

C6636233

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington



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

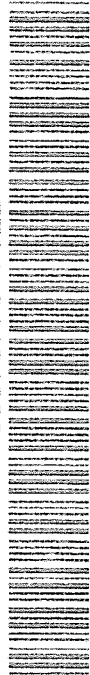
MODEL 700™ M24

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

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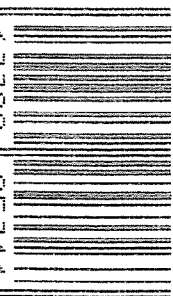
SERIAL NO.
06636233

ORDER NO.
5715



5715 06636233

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636233

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL 1 1991	1 1991	KR
	Magnaflux Bolt	JUL 1 1991	1 1991	KR
615	Rollmark Caliber	JUL 1 1991	1 1991	GS
617	Drill and Tap Sight Holes	JUL 1 1991	1 1991	FB
618	Polish Barrel	JUL 2 1991	2 1991	WB
620	Apply Coatings (Barrel Action)	7-77-91		JA
	Apply Coating (Bolt)			
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		7-6-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 $\frac{3}{4}$	5 $\frac{1}{2}$			9-6-91	DH
	G) Safety Off Force	3 $\frac{1}{4}$	3	3 $\frac{1}{4}$			9-6-91	DH
	H) Trigger Pull Test & Retainability						7-6-91	DH
	I) Firing Pin Indent	.022	.022	.022			7-6-91	DH
	J) Assemble Stock						9/6/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/6/91	RW
	M) Iron Sight Alignment						9/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/91	RW
	O) Attach Scope to Rifle						9/6/91	RW
	P) Detach & Attach Scope 20 Times						9/6/91	RW
640	Gallery Target & Test						9-9-91	DH
	A) Time						9-9-91	DH
	B) Malfunctions						9-9-91	DH
	C) Pierced Primers						9-9-91	DH
	D) Optical Clarity of Scope						9-9-91	DH
645	Inspect for Live Ammo						9-9-91	DH
655	Final Inspection						9-10-91	DH
	A) Headspace							
	B) Trigger Pull	2.11	2.21	2.15	2.12	2.13	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. CCG 36233

DATE 9-6-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.32	2.47	2.11	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.36	2.48	2.21	
PULL #3	2.38	2.33	2.37	2.15	
PULL #4	2.32	2.24	2.38	2.12	
PULL #5	2.31	2.20	2.35	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.56		
PULL #2	3.13	3.30		
PULL #3	3.03	3.38		
PULL #4	2.98	3.01		
PULL #5	3.30	3.02		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.76		4.02
PULL #2	4.34	4.72		4.00
PULL #3	4.47	4.49		4.01
PULL #4	4.46	4.56		4.16
PULL #5	4.38	4.66		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636233
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.224201
1 TO	2	.0817435
1 TO	3	.13222
1 TO	4	.491304
1 TO	5	.251766

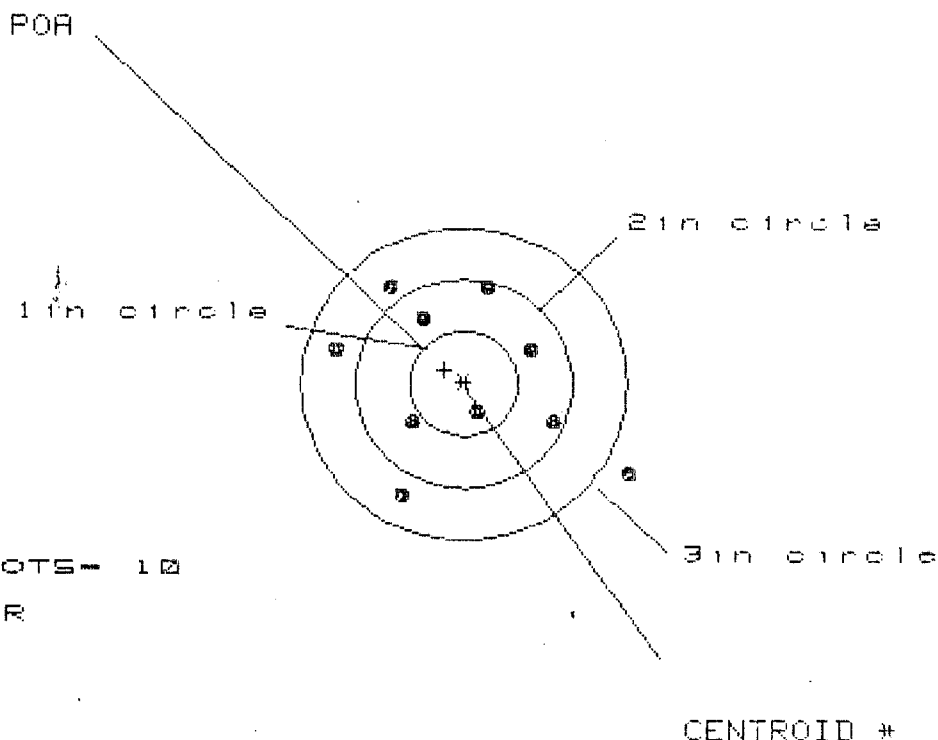
⁴
92 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1316
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .03
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134976
THE AMR FOR THIS RIFLE IS: .9508

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636233

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 9

HS= 2.759

VS= 1.985

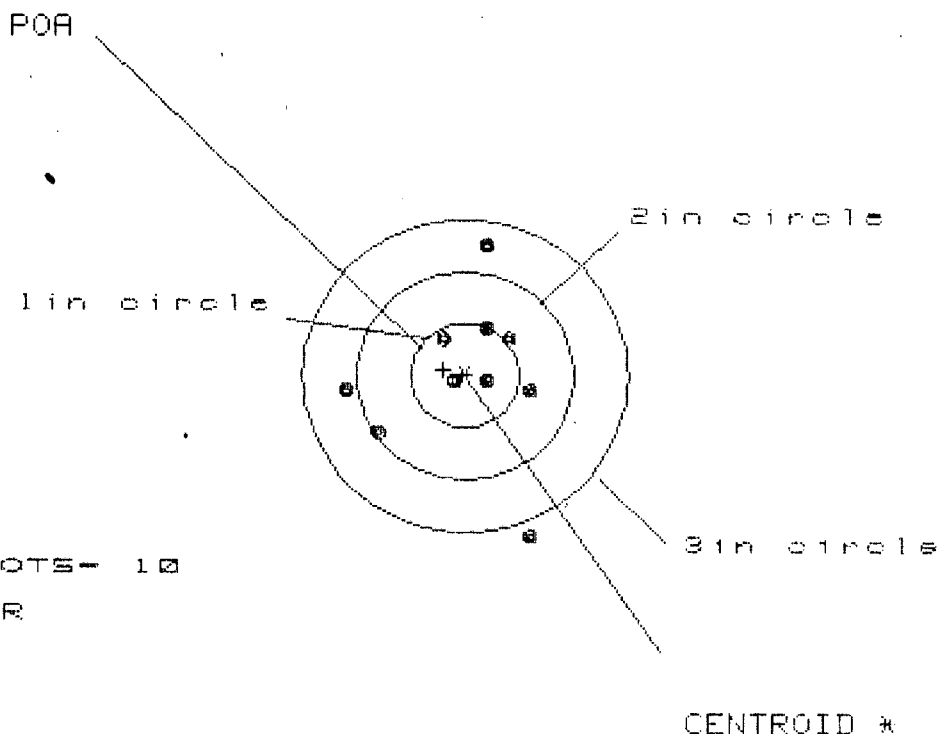
GS= 2.989

PATTERN #	:	23		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.545	.975	.845
MINIMUM X	:	-1.214	-1.043	-.616
MAXIMUM Y	:	.903	.809	.835
MINIMUM Y	:	-1.081	-1.176	-1.150
CENTROID X	:	.179	.008	.138
CENTROID Y	:	-.135	-.040	-.066
POA TO CENTROID in.	:	.224	.041	.153
MIN RADIUS	:	.290	.457	.370
MEAN RADIUS	:	.937	.836	.795
MAX RADIUS	:	1.763	1.238	1.261
HORIZONTAL SPREAD	:	2.759	2.018	1.461
VERTICAL SPREAD	:	1.985	1.985	1.985
EXTREME SPREAD	:	2.989	2.130	2.119
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

9 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.757

VS= 2.800

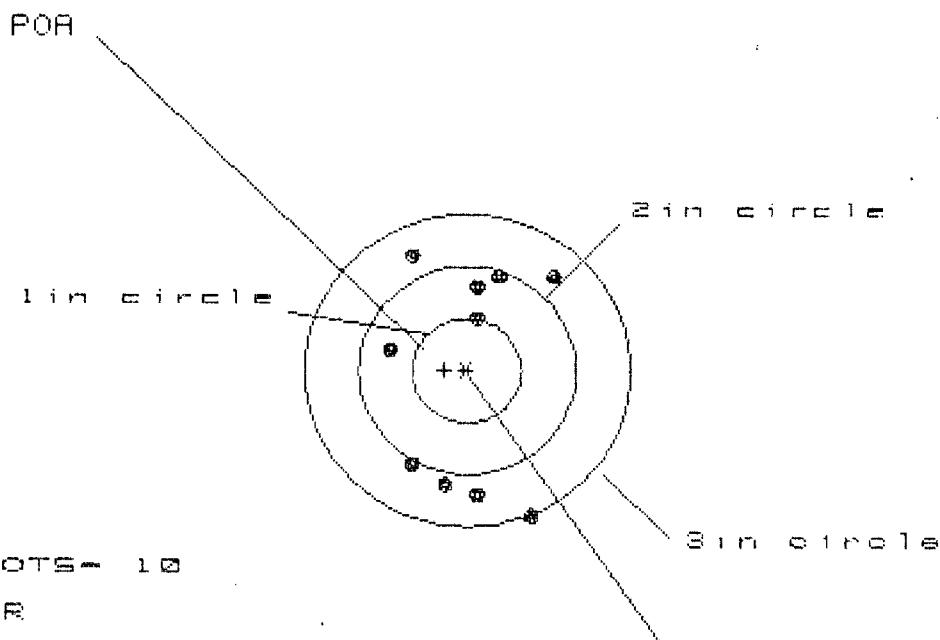
GS= 2.826

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.626	.691	.724
MINIMUM X	-1.131	-1.066	-1.033
MAXIMUM Y	1.284	1.115	.456
MINIMUM Y	-1.516	-.717	-.578
CENTROID X	.200	.136	.103
CENTROID Y	-.056	.112	-.027
POA TO CENTROID in.	.208	.176	.106
MIN RADIUS	.083	.214	.100
MEAN RADIUS	.735	.630	.564
MAX RADIUS	1.624	1.146	1.052
HORIZONTAL SPREAD	1.757	1.757	1.757
VERTICAL SPREAD	2.800	1.832	1.034
EXTREME SPREAD	2.826	2.080	1.758
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 1.508

VS= 2.420

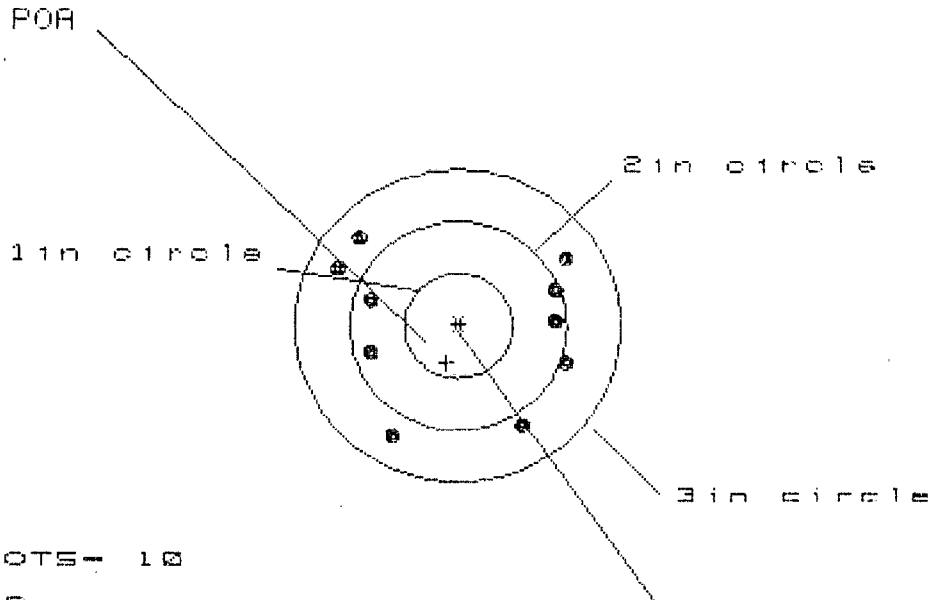
GS= 2.650

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.780	.845	.463
MINIMUM X	-.728	-.663	-.558
MAXIMUM Y	1.063	.913	1.013
MINIMUM Y	-1.357	-1.330	-1.230
CENTROID X	.208	.143	.038
CENTROID Y	-.006	.144	.044
POA TO CENTROID in.	.208	.204	.058
MIN RADIUS	.524	.390	.523
MEAN RADIUS	1.022	.937	.915
MAX RADIUS	1.474	1.345	1.266
HORIZONTAL SPREAD	1.508	1.508	1.021
VERTICAL SPREAD	2.420	2.243	2.243
EXTREME SPREAD	2.650	2.331	2.331
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 10

HS = 2.124

VS = 1.938

GS = 2.415

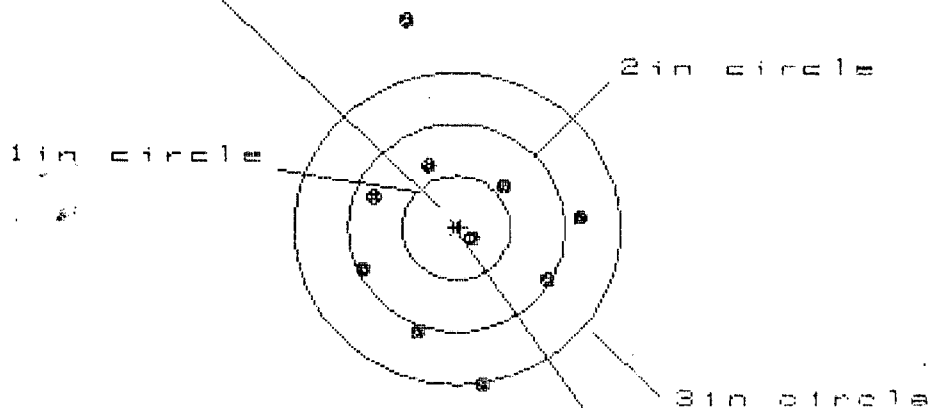
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.874	.718
MINIMUM X	:	-1.146	-1.250	-1.108
MAXIMUM Y	:	.886	.740	.820
MINIMUM Y	:	-1.052	-.954	-.874
CENTROID X	:	.107	.211	.367
CENTROID Y	:	.351	.253	.174
POA TO CENTROID in.	:	.367	.329	.406
MIN RADIUS	:	.793	.792	.655
MEAN RADIUS	:	1.064	1.025	.950
MAX RADIUS	:	1.289	1.401	1.257
HORIZONTAL SPREAD	:	2.124	2.124	1.826
VERTICAL SPREAD	:	1.938	1.694	1.694
EXTREME SPREAD	:	2.415	2.329	2.329
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 1.950

VS = 3.464

GS = 3.543

CENTROID *

PATTERN #	75	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.122	1.067	1.090
MINIMUM X	-.828	-.883	-.860
MAXIMUM Y	1.981	.858	.700
MINIMUM Y	-1.483	-1.263	-.957
CENTROID X	-.036	.019	-.004
CENTROID Y	-.004	-.224	-.066
POA TO CENTROID in.	.036	.225	.066
MIN RADIUS	.182	.164	.128
MEAN RADIUS	.996	.872	.799
MAX RADIUS	2.043	1.277	1.109
HORIZONTAL SPREAD	1.950	1.950	1.950
VERTICAL SPREAD	3.464	2.121	1.657
EXTREME SPREAD	3.543	2.184	2.023
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		