

C6636241

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

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

SERIAL NO.
 C6636241

ORDER NO.
 5716

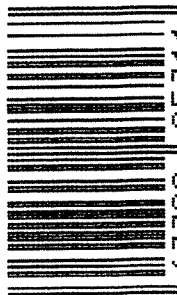
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MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636241

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636241

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KH
600	Proof		6/27/91	KH
607	Check Headspace		6/27/91	KH
610	Dis-assemble Gun		6/27/91	KH
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8/16/91	KH
	Apply Coating (Bolt)		8/16/91	KH
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KH
	C) Inspect Ejector Hole for Chamfer		8/15/91	KH
	D) Oil Firing Pin Ass'y		8/15/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/4			8/16/91	WB
	G) Safety Off Force	2	2	2			8/16/91	WB
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.0225	.022	.022			8/16/91	WB
	J) Assemble Stock						8/16/91	KL
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/16/91	KL
	M) Iron Sight Alignment						8/16/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/16/91	KL
	O) Attach Scope to Rifle						8/16/91	KL
	P) Detach & Attach Scope 20 Times						8/16/91	KL
640	Gallery Target & Test						8-19-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-19-91	AF
655	Final Inspection							
	A) Headspace						9-13-91	KL
	B) Trigger Pull	2.41	2.34	2.40	2.40	2.43	9-13-91	KL
	C) Function						9-13-91	KL
660	Pack						9-19-91	AF

MOD. _____ GA. CAL. _____ GUN # 6241

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
VF	1st	Shaver Brass + Bolt Handle Hits stock	KS
	2nd	NEW EXT. 8/20 Polished face of bolt	KS
	3rd	filed bolt Hold Slat	
	4th		
		FUNCTION	RD 6654 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	
TEST		
TGT		
PROOF	ENGINEER DH	
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. C6636241
DATE 8/16/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.38	2.58	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.37	2.48	2.34	
PULL #3	2.27	2.37	2.56	2.40	
PULL #4	2.37	2.40	2.57	2.40	
PULL #5	2.27	2.41	2.38	2.43	
TOTAL	11.63	11.93	12.57		
AVG.	2.33	2.38	2.51		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.13		
PULL #2	3.05	3.17		
PULL #3	3.09	3.05		
PULL #4	3.08	3.00		
PULL #5	3.07	3.10		
TOTAL	15.33	15.45		
AVG.	3.07	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.00		4.34
PULL #2	4.10	4.21		4.31
PULL #3	4.08	4.15		4.33
PULL #4	4.11	4.11		4.33
PULL #5	4.06	4.16		4.34
TOTAL	20.43	20.63		21.65
AVG.	4.09	4.13		4.33

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 08636241
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.350595
1 TO	2	.48386
1 TO	3	.487003
1 TO	4	.356288
1 TO	5	.471377

1
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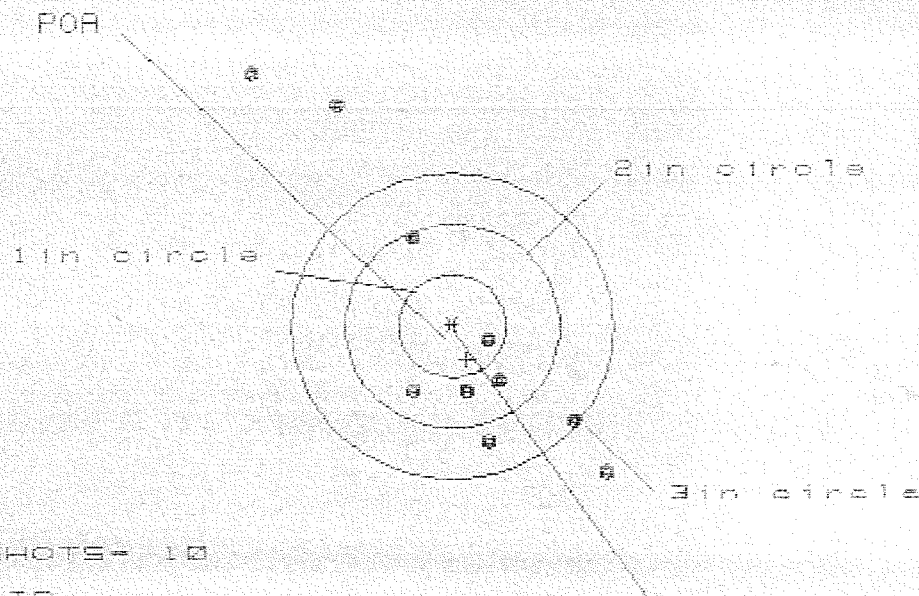
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1094
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0000
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116317

THE RM FOR THIS RIFLE IS: .9982

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C683B241

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

4E= 3.323

VS= 3.922

GS= 5.140

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.420	1.269	1.051
MINIMUM X	:	-1.903	-1.262	-.775
MAXIMUM Y	:	2.522	2.436	1.414
MINIMUM Y	:	-1.400	-1.120	-.815
CENTROID X	:	-.129	.082	.240
CENTROID Y	:	.326	.046	-.259
POA TO CENTROID in.	:	.351	.094	.353
MIN RADIUS	:	.375	.167	.109
MEAN RADIUS	:	1.361	1.028	.732
MAX RADIUS	:	3.159	2.744	1.612
HORIZONTAL SPREAD	:	3.323	2.471	1.826
VERTICAL SPREAD	:	3.922	3.556	2.229
EXTREME SPREAD	:	5.140	4.330	2.881
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0535241

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.019

VS= 1.983

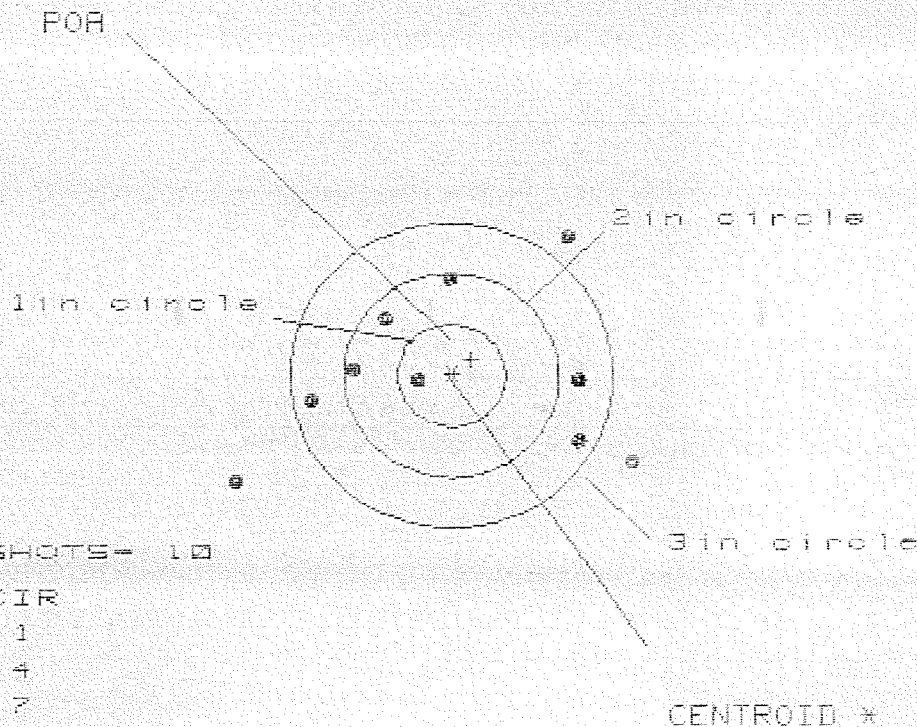
GS= 2.197

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.992	.983	.853
MINIMUM X	-1.027	-1.036	-1.790
MAXIMUM Y	1.370	.459	.401
MINIMUM Y	-.613	-.461	-.414
CENTROID X	-.026	-.017	.113
CENTROID Y	-.157	-.309	-.251
POA TO CENTROID in.	.159	.309	.275
MIN RADIUS	.100	.067	.166
MEAN RADIUS	.676	.585	.522
MAX RADIUS	1.372	1.134	.886
HORIZONTAL SPREAD	2.019	2.019	1.643
VERTICAL SPREAD	1.983	.920	.815
EXTREME SPREAD	2.197	2.097	1.681
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.734

VS= 2.321

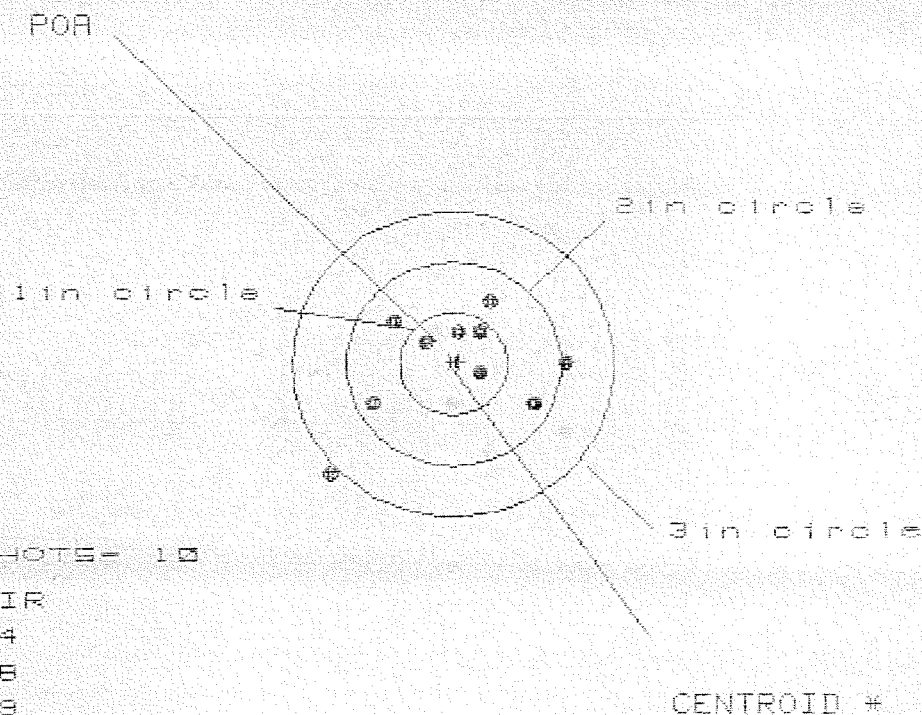
GS= 3.936

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.673	1.444	1.175
MINIMUM X	-2.061	-1.522	-1.341
MAXIMUM Y	1.309	1.197	1.079
MINIMUM Y	-1.012	-0.946	-0.896
CENTROID X	-0.183	0.046	-0.135
CENTROID Y	-0.158	-0.046	0.073
POA TO CENTROID in.	0.242	0.065	0.153
MIN RADIUS	0.312	0.564	0.466
MEAN RADIUS	1.274	1.168	1.056
MAX RADIUS	2.296	1.727	1.519
HORIZONTAL SPREAD	3.734	2.966	2.516
VERTICAL SPREAD	2.321	2.143	1.975
EXTREME SPREAD	3.936	3.029	2.854
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6535241

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.240

VS= 1.691

GS= 2.490

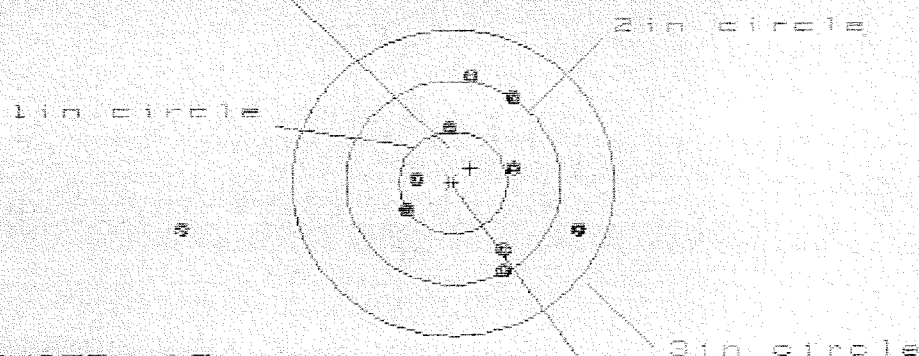
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.092	.965	.728
MINIMUM X	:	-1.148	-.896	-.775
MAXIMUM Y	:	.617	.497	.484
MINIMUM Y	:	-1.074	-.515	-.528
CENTROID X	:	-.044	.083	-.037
CENTROID Y	:	-.020	.100	.113
POA TO CENTROID in.	:	.049	.130	.119
MIN RADIUS	:	.250	.225	.179
MEAN RADIUS	:	.707	.576	.518
MAX RADIUS	:	1.572	1.010	.912
HORIZONTAL SPREAD	:	2.240	1.861	1.504
VERTICAL SPREAD	:	1.691	1.012	1.012
EXTREME SPREAD	:	2.490	1.896	1.527
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635241

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.757

VS= 1.939

GS= 3.757

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	.919	.425
MINIMUM X	-2.554	-.707	-.592
MAXIMUM Y	1.039	.992	.925
MINIMUM Y	-.900	-.947	-1.014
CENTROID X	-.165	.119	.004
CENTROID Y	-.144	-.097	-.030
POA TO CENTROID in.	.219	.153	.031
MIN RADIUS	.355	.285	.378
MEAN RADIUS	.973	.766	.716
MAX RADIUS	2.589	1.061	1.065
HORIZONTAL SPREAD	3.757	1.626	1.017
VERTICAL SPREAD	1.939	1.939	1.939
EXTREME SPREAD	3.757	1.972	1.972
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	