

C6611615

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

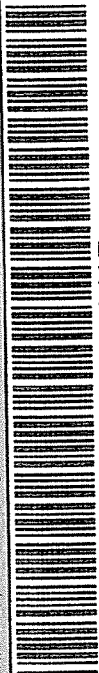
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

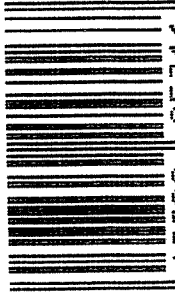
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6611615	ORDER NO. 5716
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5716 C6611615

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611615**

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		3/25/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	SS
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	SS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/2/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/2/91	K.S.
	D) Oil Firing Pin Ass'y		5/2/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	SS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/7/91	JH
	G) Safety Off Force	4	4	4			5/7/91	JH
	H) Trigger Pull Test & Retainability						5/7/91	JH
	I) Firing Pin Indent	.0215	.022	.022			5/7/91	JH
	J) Assemble Stock						5/10/91	KS
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/10/91	KS
	M) Iron Sight Alignment						5/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/10/91	KS
	O) Attach Scope to Rifle						5/10/91	KS
	P) Detach & Attach Scope 20 Times						5/10/91	KS
640	Gallery Target & Test						5/14/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/14/91	KT
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.69	2.43	2.42	2.42	2.42	5/20/91	JH
	C) Function						5-21-91	D/H
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6611615DATE 5/7/91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.47	2.38	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.55	2.49	2.43	
PULL #3	2.54	2.48	2.53	2.42	
PULL #4	2.34	2.61	2.58	2.42	
PULL #5	2.54	2.51	2.56	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.49		
PULL #2	3.25	3.38		
PULL #3	3.53	3.41		
PULL #4	3.36	3.46		
PULL #5	3.35	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	4.15	4.26		4.33
PULL #2	4.41	4.30		4.30
PULL #3	4.26	4.32		4.30
PULL #4	4.32	4.25		4.25
PULL #5	4.28	4.33		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611615
14 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.119436
1 TO	2	.10911
1 TO	3	.105119
1 TO	4	.176182
1 TO	5	.196023

←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .035
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0438402

THE AMR FOR THIS RIFLE IS: .9392

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11615

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 1.814

VS= 2.699

GS= 3.093

PATTERN #

:

11

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.713

.591

.627

MINIMUM X

:

-1.101

-.733

-.697

MAXIMUM Y

:

1.276

1.360

1.199

MINIMUM Y

:

-1.423

-1.281

-1.032

CENTROID X

:

.117

.239

.203

CENTROID Y

:

.024

-.118

.043

POA TO CENTROID in.

:

.119

.266

.207

MIN RADIUS

:

.111

.090

.052

MEAN RADIUS

:

.809

.726

.613

MAX RADIUS

:

1.685

1.482

1.353

HORIZONTAL SPREAD

:

1.814

1.324

1.324

VERTICAL SPREAD

:

2.699

2.641

2.231

EXTREME SPREAD

:

3.093

2.658

2.234

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611615

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.901

VS= 3.118

GS= 3.396

CENTROID #

PATTERN

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.553	1.458	1.278
MINIMUM X	-1.348	-1.443	-1.115
MAXIMUM Y	1.243	1.035	1.117
MINIMUM Y	-1.875	-.960	-.877
CENTROID X	.013	.108	.288
CENTROID Y	.057	.265	.183
POA TO CENTROID in.	.058	.286	.341
MIN RADIUS	.248	.128	.073
MEAN RADIUS	1.017	.856	.757
MAX RADIUS	2.060	1.588	1.418
HORIZONTAL SPREAD	2.901	2.901	2.392
VERTICAL SPREAD	3.118	1.995	1.995
EXTREME SPREAD	3.396	2.977	2.575
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611615

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.628

VS= 1.944

GS= 3.675

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.449	1.207	1.284
MINIMUM X	-2.179	-1.122	-1.046
MAXIMUM Y	1.263	1.237	.794
MINIMUM Y	-.681	-.707	-.553
CENTROID X	.112	.354	.277
CENTROID Y	-.081	-.055	-.209
POA TO CENTROID in.	.138	.358	.348
MIN RADIUS	.287	.094	.264
MEAN RADIUS	1.000	.823	.757
MAX RADIUS	2.192	1.379	1.367
HORIZONTAL SPREAD	3.628	2.329	2.329
VERTICAL SPREAD	1.944	1.944	1.347
EXTREME SPREAD	3.675	2.536	2.509
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611615

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.238

VS= 2.009

GS= 2.074

CENTROID *

PATTERN #

PR

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.669

.717

.746

MINIMUM X

-.569

-.521

-.492

MAXIMUM Y

.991

.958

.844

MINIMUM Y

-1.018

-.908

-.861

CENTROID X

.005

-.043

-.072

CENTROID Y

.160

.050

.164

POA TO CENTROID in.

.160

.066

.179

MIN RADIUS

.340

.269

.378

MEAN RADIUS

.782

.735

.710

MAX RADIUS

1.080

.959

.965

HORIZONTAL SPREAD

1.238

1.238

1.238

VERTICAL SPREAD

2.009

1.866

1.705

EXTREME SPREAD

2.074

1.875

1.782

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811615

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.516

VS= 3.072

GS= 3.073

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.110	1.040	.945
MINIMUM X	-1.406	-1.476	-1.571
MAXIMUM Y	1.505	1.331	.825
MINIMUM Y	-1.567	-1.116	-.950
CENTROID X	-.072	-.002	.093
CENTROID Y	-.028	.146	-.020
POR TO CENTROID in.	.077	.146	.095
MIN RADIUS	.509	.544	.559
MEAN RADIUS	1.088	1.009	.920
MAX RADIUS	1.688	1.565	1.611
HORIZONTAL SPREAD	2.516	2.516	2.516
VERTICAL SPREAD	3.072	2.447	1.775
EXTREME SPREAD	3.073	2.733	2.733
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	