

C6648961

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

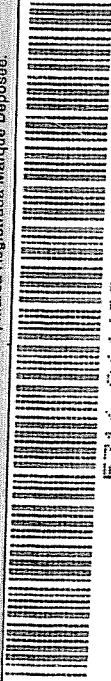
Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

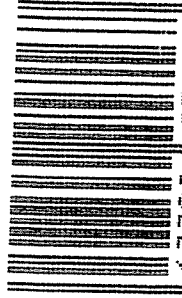
SERIAL NO. C6648961	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6648961

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648961

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	2 0 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	YG
	Magnaflux Bolt		JUL 22 1991	YG
615	Rollmark Caliber		JUL 22 1991	YG
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	YH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/11/91	RU
	G) Safety Off Force	3	3	3			9/11/91	RU
	H) Trigger Pull Test & Retainability						9/11/91	RU
	I) Firing Pin Indent	.0225	.0225	.0225			9/11/91	RU
	J) Assemble Stock						9/12/91	RW
	K) Assemble Swivel Studs						9/13/91	RU
	L) Attach Front and Rear Sight Assemblies						9/12/91	RW
	M) Iron Sight Alignment						9/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	RW
	O) Attach Scope to Rifle						9/12/91	RW
	P) Detach & Attach Scope 20 Times						9/12/91	RW
640	Gallery Target & Test						9-12-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-12-91	NF
655	Final Inspection							
	A) Headspace						9/13/91	RU
	B) Trigger Pull	2.20	2.22	2.30	2.18	2.18	9-13-91	RU
	C) Function						9/13/91	RU
660	Pack						9-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6648961

DATE 9-11-81

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.26	2.33	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.25	2.38	2.22	
PULL #3	2.49	2.24	2.26	2.30	
PULL #4	2.47	2.26	2.30	2.18	
PULL #5	2.55	2.30	2.38	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.47		
PULL #2	3.28	3.54		
PULL #3	3.61	3.55		
PULL #4	3.65	3.50		
PULL #5	3.48	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.28		4.37
PULL #2	4.28	4.37		4.36
PULL #3	4.34	4.33		4.45
PULL #4	4.38	4.33		4.40
PULL #5	4.36	4.43		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648961
13 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.165366
1 TO	2	.554985
1 TO	3	.266603
1 TO	4	.252517
1 TO	5	.263797

$\frac{2}{31}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1314
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0136
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132102
THE AMR FOR THIS RIFLE IS: 1.036

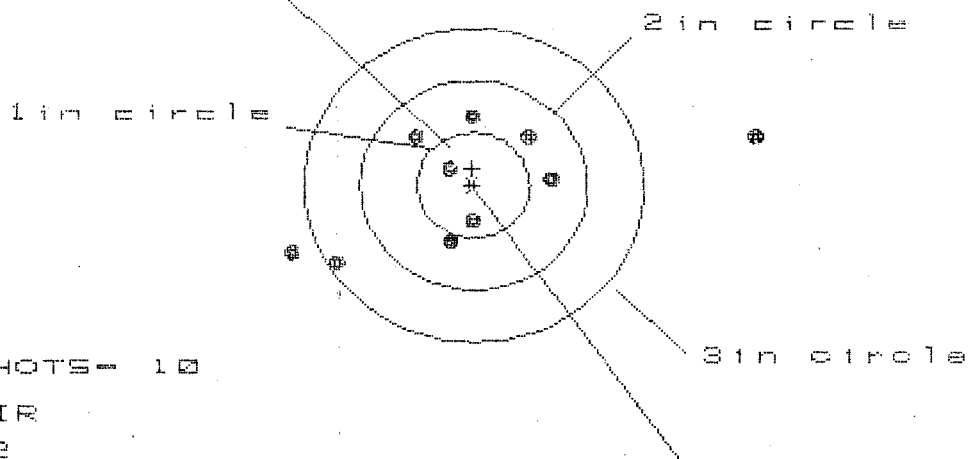
12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B9B1

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 4.092

VS= 1.355

GS= 4.240

CENTROID *

PATTERN #

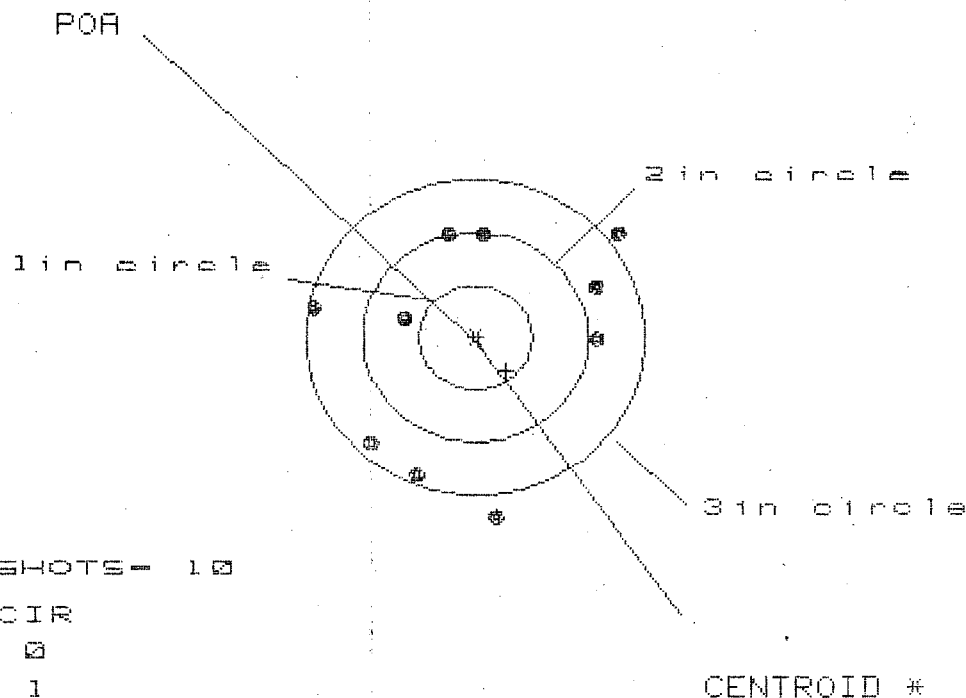
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	2.495	1.010	.845
MINIMUM X	-1.597	-1.319	-1.146
MAXIMUM Y	.619	.669	.594
MINIMUM Y	-.736	-.686	-.761
CENTROID X	.011	-.267	-.102
CENTROID Y	-.165	-.215	-.140
POA TO CENTROID in.	.165	.343	.173
MIN RADIUS	.226	.204	.128
MEAN RADIUS	.956	.775	.653
MAX RADIUS	2.537	1.451	1.376
HORIZONTAL SPREAD	4.092	2.329	1.991
VERTICAL SPREAD	1.355	1.355	1.355
EXTREME SPREAD	4.240	2.452	2.164
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0664B361

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 8

HS= 2.646

VS= 2.723

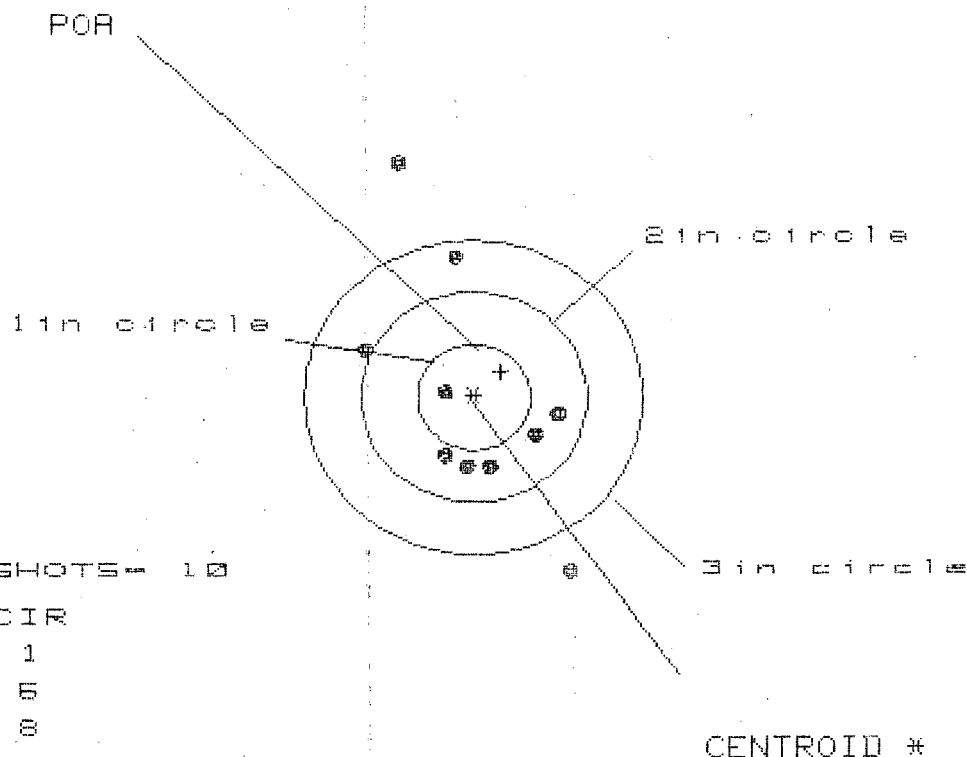
GS= 2.962

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.272	1.290
MINIMUM X	-1.394	-1.374	-1.215
MAXIMUM Y	1.017	.827	.913
MINIMUM Y	-1.706	-1.467	-1.363
CENTROID X	-.271	-.291	-.450
CENTROID Y	.313	.503	.399
POA TO CENTROID in.	.414	.581	.602
MIN RADIUS	.647	.598	.451
MEAN RADIUS	1.242	1.160	1.106
MAX RADIUS	1.715	1.551	1.407
HORIZONTAL SPREAD	2.646	2.646	2.505
VERTICAL SPREAD	2.723	2.294	2.276
EXTREME SPREAD	2.962	2.962	2.519
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	8		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648961

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.792

VS= 3.897

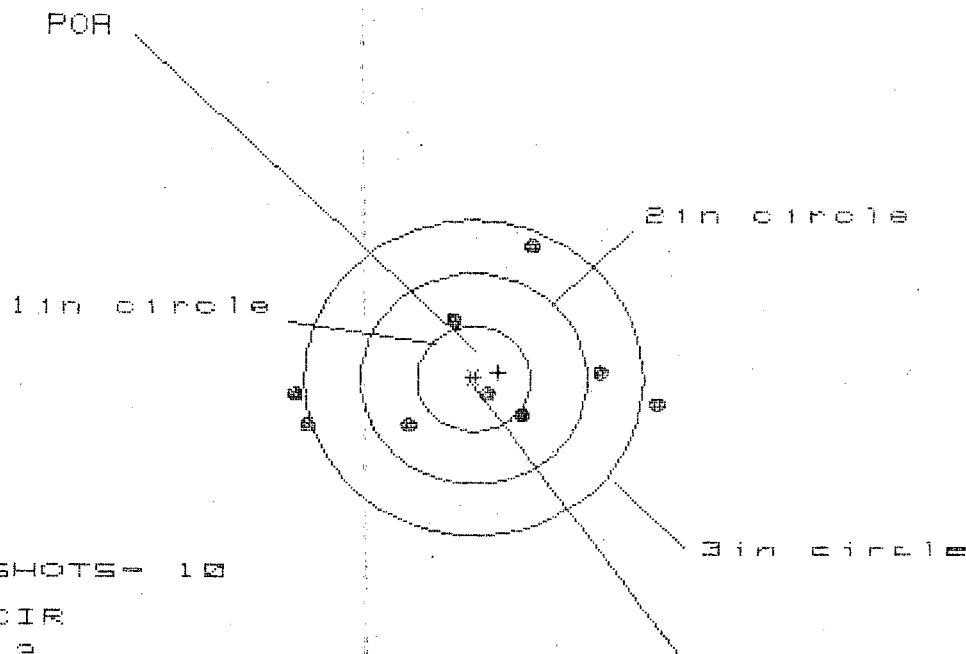
GS= 4.172

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.793	.789
MINIMUM X	:	-.929	-.999	-.900
MAXIMUM Y	:	2.218	1.554	1.375
MINIMUM Y	:	-1.679	-1.433	-.618
CENTROID X	:	-.243	-.173	-.272
CENTROID Y	:	-.246	-.492	-.313
POA TO CENTROID in.	:	.345	.522	.415
MIN RADIUS	:	.306	.439	.302
MEAN RADIUS	:	1.025	.827	.743
MAX RADIUS	:	2.305	1.637	1.379
HORIZONTAL SPREAD	:	1.792	1.792	1.689
VERTICAL SPREAD	:	3.897	2.987	1.993
EXTREME SPREAD	:	4.172	3.148	2.017
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B9B1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

ME = 2.188

VS = 1.684

GS = 3.191

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.633	1.255	1.087
MINIMUM X	-1.555	-1.374	-1.542
MAXIMUM Y	1.237	1.205	1.152
MINIMUM Y	-.447	-.479	-.532
CENTROID X	-.220	-.401	-.233
CENTROID Y	-.063	-.031	.022
POA TO CENTROID in.	.228	.402	.234
MIN RADIUS	.141	.296	.223
MEAN RADIUS	.941	.883	.788
MAX RADIUS	1.657	1.413	1.559
HORIZONTAL SPREAD	3.188	2.629	2.629
VERTICAL SPREAD	1.684	1.684	1.684
EXTREME SPREAD	3.191	2.643	2.637
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

12 Sep 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.814

VS= 1.573

GS= 3.928

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.092

1.346

1.160

MINIMUM X

-1.721

-1.489

-.801

MAXIMUM Y

.647

.690

.663

MINIMUM Y

-.925

-.854

-.881

CENTROID X

.066

-.167

.019

CENTROID Y

.093

.022

.049

POA TO CENTROID in.

.114

.168

.052

MIN RADIUS

.238

.419

.295

MEAN RADIUS

1.015

.880

.782

MAX RADIUS

2.190

1.505

1.162

HORIZONTAL SPREAD

3.814

2.835

1.961

VERTICAL SPREAD

1.573

1.544

1.544

EXTREME SPREAD

3.928

2.841

2.003

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8