

C6611679

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

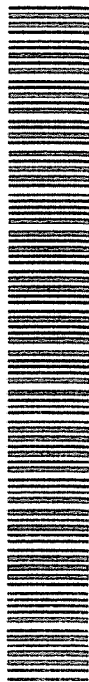
MODEL 700™ M24

SERIAL NO.
C6611679

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5716

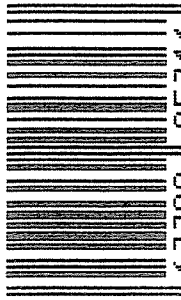
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611679

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611679

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	K.R.
	Magnaflux Bolt		"	"
615	Rollmark Caliber		"	G.S.
617	Drill and Tap Sight Holes	APR 3 1991		K.B.
618	Polish Barrel	APR 3 1991		W.B.
620	Apply Coatings (Barrel Action)		4-19-91	T.A.
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/1/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/1/91	K.S.
	D) Oil Firing Pin Ass'y		5/1/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5-15-91	J.H.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-15-91	JK
	G) Safety Off Force	4	4	4			5/15/91	JK
	H) Trigger Pull Test & Retainability						5/15/91	JK
	I) Firing Pin Indent	.022	.022	.022			5-15-91	JK
	J) Assemble Stock						5/15/91	KS
	K) Assemble Swivel Studs						5-20-91	DH
	L) Attach Front and Rear Sight Assemblies						5/15/91	KS
	M) Iron Sight Alignment						5/15/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/15/91	KS
	O) Attach Scope to Rifle						5/15/91	KS
	P) Detach & Attach Scope 20 Times						5/15/91	KS
640	Gallery Target & Test						5/16/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/16/91	KT
655	Final Inspection							
	A) Headspace						5-20-91	DH
	B) Trigger Pull	2.33	2.18	2.33	2.33	2.31	5-20-91	JK
	C) Function						5-20-91	DH
660	Pack						6-18-91	KS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611679

DATE 5-15-91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.34	2.30	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.20	2.46	2.18	
PULL #3	2.45	2.42	2.42	2.33	
PULL #4	2.46	2.42	2.38	2.33	
PULL #5	2.49	2.40	2.38	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.49		
PULL #2	3.23	3.44		
PULL #3	3.39	3.46		
PULL #4	3.44	3.50		
PULL #5	3.39	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.51		4.32
PULL #2	4.43	4.50		4.29
PULL #3	4.43	4.56		4.45
PULL #4	4.55	4.54		4.53
PULL #5	4.27	4.30		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611679
16 May 1991

CENTROIDAL DISTANCES

0 TO 1	.183003
1 TO 2	.160378
1 TO 3	.425212
1 TO 4	.353193
1 TO 5	.537208

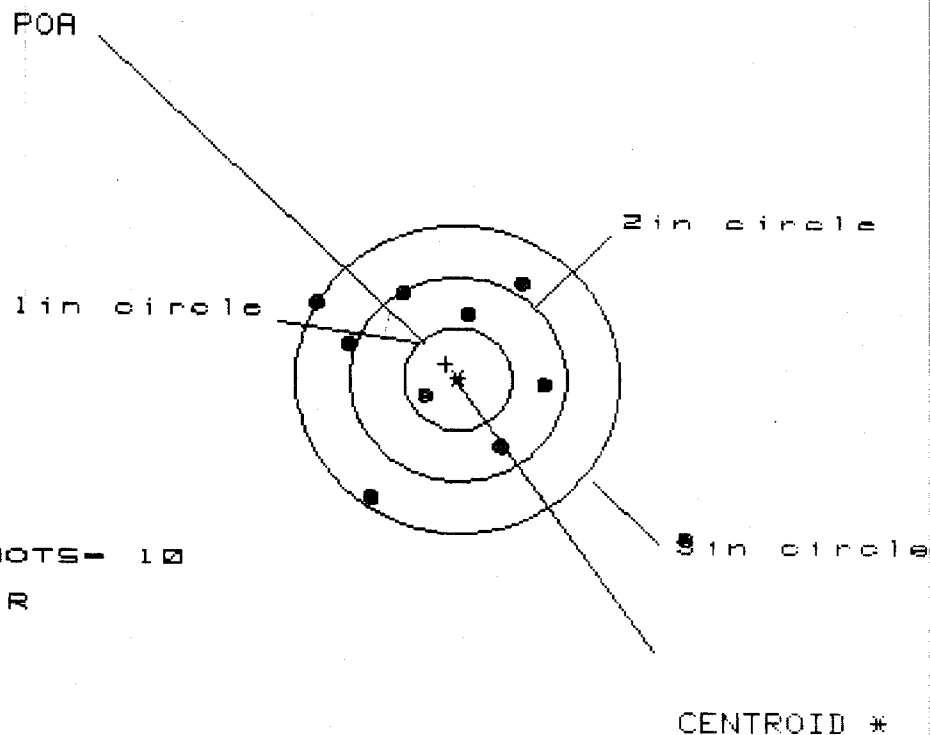
53
44 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.043
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0924
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101915
THE AMR FOR THIS RIFLE IS: 1.071

16 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611679

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.477

VS= 2.494

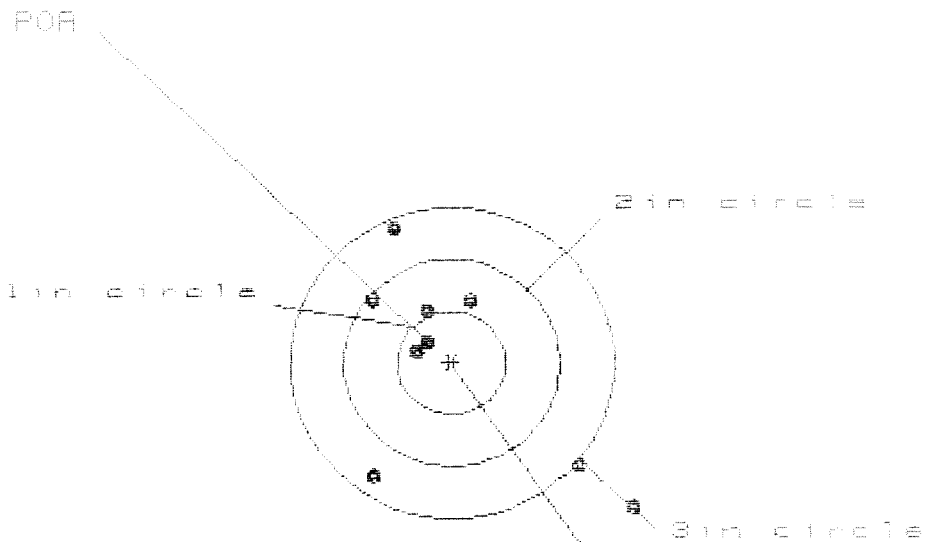
GS= 4.158

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.123	1.010	.871
MINIMUM X	:	-1.354	-1.118	-.888
MAXIMUM Y	:	.951	.779	.850
MINIMUM Y	:	-1.543	-1.298	-1.227
CENTROID X	:	.109	-.127	.012
CENTROID Y	:	-.147	.025	-.046
POA TO CENTROID in.	:	.182	.130	.048
MIN RADIUS	:	.363	.307	.329
MEAN RADIUS	:	1.127	.919	.873
MAX RADIUS	:	2.625	1.436	1.440
HORIZONTAL SPREAD	:	3.477	2.128	1.759
VERTICAL SPREAD	:	2.494	2.077	2.077
EXTREME SPREAD	:	4.158	2.541	2.541
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

16 May 1991

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CENTERFIRE PATTERNS # 2



* OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

45 = 2.435

VS = 2.670

CS = 3.434

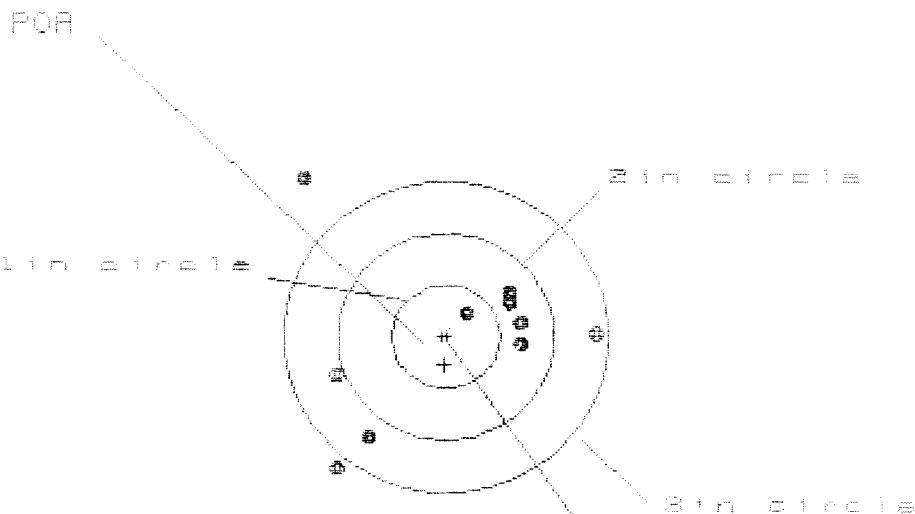
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.664	1.352	.555
MINIMUM X	:	-.771	-.586	-.417
MAXIMUM Y	:	1.264	1.108	.967
MINIMUM Y	:	-1.405	-1.280	-1.421
CENTROID X	:	.029	-.156	-.325
CENTROID Y	:	-.008	.149	.290
POA TO CENTROID in.	:	.030	.216	.436
MIN RADIUS	:	.316	.081	.133
MEAN RADIUS	:	.954	.697	.532
MAX RADIUS	:	2.178	1.762	1.465
HORIZONTAL SPREAD	:	2.435	1.938	.972
VERTICAL SPREAD	:	2.670	2.388	2.388
EXTREME SPREAD	:	3.434	2.788	2.390
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

16 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.775

VS = 2.722

GS = 3.133

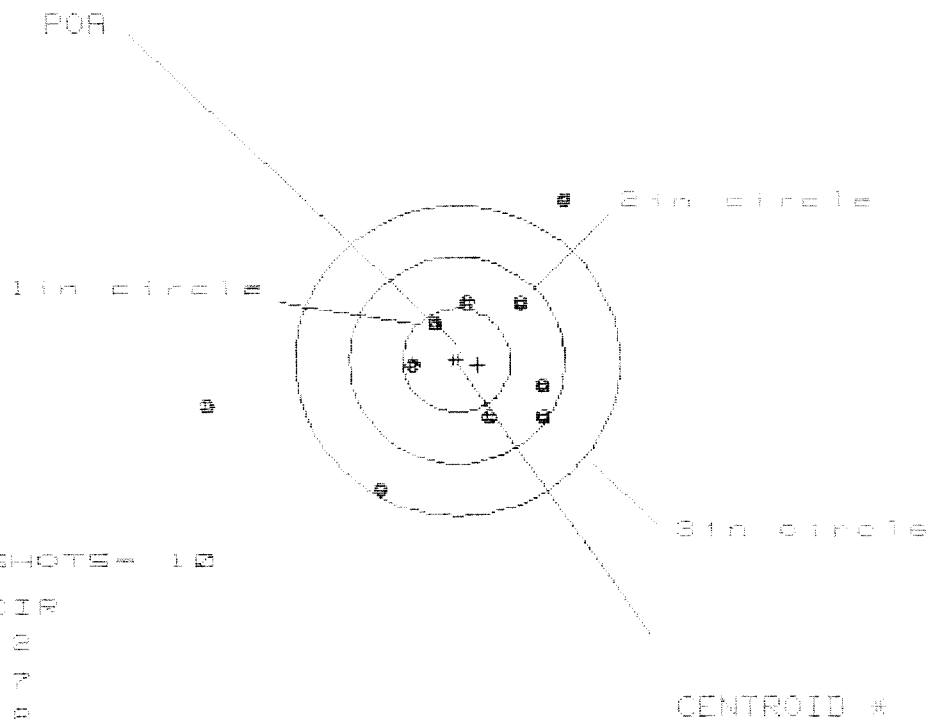
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.418	1.267	1.117
MINIMUM X	:	-1.357	-1.199	-1.327
MAXIMUM Y	:	1.490	.585	.452
MINIMUM Y	:	-1.232	-1.067	-.937
CENTROID X	:	.012	.163	.313
CENTROID Y	:	.267	.102	.235
POA TO CENTROID in.	:	.268	.192	.391
MIN RADIUS	:	.286	.411	.318
MEAN RADIUS	:	1.048	.919	.755
MAX RADIUS	:	2.015	1.605	1.386
HORIZONTAL SPREAD	:	2.775	2.466	2.444
VERTICAL SPREAD	:	2.722	1.652	1.359
EXTREME SPREAD	:	3.133	2.772	2.485
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

18 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08811879

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 3.288

VS = 2.837

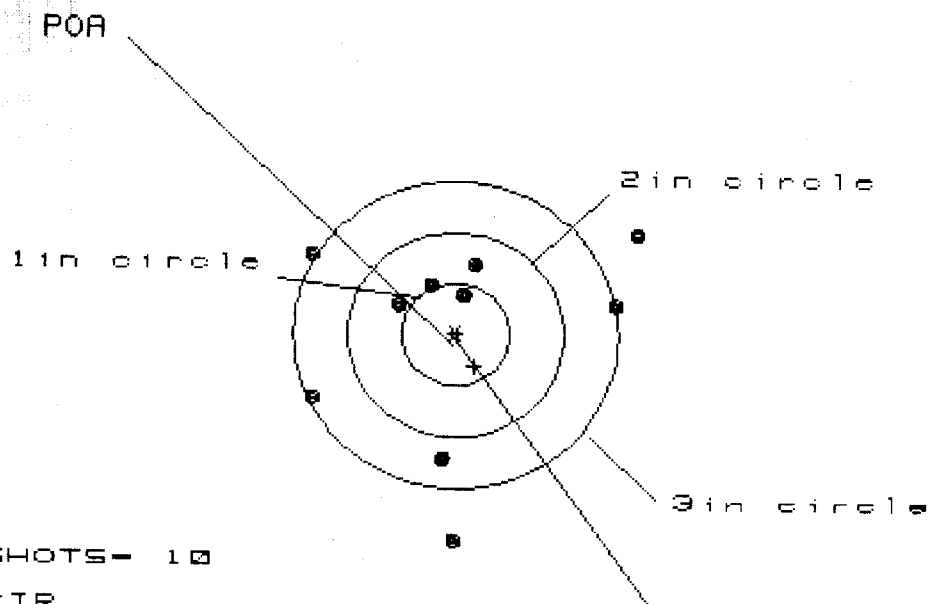
GS = 3.822

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.015	.763	.662
MINIMUM X	-2.273	-.998	-.903
MAXIMUM Y	1.558	1.514	.720
MINIMUM Y	-1.279	-1.323	-1.133
CENTROID X	-.190	.062	-.033
CENTROID Y	.041	.085	-.105
POA TO CENTROID in.	.195	.105	.110
MIN RADIUS	.370	.549	.410
MEAN RADIUS	1.027	.861	.751
MAX RADIUS	2.306	1.696	1.449
HORIZONTAL SPREAD	3.288	1.761	1.565
VERTICAL SPREAD	2.837	2.837	1.953
EXTREME SPREAD	3.822	3.339	2.270
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

16 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.063

VS= 2.970

GS= 3.418

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.717	1.720	1.729
MINIMUM X	:	-1.346	-1.343	-1.128
MAXIMUM Y	:	.955	.731	.636
MINIMUM Y	:	-2.015	-1.477	-1.386
CENTROID X	:	-.175	-.178	-.392
CENTROID Y	:	.309	.533	.442
POA TO CENTROID in.	:	.355	.562	.591
MIN RADIUS	:	.358	.137	.334
MEAN RADIUS	:	1.201	1.044	.940
MAX RADIUS	:	2.016	1.868	1.738
HORIZONTAL SPREAD	:	3.063	3.063	2.858
VERTICAL SPREAD	:	2.970	2.208	2.022
EXTREME SPREAD	:	3.418	3.389	2.948
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=			6