

C6611795

MODEL 700™ M24

Model **SMS**™

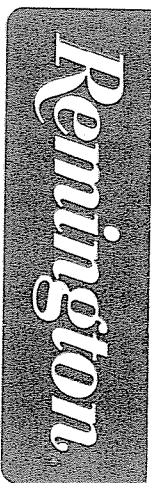
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

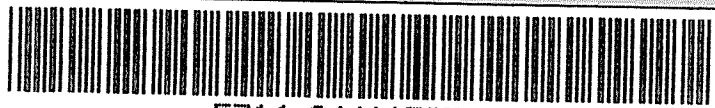
MODEL 700™ M24

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

SERIAL NO.
C6611795

ORDER NO.
5716

20



5716 C6611795

UPC



0 47700 25716 7

CFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611795

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	SL
617	Drill and Tap Sight Holes	2 2	91	LB
618	Polish Barrel RBB	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	TH
	Apply Coating (Bolt)			
625	Final Assembly		2/18/91	KL
	A) Clean inside of Bolt Assembly		2/18/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	KL
	C) Inspect Ejector Hole for Chamfer		2/18/91	KL
	D) Oil Firing Pin Ass'y		2/18/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		2-21-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4½	4½	4¾			2-21-91	DH
	G) Safety Off Force	2¼	2½	2½			2-21-91	DH
	H) Trigger Pull Test & Retainability						2-21-91	DH
	I) Firing Pin Indent	.021¾	.021	.022			2-21-91	DH
	J) Assemble Stock						2/25/91	KS
	K) Assemble Swivel Studs						3/2/91	WB
	L) Attach Front and Rear Sight Assemblies						2/25/91	KS
	M) Iron Sight Alignment						2/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						2/25/91	KS
	O) Attach Scope to Rifle						2/25/91	KS
	P) Detach & Attach Scope 20 Times						2/25/91	KS
640	Gallery Target & Test						3/1/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						3/1/91	KS
655	Final Inspection						3/2/91	WB
	A) Headspace						3/2/91	WB
	B) Trigger Pull	2.65	2.60	2.55	2.51	2.32	3/2/91	KS
	C) Function						3/2/91	WB
660	Pack						3-18-91	KS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611795

DATE 2-21-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.38	2.48	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.38	2.47	2.60	
PULL #3	2.57	2.39	2.60	2.55	
PULL #4	2.54	2.41	2.58	2.51	
PULL #5	2.51	2.38	2.57	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.29		
PULL #2	3.16	3.08		
PULL #3	3.21	3.00		
PULL #4	3.19	2.97		
PULL #5	3.22	2.94		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.10		4.21
PULL #2	4.16	4.19		4.21
PULL #3	4.17	4.12		4.16
PULL #4	4.15	4.19		4.02
PULL #5	4.07	4.21		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611795
1 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.636756
1 TO 2	.519762
1 TO 3	.601791
1 TO 4	.820366
1 TO 5	.775761

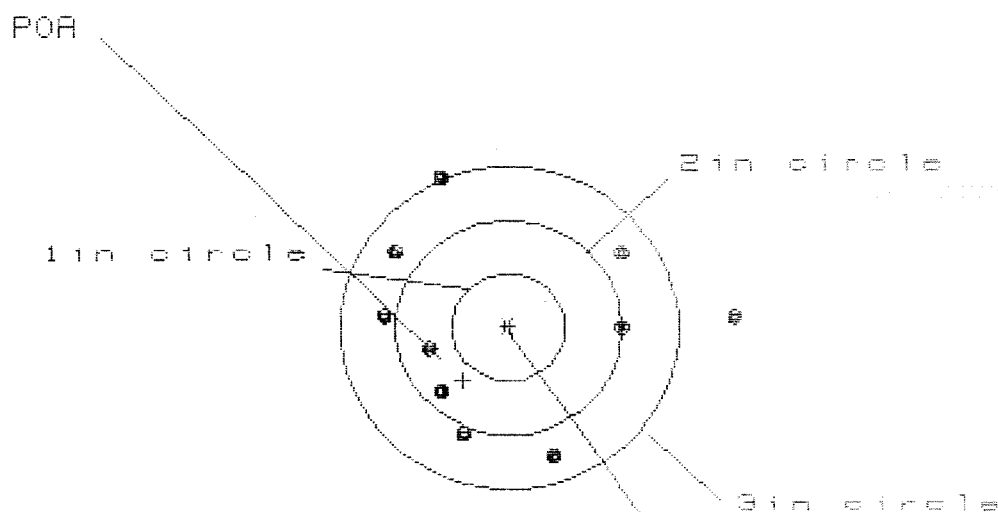
¹
50' <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0944
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0634
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113714
THE AMR FOR THIS RIFLE IS: 1.114

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06511785

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 2

3 in = 8

HS- 3.021

VS= 2.592

GS= 3.021

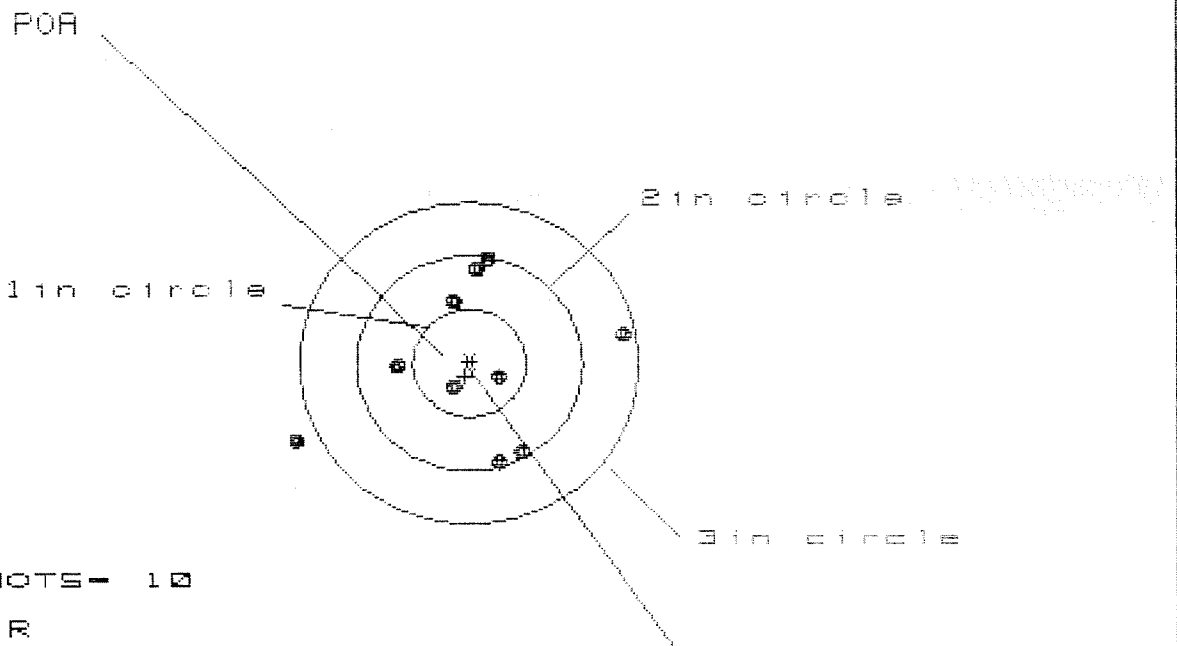
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.952	1.240	1.190
MINIMUM X	:	-1.069	-.852	-.902
MAXIMUM Y	:	1.393	1.402	.862
MINIMUM Y	:	-1.199	-1.190	-1.014
CENTROID X	:	.403	.186	.236
CENTROID Y	:	.493	.484	.308
POA TO CENTROID in.	:	.637	.518	.389
MIN RADIUS	:	.780	.570	.558
MEAN RADIUS	:	1.181	1.052	.981
MAX RADIUS	:	1.954	1.459	1.438
HORIZONTAL SPREAD	:	3.021	2.092	2.092
VERTICAL SPREAD	:	2.592	2.592	1.876
EXTREME SPREAD	:	3.021	2.787	2.308
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

1 Mar 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in = 9

HS- 2.907

VS= 1.883

GS= 3.082

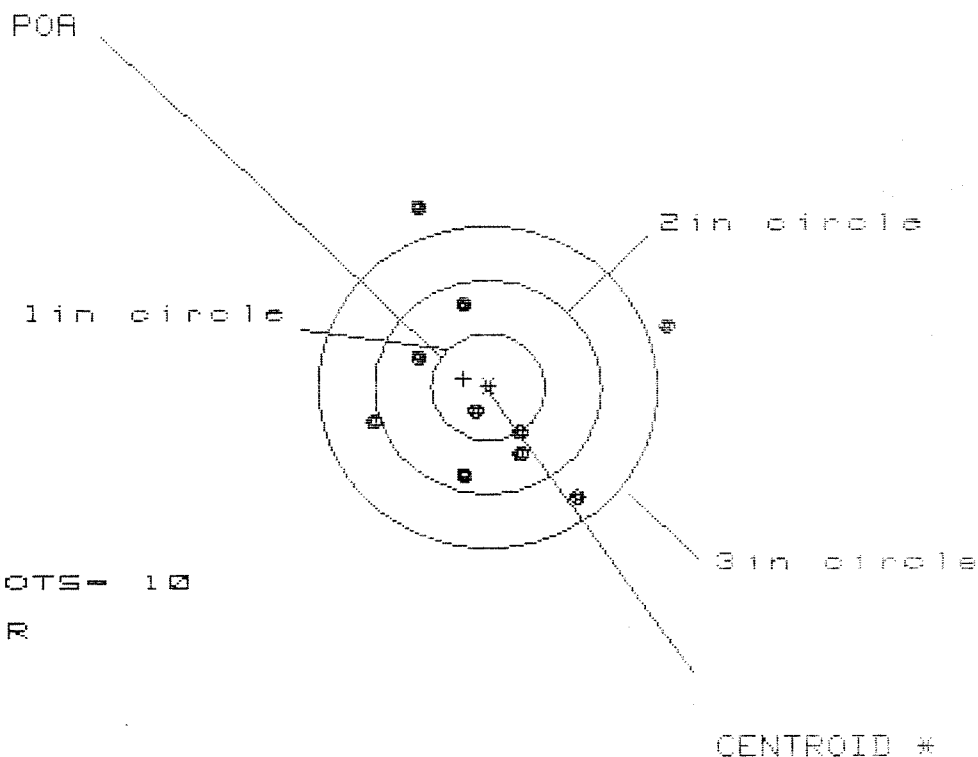
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.349	1.176	.446
MINIMUM X	:	-1.558	-.850	-.703
MAXIMUM Y	:	.931	.853	.984
MINIMUM Y	:	-.952	-1.030	-.999
CENTROID X	:	.040	.213	.066
CENTROID Y	:	.121	.199	.168
POA TO CENTROID in.	:	.128	.291	.180
MIN RADIUS	:	.238	.215	.267
MEAN RADIUS	:	.861	.766	.691
MAX RADIUS	:	1.706	1.203	1.018
HORIZONTAL SPREAD	:	2.907	2.026	1.148
VERTICAL SPREAD	:	1.883	1.883	1.883
EXTREME SPREAD	:	3.082	2.049	1.886
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.628

VS= 2.687

GS= 3.022

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.564	1.497	.902
MINIMUM X	:	-1.054	-1.131	-.943
MAXIMUM Y	:	1.714	.971	1.069
MINIMUM Y	:	-.973	-.783	-.685
CENTROID X	:	.216	.283	.095
CENTROID Y	:	-.079	-.269	-.367
POA TO CENTROID in.	:	.230	.390	.379
MIN RADIUS	:	.297	.237	.058
MEAN RADIUS	:	.969	.831	.686
MAX RADIUS	:	1.816	1.688	1.132
HORIZONTAL SPREAD	:	2.628	2.628	1.845
VERTICAL SPREAD	:	2.687	1.754	1.754
EXTREME SPREAD	:	3.022	2.795	2.017
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Mar 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in - 0

2in - 3

3in - 8

HS- 2.726

VS- 3.934

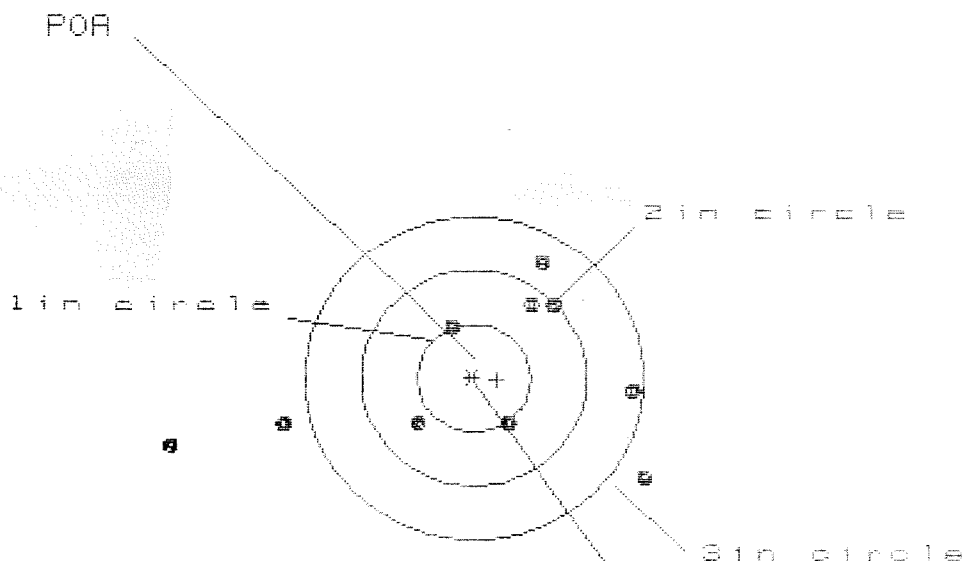
GS- 3.989

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	1.480	.912
MINIMUM X	:	-1.250	-1.086	-.901
MAXIMUM Y	:	1.812	1.576	1.191
MINIMUM Y	:	-2.122	-1.637	-1.440
CENTROID X	:	.021	-.143	-.329
CENTROID Y	:	-.233	.003	-.194
POA TO CENTROID in.	:	.234	.143	.382
MIN RADIUS	:	.523	.249	.467
MEAN RADIUS	:	1.305	1.110	.965
MAX RADIUS	:	2.585	2.163	1.545
HORIZONTAL SPREAD	:	2.726	2.566	1.813
VERTICAL SPREAD	:	3.934	3.213	2.631
EXTREME SPREAD	:	3.989	3.398	2.779
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 7

HS- 4.233

VS- 1.993

GS- 4.242

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.524	1.223	1.281
MINIMUM X	:	-2.709	-2.009	-1.856
MAXIMUM Y	:	1.075	1.004	.881
MINIMUM Y	:	-.917	-.989	-.652
CENTROID X	:	-.208	.093	-.060
CENTROID Y	:	.015	.087	.210
POA TO CENTROID in.	:	.209	.127	.219
MIN RADIUS	:	.533	.476	.470
MEAN RADIUS	:	1.255	1.031	.949
MAX RADIUS	:	2.784	2.077	1.967
HORIZONTAL SPREAD	:	4.233	3.232	3.137
VERTICAL SPREAD	:	1.993	1.993	1.533
EXTREME SPREAD	:	4.242	3.265	3.159
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	