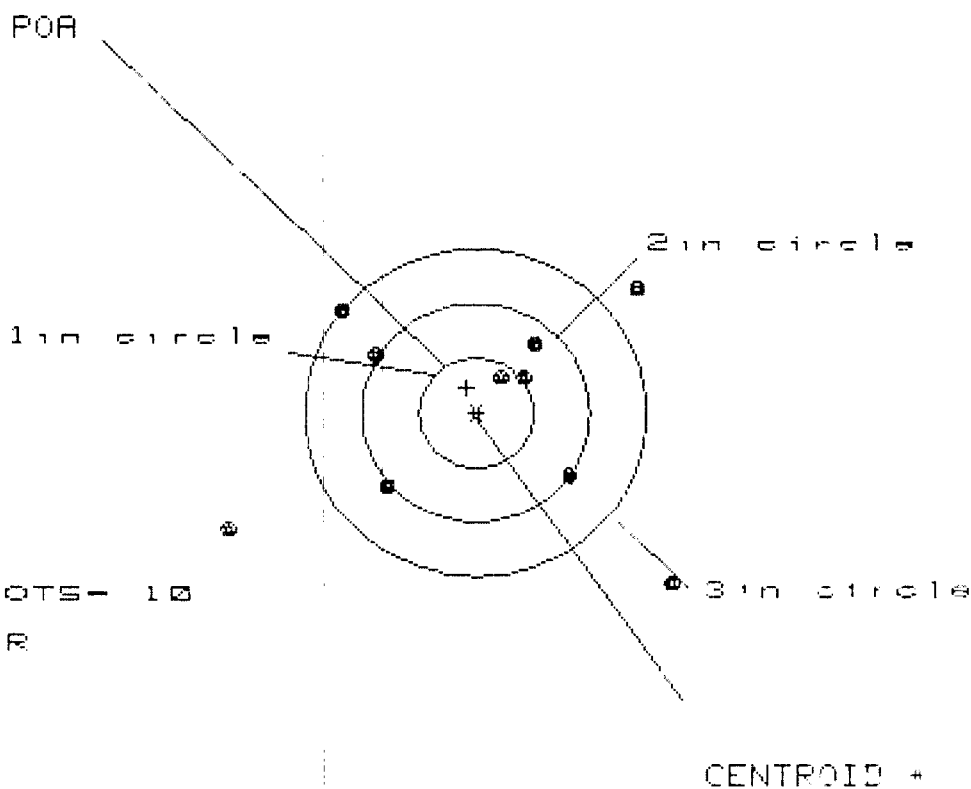
GS= 3.662

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.507	.489	.537
MINIMUM X	:	-.986	-1.004	-.956
MAXIMUM Y	:	1.621	1.399	1.028
MINIMUM Y	:	-1.999	-.956	-.781
CENTROID X	:	-.210	-.192	-.240
CENTROID Y	:	.004	.226	.052
POA TO CENTROID in.	:	.210	.297	.245
MIN RADIUS	:	.274	.456	.326
MEAN RADIUS	:	.973	.857	.760
MAX RADIUS	:	2.006	1.449	1.140
HORIZONTAL SPREAD	:	1.493	1.493	1.493
VERTICAL SPREAD	:	3.620	2.355	1.810
EXTREME SPREAD	:	3.662	2.517	2.060
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 3.977

VS= 2.642

GS= 4.252

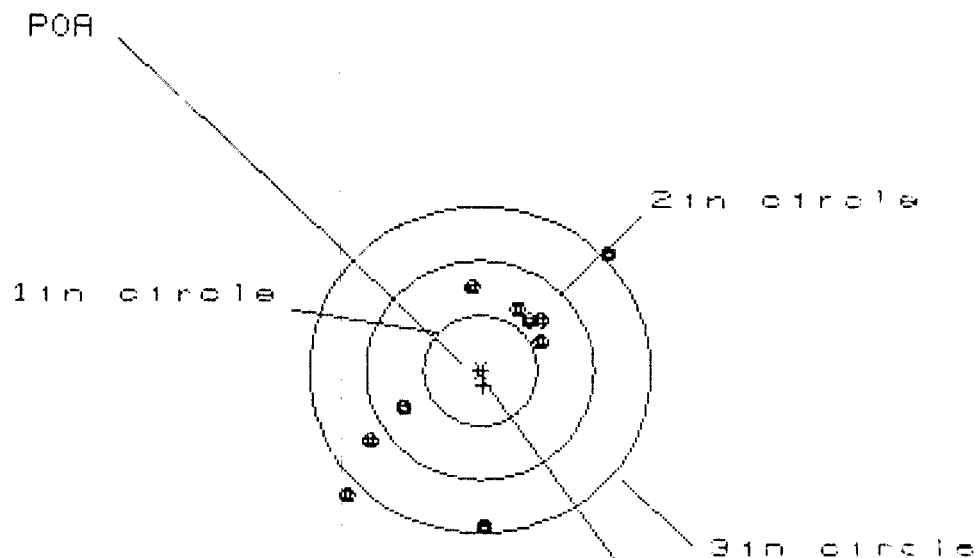
CENTROID +

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.755	1.508	1.374
MINIMUM X	:	-2.222	-1.435	-1.247
MAXIMUM Y	:	1.112	.994	.788
MINIMUM Y	:	-1.530	-1.648	-1.034
CENTROID X	:	.083	.330	.142
CENTROID Y	:	-.232	-.114	.092
POR TO CENTROID in.	:	.246	.349	.169
MIN RADIUS	:	.378	.220	.119
MEAN RADIUS	:	1.296	1.106	.938
MAX RADIUS	:	2.463	2.234	1.584
HORIZONTAL SPREAD	:	3.977	2.943	2.621
VERTICAL SPREAD	:	2.642	2.642	1.822
EXTREME SPREAD	:	4.252	3.862	2.836
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

24 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.372

VS= 2.590

GS= 3.253

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.153	1.017	.512
MINIMUM X	:	-1.219	-1.120	-.993
MAXIMUM Y	:	1.109	.985	.758
MINIMUM Y	:	-1.481	-1.605	-1.482
CENTROID X	:	-.028	.108	-.019
CENTROID Y	:	.139	.263	.139
POA TO CENTROID in.	:	.141	.284	.141
MIN RADIUS	:	.577	.405	.569
MEAN RADIUS	:	1.007	.879	.850
MAX RADIUS	:	1.653	1.610	1.482
HORIZONTAL SPREAD	:	2.372	2.137	1.505
VERTICAL SPREAD	:	2.590	2.590	2.239
EXTREME SPREAD	:	3.253	2.831	2.240
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611588
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.377107
1 TO	2	.410488
1 TO	3	.474435
1 TO	4	.535318
1 TO	5	.529854

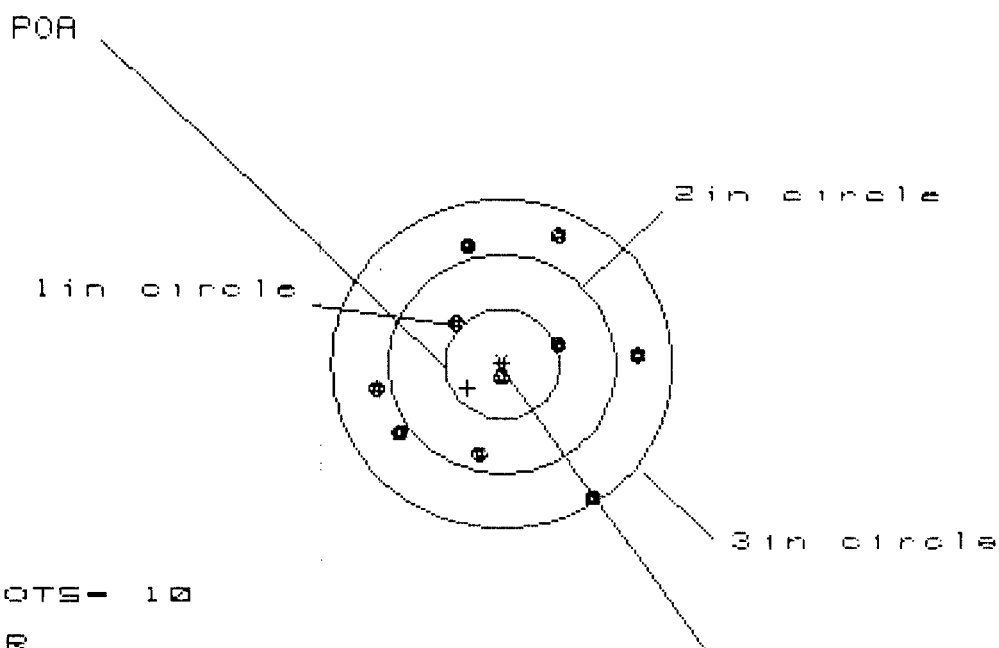
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0294
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0302638
THE AMR FOR THIS RIFLE IS: .9114

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611588

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.336

VS= 2.396

GS= 2.473

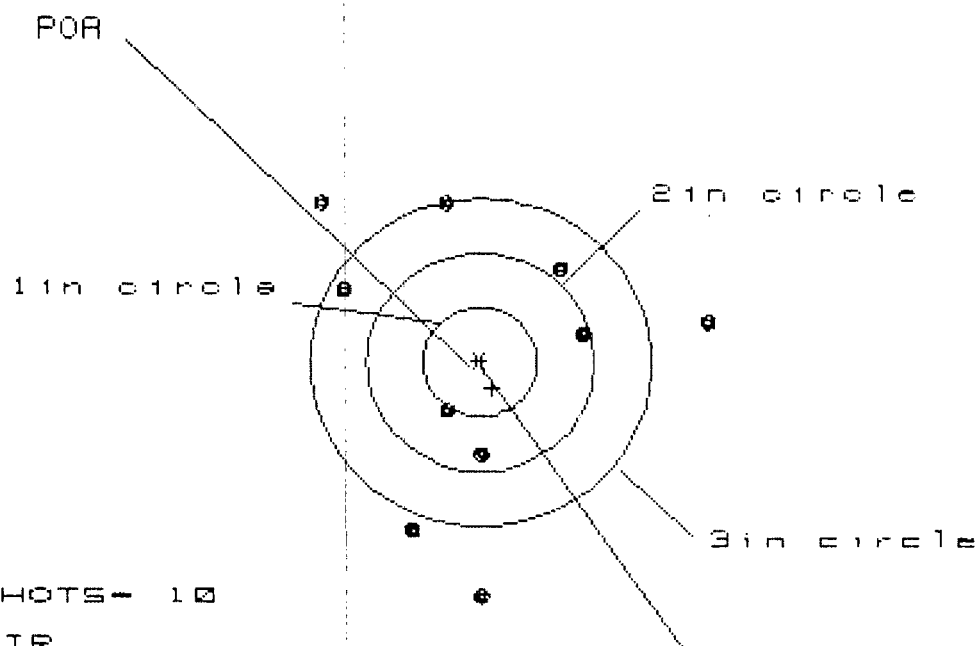
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.200	1.289	1.362
MINIMUM X	:	-1.136	-1.047	-.974
MAXIMUM Y	:	1.224	1.093	1.059
MINIMUM Y	:	-1.172	-.951	-.814
CENTROID X	:	.307	.218	.145
CENTROID Y	:	.219	.350	.213
POA TO CENTROID in.	:	.378	.412	.258
MIN RADIUS	:	.090	.226	.158
MEAN RADIUS	:	.926	.867	.805
MAX RADIUS	:	1.421	1.290	1.364
HORIZONTAL SPREAD	:	2.336	2.336	2.336
VERTICAL SPREAD	:	2.396	2.044	1.873
EXTREME SPREAD	:	2.473	2.351	2.351
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

15 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS = 3.420

VS = 3.623

GS = 3.841

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.050	2.045	1.203
MINIMUM X	:	-1.370	-1.375	-1.119
MAXIMUM Y	:	1.440	1.197	1.210
MINIMUM Y	:	-2.183	-1.759	-1.746
CENTROID X	:	-1.103	-1.098	-1.354
CENTROID Y	:	.239	.482	.469
POA TO CENTROID in.	:	.260	.492	.588
MIN RADIUS	:	.574	.788	.707
MEAN RADIUS	:	1.422	1.331	1.231
MAX RADIUS	:	2.184	2.048	1.771
HORIZONTAL SPREAD	:	3.420	3.420	2.322
VERTICAL SPREAD	:	3.623	2.956	2.956
EXTREME SPREAD	:	3.841	3.586	3.050
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611588

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in - 4

2 in - 5

3 in - 9

HS= 2.678

VS= 1.930

GS= 2.683

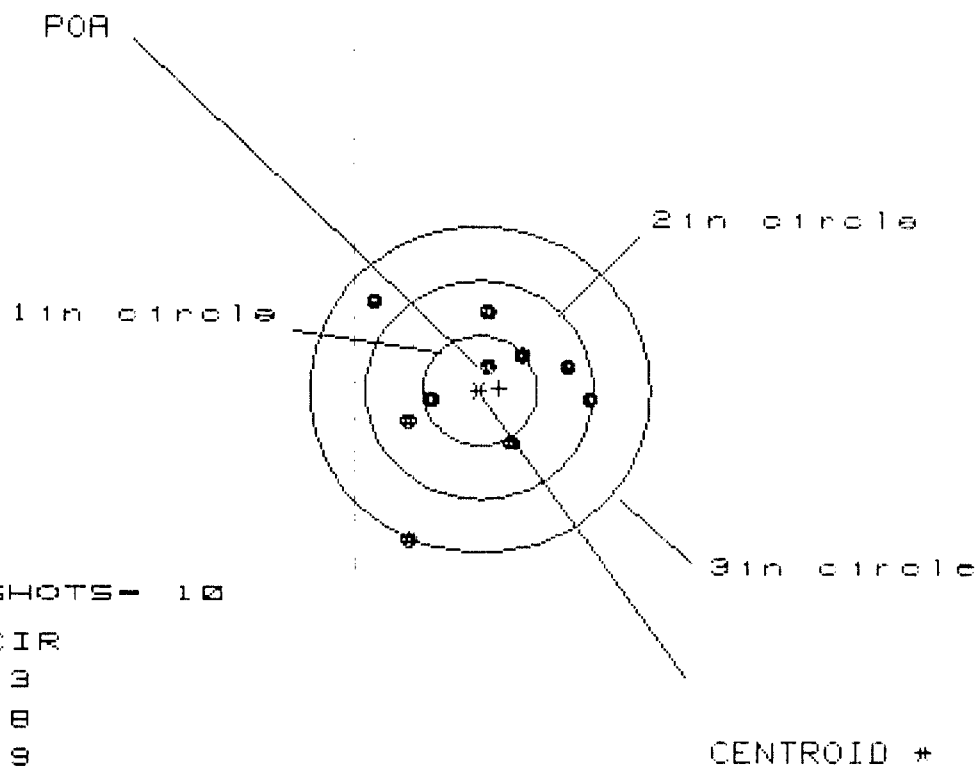
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.022	.838	.670
MINIMUM X	:	-1.656	-1.341	-.667
MAXIMUM Y	:	.894	.877	.664
MINIMUM Y	:	-1.036	-1.053	-.943
CENTROID X	:	.027	.211	.379
CENTROID Y	:	-.164	-.147	-.257
POA TO CENTROID in.	:	.166	.257	.458
MIN RADIUS	:	.208	.116	.285
MEAN RADIUS	:	.824	.712	.612
MAX RADIUS	:	1.663	1.603	.971
HORIZONTAL SPREAD	:	2.678	2.179	1.337
VERTICAL SPREAD	:	1.930	1.930	1.607
EXTREME SPREAD	:	2.683	2.599	1.666
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611588

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in - 9

HS- 1.879

VS- 2.232

GS- 2.249

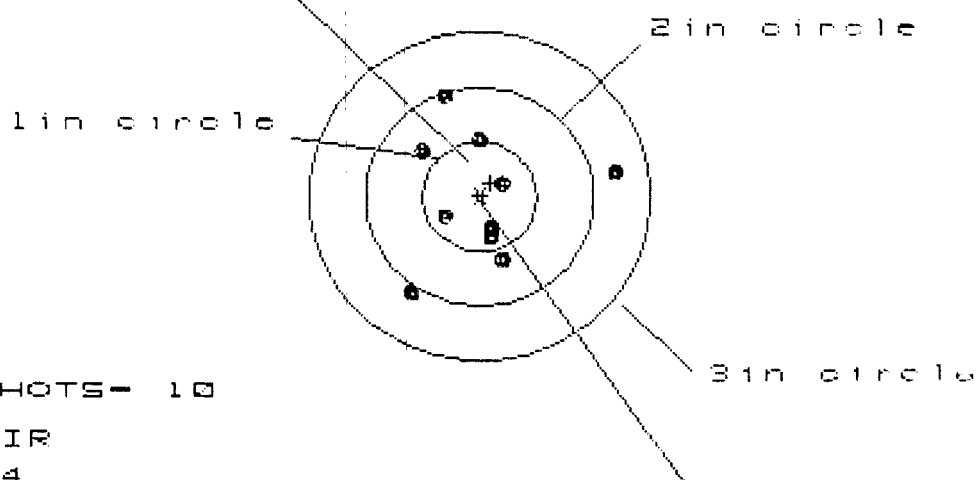
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	.914	.793
MINIMUM X	:	-.896	-.965	-.809
MAXIMUM Y	:	.838	.684	.603
MINIMUM Y	:	-1.393	-.619	-.534
CENTROID X	:	-.171	-.102	.019
CENTROID Y	:	-.022	.132	.047
POA TO CENTROID in.	:	.173	.167	.050
MIN RADIUS	:	.212	.066	.211
MEAN RADIUS	:	.757	.639	.574
MAX RADIUS	:	1.527	1.183	.898
HORIZONTAL SPREAD	:	1.879	1.879	1.602
VERTICAL SPREAD	:	2.232	1.303	1.137
EXTREME SPREAD	:	2.249	2.071	1.628
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611588

CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.785

VS= 1.784

GS= 2.063

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.187	.371	.313
MINIMUM X	-.598	-.466	-.421
MAXIMUM Y	.928	.948	.844
MINIMUM Y	-.856	-.836	-.690
CENTROID X	-.096	-.228	-.170
CENTROID Y	-.125	-.145	-.041
POR TO CENTROID in.	.158	.270	.175
MIN RADIUS	.245	.175	.289
MEAN RADIUS	.628	.560	.511
MAX RADIUS	1.201	.966	.877
HORIZONTAL SPREAD	1.785	.837	.734
VERTICAL SPREAD	1.784	1.784	1.534
EXTREME SPREAD	2.063	1.806	1.609
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		