

C6636308

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

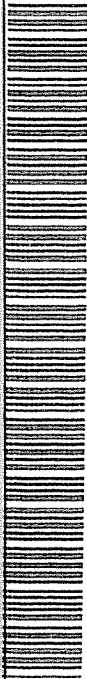
Capacity

Order No. **5716**

*Includes 1 in chamber.

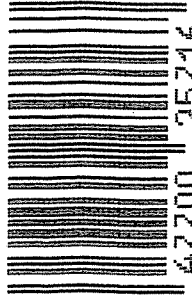


Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6636308	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6636308

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636308

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	9 1	Rw
600	Proof	4 30	9 1	Rw
607	Check Headspace	4 30	9 1	Rw
610	Dis-assemble Gun	4 30	9 1	Rw
612	Magnaflux Barrel Action	5 6 9	1	KCR
	Magnaflux Bolt	5 6 9	1	KCR
615	Rollmark Caliber	5 6 9	1	68
617	Drill and Tap Sight Holes	5 10 9	1	B
618	Polish Barrel	5 10 9	1	W B
620	Apply Coatings (Barrel Action)		5/30/91	TH
	Apply Coating (Bolt)		5/30/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			6-13-91	DH
	G) Safety Off Force	3	3	3			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.021	.020	.020			6-13-91	DH
	J) Assemble Stock						6-14-91	RW
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-14-91	RW
	M) Iron Sight Alignment						6-14-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-14-91	RW
	O) Attach Scope to Rifle						6-14-91	RW
	P) Detach & Attach Scope 20 Times						6-14-91	RW
640	Gallery Target & Test						6-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-14-91	NF
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.36	2.36	2.40	2.46	2.50	6-15-91	RW
	C) Function						6-15-91	DH
660	Pack						6-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636308

DATE 6-13-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.14	2.26	2.53	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.13	2.19	2.55	2.36	
PULL #3	2.15	2.20	2.42	2.40	
PULL #4	2.18	2.21	2.40	2.46	
PULL #5	2.12	2.17	2.53	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.11		
PULL #2	3.11	3.00		
PULL #3	3.11	3.08		
PULL #4	3.04	2.96		
PULL #5	3.04	3.09		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.39		4.28
PULL #2	4.24	4.00		4.13
PULL #3	4.26	4.31		4.28
PULL #4	4.02	4.31		4.22
PULL #5	4.20	4.34		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636308
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.145798
1 TO	2	.0516236
1 TO	3	.446126
1 TO	4	.179778
1 TO	5	.202032

3

<----POA

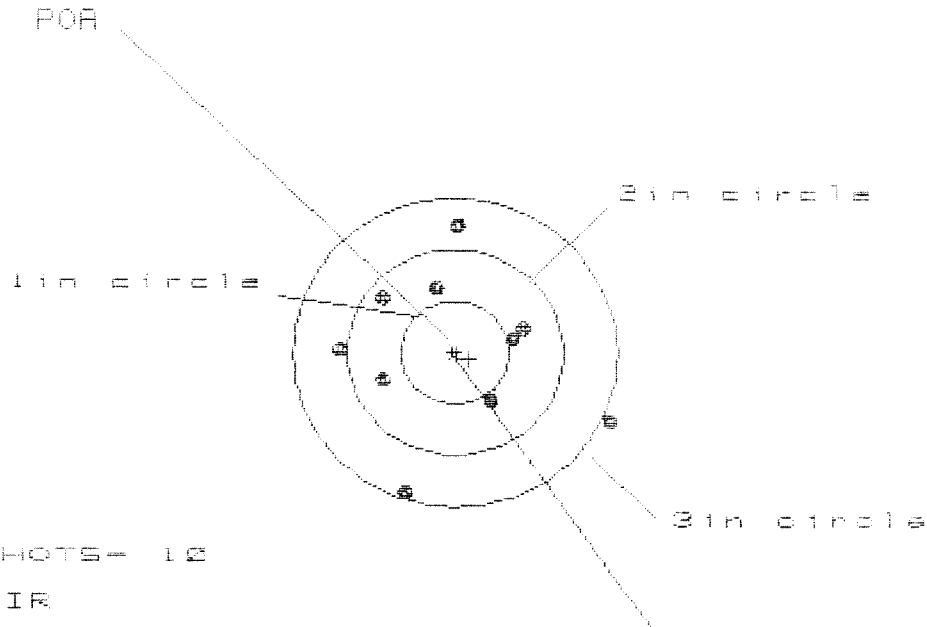
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0382
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0604
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0714661

THE AMR FOR THIS RIFLE IS: 1.012

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636308

CENTERFIRE PATTERNS # 1



OF SHOTS= 12

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 2.522

VS= 2.552

GS= 2.612

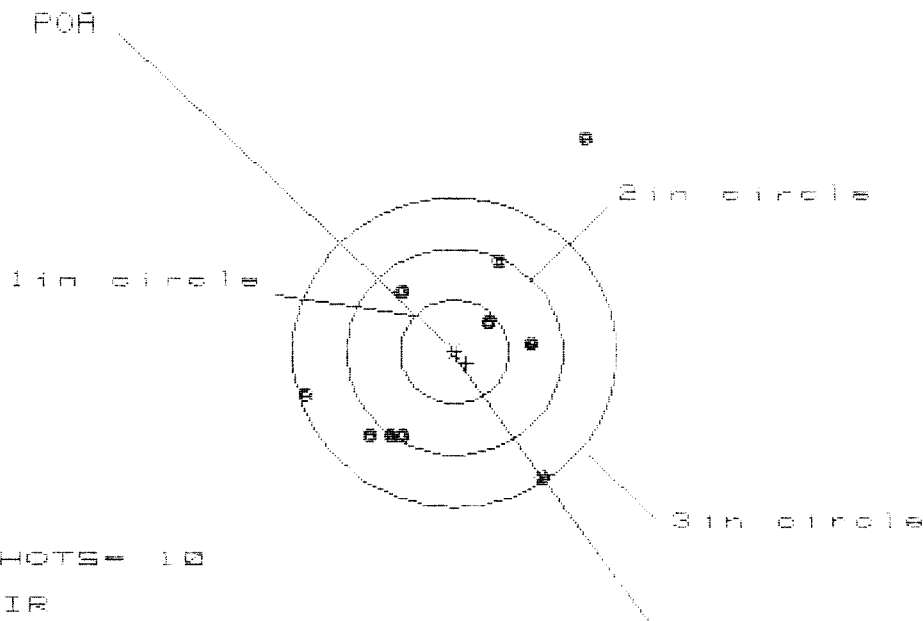
CENTROID +

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.445	.792	.757
MINIMUM X	:	-1.077	-.917	-.952
MAXIMUM Y	:	1.192	1.123	.944
MINIMUM Y	:	-1.360	-1.429	-.739
CENTROID X	:	-.131	-.291	-.256
CENTROID Y	:	.064	.133	.312
POA TO CENTROID in.	:	.146	.320	.403
MIN RADIUS	:	.584	.527	.352
MEAN RADIUS	:	.932	.849	.749
MAX RADIUS	:	1.573	1.457	.971
HORIZONTAL SPREAD	:	2.522	1.789	1.789
VERTICAL SPREAD	:	2.552	2.552	1.603
EXTREME SPREAD	:	2.612	2.599	1.715
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.532

VS= 3.298

GS= 3.670

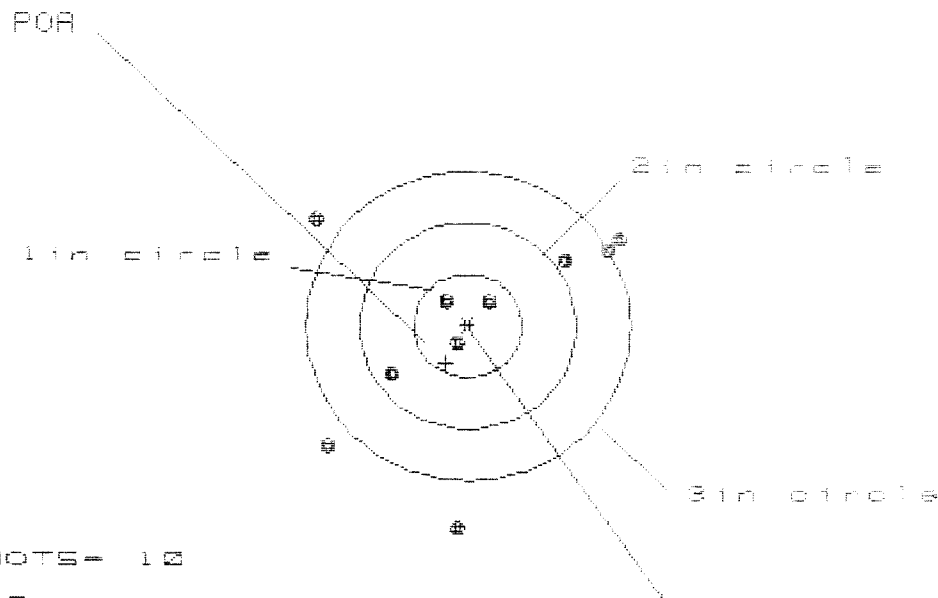
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.250	.953	.798
MINIMUM X	:	-1.382	-1.243	-.783
MAXIMUM Y	:	2.133	1.107	1.083
MINIMUM Y	:	-1.165	-.928	-.952
CENTROID X	:	-.112	-.251	-.096
CENTROID Y	:	.112	-.125	-.101
POA TO CENTROID in.	:	.159	.280	.139
MIN RADIUS	:	.454	.618	.599
MEAN RADIUS	:	1.123	.949	.905
MAX RADIUS	:	2.472	1.330	1.242
HORIZONTAL SPREAD	:	2.632	2.196	1.581
VERTICAL SPREAD	:	3.298	2.035	2.035
EXTREME SPREAD	:	3.670	2.318	2.178
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HS= 2.847

VS= 2.945

GS= 3.378

CENTROID #

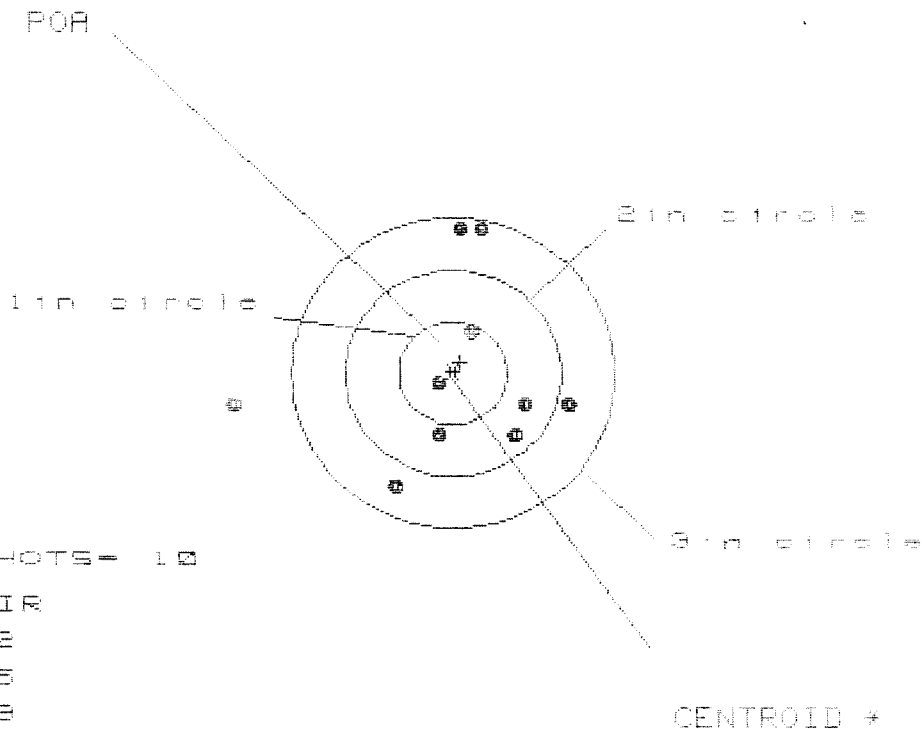
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.439	1.429	1.252
MINIMUM X	:	-1.403	-1.418	-1.493
MAXIMUM Y	:	1.005	.790	.729
MINIMUM Y	:	-1.940	-1.339	-1.240
CENTROID X	:	.201	.211	.388
CENTROID Y	:	.362	.577	.479
POA TO CENTROID in.	:	.414	.614	.616
MIN RADIUS	:	.154	.192	.117
MEAN RADIUS	:	1.120	1.016	.933
MAX RADIUS	:	1.942	1.877	1.941
HORIZONTAL SPREAD	:	2.847	2.847	2.745
VERTICAL SPREAD	:	2.945	2.129	1.969
EXTREME SPREAD	:	3.378	3.378	3.378
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

14 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 3.118

VS= 2.524

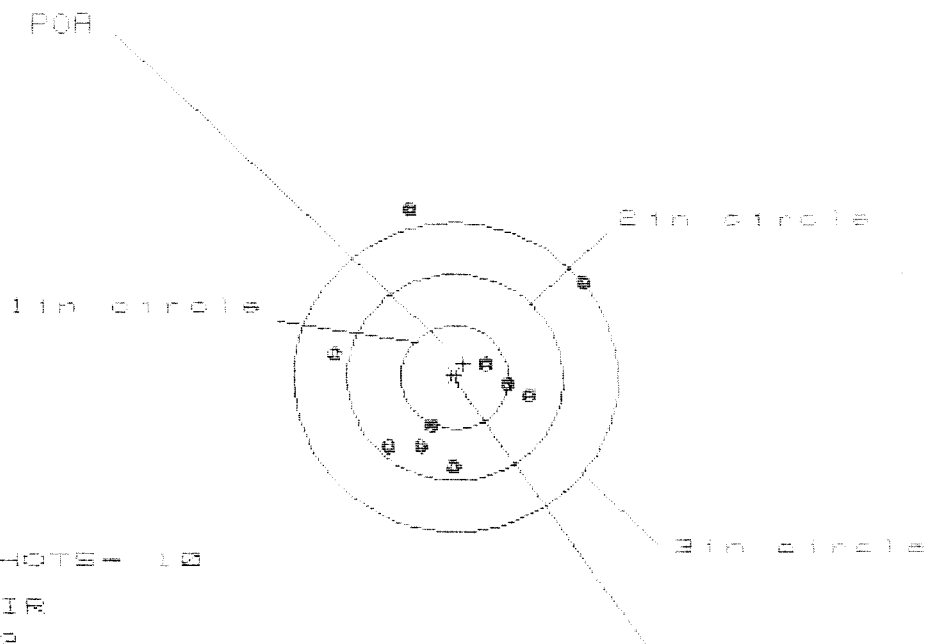
GS= 3.118

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	.841	.845
MINIMUM X	:	-2.050	-.752	-.748
MAXIMUM Y	:	1.402	1.374	1.537
MINIMUM Y	:	-1.122	-1.150	-.979
CENTROID X	:	-.067	.160	.156
CENTROID Y	:	-.104	-.076	-.247
POA TO CENTROID in.	:	.124	.177	.292
MIN RADIUS	:	.132	.347	.326
MEAN RADIUS	:	1.000	.862	.769
MAX RADIUS	:	2.066	1.377	1.547
HORIZONTAL SPREAD	:	3.118	1.593	1.593
VERTICAL SPREAD	:	2.524	2.524	2.516
EXTREME SPREAD	:	3.118	2.645	2.582
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1981

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN ONE

IN TWO

IN THREE

MIN = 0.000

VAR = 0.450

STD = 0.660

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.192	1.141	.763
MINIMUM X	:	-1.070	-1.121	-.578
MAXIMUM Y	:	1.626	1.142	.519
MINIMUM Y	:	-.866	-.685	-.542
CENTROID X	:	-.082	-.031	-.173
CENTROID Y	:	-.132	-.313	-.455
POR TO CENTROID in.	:	.156	.314	.487
MIN RADIUS	:	.323	.386	.185
MEAN RADIUS	:	.884	.752	.612
MAX RADIUS	:	1.690	1.614	1.108
HORIZONTAL SPREAD	:	2.262	2.262	1.742
VERTICAL SPREAD	:	2.492	1.827	1.862
EXTREME SPREAD	:	2.538	2.462	1.778
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	