

C6649015

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700™ M24

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

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

SERIAL NO.
C6649015

ORDER NO.
5716

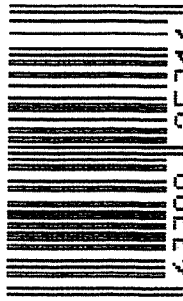
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

0.5



5716 C6649015

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649015

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KA
600	Proof		7/24/91	KA
607	Check Headspace		7/24/91	KA
610	Dis-assemble Gun		7/24/91	KA
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	KA
	Apply Coating (Bolt)		8-27-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KA
	C) Inspect Ejector Hole for Chamfer		9/4/91	KA
	D) Oil Firing Pin Ass'y		9/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9-5-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	7	6			9-5-91	DH
	G) Safety Off Force	3	3	3			9-5-91	DH
	H) Trigger Pull Test & Retainability						9-5-91	DH
	I) Firing Pin Indent	.020	.020	.020			9-5-91	DH
	J) Assemble Stock						9/5/91	KK
	K) Assemble Swivel Studs						9-12-91	A
	L) Attach Front and Rear Sight Assemblies						9/5/91	KK
	M) Iron Sight Alignment						9/5/91	KK
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	KK
	O) Attach Scope to Rifle						9/5/91	KK
	P) Detach & Attach Scope 20 Times						9/5/91	KK
640	Gallery Target & Test						9/6/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/6/91	KT
655	Final Inspection						9-12-91	A
	A) Headspace							
	B) Trigger Pull	2.43	2.52	2.44	2.48	2.40	9/12/91	JH
	C) Function						9-12-91	K
660	Pack						9-12-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6649015

DATE 9-5-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.46	2.60	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.44	2.46	2.52	
PULL #3	2.50	2.44	2.51	2.44	
PULL #4	2.42	2.42	2.32	2.48	
PULL #5	2.51	2.39	2.39	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.25		
PULL #2	3.29	3.25		
PULL #3	3.22	3.25		
PULL #4	3.24	3.25		
PULL #5	3.18	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.15		4.07
PULL #2	4.20	4.39		4.30
PULL #3	4.34	4.46		4.13
PULL #4	4.32	4.23		4.13
PULL #5	4.54	4.25		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649015
7 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.162049
1 TO	2	.331228
1 TO	3	.555993
1 TO	4	.267959
1 TO	5	.289886

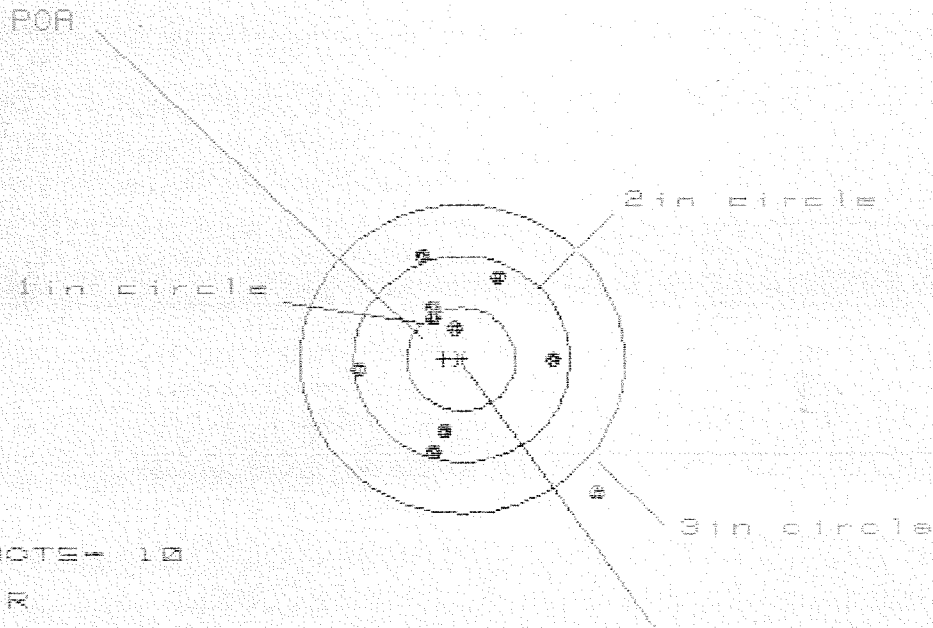
32^{15} <----POA

AVERAGE COORDINATE FOR THIS RIFLE IS: .0468
AVERAGE COORDINATE FOR THIS RIFLE IS: -.05
AVERAGE COORDINATE POI RADIUS FOR THIS RIFLE IS: .000000
AVERAGE COORDINATE FOR THIS RIFLE IS: .8922

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649015

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

HZ CH

110 = 0

210 = 0

310 = 0

IM = 0.100

VS = 0.269

GS = 0.736

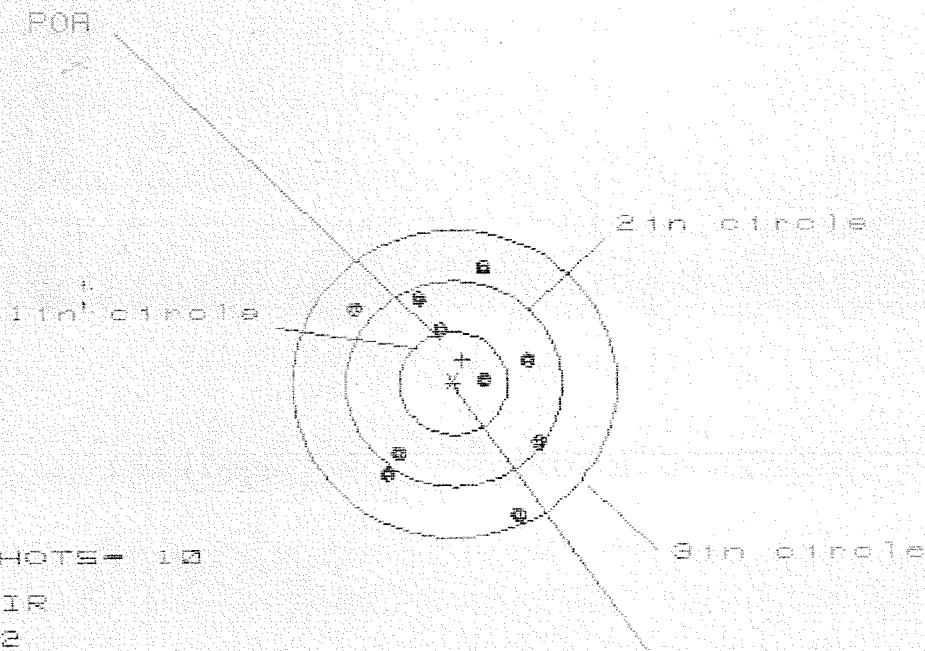
CENTROID #

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.203	.986	.962
MINIMUM X		-.929	-.795	-.819
MAXIMUM Y		.996	.854	.759
MINIMUM Y		-1.273	-1.037	-.930
CENTROID X		.162	.028	.052
CENTROID Y		-.004	.138	.031
POA TO CENTROID in.		.162	.141	.061
MIN RADIUS		.301	.141	.246
MEAN RADIUS		.839	.682	.677
MAX RADIUS		1.752	1.047	.962
HORIZONTAL SPREAD		2.132	1.781	1.781
VERTICAL SPREAD		2.269	1.891	1.689
EXTREME SPREAD		2.736	1.892	1.803
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.636

VS = 2.442

GS = 2.517

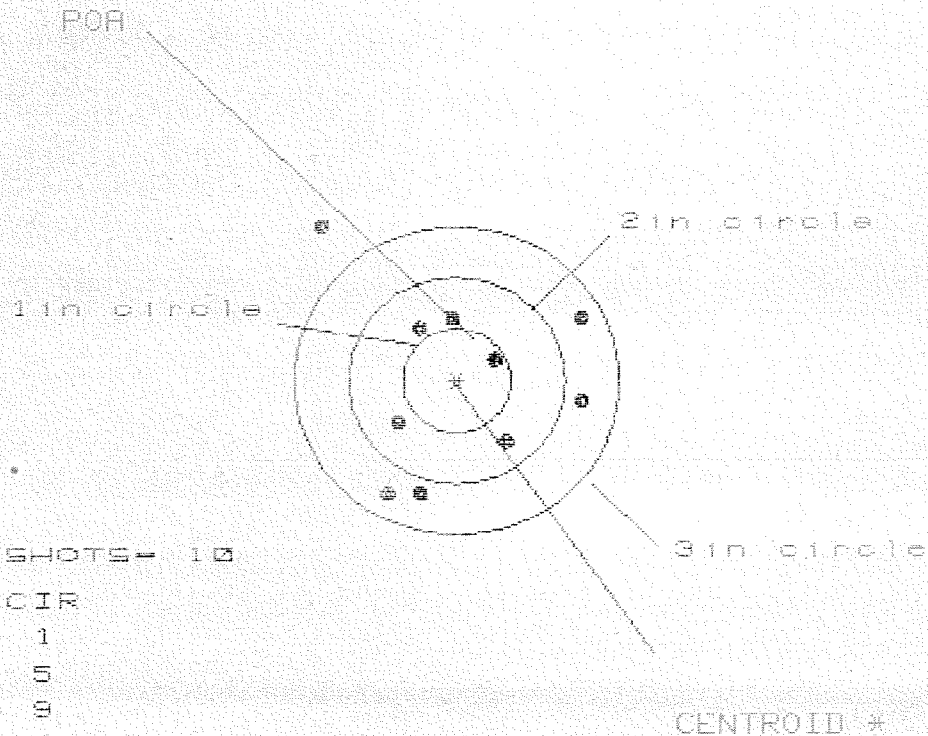
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.740	.800	.695
MINIMUM X	-.896	-.836	-.697
MAXIMUM Y	1.130	.984	1.060
MINIMUM Y	-1.312	-1.033	-.957
CENTROID X	-.082	-.142	-.037
CENTROID Y	-.228	-.082	-.158
POA TO CENTROID in.	.242	.163	.162
MIN RADIUS	.309	.343	.264
MEAN RADIUS	.908	.835	.798
MAX RADIUS	1.419	1.191	1.184
HORIZONTAL SPREAD	1.636	1.636	1.392
VERTICAL SPREAD	2.442	2.017	2.017
EXTREME SPREAD	2.517	2.231	2.231
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.455

VS = 2.591

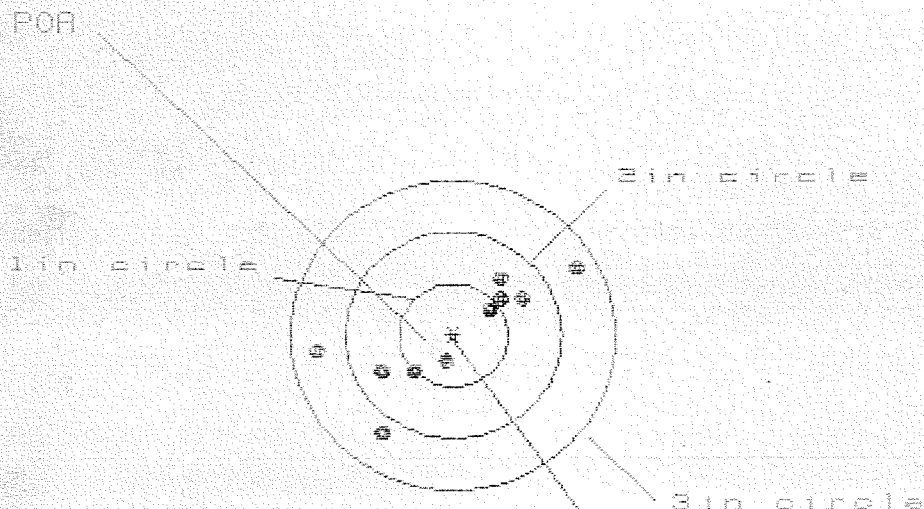
GS = 2.938

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.199	1.060	1.170
MINIMUM X	-1.256	-.779	-.647
MAXIMUM Y	1.456	.795	.849
MINIMUM Y	-1.135	-.974	-.874
CENTROID X	-.356	-.217	-.349
CENTROID Y	-.286	-.367	-.467
POA TO CENTROID in.	.411	.427	.583
MIN RADIUS	.385	.397	.502
MEAN RADIUS	.990	.875	.813
MAX RADIUS	1.923	1.325	1.172
HORIZONTAL SPREAD	2.455	1.839	1.817
VERTICAL SPREAD	2.591	1.769	1.723
EXTREME SPREAD	2.938	2.552	2.048
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

7 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.374

VS= 1.564

GS= 2.505

CENTROID *

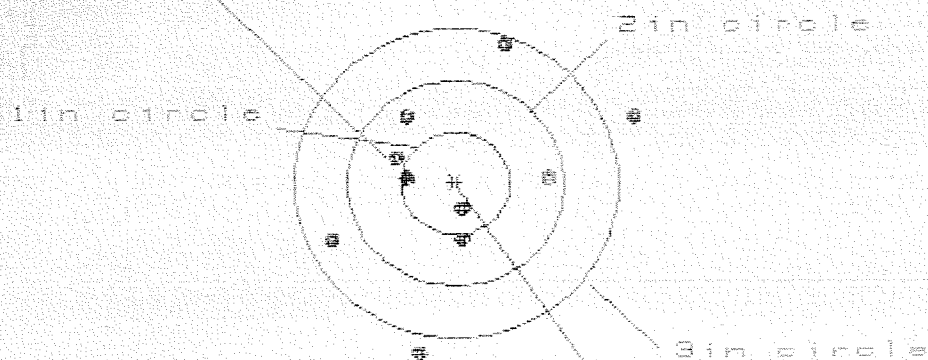
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.147	.803	.665
MINIMUM X	-1.227	-1.099	-.683
MAXIMUM Y	.623	.579	.566
MINIMUM Y	-.941	-.872	-.885
CENTROID X	.063	-.065	-.073
CENTROID Y	.245	.176	.189
POA TO CENTROID in.	.253	.187	.202
MIN RADIUS	.281	.232	.227
MEAN RADIUS	.762	.699	.633
MAX RADIUS	1.306	1.104	1.088
HORIZONTAL SPREAD	2.374	1.902	1.348
VERTICAL SPREAD	1.564	1.451	1.451
EXTREME SPREAD	2.505	1.972	1.826
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

2 Sep 1991

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.785

VS= 2.991

GS= 3.113

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.625	1.025	1.000
MINIMUM X	:	-1.160	-.980	-1.005
MAXIMUM Y	:	1.347	1.422	1.226
MINIMUM Y	:	-1.644	-1.569	-.707
CENTROID X	:	.447	.266	.291
CENTROID Y	:	-.057	-.132	.064
FOR TO CENTROID in.	:	.450	.297	.298
MIN RADIUS	:	.219	.236	.334
MEAN RADIUS	:	.962	.844	.752
MAX RADIUS	:	1.760	1.582	1.381
HORIZONTAL SPREAD	:	2.785	2.005	2.005
VERTICAL SPREAD	:	2.991	2.991	1.933
EXTREME SPREAD	:	3.113	3.113	2.536
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	