

06611645

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington




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

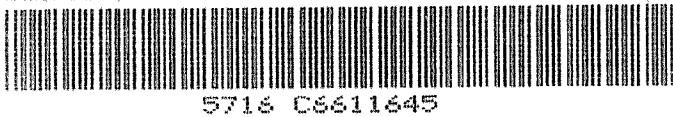
MODEL 700™ M24

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

20

SERIAL NO.
C6611645

ORDER NO.
5716



Referred
StockGUN SERIAL # **C6611645**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		11	11
615	Rollmark Caliber		11	G.S.
617	Drill and Tap Sight Holes	APR	3 1991	1-B
618	Polish Barrel	APR	3 1991	1-B
620	Apply Coatings (Barrel Action)		4-19-91	1-B
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/2/91	1-C
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	1-C
	C) Inspect Ejector Hole for Chamfer		5/2/91	1-C
	D) Oil Firing Pin Ass'y		5/2/91	1-C
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	D/H

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-9-91	AC
	G) Safety Off Force	3	3	3			5-9-91	AC
	H) Trigger Pull Test & Retainability						5-9-91	D/H
	I) Firing Pin Indent	.20	.20	.20			5-9-91	AC
	J) Assemble Stock						5/9/91	KS
	K) Assemble Swivel Studs						5-18-91	A
	L) Attach Front and Rear Sight Assemblies						5/9/91	KS
	M) Iron Sight Alignment						5/9/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	KS
	O) Attach Scope to Rifle						5/9/91	KS
	P) Detach & Attach Scope 20 Times						5/9/91	KS
640	Gallery Target & Test						5/11/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						5/11/91	KJ
655	Final Inspection							
	A) Headspace						5-18-91	A
	B) Trigger Pull	2.58	2.15	2.59	2.44	2.49	5/13/91	DL
	C) Function						5-18-91	AC
660	Pack						6-19-91	VC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. CC611645DATE 5-9-91TESTER PA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.78	2.63	2.58	MIN. SETTING,
PULL #2	2.33	2.62	2.82	2.15	NO. AVG. OF 5
PULL #3	2.44	2.67	2.47	2.59	READINGS ACCEPT-
PULL #4	2.57	2.67	2.63	2.44	ABLE LESS THAN 2#
PULL #5	2.42	2.53	2.79	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.46	3.07			
PULL #2	3.53	3.02			
PULL #3	3.20	2.97			
PULL #4	3.97	2.97			
PULL #5	2.97	2.98			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX. SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.06		4.30
PULL #2	3.98	4.13		4.21
PULL #3	4.01	4.02		4.37
PULL #4	4.03	3.98		4.34
PULL #5	4.00	4.09		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611645
11 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0984886
1 TO	2	.261819
1 TO	3	.123406
1 TO	4	.146003
1 TO	5	.292617

§ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0662
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0302
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .001
THE HMR FOR THIS RIFLE IS: 1.021

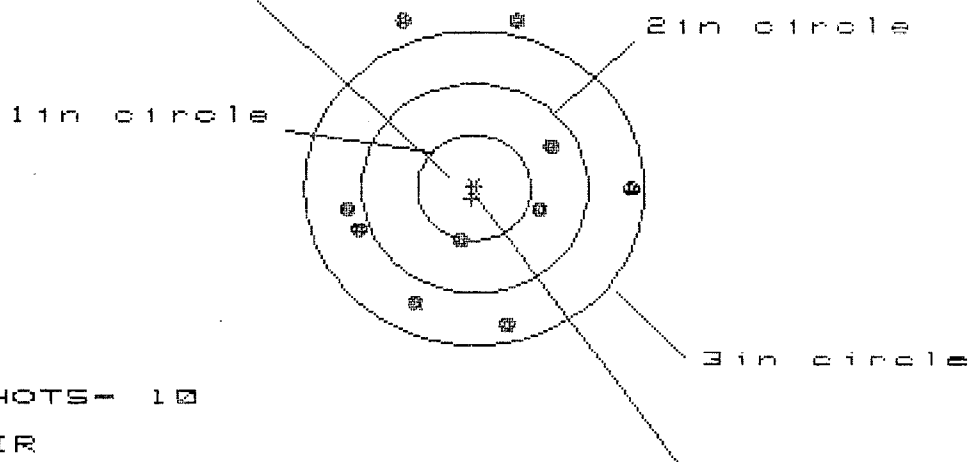
11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6511645

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in - 0

2in - 3

3in - 8

HS- 2.466

VS- 2.893

GS- 3.019

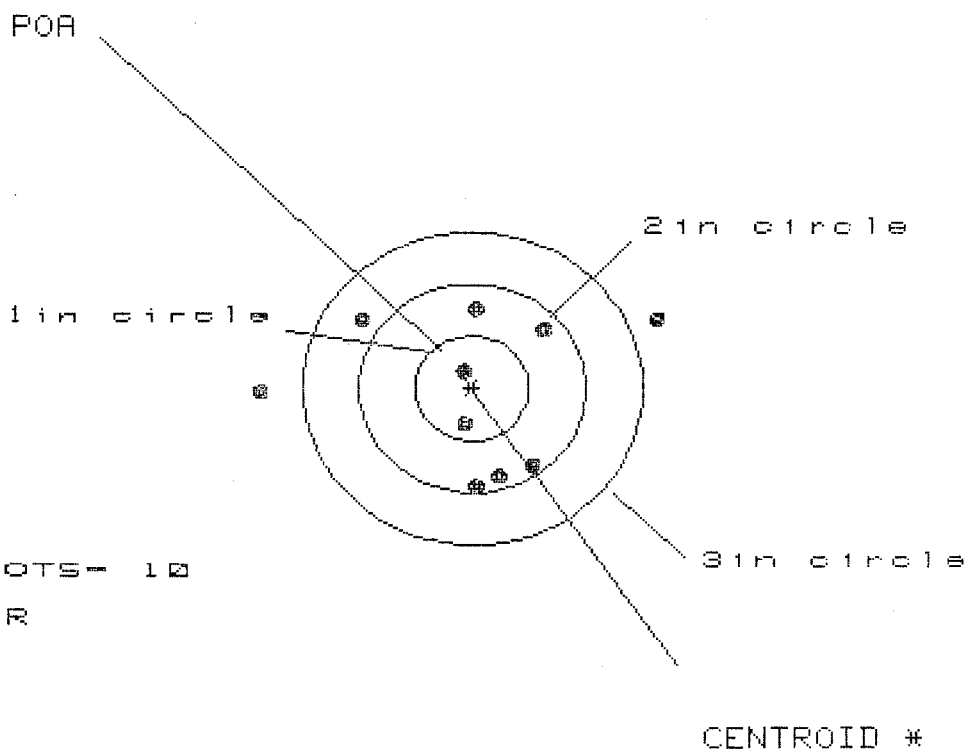
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.365	1.299	1.337
MINIMUM X	-1.101	-1.167	-1.129
MAXIMUM Y	1.634	1.788	.833
MINIMUM Y	-1.259	-1.078	-.854
CENTROID X	.022	.088	.050
CENTROID Y	.096	-.085	-.309
POA TO CENTROID in.	.099	.122	.313
MIN RADIUS	.522	.376	.182
MEAN RADIUS	1.141	1.038	.899
MAX RADIUS	1.738	1.813	1.388
HORIZONTAL SPREAD	2.466	2.466	2.466
VERTICAL SPREAD	2.893	2.866	1.687
EXTREME SPREAD	3.019	2.868	2.471
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611645

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 3.532

VS = 1.640

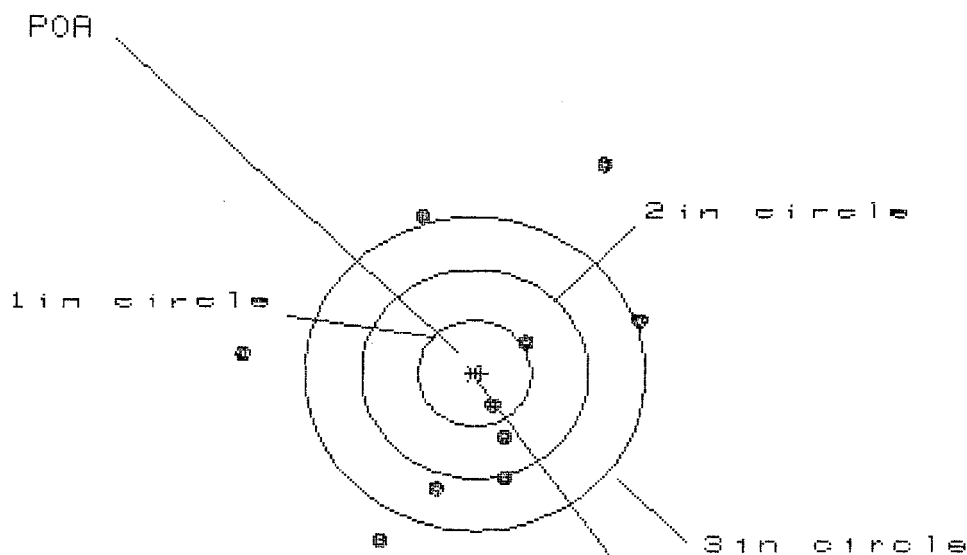
GS = 3.600

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.611	1.397	.581
MINIMUM X	:	-1.921	-1.174	-.999
MAXIMUM Y	:	.722	.716	.799
MINIMUM Y	:	-.918	-.924	-.841
CENTROID X	:	.072	.286	.111
CENTROID Y	:	-.161	-.155	-.238
POA TO CENTROID in.	:	.177	.325	.263
MIN RADIUS	:	.217	.359	.240
MEAN RADIUS	:	.959	.853	.735
MAX RADIUS	:	1.922	1.549	1.214
HORIZONTAL SPREAD	:	3.532	2.571	1.580
VERTICAL SPREAD	:	1.640	1.640	1.640
EXTREME SPREAD	:	3.600	2.572	1.978
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611645

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS = 3.425

VS = 3.535

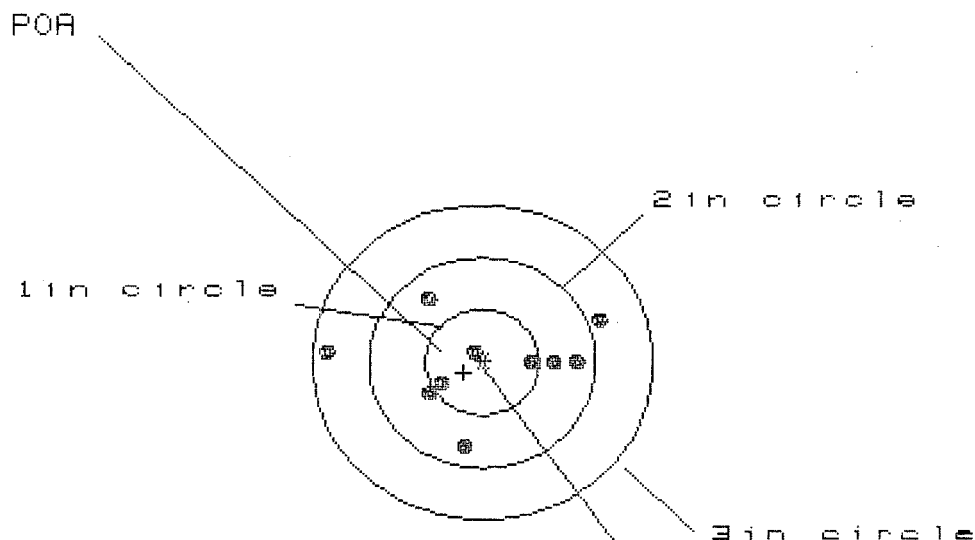
GS = 4.063

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.403	1.527	1.290
MINIMUM X	:	-2.022	-1.898	-1.002
MAXIMUM Y	:	1.987	1.680	1.729
MINIMUM Y	:	-1.548	-1.327	-1.278
CENTROID X	:	-.053	-.177	.061
CENTROID Y	:	-.002	-.223	-.272
POA TO CENTROID in.	:	.053	.285	.279
MIN RADIUS	:	.363	.324	.084
MEAN RADIUS	:	1.272	1.128	.951
MAX RADIUS	:	2.278	1.938	1.803
HORIZONTAL SPREAD	:	3.425	3.425	2.292
VERTICAL SPREAD	:	3.535	3.007	3.007
EXTREME SPREAD	:	4.063	3.441	3.074
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611645

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.386

VS= 1.406

GS= 2.401

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.833	.780
MINIMUM X	:	-1.398	-.645	-.541
MAXIMUM Y	:	.623	.635	.682
MINIMUM Y	:	-.783	-.771	-.724
CENTROID X	:	.168	.323	.219
CENTROID Y	:	.095	.084	.037
POA TO CENTROID in.	:	.193	.334	.222
MIN RADIUS	:	.093	.206	.166
MEAN RADIUS	:	.708	.624	.580
MAX RADIUS	:	1.401	.915	.860
HORIZONTAL SPREAD	:	2.386	1.478	1.321
VERTICAL SPREAD	:	1.406	1.406	1.406
EXTREME SPREAD	:	2.401	1.653	1.438
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611645

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.463

VS= 3.280

GS= 3.760

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.399
MINIMUM X	-1.063
MAXIMUM Y	2.065
MINIMUM Y	-1.215
CENTROID X	.122
CENTROID Y	-.179
POA TO CENTROID in.	.216
*IN RADIUS	.320
MEAN RADIUS	1.025
MAX RADIUS	2.111
HORIZONTAL SPREAD	2.463
VERTICAL SPREAD	3.280
EXTREME SPREAD	3.760
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8