

C6648997

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

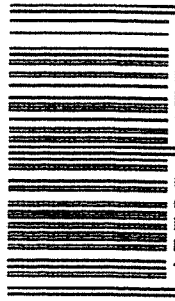
Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6648997
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716

UPC



0 47700 25716 7



5716 C6648997

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648997

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	2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		7/28/91	LB
	Apply Coating (Bolt)		7/28/91	LB
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 3/4	4 1/4			9-9-91	D/H
	G) Safety Off Force	2	2	2			9-9-91	D/H
	H) Trigger Pull Test & Retainability						9/9/91	SH
	I) Firing Pin Indent	.022	.021	.022			9-9-91	D/H
	J) Assemble Stock						9/9/91	RW
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						9/9/91	RW
	M) Iron Sight Alignment						9/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	RW
	O) Attach Scope to Rifle						9/9/91	RW
	P) Detach & Attach Scope 20 Times						9/9/91	RW
640	Gallery Target & Test						9-10-91	AC
	A) Time						9-10-91	AC
	B) Malfunctions						9-10-91	AC
	C) Pierced Primers						9-10-91	AC
	D) Optical Clarity of Scope						9-10-91	AC
645	Inspect for Live Ammo						9-10-91	AC
655	Final Inspection							
	A) Headspace						9-13-91	AC
	B) Trigger Pull	2.18	2.13	2.22	2.24	2.26	9-13-91	SH
	C) Function						9-13-91	AC
660	Pack						9-17-91	D/H

MOD. _____ GA. _____ GUN # 6648897
 CAL. _____

INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaves brass and ejector sticks	
	2nd	Polish face of Bolt & Reamed Ejector Hole	PW
	3rd		
	4th		
		FINAL INSPECTION	RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	50 RDS	
TEST		
TGT		
PROOF	TEST	
TEST		
TGT		
PROOF	OK	
TEST		
TGT		
PROOF	9-13-91 DM	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6648997

DATE 9-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.31	2.35	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.34	2.43	2.13	
PULL #3	2.23	2.25	2.45	2.22	
PULL #4	2.35	2.30	2.50	2.24	
PULL #5	2.26	2.22	2.44	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.23		
PULL #2	3.22	3.20		
PULL #3	3.27	3.35		
PULL #4	3.32	3.46		
PULL #5	3.26	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.23		4.35
PULL #2	4.27	4.18		4.39
PULL #3	4.53	4.30		4.38
PULL #4	4.48	4.30		4.37
PULL #5	4.20	4.33		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648997
10 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.299247
1 TO 2	.508898
1 TO 3	.287327
1 TO 4	.3222
1 TO 5	.608252

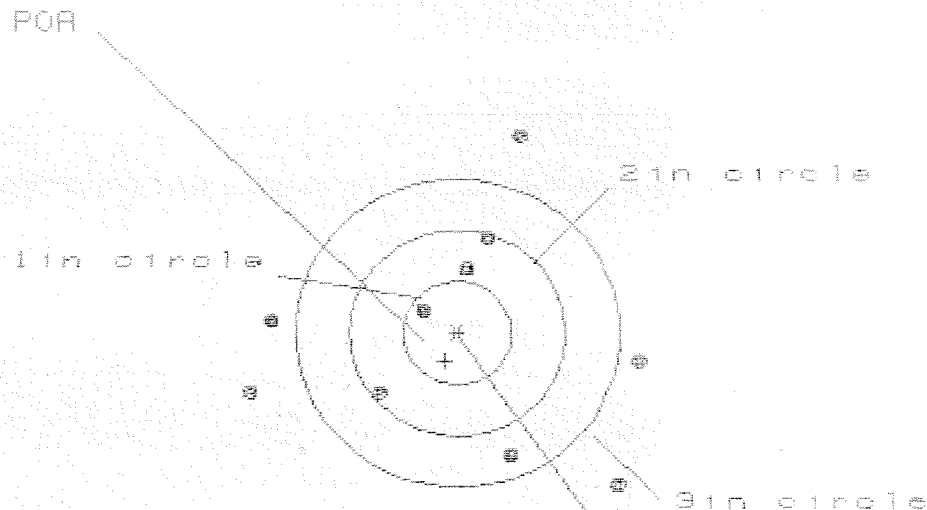
$\bar{x} = \frac{1}{5} \sum x_i$ ←--- POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0536
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0775072
THE AMR FOR THIS RIFLE IS: 1.21

18 Sep 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6648397

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 3.560

VS = 3.396

GS = 3.595

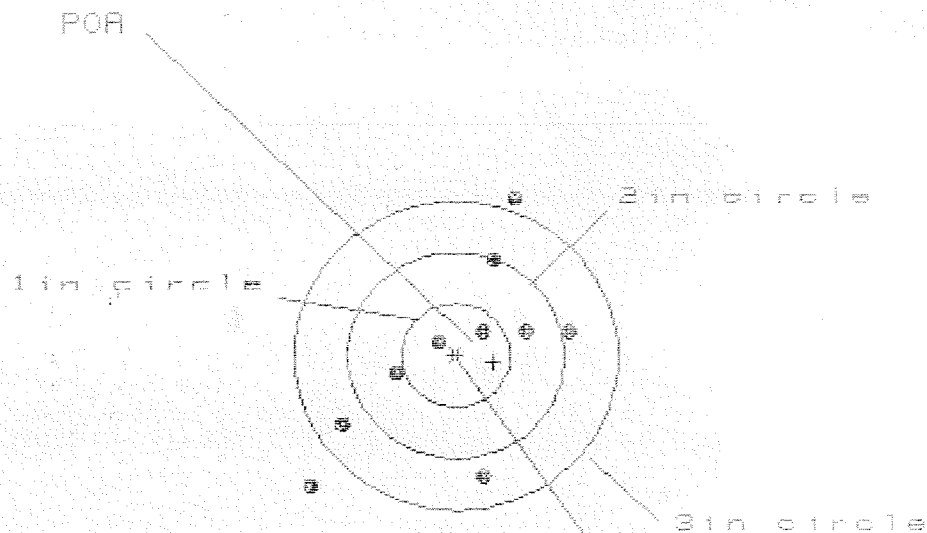
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.660	1.827	1.919
MINIMUM X	-1.900	-1.733	-1.641
MAXIMUM Y	1.949	1.788	.995
MINIMUM Y	-1.447	-1.288	-1.064
CENTROID X	.118	-.049	-.141
CENTROID Y	.275	.436	.212
POA TO CENTROID in.	.299	.439	.255
MIN RADIUS	.368	.136	.302
MEAN RADIUS	1.364	1.240	1.165
MAX RADIUS	2.091	1.932	1.926
HORIZONTAL SPREAD	3.560	3.560	3.560
VERTICAL SPREAD	3.396	3.076	2.059
EXTREME SPREAD	3.595	3.572	3.572
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 5		

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS64BS97

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.456

VS = 2.789

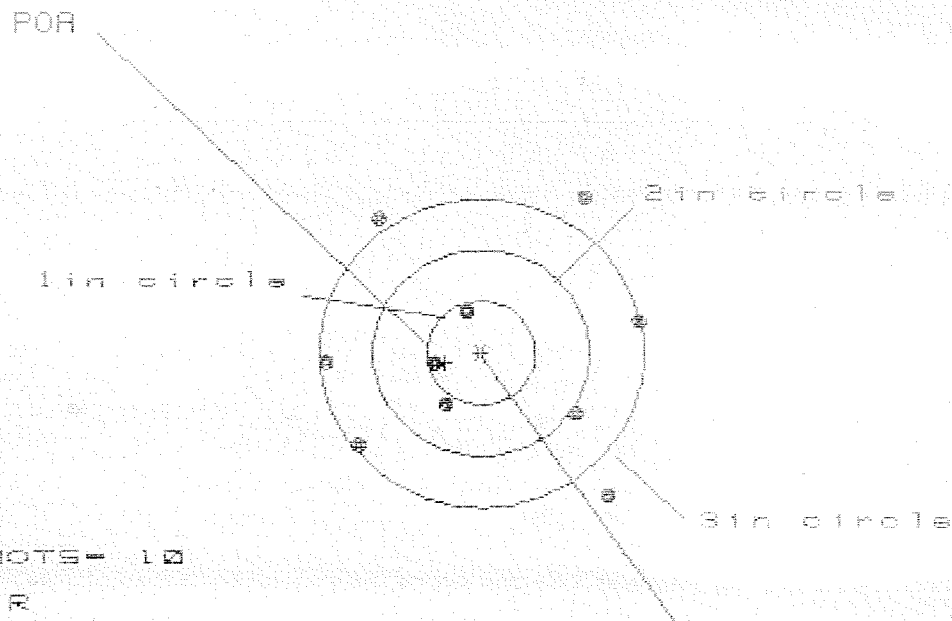
GS = 3.416

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	.920	.975
MINIMUM X	:	-1.382	-1.191	-1.136
MAXIMUM Y	:	1.496	1.353	.955
MINIMUM Y	:	-1.293	-1.318	-1.149
CENTROID X	:	-.346	-.192	-.247
CENTROID Y	:	.066	.209	.040
POA TO CENTROID in.	:	.352	.284	.250
MIN RADIUS	:	.210	.136	.300
MEAN RADIUS	:	.983	.846	.791
MAX RADIUS	:	1.892	1.433	1.299
HORIZONTAL SPREAD	:	2.456	2.111	2.111
VERTICAL SPREAD	:	2.789	2.671	2.104
EXTREME SPREAD	:	3.416	2.698	2.300
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648997

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.901

VS= 2.942

GS= 3.446

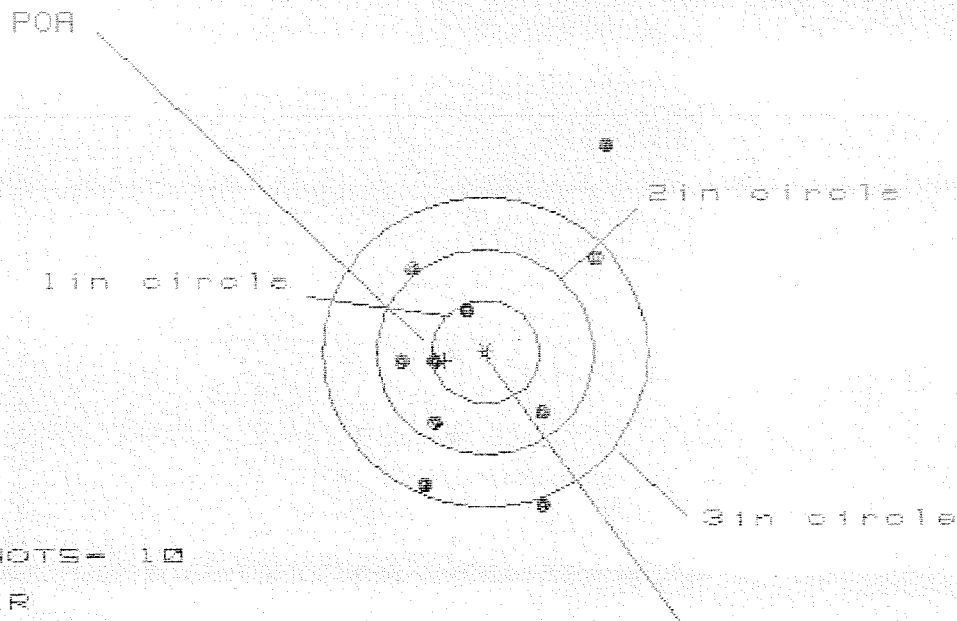
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.442	1.573	1.711
MINIMUM X	:	-1.459	-1.328	-1.190
MAXIMUM Y	:	1.507	1.347	1.325
MINIMUM Y	:	-1.435	-1.053	-0.884
CENTROID X	:	.337	.206	.068
CENTROID Y	:	.089	.249	.088
POA TO CENTROID in.	:	.349	.323	.186
MIN RADIUS	:	.402	.264	.142
MEAN RADIUS	:	1.210	1.116	.996
MAX RADIUS	:	1.854	1.742	1.744
HORIZONTAL SPREAD	:	2.901	2.901	2.901
VERTICAL SPREAD	:	2.942	2.400	2.209
EXTREME SPREAD	:	3.446	3.205	2.933
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648997

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.889

VS= 3.466

GS= 3.687

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.077	1.125	1.205
MINIMUM X	:	-.812	-.692	-.612
MAXIMUM Y	:	2.031	1.106	.955
MINIMUM Y	:	-1.435	-1.209	-1.211
CENTROID X	:	.376	.256	.176
CENTROID Y	:	.082	-.144	.007
POA TO CENTROID in.	:	.384	.294	.176
MIN RADIUS	:	.481	.363	.270
MEAN RADIUS	:	1.102	.926	.845
MAX RADIUS	:	2.299	1.578	1.538
HORIZONTAL SPREAD	:	1.889	1.817	1.817
VERTICAL SPREAD	:	3.466	2.315	2.166
EXTREME SPREAD	:	3.687	2.656	2.656
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

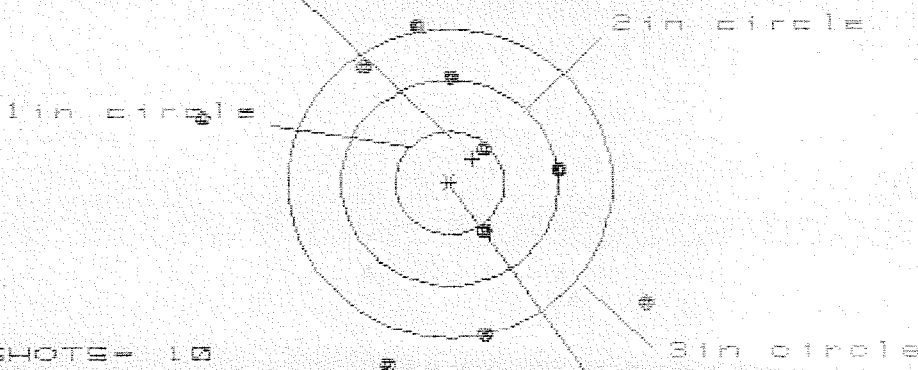
10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B997

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 4.054

VS= 3.317

GS= 4.421

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.783
MINIMUM X	-2.272
MAXIMUM Y	1.518
MINIMUM Y	-1.799
CENTROID X	-.215
CENTROID Y	-.234
POA TO CENTROID in.	.317
MIN RADIUS	.475
MEAN RADIUS	1.392
MAX RADIUS	2.359
HORIZONTAL SPREAD	4.054
VERTICAL SPREAD	3.317
EXTREME SPREAD	4.421
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	6

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648997
16 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.579418
1 TO 2	.752367
1 TO 3	.622534
1 TO 4	.546445
1 TO 5	.838518

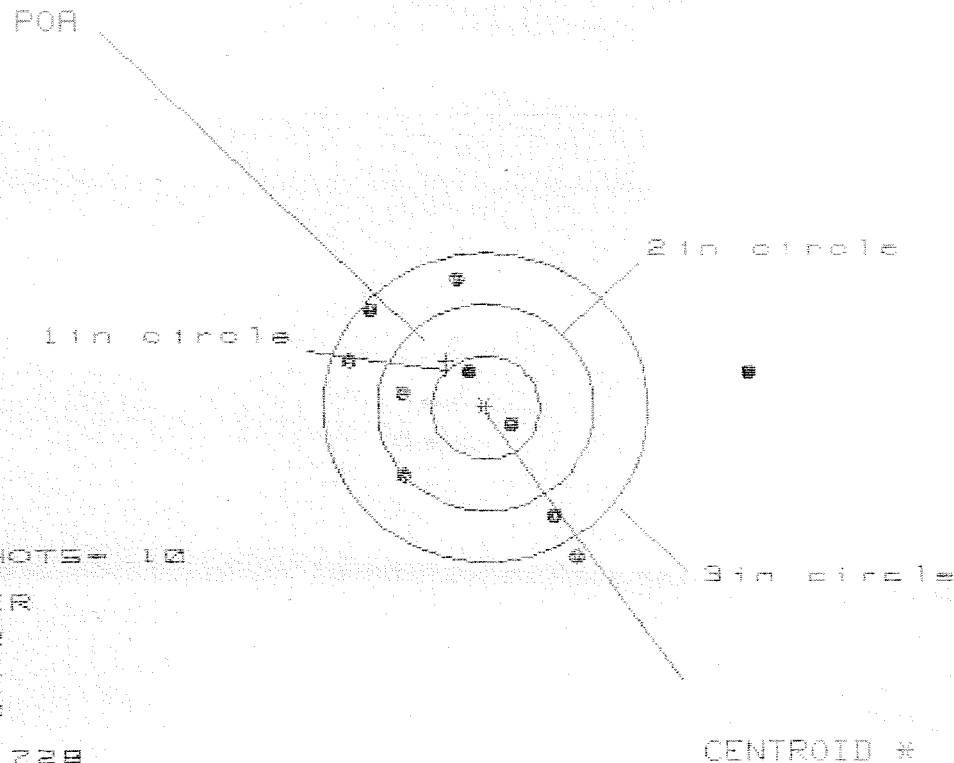
POI
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0278
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0964915
THE AMR FOR THIS RIFLE IS: 1.009

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648997.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 3.728

VS = 2.710

GS = 3.728

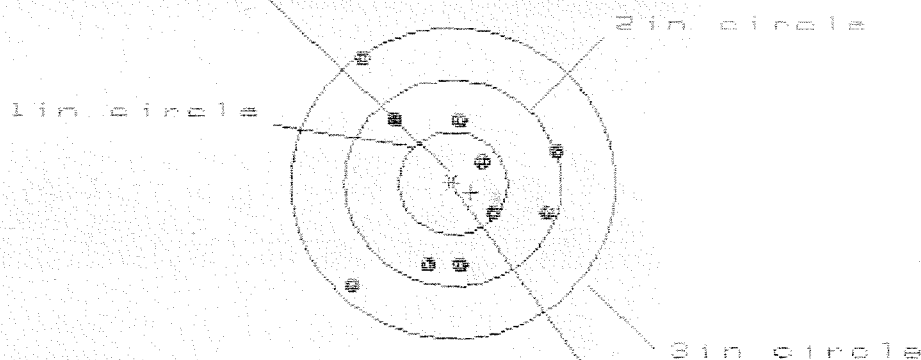
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.456	1.155	1.096
MINIMUM X	:	-1.272	-.999	-.855
MAXIMUM Y	:	1.255	1.295	1.118
MINIMUM Y	:	-1.455	-1.415	-1.221
CENTROID X	:	.365	.092	-.052
CENTROID Y	:	-.450	-.490	-.313
POA TO CENTROID in.	:	.579	.498	.317
MIN RADIUS	:	.312	.395	.347
MEAN RADIUS	:	1.195	1.016	.877
MAX RADIUS	:	2.482	1.827	1.641
HORIZONTAL SPREAD	:	3.728	2.154	1.951
VERTICAL SPREAD	:	2.710	2.710	2.339
EXTREME SPREAD	:	3.728	3.089	2.676
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648997.1

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.912

VS= 2.227

GS= 2.305

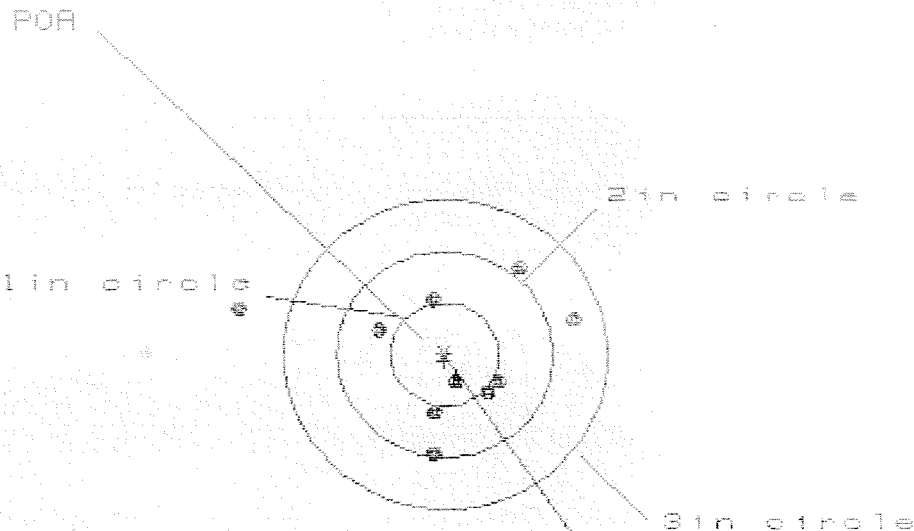
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.959	.872	.742
MINIMUM X	:	-.953	-1.040	-.710
MAXIMUM Y	:	1.252	.802	.698
MINIMUM Y	:	-.975	-.836	-.770
CENTROID X	:	-.165	-.078	.053
CENTROID Y	:	.084	-.055	.049
POA TO CENTROID in.	:	.185	.095	.072
MIN RADIUS	:	.331	.328	.250
MEAN RADIUS	:	.863	.774	.676
MAX RADIUS	:	1.481	1.334	.987
HORIZONTAL SPREAD	:	1.912	1.912	1.451
VERTICAL SPREAD	:	2.227	1.638	1.476
EXTREME SPREAD	:	2.305	2.305	1.631
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.139

VS= 1.775

GS= 3.141

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	.988	.610
MINIMUM X	:	-1.936	-.831	-.708
MAXIMUM Y	:	.825	.871	.915
MINIMUM Y	:	-.950	-.904	-.860
CENTROID X	:	.008	.223	.100
CENTROID Y	:	.060	.014	-.030
POA TO CENTROID in.	:	.061	.223	.104
MIN RADIUS	:	.229	.235	.135
MEAN RADIUS	:	.830	.672	.608
MAX RADIUS	:	1.980	1.047	1.100
HORIZONTAL SPREAD	:	3.139	1.819	1.318
VERTICAL SPREAD	:	1.775	1.775	1.775
EXTREME SPREAD	:	3.141	1.950	1.950
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648397.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.600

VS= 1.807

GS= 2.916

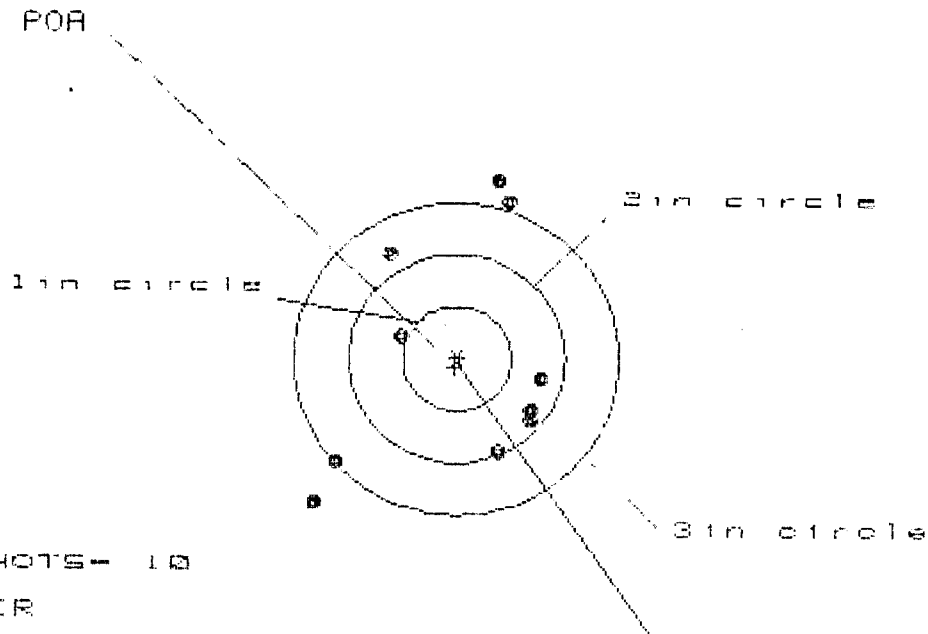
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	1.469	1.401
MINIMUM X	:	-1.256	-1.106	-.923
MAXIMUM Y	:	1.109	.388	.425
MINIMUM Y	:	-.698	-.574	-.537
CENTROID X	:	.236	.086	-.097
CENTROID Y	:	.081	-.043	-.080
POA TO CENTROID in.	:	.249	.096	.126
MIN RADIUS	:	.143	.038	.138
MEAN RADIUS	:	.959	.846	.766
MAX RADIUS	:	1.743	1.499	1.404
HORIZONTAL SPREAD	:	2.600	2.575	2.324
VERTICAL SPREAD	:	1.807	.962	.962
EXTREME SPREAD	:	2.916	2.595	2.325
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06646397.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 6

HS= 2.128

VS= 3.103

GS= 3.553

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.825	.680	.715
MINIMUM X	-1.383	-1.249	-1.211
MAXIMUM Y	1.731	1.579	1.600
MINIMUM Y	-1.372	-1.185	-1.206
CENTROID X	.018	.163	.125
CENTROID Y	.086	.238	.041
POA TO CENTROID in.	.088	.289	.134
MIN RADIUS	.516	.625	.635
MEAN RADIUS	1.197	1.111	1.019
MAX RADIUS	1.892	1.722	1.650
HORIZONTAL SPREAD	2.128	1.929	1.929
VERTICAL SPREAD	3.103	2.764	2.588
EXTREME SPREAD	3.553	3.160	3.052
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		6	