

CE648922

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700TM M24

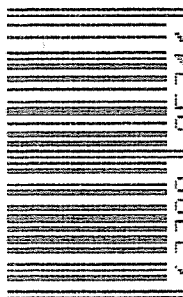
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6648922

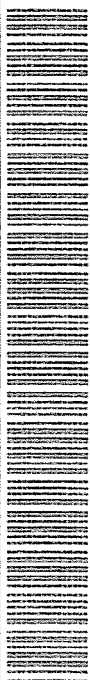
ORDER NO.
5716

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LPC



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5716 C6648922

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648922

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-2-91	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5 1/2			8-12-91	DH
	G) Safety Off Force	3	3	3			8-12-91	DH
	H) Trigger Pull Test & Retainability						8-12-91	JU
	I) Firing Pin Indent	.021	.020	.021			8-12-91	DH
	J) Assemble Stock						8-12-91	RW
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8-12-91	RW
	M) Iron Sight Alignment						8-12-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-12-91	RW
	O) Attach Scope to Rifle						8-12-91	RW
	P) Detach & Attach Scope 20 Times						8-12-91	RW
640	Gallery Target & Test						8-12-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-12-91	NF
655	Final Inspection							
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.63	2.54	2.54	2.51	2.56	8-13-91	JU
	C) Function						8-13-91	DH
660	Pack						9-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6648922

DATE 8-10-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.46	2.50	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.36	2.53	2.54	
PULL #3	2.45	2.51	2.49	2.54	
PULL #4	2.42	2.53	2.51	2.51	
PULL #5	2.39	2.49	2.55	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.57		
PULL #2	3.23	3.22		
PULL #3	3.22	3.45		
PULL #4	3.17	3.43		
PULL #5	3.21	3.37		
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	4.52		4.51
PULL #2	4.21	4.27		4.54
PULL #3	4.20	4.48		4.54
PULL #4	4.55	4.50		4.50
PULL #5	4.49	4.48		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6648922

112 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.295495
1 TO	2	.139004
1 TO	3	.0480104
1 TO	4	.06
1 TO	5	.258822

4 (----POA

1. AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1058

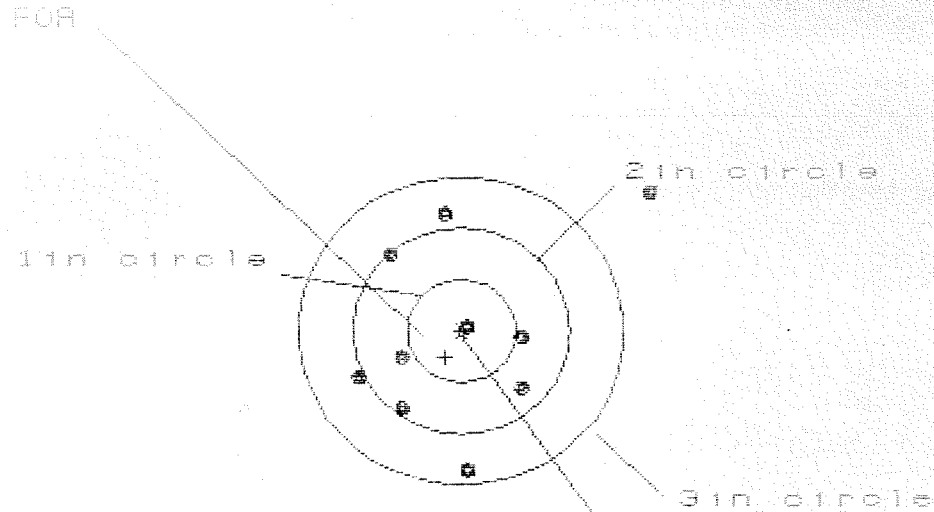
2. AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1796

3. AVERAGE POI RADIUS FOR THIS RIFLE IS: .209446

4. AVERAGE THIS RIFLE IS: .9736

FILE:/PATTERNING/CENTERFIRE_PATT/C854B922

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HE= 2.749

VS= 2.740

GS= 3.278

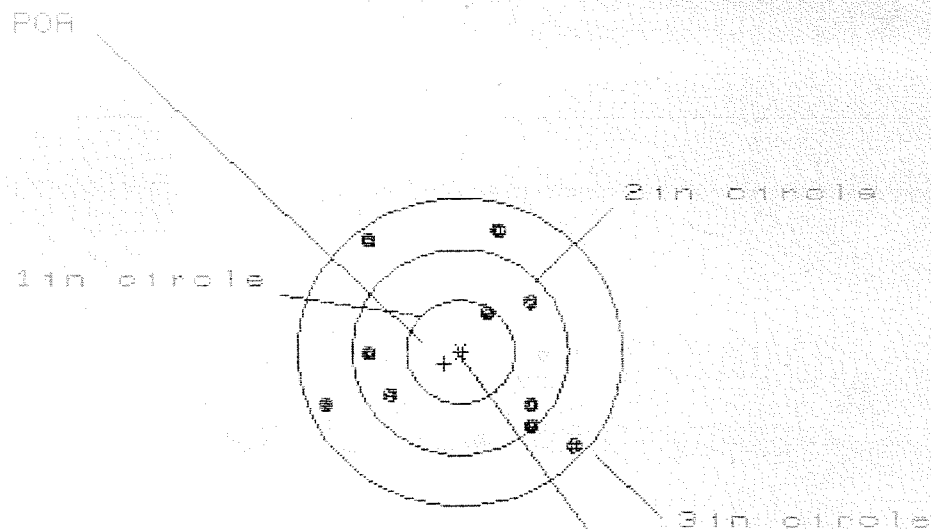
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.788	.720	.752
MINIMUM X	:	-.961	-.762	-.730
MAXIMUM Y	:	1.377	1.300	1.152
MINIMUM Y	:	-1.363	-1.210	-.779
CENTROID X	:	.151	-.048	-.080
CENTROID Y	:	.254	.101	.252
FOR TO CENTROID in.	:	.295	.112	.265
MIN RADIUS	:	.063	.314	.282
MEAN RADIUS	:	.982	.823	.768
MAX RADIUS	:	2.257	1.306	1.158
HORIZONTAL SPREAD	:	2.749	1.482	1.482
VERTICAL SPREAD	:	2.740	2.513	1.931
EXTREME SPREAD	:	3.278	2.519	1.990
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	9	9	9

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.290

VS= 2.024

GS= 2.731

CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	.954	.694
MINIMUM X	-1.240	-1.336	-1.216
MAXIMUM Y	1.151	1.271	1.177
MINIMUM Y	-.873	-.753	-.726
CENTROID X	.150	.246	.126
CENTROID Y	.115	-.005	.089
POA TO CENTROID in.	.189	.246	.154
MIN RADIUS	.474	.531	.509
MEAN RADIUS	1.002	.948	.911
MAX RADIUS	1.380	1.399	1.319
HORIZONTAL SPREAD	2.290	2.290	1.910
VERTICAL SPREAD	2.024	2.024	1.903
EXTREME SPREAD	2.731	2.315	2.290
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.249

VS= 2.809

GS= 2.831

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.999

.924

.948

MINIMUM X

-1.250

-1.325

-1.301

MAXIMUM Y

1.839

1.783

.526

MINIMUM Y

-.978

-.765

-.553

CENTROID X

.179

.254

.238

CENTROID Y

.215

.010

-.202

POA TO CENTROID in.

.279

.255

.307

MIN RADIUS

.442

.438

.452

MEAN RADIUS

1.092

.951

.841

MAX RADIUS

1.962

1.714

1.382

HORIZONTAL SPREAD

2.249

2.249

2.249

VERTICAL SPREAD

2.809

2.468

1.079

EXTREME SPREAD

2.831

2.793

2.339

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

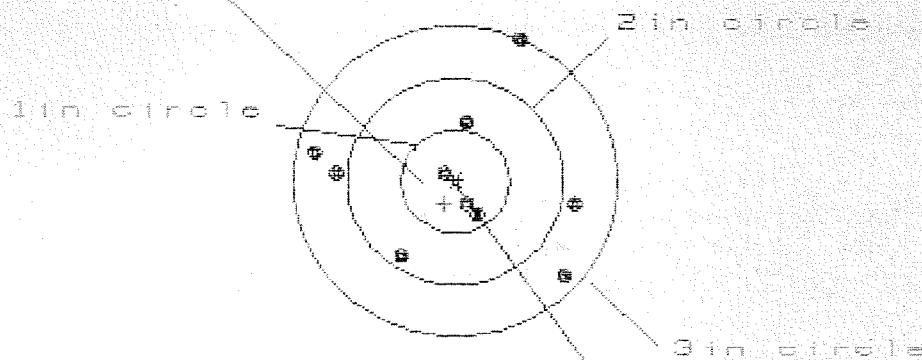
18 Aug 1991

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CENTERFIRE PATTERNS

4

POR



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.409

VS = 2.365

GS = 2.715

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.057	1.126	1.265
MINIMUM X	:	-1.352	-1.283	-1.144
MAXIMUM Y	:	1.413	.713	.614
MINIMUM Y	:	-.952	-.795	-.615
CENTROID X	:	.103	.034	-.105
CENTROID Y	:	.218	.061	.161
POR TO CENTROID in.	:	.241	.070	.192
MIN RADIUS	:	.111	.181	.210
MEAN RADIUS	:	.874	.789	.728
MAX RADIUS	:	1.543	1.372	1.279
HORIZONTAL SPREAD	:	2.409	2.409	2.409
VERTICAL SPREAD	:	2.365	1.508	1.228
EXTREME SPREAD	:	2.715	2.715	2.476
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS= 3.154

VS= 2.347

GS= 3.470

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.962
MINIMUM X	-2.192
MAXIMUM Y	.899
MINIMUM Y	-1.448
CENTROID X	-.054
CENTROID Y	.096
POA TO CENTROID in.	.110
MIN RADIUS	.320
MEAN RADIUS	.918
MAX RADIUS	2.311
HORIZONTAL SPREAD	3.154
VERTICAL SPREAD	2.347
EXTREME SPREAD	3.470
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	8