

C6636293

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

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

MODEL 700™ M24

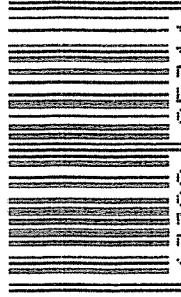
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

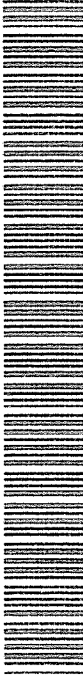
SERIAL NO.
C6636293

ORDER NO.
5716

UPC



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5716 C6636293

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636293**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	EB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	PA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-10-91	DH
	G) Safety Off Force	2	2	2			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	JK
	I) Firing Pin Indent	.022	.021	.020			8-10-91	DH
	J) Assemble Stock						8/13/91	KA
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/13/91	KA
	M) Iron Sight Alignment						8/13/91	KA
	N) Detach Front & Rear Sights & place in numbered container						8/13/91	KA
	O) Attach Scope to Rifle						8/13/91	KA
	P) Detach & Attach Scope 20 Times						8/13/91	KA
640	Gallery Target & Test						8-14-91	DH
	A) Time						8-14-91	DH
	B) Malfunctions						8-14-91	DH
	C) Pierced Primers						8-14-91	DH
	D) Optical Clarity of Scope						8-14-91	DH
645	Inspect for Live Ammo						8-14-91	DH
655	Final Inspection						8-15-91	DH
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.53	2.47	2.55	2.50	2.48	8-14-91	JK
	C) Function						8-15-91	DH
660	Pack						8-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6636293

DATE 8-10-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.48	2.50	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.42	2.48	2.47	
PULL #3	2.48	2.40	2.44	2.55	
PULL #4	2.48	2.58	2.52	2.50	
PULL #5	2.58	2.60	2.55	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.21		
PULL #2	3.23	3.60		
PULL #3	3.20	3.27		
PULL #4	3.15	3.20		
PULL #5	3.26	3.34		
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	4.38		4.42
PULL #2	4.23	4.54		4.54
PULL #3	4.15	4.44		4.51
PULL #4	4.60	4.50		4.50
PULL #5	4.32	4.49		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636293
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.468001
1 TO	2	1.03757
1 TO	3	.694112
1 TO	4	.830663
1 TO	5	.283863

24.7×10^5 <----POA

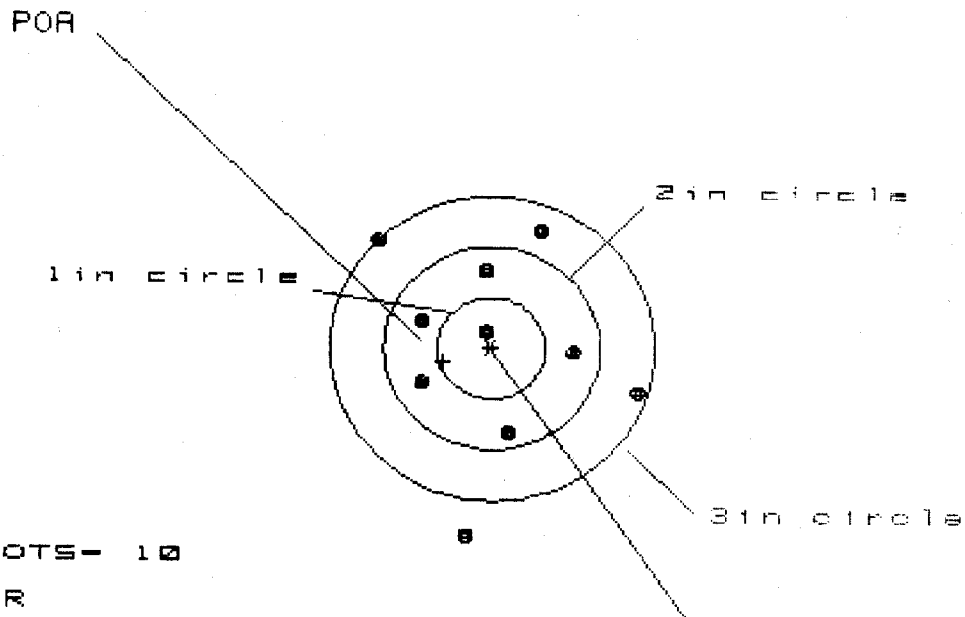
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0100
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0771564

THE AMR FOR THIS RIFLE IS: .8384

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636293

CENTERFIRE PATTERNS # 1



+ OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.345

VS= 2.955

GS= 3.047

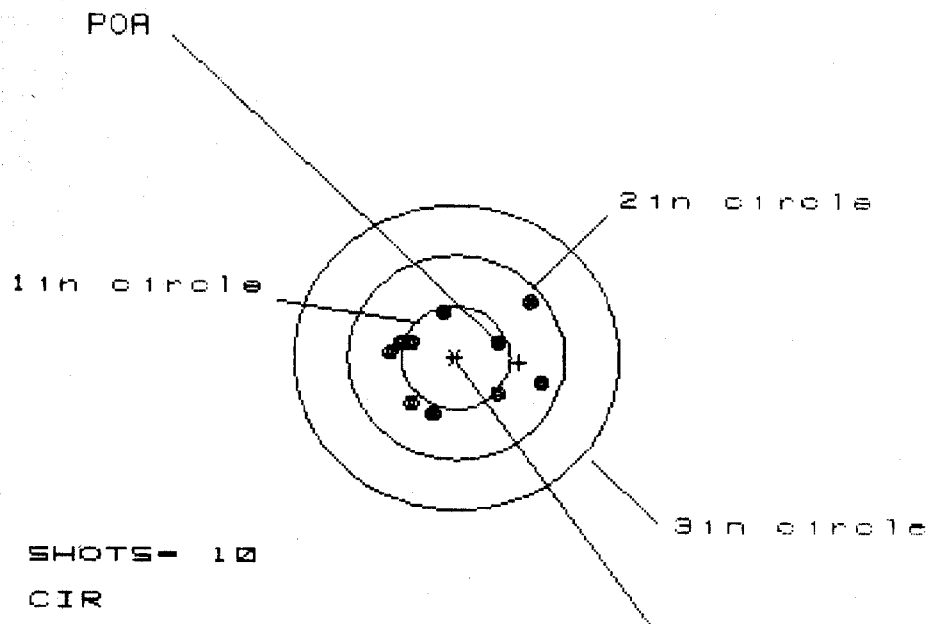
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.323	1.295	1.164
MINIMUM X	-1.022	-1.050	-.831
MAXIMUM Y	1.160	.961	1.076
MINIMUM Y	-1.795	-.997	-.883
CENTROID X	.449	.477	.608
CENTROID Y	.132	.331	.216
POA TO CENTROID in.	.468	.580	.645
MIN RADIUS	.131	.116	.217
MEAN RADIUS	.988	.878	.822
MAX RADIUS	1.811	1.443	1.276
HORIZONTAL SPREAD	2.345	2.345	1.995
VERTICAL SPREAD	2.955	1.958	1.958
EXTREME SPREAD	3.047	2.812	2.100
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

22 Aug 1991

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CENTERFIRE PATTERNS # 2



* OF SHOTS- 10

* IN CIR

1in = 3

2in = 10

3in = 10

HS= 1.418

VS= 1.059

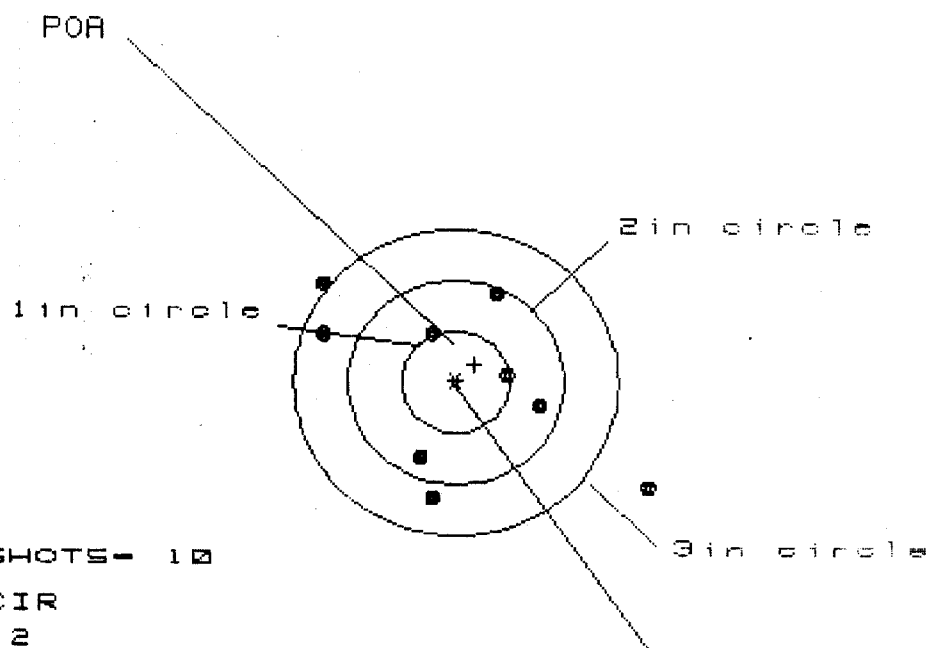
GS= 1.473

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.777	.853	.608
MINIMUM X	:	-.641	-.565	-.458
MAXIMUM Y	:	.548	.546	.527
MINIMUM Y	:	-.511	-.450	-.469
CENTROID X	:	-.585	-.661	-.768
CENTROID Y	:	.046	-.015	.004
POA TO CENTROID in.	:	.587	.661	.768
MIN RADIUS	:	.438	.396	.298
MEAN RADIUS	:	.593	.549	.488
MAX RADIUS	:	.875	.867	.668
HORIZONTAL SPREAD	:	1.418	1.418	1.066
VERTICAL SPREAD	:	1.059	.996	.996
EXTREME SPREAD	:	1.473	1.450	1.136
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.018

VS= 2.119

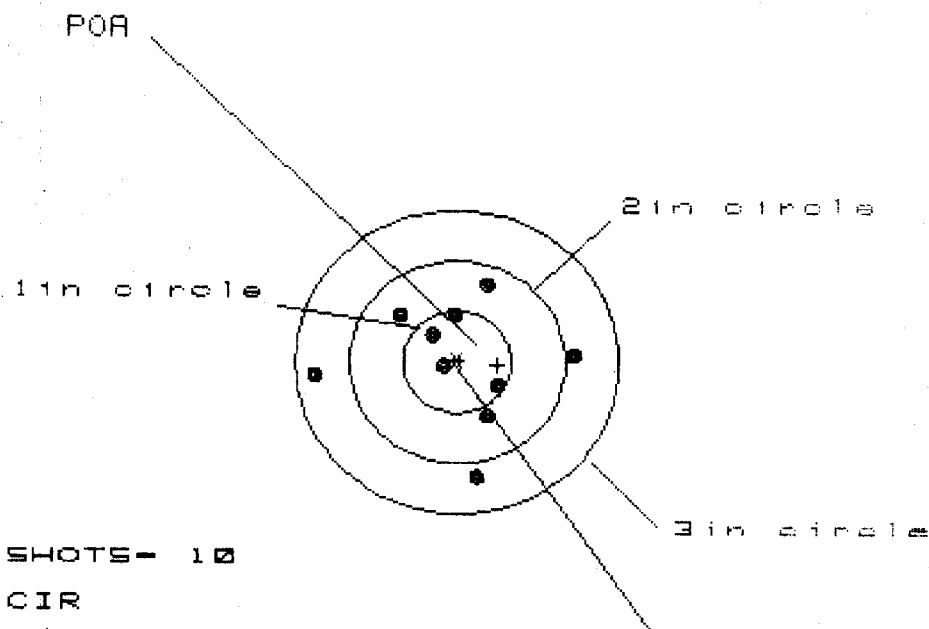
GS= 3.624

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.754	.983	.849
MINIMUM X	:	-1.264	-1.069	-1.125
MAXIMUM Y	:	.947	.829	.823
MINIMUM Y	:	-1.172	-1.290	-1.186
CENTROID X	:	-.175	-.370	-.236
CENTROID Y	:	-.172	-.054	-.158
POA TO CENTROID in.	:	.245	.374	.284
MIN RADIUS	:	.475	.310	.439
MEAN RADIUS	:	1.017	.880	.818
MAX RADIUS	:	2.049	1.353	1.229
HORIZONTAL SPREAD	:	3.018	2.052	1.974
VERTICAL SPREAD	:	2.119	2.119	2.009
EXTREME SPREAD	:	3.624	2.385	2.121
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	6	6	6
NUMBER IN THREE INCH CIRCLE	=	8	8	8

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.273

VS= 1.888

GS= 2.386

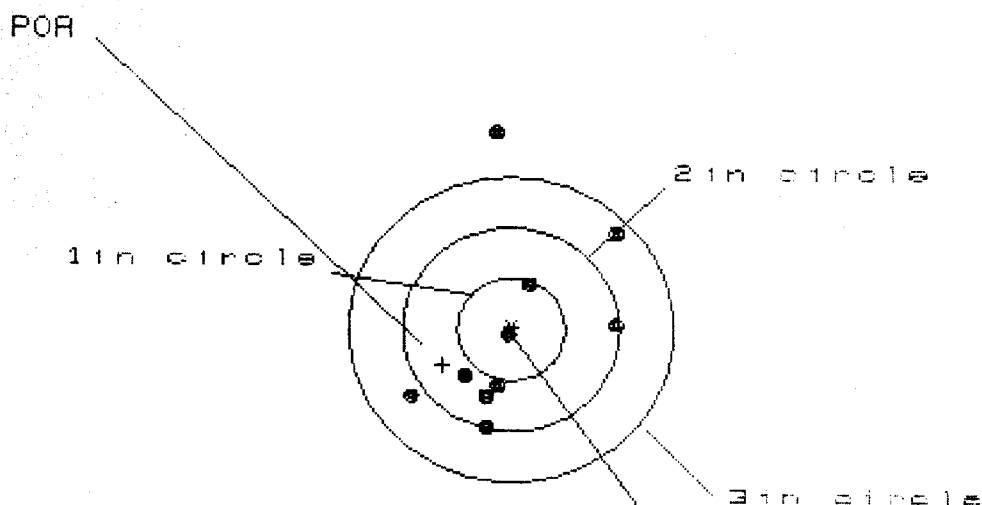
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.074	.929	.933
MINIMUM X	-1.299	-.626	-.621
MAXIMUM Y	.757	.742	.599
MINIMUM Y	-1.132	-1.146	-.724
CENTROID X	-.375	-.230	-.234
CENTROID Y	.027	.042	.185
POA TO CENTROID in.	.376	.234	.299
MIN RADIUS	.175	.294	.324
MEAN RADIUS	.701	.634	.556
MAX RADIUS	1.306	1.147	.935
HORIZONTAL SPREAD	2.373	1.555	1.555
VERTICAL SPREAD	1.888	1.888	1.323
EXTREME SPREAD	2.386	1.891	1.598
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.875

VS= 2.929

GS= 2.931

CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.960	1.077
MINIMUM X	:	-.899	-.915	-.798
MAXIMUM Y	:	1.940	1.198	.826
MINIMUM Y	:	-.989	-.774	-.624
CENTROID X	:	.632	.648	.531
CENTROID Y	:	.349	.134	-.016
POA TO CENTROID in.	:	.722	.662	.531
MIN RADIUS	:	.101	.148	.148
MEAN RADIUS	:	.893	.730	.581
MAX RADIUS	:	1.945	1.523	1.142
HORIZONTAL SPREAD	:	1.875	1.875	1.875
VERTICAL SPREAD	:	2.929	1.972	1.450
EXTREME SPREAD	:	2.931	2.492	2.000
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	