

C6636013

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

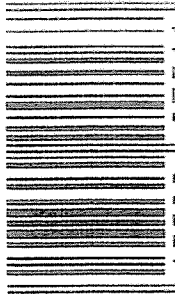
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. D6636013	20
ORDER NO. 5716	



5716 D6636013

UPC



0 47700 25716 7

MOD. _____		GA. CAL. _____	GUN # _____
#	C6636913		
TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
C-791		Bolt handle hits stock	KS
DH			
	2nd		
4/7/91		Repaired	KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636013

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6-6-91	JH
	G) Safety Off Force	4	4	4			6-6-91	JH
	H) Trigger Pull Test & Retainability						6-6-91	JH
	I) Firing Pin Indent	.020	.0205	.0205			6-6-91	JH
	J) Assemble Stock						6-6-91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						4/6/91	KS
	M) Iron Sight Alignment						4/6/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/6/91	KS
	O) Attach Scope to Rifle						4/6/91	KS
	P) Detach & Attach Scope 20 Times						4/6/91	KS
640	Gallery Target & Test						6-7-91	DH
	A) Time						6-7-91	DH
	B) Malfunctions						6-7-91	DH
	C) Pierced Primers						6-7-91	DH
	D) Optical Clarity of Scope						6-7-91	DH
645	Inspect for Live Ammo						6-7-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.42	2.37	2.42	2.40	2.46	6-13-91	JH
	C) Function						6-13-91	A
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636013

DATE 6-6-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.38	2.22	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.22	2.32	2.37	
PULL #3	2.45	2.36	2.38	2.42	
PULL #4	2.48	2.31	2.28	2.40	
PULL #5	2.22	2.29	2.32	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.45		
PULL #2	3.44	3.48		
PULL #3	3.32	3.46		
PULL #4	3.20	3.40		
PULL #5	3.49	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.55		4.32
PULL #2	4.45	4.20		4.40
PULL #3	4.28	4.36		4.52
PULL #4	4.50	4.40		4.48
PULL #5	4.56	4.21		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636013
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.405317
1 TO	2	.601722
1 TO	3	.847143
1 TO	4	.837741
1 TO	5	.437156

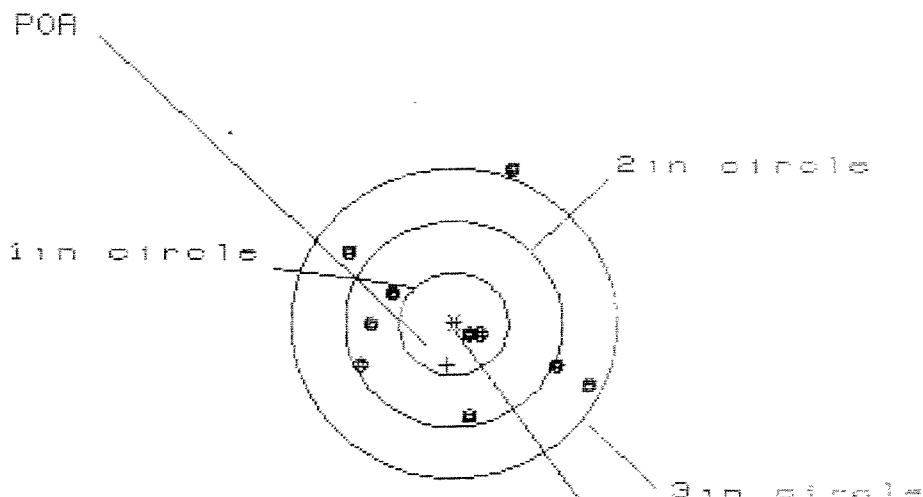
$\frac{2}{3} + \frac{1}{4} \times 5$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0888
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0128
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0897178
THE AMR FOR THIS RIFLE IS: .957

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883B013

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.208

VS= 2.372

GS= 2.612

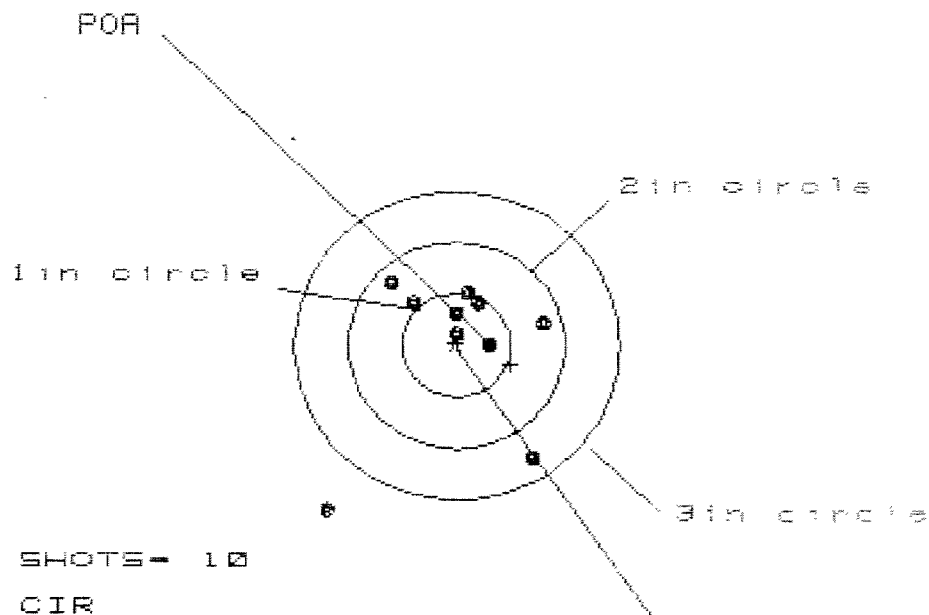
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.277	1.204
MINIMUM X	:	-.988	-.931	-.772
MAXIMUM Y	:	1.478	.911	.850
MINIMUM Y	:	-.894	-.729	-.790
CENTROID X	:	.059	.002	-.157
CENTROID Y	:	.401	.236	.297
POA TO CENTROID in.	:	.405	.236	.336
MIN RADIUS	:	.154	.161	.315
MEAN RADIUS	:	.892	.802	.729
MAX RADIUS	:	1.564	1.366	1.252
HORIZONTAL SPREAD	:	2.208	2.208	1.976
VERTICAL SPREAD	:	2.372	1.640	1.640
EXTREME SPREAD	:	2.612	2.612	2.307
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.959

VS= 2.192

GS= 2.678

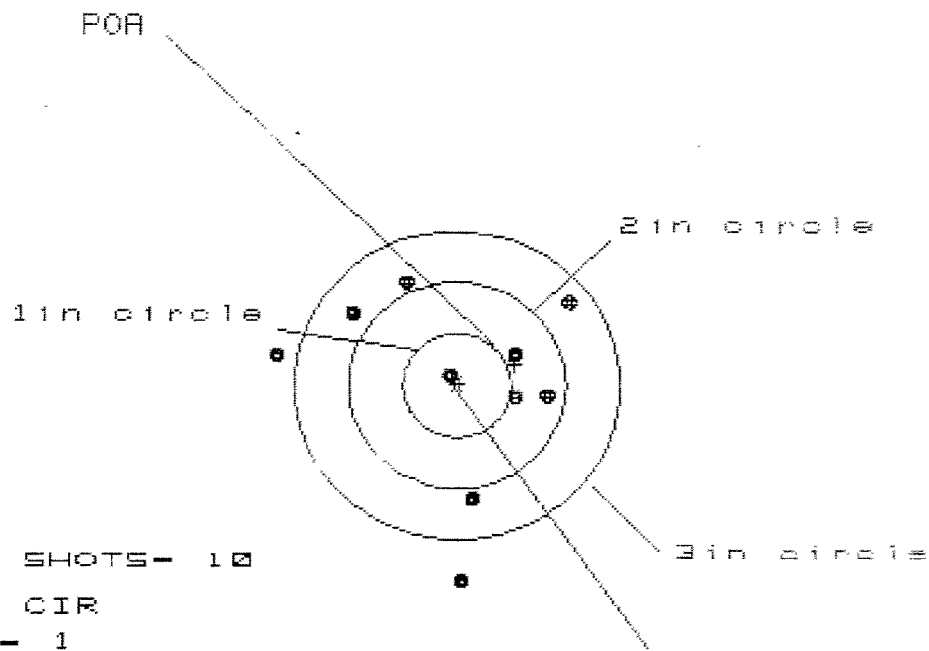
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.807	.679	.757
MINIMUM X	:	-1.152	-.732	-.654
MAXIMUM Y	:	.587	.409	.257
MINIMUM Y	:	-1.605	-1.215	-.279
CENTROID X	:	-.503	-.375	-.453
CENTROID Y	:	.186	.364	.516
POA TO CENTROID in.	:	.536	.523	.696
MIN RADIUS	:	.113	.135	.067
MEAN RADIUS	:	.721	.508	.368
MAX RADIUS	:	1.976	1.366	.765
HORIZONTAL SPREAD	:	1.959	1.411	1.411
VERTICAL SPREAD	:	2.192	1.624	.536
EXTREME SPREAD	:	2.678	2.116	1.458
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.594

VS= 2.842

GS= 2.879

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.067
MINIMUM X	-1.627
MAXIMUM Y	.969
MINIMUM Y	-1.873
CENTROID X	-.535
CENTROID Y	-.203
POA TO CENTROID in.	.572
MIN RADIUS	.124
MEAN RADIUS	1.030
MAX RADIUS	1.874
HORIZONTAL SPREAD	2.694
VERTICAL SPREAD	2.842
EXTREME SPREAD	2.879
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

7 Jun 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 2.335

VS= 3.689

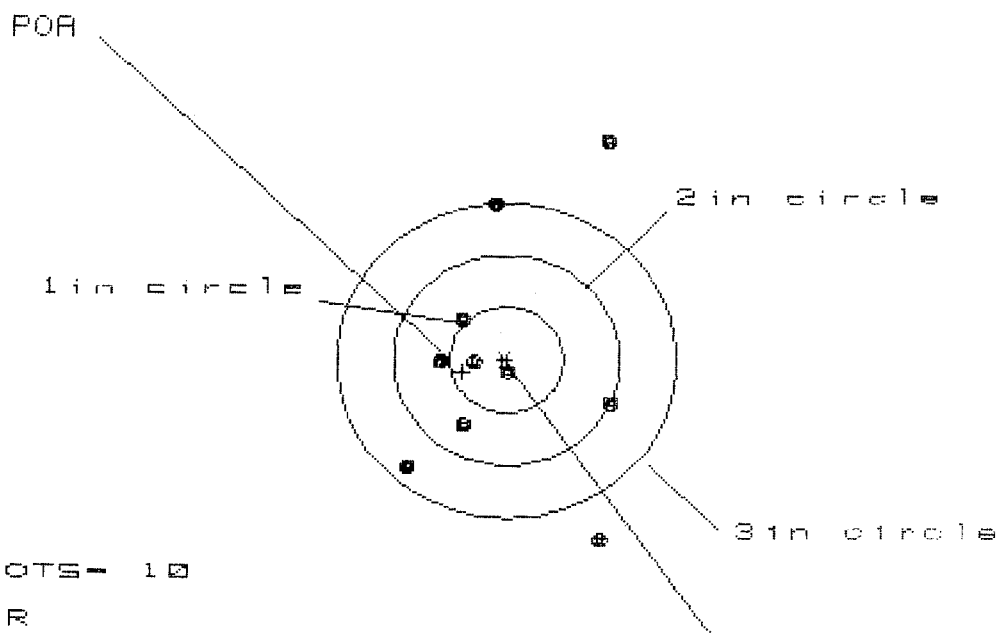
GS= 3.785

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.310	1.284	1.259
MINIMUM X	:	-1.025	-1.051	-0.976
MAXIMUM Y	:	1.581	1.347	0.869
MINIMUM Y	:	-2.107	-1.258	-1.089
CENTROID X	:	.148	.174	.099
CENTROID Y	:	-.432	-.198	-.367
POA TO CENTROID in.	:	.457	.264	.380
MIN RADIUS	:	.543	.461	.524
MEAN RADIUS	:	1.124	.971	.915
MAX RADIUS	:	2.120	1.798	1.742
HORIZONTAL SPREAD	:	2.335	2.335	2.335
VERTICAL SPREAD	:	3.689	2.685	1.952
EXTREME SPREAD	:	3.785	3.047	3.047
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.788

VS= 3.815

GS= 3.815

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.996	1.116
MINIMUM X	-.891	-.792	-.672
MAXIMUM Y	2.081	1.688	1.500
MINIMUM Y	-1.734	-1.503	-.955
CENTROID X	.387	.288	.168
CENTROID Y	.112	-.119	.068
POA TO CENTROID in.	.403	.312	.182
MIN RADIUS	.135	.119	.103
MEAN RADIUS	1.018	.844	.683
MAX RADIUS	2.265	1.783	1.504
HORIZONTAL SPREAD	1.788	1.788	1.788
VERTICAL SPREAD	3.815	3.191	2.455
EXTREME SPREAD	3.815	3.337	2.574
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		