

C6611715

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Remington®

MODEL 700™ H24

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

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

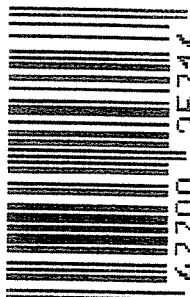
SERIAL NO.
C6611715

ORDER NO.
5716



5716 C6611715

UPC



0 47700 25716 7

GUN SERIAL # C6611715

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCK
	Magnaflux Bolt	5 6 91		KCK
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		LB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	JA
	Apply Coating (Bolt)			
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		6-6-91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	JU
	G) Safety Off Force	3	3	3			6-6-91	JU
	H) Trigger Pull Test & Retainability						6-6-91	JU
	I) Firing Pin Indent	.0215	.0215	.0215			6-6-91	JU
	J) Assemble Stock						6/6/91	RW
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/6/91	RW
	M) Iron Sight Alignment						6/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	RW
	O) Attach Scope to Rifle						6/6/91	RW
	P) Detach & Attach Scope 20 Times						6/6/91	RW
640	Gallery Target & Test						6-7-91	AC
	A) Time						6-7-91	AC
	B) Malfunctions						6-7-91	AC
	C) Pierced Primers						6-7-91	AC
	D) Optical Clarity of Scope						6-7-91	AC
645	Inspect for Live Ammo						6-7-91	AC
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.12	2.15	2.15	2.16	2.15	6-13-91	JU
	C) Function						6-13-91	A
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611715
DATE 6-6-91
TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.40	2.38	2.12	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.36	2.40	2.15	
PULL #3	2.38	2.35	2.44	2.15	
PULL #4	2.24	2.41	2.28	2.16	
PULL #5	2.24	2.37	2.20	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.50		
PULL #2	3.15	3.53		
PULL #3	3.36	3.55		
PULL #4	3.46	3.51		
PULL #5	3.40	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.30		4.32
PULL #2	4.43	4.42		4.42
PULL #3	4.33	4.20		4.45
PULL #4	4.32	4.37		4.44
PULL #5	4.41	4.28		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611715
7 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.397955
1 TO 2	.22102
1 TO 3	.369878
1 TO 4	.110023
1 TO 5	.323736

3.5
2.5
+-----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4358
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .506342

THE AMR FOR THIS RIFLE IS: .9318

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

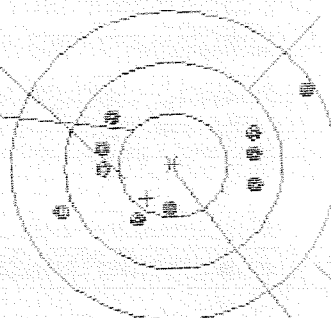
CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 2.249

VS= 1.202

GS= 2.499

CENTROID *

PATTERN #

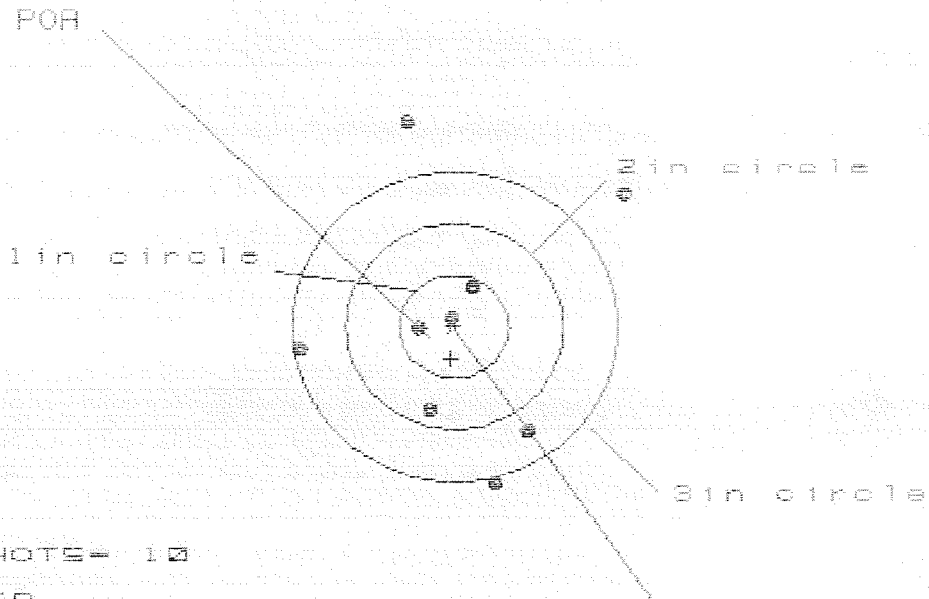
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	.853	.743
MINIMUM X	-1.014	-.877	-.659
MAXIMUM Y	.649	.547	.501
MINIMUM Y	-.553	-.481	-.527
CENTROID X	.252	.115	.225
CENTROID Y	.308	.236	.282
POA TO CENTROID in.	.398	.262	.360
MIN RADIUS	.404	.340	.376
MEAN RADIUS	.791	.699	.672
MAX RADIUS	1.395	.951	.792
HORIZONTAL SPREAD	2.249	1.730	1.402
VERTICAL SPREAD	1.202	1.028	1.028
EXTREME SPREAD	2.499	1.862	1.458
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 3.0320

VS= 3.496

GS= 3.575

CENTROID #

PATTERN #

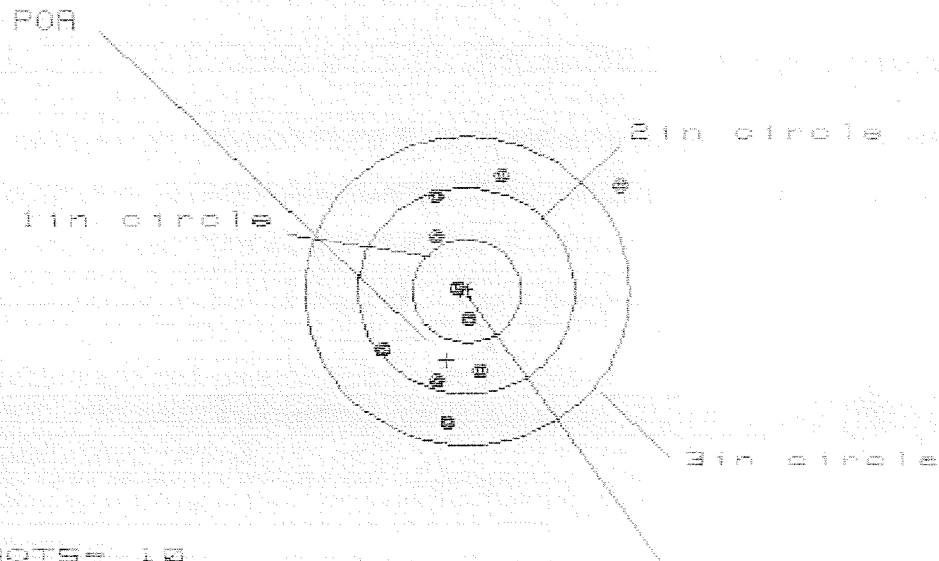
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.578	.816	.789
MINIMUM X	-1.442	-1.267	-1.294
MAXIMUM Y	1.949	2.094	.801
MINIMUM Y	-1.547	-1.402	-1.140
CENTROID X	.031	-.144	-.117
CENTROID Y	.311	.166	-.096
POA TO CENTROID in.	.313	.220	.151
MIN RADIUS	.045	.176	.404
MEAN RADIUS	1.032	.895	.771
MAX RADIUS	2.050	2.105	1.314
HORIZONTAL SPREAD	3.020	2.083	2.083
VERTICAL SPREAD	3.496	3.496	1.941
EXTREME SPREAD	3.575	3.575	2.260
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611715

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.252

VS= 2.424

GS= 2.858

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.462

.500

.494

MINIMUM X

:

-.790

-.627

-.633

MAXIMUM Y

:

1.150

1.266

1.121

MINIMUM Y

:

-1.274

-1.158

-.942

CENTROID X

:

.181

.018

.024

CENTROID Y

:

.671

.555

.700

POA TO CENTROID in.

:

.695

.555

.700

MIN RADIUS

:

.115

.159

.047

MEAN RADIUS

:

.893

.767

.712

MAX RADIUS

:

1.797

1.361

1.225

HORIZONTAL SPREAD

:

2.252

1.127

1.127

VERTICAL SPREAD

:

2.424

2.424

2.063

EXTREME SPREAD

:

2.858

2.485

2.157

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

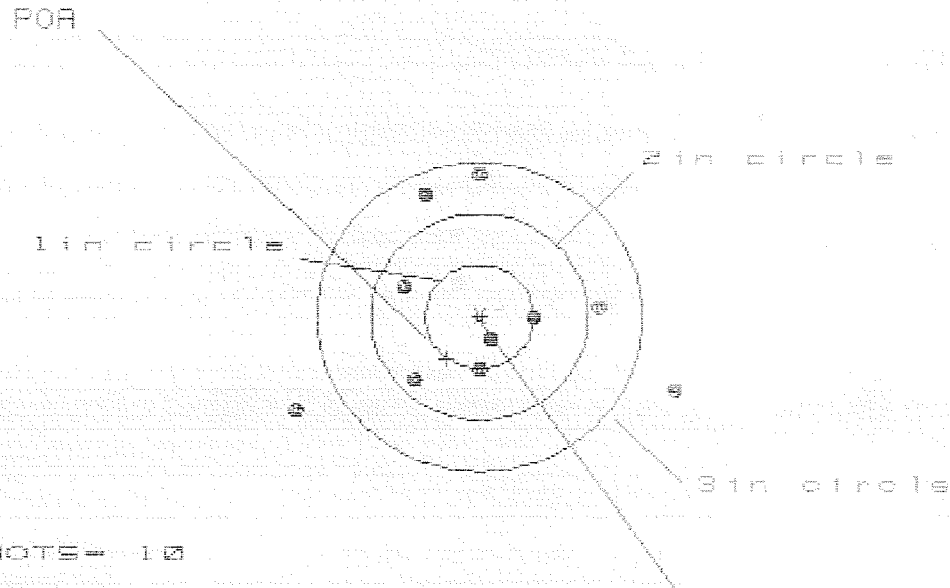
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.457

VS = 2.384

GS = 3.467

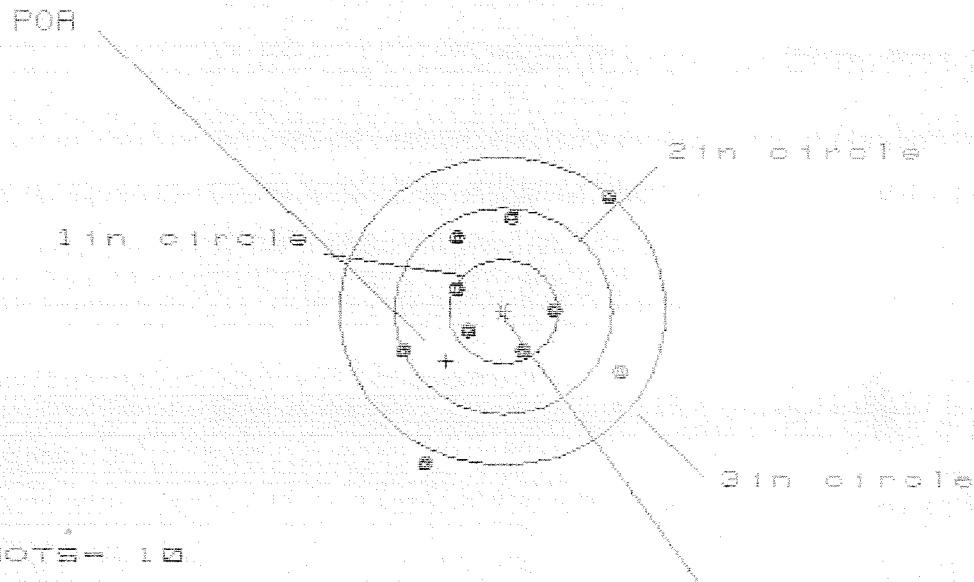
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.791	1.324	1.140
MINIMUM X	:	-1.666	-1.467	-1.726
MAXIMUM Y	:	1.436	1.359	1.231
MINIMUM Y	:	-1.948	-1.025	-1.770
CENTROID X	:	.300	.101	.285
CENTROID Y	:	.407	.484	.612
POA TO CENTROID in.	:	.506	.494	.675
MIN RADIUS	:	.261	.442	.457
MEAN RADIUS	:	1.057	.971	.863
MAX RADIUS	:	1.918	1.790	1.231
HORIZONTAL SPREAD	:	3.457	2.791	1.866
VERTICAL SPREAD	:	2.384	2.384	2.001
EXTREME SPREAD	:	3.467	2.994	2.088
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/08611715

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS= 2.036

VS= 2.599

GS= 3.128

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.070	.987	1.101
MINIMUM X	-1.966	-1.049	-1.935
MAXIMUM Y	1.151	.990	.874
MINIMUM Y	-1.448	-.693	-.569
CENTROID X	.525	.608	.494
CENTROID Y	.482	.643	.519
POA TO CENTROID IN.	.713	.885	.716
MIN RADIUS	.351	.421	.349
MEAN RADIUS	.886	.803	.711
MAX RADIUS	1.628	1.348	1.240
HORIZONTAL SPREAD	2.036	2.036	2.036
VERTICAL SPREAD	2.599	1.683	1.443
EXTREME SPREAD	3.128	2.514	2.039
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		