

C6498844

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington




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

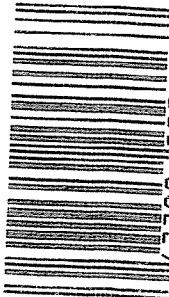
MODEL 700™ M24

SERIAL NO.
C6498844

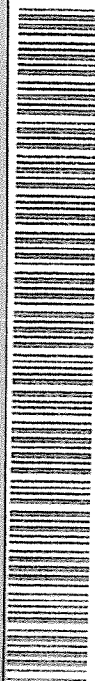
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6498844

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498844
8 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.197041
1 TO	2	.539083
1 TO	3	.058
1 TO	4	.7378
1 TO	5	.208614

⁴
 θ_2^+ <----POA

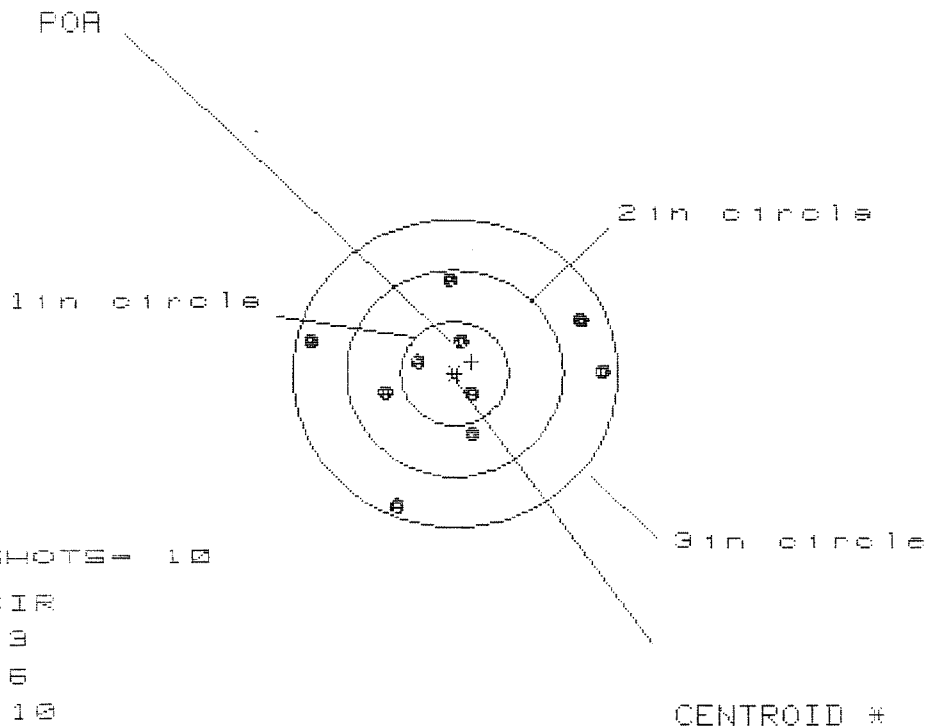
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .225494
THE AMR FOR THIS RIFLE IS: .8334

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C849B844

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.711

VS= 2.200

GS= 2.720

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.349	1.198	1.186
MINIMUM X	:	-1.362	-.758	-.609
MAXIMUM Y	:	.945	.976	.988
MINIMUM Y	:	-1.255	-1.224	-1.212
CENTROID X	:	-.160	-.009	-.158
CENTROID Y	:	-.115	-.146	-.158
POA TO CENTROID in.	:	.197	.146	.224
MIN RADIUS	:	.254	.189	.217
MEAN RADIUS	:	.844	.789	.711
MAX RADIUS	:	1.391	1.385	1.332
HORIZONTAL SPREAD	:	2.711	1.956	1.795
VERTICAL SPREAD	:	2.200	2.200	2.200
EXTREME SPREAD	:	2.720	2.477	2.477
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

8 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CS498844

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 2.564

VS= 1.216

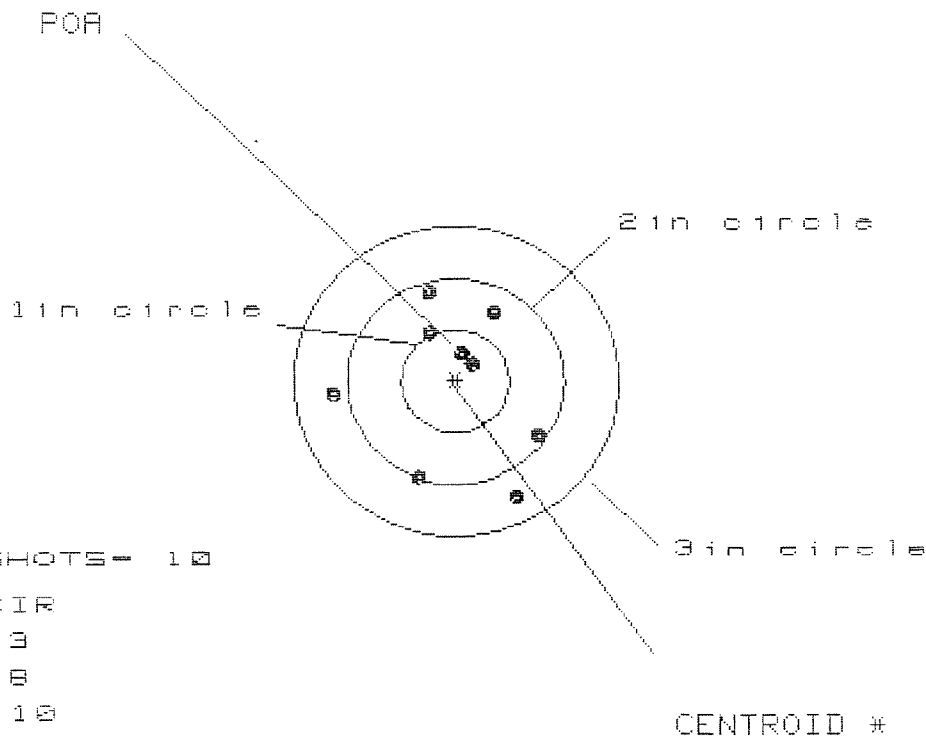
QS= 2.565

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.067	.848
MINIMUM X	:	-1.348	-1.112	-.979
MAXIMUM Y	:	.484	.460	.441
MINIMUM Y	:	-.732	-.756	-.775
CENTROID X	:	.233	.382	.249
CENTROID Y	:	-.484	-.460	-.441
POA TO CENTROID in.	:	.537	.598	.506
MIN RADIUS	:	.507	.394	.510
MEAN RADIUS	:	.849	.771	.732
MAX RADIUS	:	1.364	1.173	1.149
HORIZONTAL SPREAD	:	2.564	2.179	1.827
VERTICAL SPREAD	:	1.216	1.216	1.216
EXTREME SPREAD	:	2.565	2.243	2.148
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.916

VS= 2.006

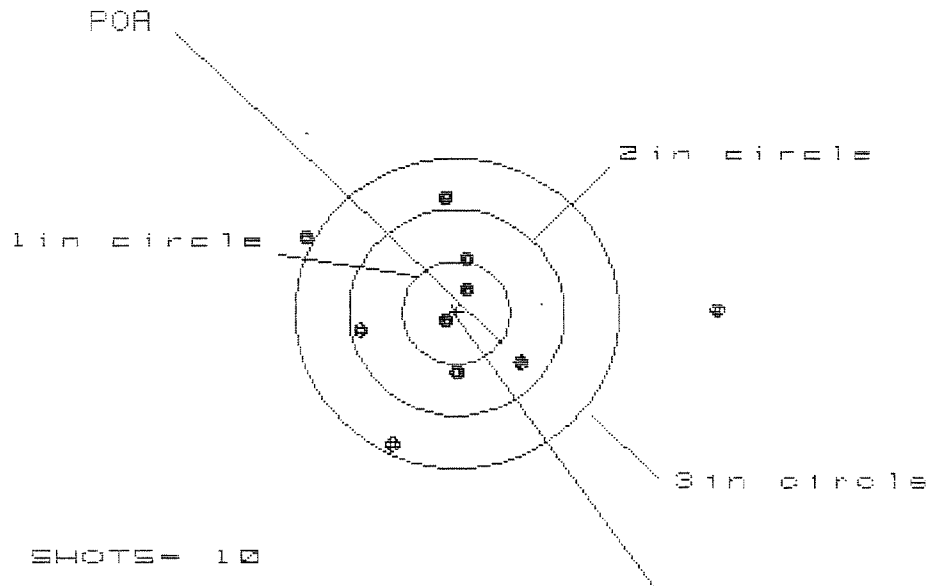
CS= 2.156

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.792	.852	.720
MINIMUM X	:	-1.124	-1.064	-.378
MAXIMUM Y	:	.866	.739	.712
MINIMUM Y	:	-1.140	-1.020	-1.046
CENTROID X	:	-.160	-.220	-.087
CENTROID Y	:	-.173	-.046	-.020
POA TO CENTROID in.	:	.236	.225	.090
MIN RADIUS	:	.222	.128	.090
MEAN RADIUS	:	.724	.623	.534
MAX RADIUS	:	1.263	1.104	1.113
HORIZONTAL SPREAD	:	1.916	1.916	1.097
VERTICAL SPREAD	:	2.006	1.759	1.759
EXTREME SPREAD	:	2.156	1.977	1.776
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.751

VS = 2.400

GS = 3.809

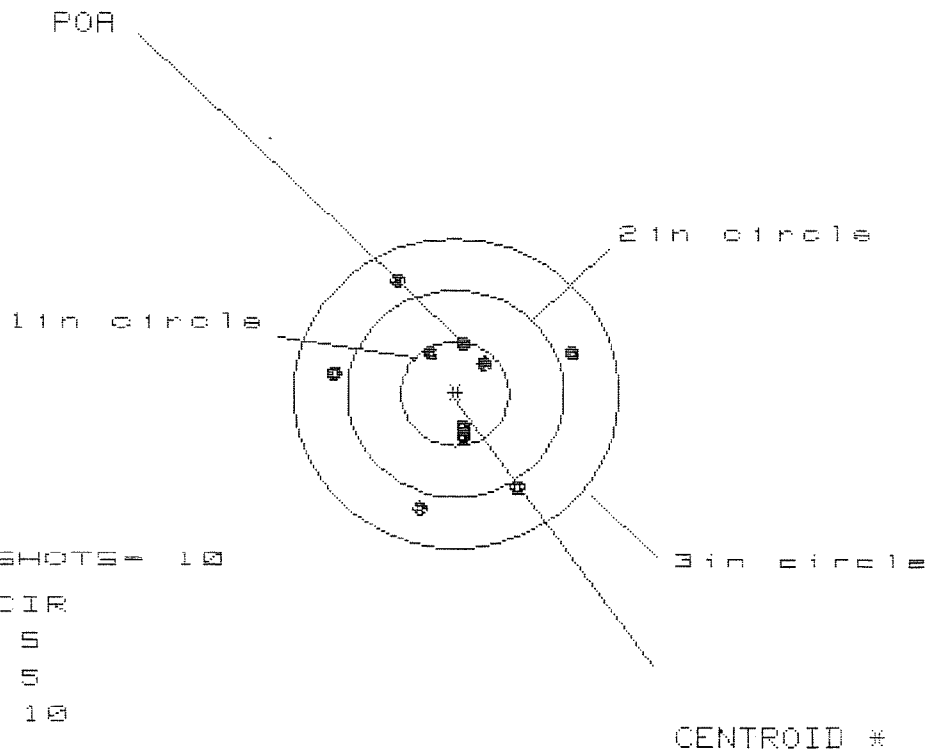
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.383	.825	.687
MINIMUM X	:	-1.368	-1.103	-.807
MAXIMUM Y	:	1.133	1.135	1.220
MINIMUM Y	:	-1.267	-1.265	-1.180
CENTROID X	:	-.603	-.868	-.730
CENTROID Y	:	.475	.473	.388
POA TO CENTROID in.	:	.768	.989	.827
MIN RADIUS	:	.151	.196	.034
MEAN RADIUS	:	.964	.810	.709
MAX RADIUS	:	2.383	1.319	1.286
HORIZONTAL SPREAD	:	3.751	1.928	1.494
VERTICAL SPREAD	:	2.400	2.400	2.400
EXTREME SPREAD	:	3.809	2.460	2.460
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 5

2in = 5

3in = 10

HS= 2.267

VS= 2.192

GS= 2.290

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.094	.963	.887
MINIMUM X	:	-1.173	-.612	-.524
MAXIMUM Y	:	1.074	1.096	.607
MINIMUM Y	:	-1.118	-1.096	-.959
CENTROID X	:	-.272	-.141	-.065
CENTROID Y	:	-.291	-.313	-.450
POA TO CENTROID in.	:	.398	.344	.455
MIN RADIUS	:	.360	.324	.214
MEAN RADIUS	:	.786	.730	.656
MAX RADIUS	:	1.191	1.255	1.093
HORIZONTAL SPREAD	:	2.267	1.575	1.411
VERTICAL SPREAD	:	2.192	2.192	1.566
EXTREME SPREAD	:	2.290	2.290	2.074
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498844

DATE 9-4-90

TESTER JAL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.23	2.22	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.17	2.27	2.50	
PULL #3	2.24	2.20	2.22	2.24	
PULL #4	2.25	2.19	2.24	2.26	
PULL #5	2.25	2.23	2.50	2.30	
TOTAL	11.18	11.02	11.45	11.67	
AVG.	2.236	2.204	2.29	2.334	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.31	3.20		
PULL #3	3.27	3.23		
PULL #4	3.20	3.32		
PULL #5	3.20	3.25		
TOTAL	16.34	16.22		
AVG.	3.268	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.27		4.20
PULL #2	4.24	4.22		4.22
PULL #3	4.26	4.22		4.25
PULL #4	4.27	4.31		4.24
PULL #5	4.26	4.26		4.19
TOTAL	21.25	21.28		21.10
AVG.	4.25	4.256		4.22

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498844

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		6/22/90	KCR
615	Rollmark Caliber		5/22/90	GS
617	Drill and Tap Sight Holes		5/23/90	LB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		5-4-90	JA
	Apply Coating (Bolt)		5-4-90	JA
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-4-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			7/26/90	981
	G) Safety Off Force	3	3	3			7/26/90	981
	H) Trigger Pull Test & Retainability						9-4-90	981
	I) Firing Pin Indent	.022	.022	.022			7/26/90	981
	J) Assemble Stock						7/30/90	Rw
	K) Assemble Swivel Studs						9/5/90	988
	L) Attach Front and Rear Sight Assemblies						7/30/90	Rw
	M) Iron Sight Alignment						7/30/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	Rw
	O) Attach Scope to Rifle						7/30/90	Rw
	P) Detach & Attach Scope 20 Times						7/30/90	Rw
640	Gallery Target & Test						8-8-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						8-8-90	A
655	Final Inspection							
	A) Headspace						9/5/90	988
	B) Trigger Pull	2.32	2.50	2.24	2.26	2.30	9-4-90	981
	C) Function						9/5/90	988
660	Pack						9/29/90	1F