

C6636012

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®
HODEL 700™ H24

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

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

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

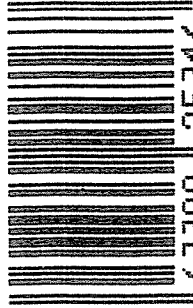
SERIAL NO.	C6636012
ORDER NO.	5716

20



5716 C6636012

LIPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636012

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8		RW
610	Dis-assemble Gun		91	RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	q
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 19 1991	LS
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/16/91	KR
	D) Oil Firing Pin Ass'y		5/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/25/91	JH
	G) Safety Off Force	4	4	4			5/25/91	JH
	H) Trigger Pull Test & Retainability						5/25/91	JH
	I) Firing Pin Indent	.0205	.021	.021			5/25/91	JH
	J) Assemble Stock						5/25/91	RW
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	RW
	M) Iron Sight Alignment						5/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	RW
	O) Attach Scope to Rifle						5/25/91	RW
	P) Detach & Attach Scope 20 Times						5/25/91	RW
640	Gallery Target & Test						5-29-91	AC
	A) Time						5-29-91	AC
	B) Malfunctions						5-29-91	AC
	C) Pierced Primers						5-29-91	AC
	D) Optical Clarity of Scope						5-29-91	AC
645	Inspect for Live Ammo						5-29-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.48	2.50	2.47	2.29	2.40	6/1/91	JH
	C) Function						6-1-91	D/H
660	Pack						6-20-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636012

DATE 5/25/91

TESTER JR.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.32	2.51	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.23	2.38	2.50	
PULL #3	2.46	2.28	2.44	2.47	
PULL #4	2.47	2.34	2.38	2.29	
PULL #5	2.43	2.57	2.36	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.58		
PULL #2	3.48	3.58		
PULL #3	3.44	3.46		
PULL #4	3.44	3.45		
PULL #5	3.40	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.37		4.41
PULL #2	4.10	4.21		4.53
PULL #3	4.28	4.47		4.38
PULL #4	4.34	4.33		4.30
PULL #5	4.51	4.38		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636012
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.407767
1 TO	2	.789734
1 TO	3	.858742
1 TO	4	.377414
1 TO	5	.0588727

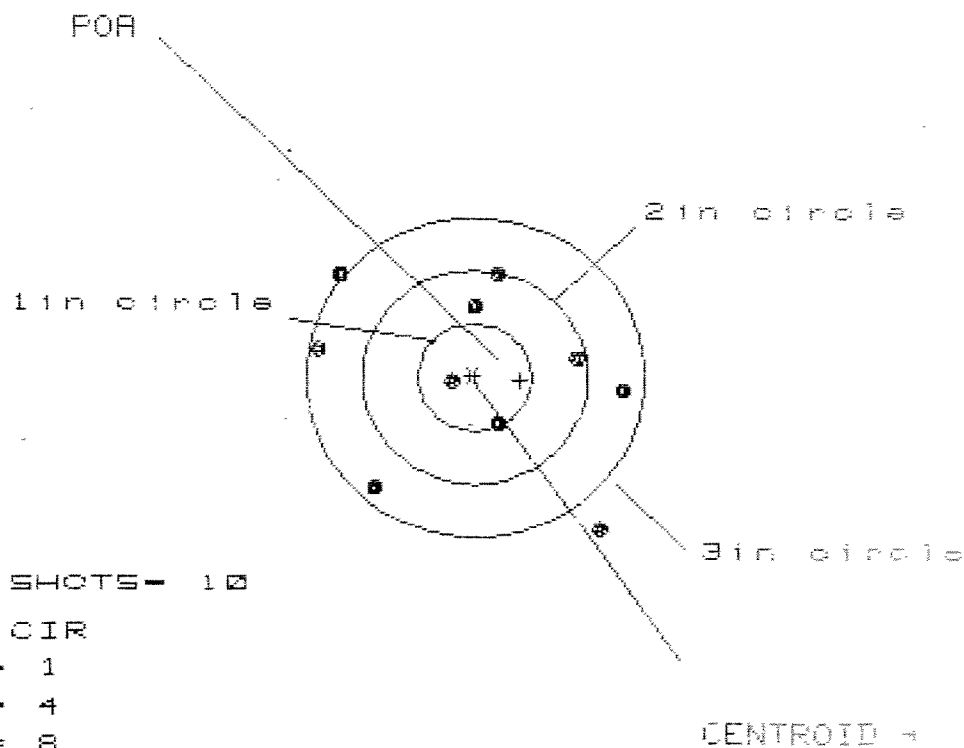
3
2
1 + <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2696
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2324
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .355941
THE AMR FOR THIS RIFLE IS: .9124

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636012

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.776

VS= 2.432

GS= 3.317

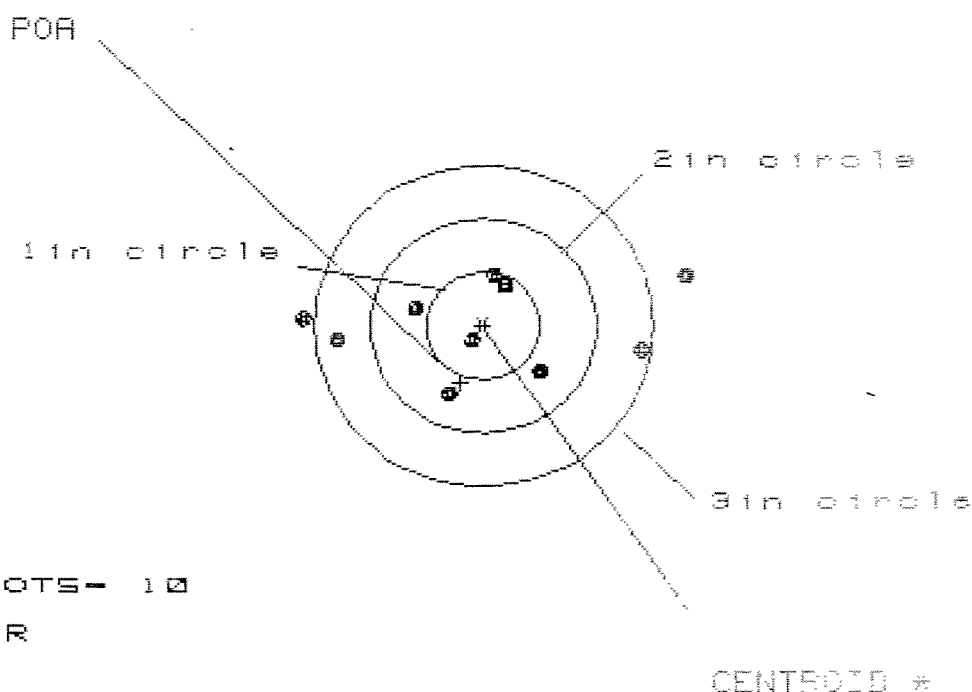
CENTROID +

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.459	1.324
MINIMUM X	:	-1.435	-1.317	-1.453
MAXIMUM Y	:	1.008	.849	.954
MINIMUM Y	:	-1.424	-1.230	-1.125
CENTROID X	:	-.407	-.525	-.389
CENTROID Y	:	.025	.184	.079
POA TO CENTROID in.	:	.407	.556	.397
MIN RADIUS	:	.184	.211	.219
MEAN RADIUS	:	1.083	.997	.935
MAX RADIUS	:	1.779	1.492	1.475
HORIZONTAL SPREAD	:	2.776	2.776	2.776
VERTICAL SPREAD	:	2.432	2.079	2.079
EXTREME SPREAD	:	3.317	2.814	2.814
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

25 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.440

VS= 1.096

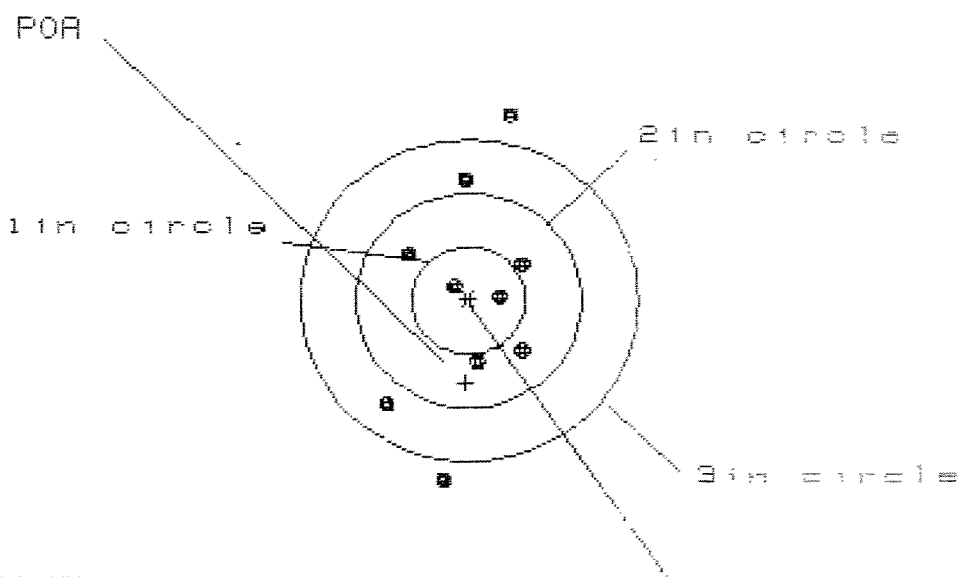
GS= 3.461

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.790	1.584	1.402
MINIMUM X	:	-1.650	-1.451	-1.274
MAXIMUM Y	:	.467	.487	.505
MINIMUM Y	:	-.629	-.577	-.559
CENTROID X	:	.201	.002	.184
CENTROID Y	:	.529	.477	.439
POA TO CENTROID in.	:	.566	.477	.496
MIN RADIUS	:	.138	.111	.085
MEAN RADIUS	:	.924	.810	.715
MAX RADIUS	:	1.850	1.597	1.415
HORIZONTAL SPREAD	:	3.440	3.035	2.676
VERTICAL SPREAD	:	1.096	1.064	1.064
EXTREME SPREAD	:	3.461	3.055	2.680
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.191

VS= 3.368

GS= 3.416

CENTROID *

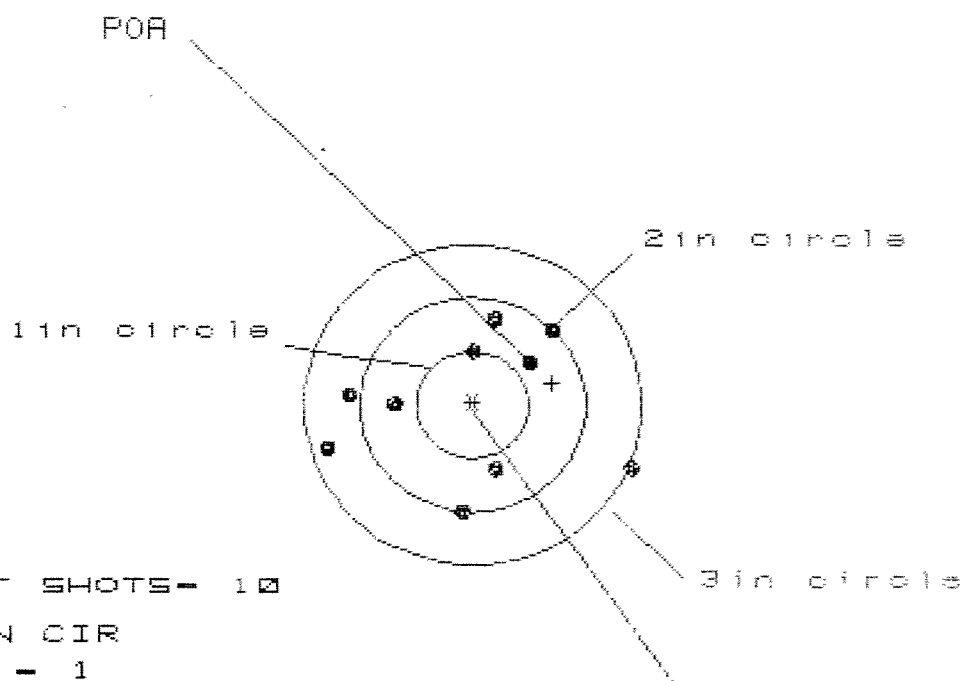
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.513	.551	.527
MINIMUM X	:	-.678	-.640	-.664
MAXIMUM Y	:	1.735	1.316	1.136
MINIMUM Y	:	-1.632	-1.440	-.984
CENTROID X	:	.027	-.011	.013
CENTROID Y	:	.766	.574	.754
POA TO CENTROID in.	:	.767	.574	.754
MIN RADIUS	:	.195	.315	.190
MEAN RADIUS	:	.873	.777	.606
MAX RADIUS	:	1.768	1.452	1.187
HORIZONTAL SPREAD	:	1.191	1.191	1.191
VERTICAL SPREAD	:	3.368	2.756	2.120
EXTREME SPREAD	:	3.416	2.765	2.223
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

29 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.718

VS= 1.745

GS= 2.725

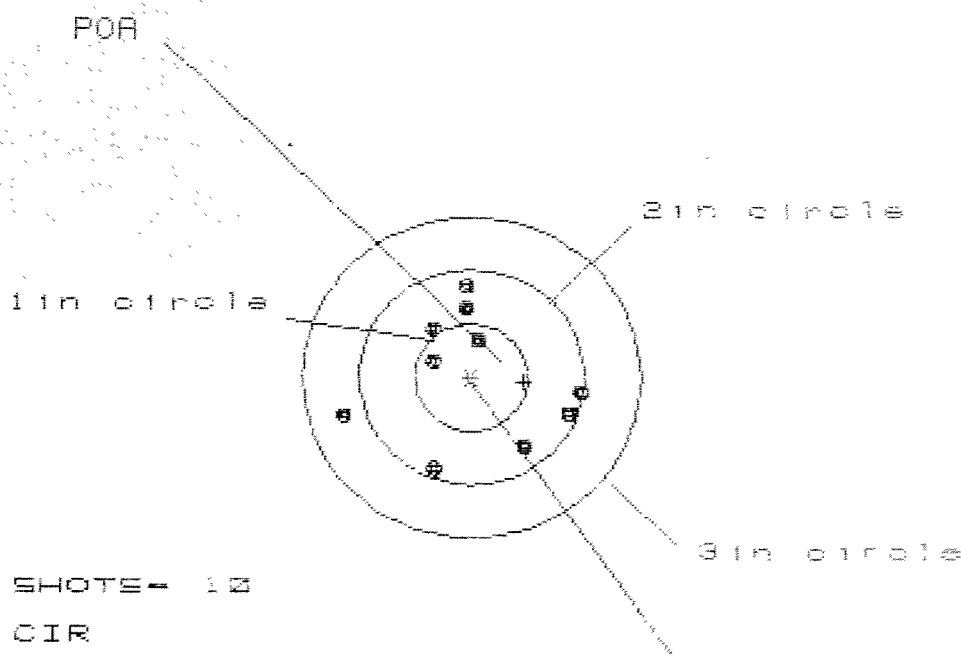
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.436	.838	.538
MINIMUM X	:	-1.282	-1.123	-1.028
MAXIMUM Y	:	.771	.707	.651
MINIMUM Y	:	-.974	-1.038	-1.034
CENTROID X	:	-.707	-.866	-.726
CENTROID Y	:	-.204	-.140	-.034
POA TO CENTROID in.	:	.736	.878	.731
MIN RADIUS	:	.497	.469	.379
MEAN RADIUS	:	.929	.847	.792
MAX RADIUS	:	1.548	1.208	1.099
HORIZONTAL SPREAD	:	2.718	1.961	1.728
VERTICAL SPREAD	:	1.745	1.745	1.745
EXTREME SPREAD	:	2.725	2.230	1.838
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 12

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 2.081

VS= 1.653

GS= 2.096

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.943
MINIMUM X	-1.138
MAXIMUM Y	.833
MINIMUM Y	-.820
CENTROID X	-.462
CENTROID Y	.046
POA TO CENTROID in.	.465
MIN RADIUS	.345
MEAN RADIUS	.753
MAX RADIUS	1.204
HORIZONTAL SPREAD	2.081
VERTICAL SPREAD	1.653
EXTREME SPREAD	2.096
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10