

C6648984

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.

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

MODEL 700TM M24

SERIAL NO. C6648984

ORDER NO. 5716

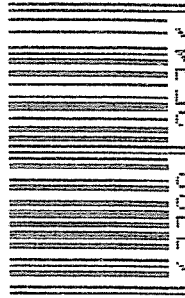
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6648984

LPC



0 47700 25716 2

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648984

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	YH
600	Proof		7/24/91	YH
607	Check Headspace		7/24/91	YH
610	Dis-assemble Gun		7/24/91	YH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	GS
617	Drill and Tap Sight Holes		AUG 7 1991	GS
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	YH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	YH
	C) Inspect Ejector Hole for Chamfer		8/29/91	YH
	D) Oil Firing Pin Ass'y		8/29/91	YH
	E) Adjust Trigger Pull to Min Setting and Stake		9/3/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/4	6	6			9-3-91	DH
	G) Safety Off Force	2 3/4	2 3/4	3			9-3-91	DH
	H) Trigger Pull Test & Retainability						9-3-91	DL
	I) Firing Pin Indent	.021	.021	.022			9-3-91	DH
	J) Assemble Stock						9/3/91	KA
	K) Assemble Swivel Studs						9-9-91	K
	L) Attach Front and Rear Sight Assemblies						9/3/91	KA
	M) Iron Sight Alignment						9/3/91	KA
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	KA
	O) Attach Scope to Rifle						9/3/91	KA
	P) Detach & Attach Scope 20 Times						9/3/91	KA
640	Gallery Target & Test						9/4/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						9/4/91	KT
655	Final Inspection							
	A) Headspace						9-9-91	K
	B) Trigger Pull	2.55	2.43	2.43	2.41	2.49	9-6-91	DL
	C) Function						9-9-91	K
660	Pack						9-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6648984

DATE 9-3-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.44	2.53	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.42	2.50	2.43	
PULL #3	2.37	2.42	2.48	2.43	
PULL #4	2.41	2.44	2.44	2.41	
PULL #5	2.42	2.51	2.51	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.44		
PULL #2	3.22	3.24		
PULL #3	3.33	3.42		
PULL #4	3.25	3.44		
PULL #5	3.41	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.39		4.34
PULL #2	4.41	4.31		4.45
PULL #3	4.37	4.47		4.31
PULL #4	4.39	4.31		4.33
PULL #5	4.45	4.43		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6648984

4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.336933
1 TO 2	.389281
1 TO 3	.210038
1 TO 4	.323736
1 TO 5	.299813

(----POA

COORDINATE FOR THIS RIFLE IS: -.0372

COORDINATE FOR THIS RIFLE IS: .1034

SPACE POI RADIUS FOR THIS RIFLE IS: .109888

SPACE .9412

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B9B4

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.396

VS= 2.896

GS= 2.942

CENTROID *

PATTERN #

SHOTS (BEST OF)

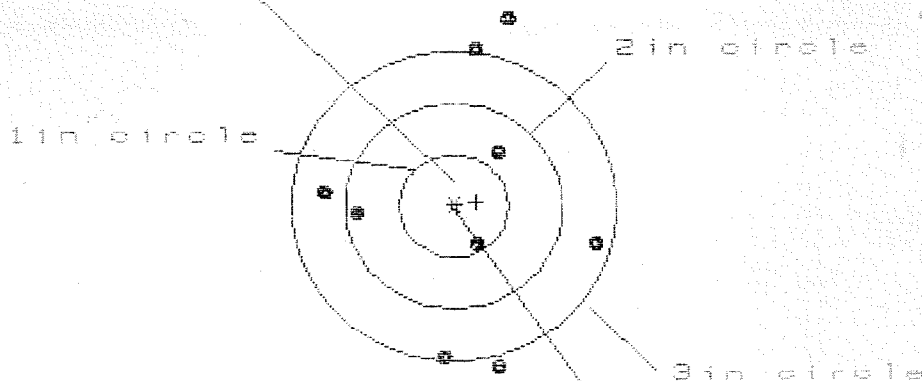
	10	9	8
MAXIMUM X	1.104	1.050	.882
MINIMUM X	-1.292	-1.346	-.660
MAXIMUM Y	.763	.526	.553
MINIMUM Y	-2.133	-.745	-.718
CENTROID X	-.068	-.014	.154
CENTROID Y	.330	.567	.540
POA TO CENTROID in.	.337	.567	.562
MIN RADIUS	.083	.172	.112
95% RADIUS	.840	.660	.564
90% RADIUS	2.187	1.363	.892
HORIZONTAL SPREAD	2.396	2.396	1.542
VERTICAL SPREAD	2.896	1.271	1.271
EXTREME SPREAD	2.942	2.398	1.564
COUNT IN ONE INCH CIRCLE =		3	
COUNT IN TWO INCH CIRCLE =		7	
COUNT IN THREE INCH CIRCLE =		9	

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648984

CENTERFIRE PATTERNS # 2

POB



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.509

VS= 3.449

GS= 3.449

CENTROID +

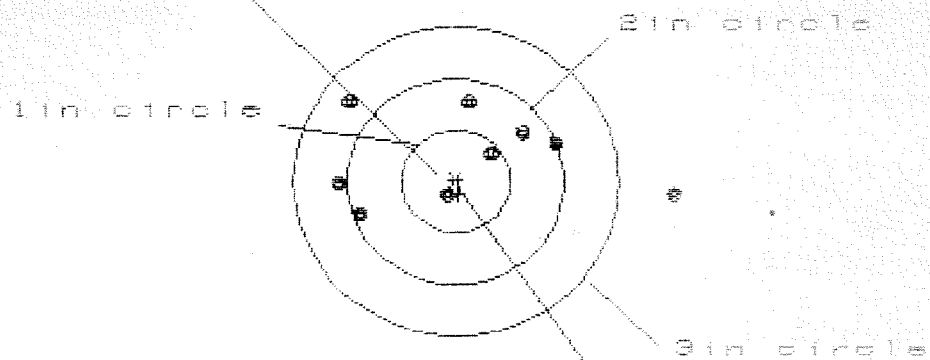
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.316	1.371	1.433
MINIMUM X	:	-1.193	-1.138	-1.077
MAXIMUM Y	:	1.842	1.691	1.515
MINIMUM Y	:	-1.607	-1.402	-1.476
CENTROID X	:	-.206	-.261	-.323
CENTROID Y	:	-.034	-.239	-.063
POB TO CENTROID in.	:	.209	.353	.329
MIN RADIUS	:	.362	.245	.404
MEAN RADIUS	:	1.191	1.091	1.032
MAX RADIUS	:	1.907	1.716	1.556
HORIZONTAL SPREAD	:	2.509	2.509	2.509
VERTICAL SPREAD	:	3.449	3.093	2.991
EXTREME SPREAD	:	3.449	3.100	3.006
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648984

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.129

VS= 2.827

GS= 3.548

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.037	1.928	1.058
MINIMUM X	:	-1.092	-1.201	-1.960
MAXIMUM Y	:	1.803	.578	.531
MINIMUM Y	:	-2.024	-.584	-.631
CENTROID X	:	-.018	.091	-.158
CENTROID Y	:	.126	.351	.398
POA TO CENTROID in.	:	.127	.362	.426
MIN RADIUS	:	.138	.220	.383
MEAN RADIUS	:	1.072	.904	.780
MAX RADIUS	:	2.248	1.965	1.053
HORIZONTAL SPREAD	:	3.129	3.129	2.010
VERTICAL SPREAD	:	2.827	1.162	1.162
EXTREME SPREAD	:	3.548	3.184	2.937
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C654B984

CENTERFIRE PATTERNS

4

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.098

VS= 2.318

GS= 2.338

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.978	.891	.831
MINIMUM X	-1.128	-1.267	-1.267
MAXIMUM Y	1.155	.685	.555
MINIMUM Y	-1.163	-1.034	-.508
CENTROID X	.186	.185	.245
CENTROID Y	.057	-.072	.058
POB TO CENTROID in.	.120	.198	.252
MIN RADIUS	.107	.135	.032
MEAN RADIUS	.800	.724	.658
MAX RADIUS	1.357	1.222	1.307
HORIZONTAL SPREAD	2.098	2.098	2.098
VERTICAL SPREAD	2.318	1.719	1.063
EXTREME SPREAD	2.338	2.228	2.228
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

1 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648984

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.632

VS= 2.850

GS= 3.061

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.911

.856

.370

MINIMUM X

-.721

-.776

-1.669

MAXIMUM Y

.899

.682

.751

MINIMUM Y

-1.951

-.752

-.683

CENTROID X

.000

.055

-.052

CENTROID Y

.038

.255

.186

POA TO CENTROID in.

.038

.261

.193

MIN RADIUS

.093

.307

.250

MEAN RADIUS

.803

.680

.620

MAX RADIUS

2.012

1.020

.816

HORIZONTAL SPREAD

1.632

1.632

1.039

VERTICAL SPREAD

2.850

1.434

1.434

EXTREME SPREAD

3.061

1.722

1.451

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9