

C6635008

MODEL 700™ M24

Model **SMS**™

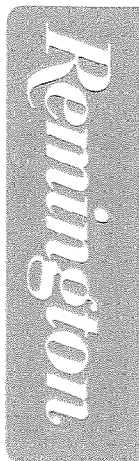
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

Stock
RepairedRepair
ob.
6/27/91

GUN SERIAL #

C 6636008

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GR
617	Drill and Tap Sight Holes	5 15 9 1		Lb
618	Polish Barrel	5 15 9 1		w.b
620	Apply Coatings (Barrel Action)		5-31-91	AA
	Apply Coating (Bolt)			
625	Final Assembly		6/4/91	K.S.
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/91	K.S.
	C) Inspect Ejector Hole for Chamfer		6/4/91	K.S.
	D) Oil Firing Pin Ass'y		6/4/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	PA

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	6-10-91	JK		
	G) Safety Off Force	4	4	4	6-10-91	JK		
	H) Trigger Pull Test & Retainability				6-10-91	JK		
	I) Firing Pin Indent	.0215	.0215	.0215	6-10-91	JK		
	J) Assemble Stock				6-10-91	KS		
	K) Assemble Swivel Studs				6-12-91	A		
	L) Attach Front and Rear Sight Assemblies				6-10-91	KS		
	M) Iron Sight Alignment				6-10-91	KS		
	N) Detach Front & Rear Sights & place in numbered container				6-10-91	KS		
	O) Attach Scope to Rifle				6-10-91	KS		
	P) Detach & Attach Scope 20 Times				6-10-91	KS		
640	Gallery Target & Test				6-11-91	AC		
	A) Time				6-11-91	AC		
	B) Malfunctions				6-11-91	AC		
	C) Pierced Primers				6-11-91	AC		
	D) Optical Clarity of Scope				6-11-91	AC		
645	Inspect for Live Ammo				6-11-91	AC		
655	Final Inspection							
	A) Headspace				6-12-91	A		
	B) Trigger Pull	2.60	2.29	2.53	2.54	2.64	6-12-91	JK
	C) Function						6-12-91	A
660	Pack						6-20-91	VF

Remington
 MODEL 700TH H24

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

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

SERIAL NO.
 C6636008

ORDER NO.
 5716

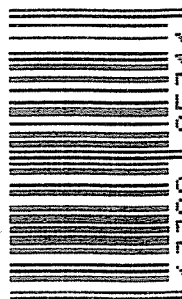
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636008

UPC



0 47700 25716 7

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636008
DATE 6-10-91
TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.40	2.38	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.41	2.38	2.29	
PULL #3	2.46	2.43	2.40	2.53	
PULL #4	2.42	2.38	2.45	2.54	
PULL #5	2.46	2.42	2.48	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.31		
PULL #2	3.21	3.39		
PULL #3	3.64	3.44		
PULL #4	3.33	3.54		
PULL #5	3.60	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.19		4.36
PULL #2	4.41	4.36		4.28
PULL #3	4.28	4.40		4.30
PULL #4	4.38	4.17		4.34
PULL #5	4.37	4.40		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636008
11 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.188449
1 TO	2	.299933
1 TO	3	.313081
1 TO	4	.405623
1 TO	5	.269742

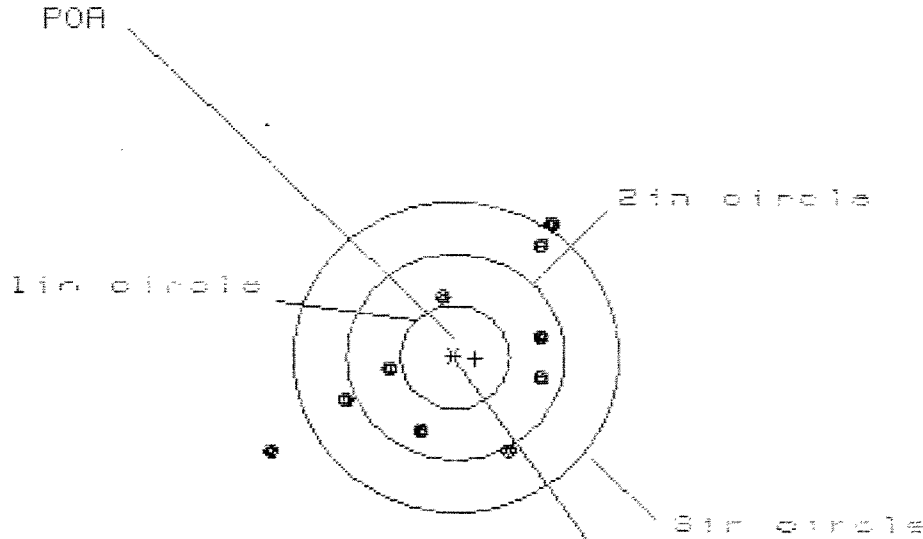
$\frac{2}{174}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0558
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0594
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0014905
THE AMR FOR THIS RIFLE IS: .842

1) Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C653B008

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 5

HS = 2.525

VS = 2.209

GS = 3.431

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.745	.724
MINIMUM X	:	-1.692	-1.247	-1.154
MAXIMUM Y	:	1.309	1.209	1.163
MINIMUM Y	:	-.900	-.994	-.843
CENTROID X	:	-.188	-.000	-.093
CENTROID Y	:	.013	.113	-.030
POA TO CENTROID in.	:	.188	.113	.101
MIN RADIUS	:	.575	.567	.666
MEAN RADIUS	:	1.062	.952	.982
MAX RADIUS	:	1.916	1.420	1.346
HORIZONTAL SPREAD	:	2.625	1.992	1.888
VERTICAL SPREAD	:	2.209	2.203	2.006
EXTREME SPREAD	:	3.431	2.662	2.411
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

11 Jun 1991

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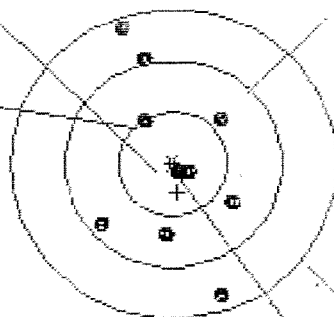
CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.181

VS = 2.628

GS = 0.709

CENTROID #

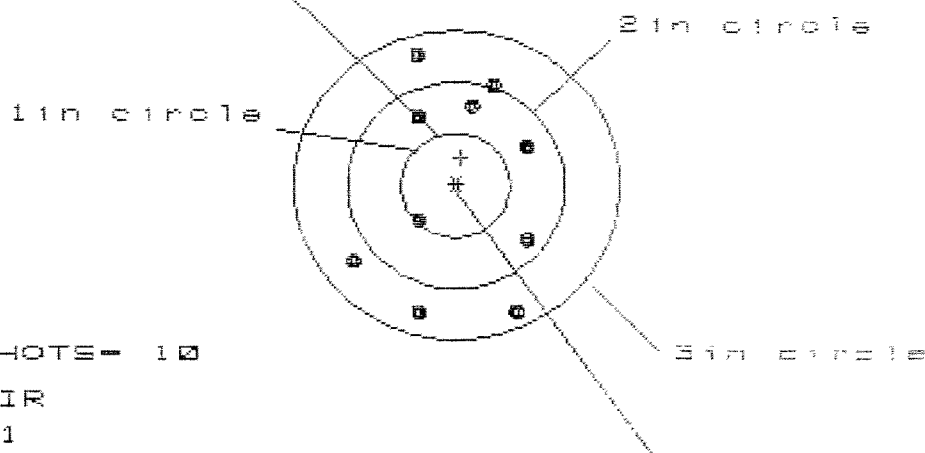
PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.570	.617	.571
MINIMUM X	-.611	-.564	-.610
MAXIMUM Y	1.313	1.167	1.026
MINIMUM Y	-1.315	-.809	-.663
CENTROID X	-.042	-.089	-.043
CENTROID Y	.275	.421	.275
POR TO CENTROID in.	.278	.430	.278
MIN RADIUS	.039	.191	.040
MEAN RADIUS	.730	.675	.568
MAX RADIUS	1.381	1.224	1.051
HORIZONTAL SPREAD	1.181	1.181	1.181
VERTICAL SPREAD	2.628	1.976	1.689
EXTREME SPREAD	2.759	2.014	1.701
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.570

VS= 2.543

GS= 2.717

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.667	.625	.693
MINIMUM X	-.903	-.945	-.877
MAXIMUM Y	1.315	1.106	.970
MINIMUM Y	-1.228	-1.082	-1.192
CENTROID X	-.052	-.010	-.078
CENTROID Y	-.269	-.415	-.280
FOR TO CENTROID in.	.274	.415	.290
MIN RADIUS	.490	.435	.464
MEAN RADIUS	.979	.932	.883
MAX RADIUS	1.367	1.210	1.244
HORIZONTAL SPREAD	1.570	1.570	1.570
VERTICAL SPREAD	2.543	2.188	2.163
EXTREME SPREAD	2.717	2.287	2.287
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS= 2.0000

VS= 1.560

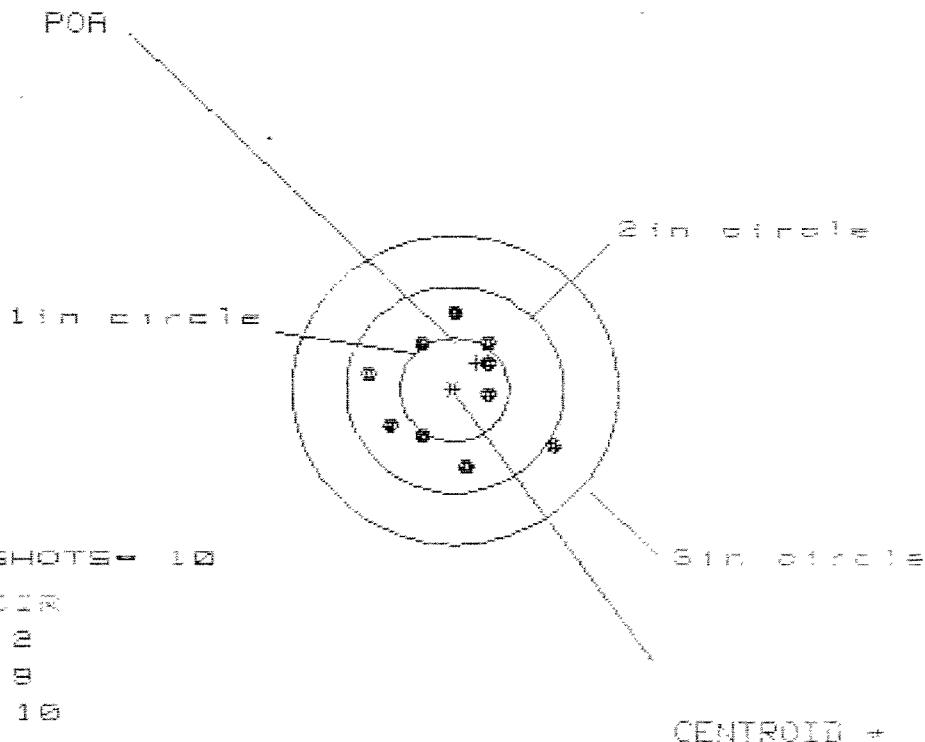
GS= 2.147

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.127	.815	.711
MINIMUM X	:	-.953	-.828	-.803
MAXIMUM Y	:	.752	.693	.686
MINIMUM Y	:	-.808	-.867	-.874
CENTROID X	:	.211	.086	.190
CENTROID Y	:	-.060	-.001	.006
POB TO CENTROID in.	:	.220	.086	.190
MIN RADIUS	:	.359	.436	.426
MEAN RADIUS	:	.798	.740	.724
MAX RADIUS	:	1.245	.932	.906
HORIZONTAL SPREAD	:	2.090	1.643	1.514
VERTICAL SPREAD	:	1.560	1.560	1.560
EXTREME SPREAD	:	2.147	1.646	1.570
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.682

VS = 1.505

GS = 1.858

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	6
MAXIMUM X	:	.935	.402	.322
MINIMUM X	:	-.747	-.643	-.613
MAXIMUM Y	:	.743	.678	.695
MINIMUM Y	:	-.762	-.827	-.818
CENTROID X	:	-.208	-.312	-.232
CENTROID Y	:	-.256	-.191	-.208
FOR TO CENTROID in.	:	.330	.366	.312
MIN RADIUS	:	.262	.373	.291
MEAN RADIUS	:	.641	.584	.563
MAX RADIUS	:	1.103	.848	.817
HORIZONTAL SPREAD	:	1.682	1.045	.905
VERTICAL SPREAD	:	1.505	1.505	1.505
EXTREME SPREAD	:	1.858	1.505	1.505
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	