

C6636287

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ N24

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

20

SERIAL NO.
C6636287

ORDER NO.
5716

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



5716 C6636287

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636287

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS.
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/9-91	JA
	Apply Coating (Bolt)		5/9-91	JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/3/91	JA

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	6/3/91	JA
	G) Safety Off Force	4	4	4	6/3/91	JA
	H) Trigger Pull Test & Retainability	6			4/3/91	JA
	I) Firing Pin Indent	.023	.0225	.0225	6/3/91	JA
	J) Assemble Stock				6/4/91	KS
	K) Assemble Swivel Studs				6-13-91	K
	L) Attach Front and Rear Sight Assemblies				6/4/91	KS
	M) Iron Sight Alignment				6/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container				6/4/91	KS
	O) Attach Scope to Rifle				6/4/91	KS
	P) Detach & Attach Scope 20 Times				6/4/91	KS
640	Gallery Target & Test				6/5/91	KT
	A) Time					KT
	B) Malfunctions					KT
	C) Pierced Primers					KT
	D) Optical Clarity of Scope					KT
645	Inspect for Live Ammo				6/5/91	KT
655	Final Inspection					
	A) Headspace				6-13-91	A
	B) Trigger Pull	2.72	2.65	2.64	6-13-91	JA
	C) Function				6-13-91	A
660	Pack				6-20-91	AF

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Ejector stick	KS
	2nd	6/17/91 POLISHED EJECTOR	KS
	3rd	100 Rd test June 12, 1991	OK
	4th		

FUNCTION RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 k.l test June 12, 1991	KS
TEST AC		
TGT		
PROOF		
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. C-6636287

DATE 6-3-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.49	2.42	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.34	2.38	2.65	
PULL #3	2.35	2.31	2.30	2.64	
PULL #4	2.48	2.34	2.26	2.72	
PULL #5	2.42	2.31	2.25	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.33		
PULL #2	3.34	3.31		
PULL #3	3.33	3.32		
PULL #4	3.34	3.33		
PULL #5	3.32	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.54		4.54
PULL #2	4.15	4.50		4.51
PULL #3	4.18	4.54		4.56
PULL #4	4.54	4.55		4.23
PULL #5	4.52	4.53		4.59
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636287
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.232691
1 TO	2	.43666
1 TO	3	.0383275
1 TO	4	.236409
1 TO	5	.340918

9/3 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0228
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0848
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0876116
THE AMR FOR THIS RIFLE IS: 1.112

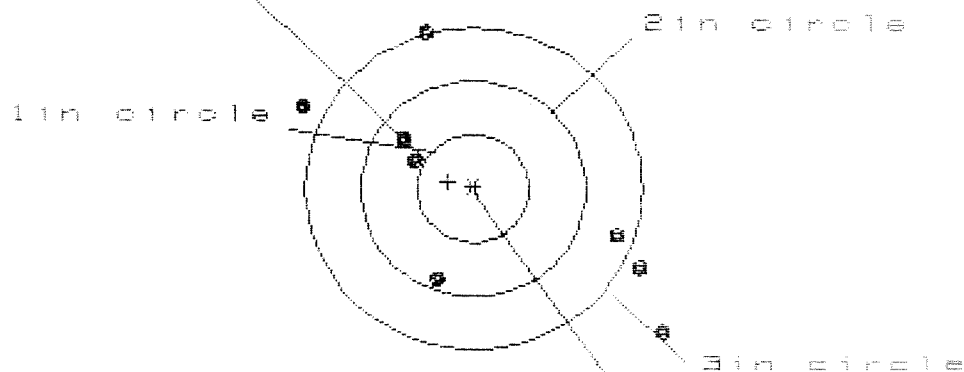
5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636287

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 3.249

VS= 4.558

GS= 4.621

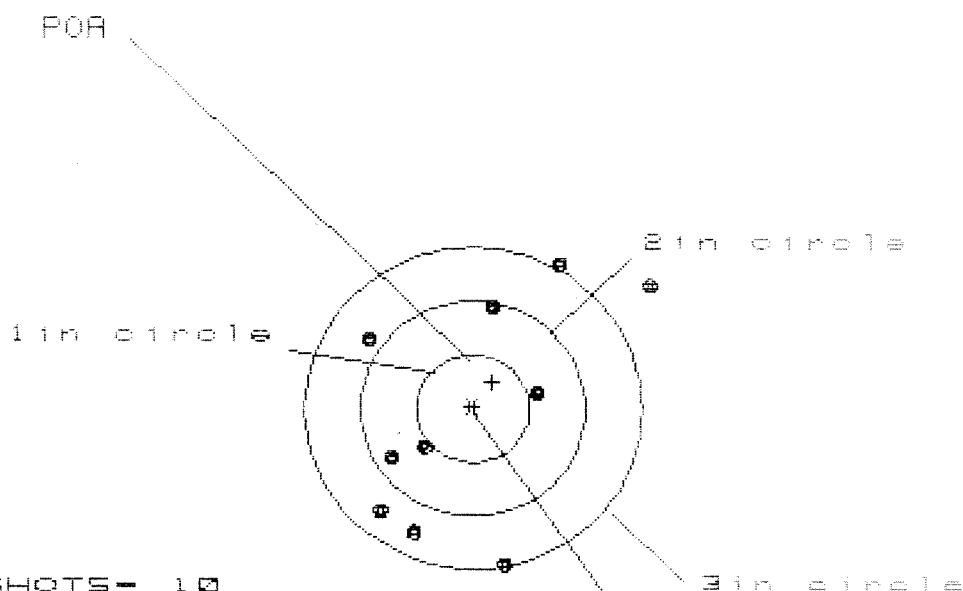
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.789	1.617	1.605
MINIMUM X	:	-1.540	-1.632	-1.429
MAXIMUM Y	:	2.506	1.700	1.565
MINIMUM Y	:	-2.053	-1.774	-1.909
CENTROID X	:	.224	.316	.113
CENTROID Y	:	-.063	-.341	-.206
POA TO CENTROID in.	:	.232	.465	.235
MIN RADIUS	:	.601	.717	.602
MEAN RADIUS	:	1.537	1.411	1.306
MAX RADIUS	:	2.638	1.945	1.912
HORIZONTAL SPREAD	:	3.249	3.249	3.034
VERTICAL SPREAD	:	4.558	3.474	3.474
EXTREME SPREAD	:	4.621	3.854	3.483
NUMBER IN ONE INCH CIRCLE	=	1	3	5
NUMBER IN TWO INCH CIRCLE	=	3	5	5
NUMBER IN THREE INCH CIRCLE	=	5	5	5

5 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.531

VS= 2.840

GS= 3.189

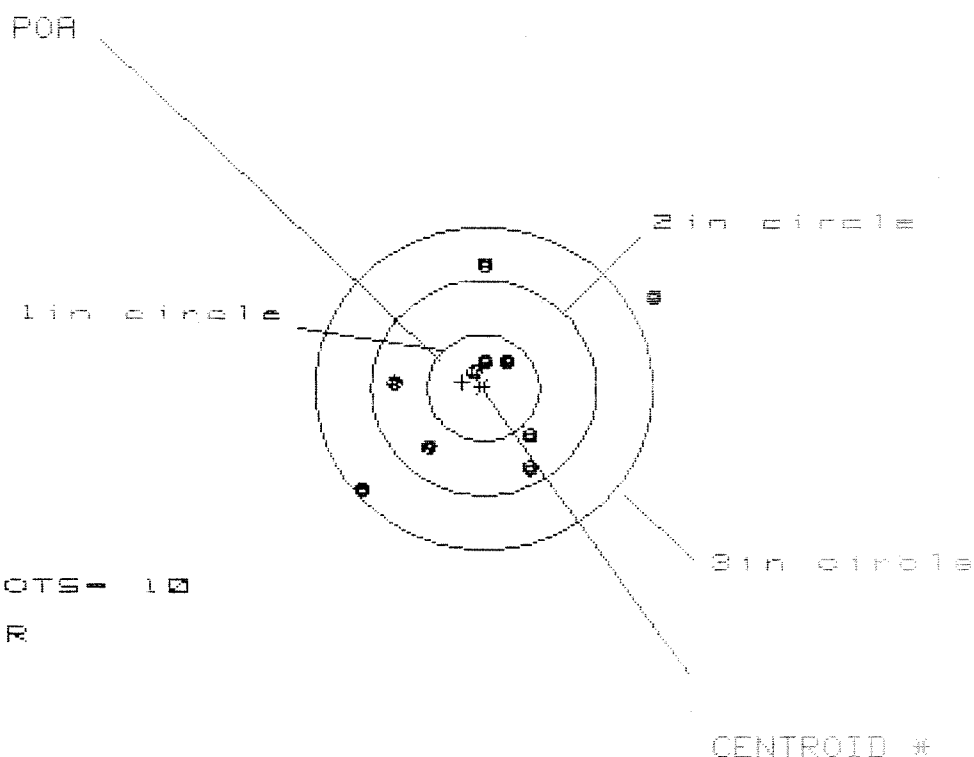
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.620	.934	.870
MINIMUM X	:	-.911	-.731	-.614
MAXIMUM Y	:	1.395	1.523	1.251
MINIMUM Y	:	-1.445	-1.317	-1.127
CENTROID X	:	-.172	-.352	-.469
CENTROID Y	:	-.247	-.375	-.565
POA TO CENTROID in.	:	.301	.514	.734
MIN RADIUS	:	.564	.343	.168
MEAN RADIUS	:	1.159	1.024	.873
MAX RADIUS	:	1.985	1.786	1.352
HORIZONTAL SPREAD	:	2.531	1.665	1.484
VERTICAL SPREAD	:	2.840	2.840	2.378
EXTREME SPREAD	:	3.189	2.887	2.409
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Jun 1981

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.578

VS = 2.053

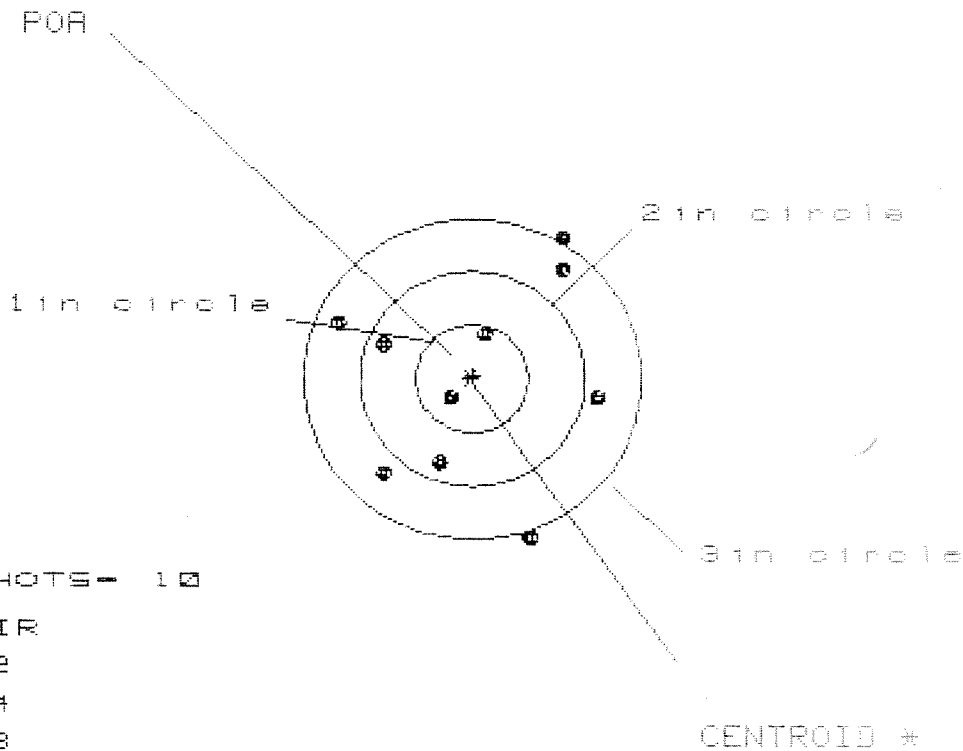
GS = 3.129

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.483	.585	.468
MINIMUM X	:	-1.095	-.930	-.784
MAXIMUM Y	:	1.155	1.253	1.153
MINIMUM Y	:	-.897	-.800	-.719
CENTROID X	:	.187	.022	.139
CENTROID Y	:	-.053	-.151	-.051
POA TO CENTROID in.	:	.195	.152	.148
MIN RADIUS	:	.153	.211	.121
MEAN RADIUS	:	.809	.715	.618
MAX RADIUS	:	1.722	1.261	1.153
HORIZONTAL SPREAD	:	2.578	1.515	1.253
VERTICAL SPREAD	:	2.053	2.053	1.872
EXTREME SPREAD	:	3.129	2.317	1.921
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.281

VS= 2.884

GS= 2.884

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.080	1.174	1.249
MINIMUM X	:	-1.201	-1.107	-1.032
MAXIMUM Y	:	1.369	1.172	1.001
MINIMUM Y	:	-1.515	-1.363	-0.875
CENTROID X	:	-0.009	-0.103	-0.178
CENTROID Y	:	-0.023	-0.175	-0.004
POA TO CENTROID in.	:	.024	.203	.178
MIN RADIUS	:	.299	.131	.236
MEAN RADIUS	:	1.040	.951	.875
MAX RADIUS	:	1.609	1.490	1.368
HORIZONTAL SPREAD	:	2.281	2.281	2.281
VERTICAL SPREAD	:	2.884	2.535	1.876
EXTREME SPREAD	:	2.904	2.622	2.453
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 8

HS = 1.548

VS = 3.378

GS = 3.443

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.731
MINIMUM X	-.817
MAXIMUM Y	1.522
MINIMUM Y	-1.856
CENTROID X	-.116
CENTROID Y	-.038
POA TO CENTROID in.	.122
MIN RADIUS	.552
MEAN RADIUS	1.015
MAX RADIUS	1.968
HORIZONTAL SPREAD	1.548
VERTICAL SPREAD	3.378
EXTREME SPREAD	3.443
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8