

C6636030

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400036913




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

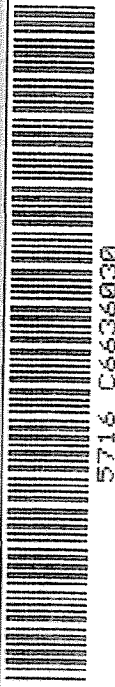
MODEL 700TM H24

SERIAL NO.
C6636030

ORDER NO.
5716

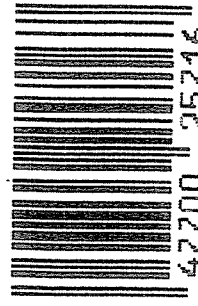
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marquo Deposoo.

20



5716 C6636030

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636030

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 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action	APR 9 1991		KP
	Magnaflux Bolt	APR 9 1991		Y
615	Rollmark Caliber	APR 9 1991		GS
617	Drill and Tap Sight Holes	APR 9 1991		LB
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			RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-21-91	DH
	G) Safety Off Force	2	2	2			5-21-91	DH
	H) Trigger Pull Test & Retainability						5-20-91	DH
	I) Firing Pin Indent	.020	.020	.021			5-21-91	DH
	J) Assemble Stock						5/23/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/23/91	RW
	M) Iron Sight Alignment						5/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	RW
	O) Attach Scope to Rifle						5/23/91	RW
	P) Detach & Attach Scope 20 Times						5/23/91	RW
640	Gallery Target & Test						5/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/23/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.57	2.50	2.49	2.54	2.60	6/1/91	SC
	C) Function						6-1-91	DH
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636030
DATE 5-20-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.34	2.62	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.33	2.51	2.50	
PULL #3	2.40	2.35	2.17	2.49	
PULL #4	2.34	2.32	2.53	2.54	
PULL #5	2.33	2.36	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.37		
PULL #2	3.44	3.37		
PULL #3	3.20	3.29		
PULL #4	3.31	3.34		
PULL #5	3.37	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.18		4.23
PULL #2	4.28	4.24		4.15
PULL #3	4.15	4.16		4.14
PULL #4	4.23	4.30		4.07
PULL #5	4.20	4.27		3.97
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636030
23 May 1991

CENTROIDAL DISTANCES

0 TO	1	.240832
1 TO	2	.385695
1 TO	3	.145121
1 TO	4	.1364
1 TO	5	.281016

$\frac{3}{6}^2$ <----POA

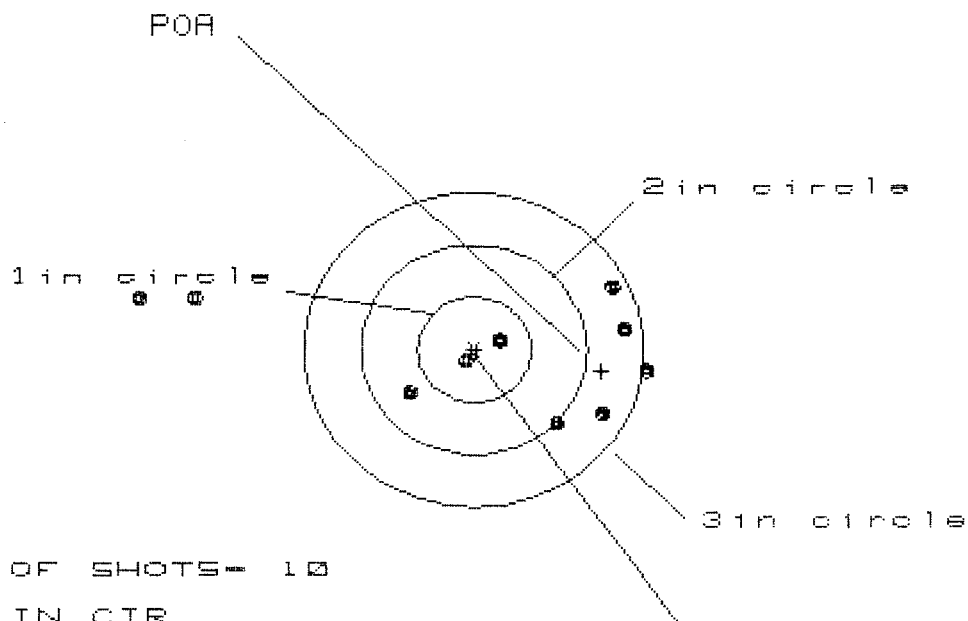
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .174
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1632
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .238559
THE AMR FOR THIS RIFLE IS: 1.092

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636030

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 4.482

VS= 1.279

GS= 4.537

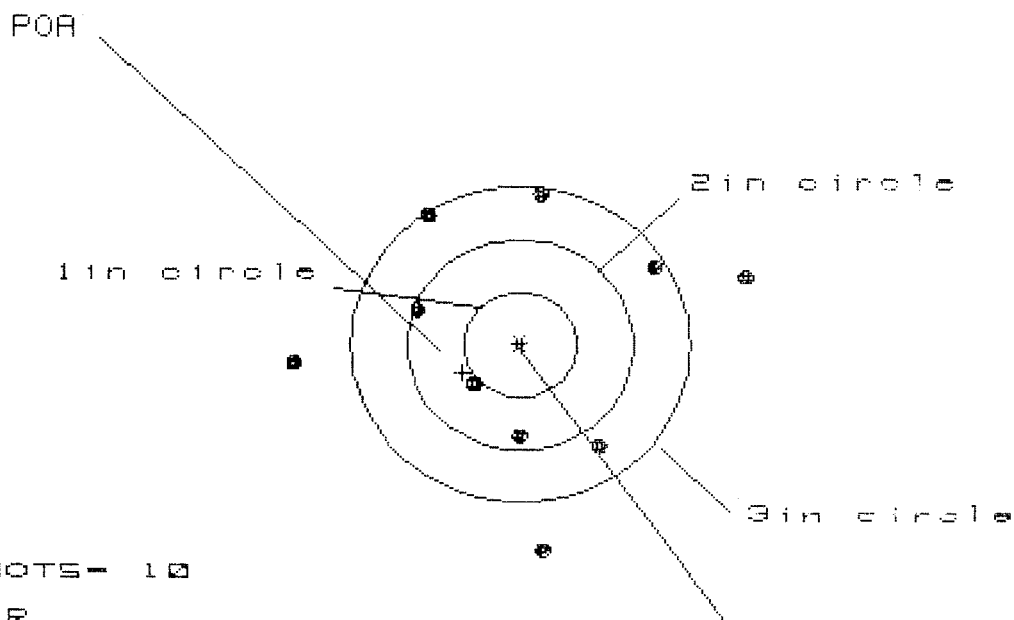
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.218	.870
MINIMUM X	:	-2.938	-2.785	-1.255
MAXIMUM Y	:	.596	.655	.726
MINIMUM Y	:	-.683	-.624	-.553
CENTROID X	:	-1.128	-.802	-.454
CENTROID Y	:	.204	.145	.074
POA TO CENTROID in.	:	1.147	.815	.460
MIN RADIUS	:	.132	.185	.495
MEAN RADIUS	:	1.302	1.045	.774
MAX RADIUS	:	2.985	2.842	1.289
HORIZONTAL SPREAD	:	4.482	4.003	2.125
VERTICAL SPREAD	:	1.279	1.279	1.279
EXTREME SPREAD	:	4.537	4.061	2.139
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	7		

23 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 6

HSI = 4.021

VS = 3.381

GS = 4.099

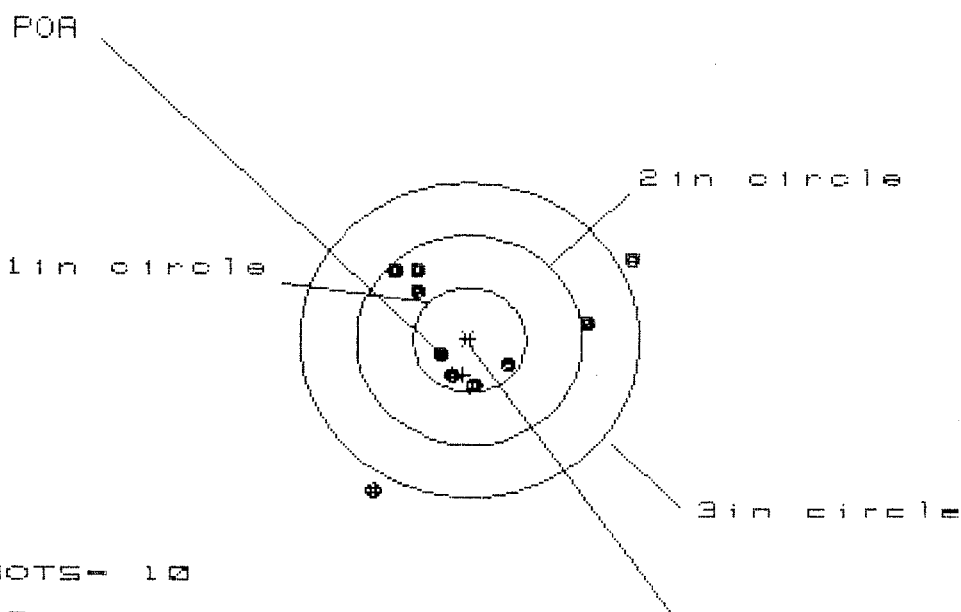
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.969	1.741	1.178
MINIMUM X	:	-2.052	-1.109	-.891
MAXIMUM Y	:	1.442	1.420	1.492
MINIMUM Y	:	-1.939	-1.961	-1.889
CENTROID X	:	.509	.737	.519
CENTROID Y	:	.264	.286	.214
POA TO CENTROID in.	:	.573	.790	.561
MIN RADIUS	:	.590	.787	.566
MEAN RADIUS	:	1.400	1.330	1.231
MAX RADIUS	:	2.061	1.963	1.894
HORIZONTAL SPREAD	:	4.021	2.850	2.069
VERTICAL SPREAD	:	3.381	3.381	3.381
EXTREME SPREAD	:	4.099	3.381	3.381
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 8

HS = 2.389

VS = 2.155

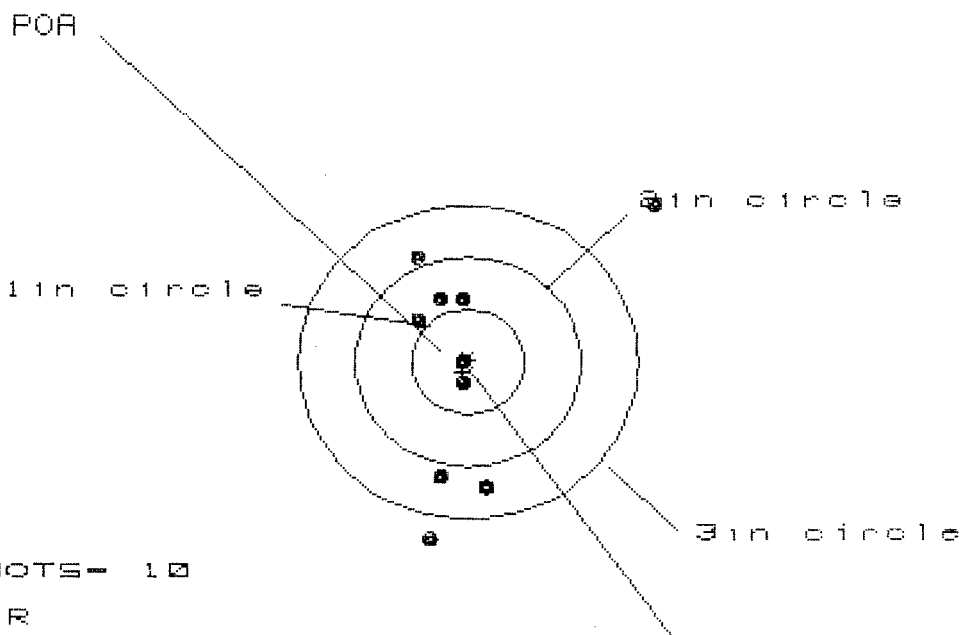
GS = 3.217

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.487	1.224	1.132
MINIMUM X	:	-.982	-.737	-.631
MAXIMUM Y	:	.758	.770	.605
MINIMUM Y	:	-1.397	-1.312	-.541
CENTROID X	:	.056	-.109	-.017
CENTROID Y	:	.330	.245	.409
POA TO CENTROID in.	:	.334	.269	.410
MIN RADIUS	:	.280	.099	.285
MEAN RADIUS	:	.836	.712	.629
MAX RADIUS	:	1.669	1.505	1.133
HORIZONTAL SPREAD	:	2.389	1.961	1.763
VERTICAL SPREAD	:	2.155	2.082	1.147
EXTREME SPREAD	:	3.217	2.485	1.849
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.148

VS= 3.286

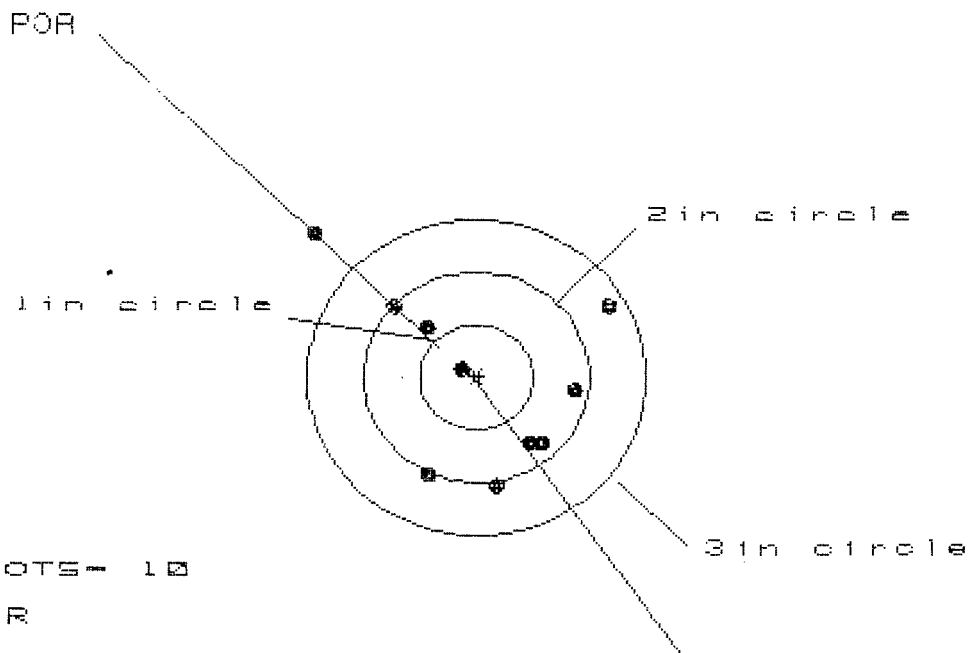
GS= 3.861

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.677	.322	.301
MINIMUM X	:	-.471	-.284	-.305
MAXIMUM Y	:	1.551	1.171	.976
MINIMUM Y	:	-1.734	-1.562	-1.247
CENTROID X	:	.046	-.141	-.120
CENTROID Y	:	.095	-.078	.117
POA TO CENTROID in.	:	.105	.161	.168
MIN RADIUS	:	.044	.174	.125
MEAN RADIUS	:	.961	.822	.684
MAX RADIUS	:	2.285	1.571	1.283
HORIZONTAL SPREAD	:	2.148	.606	.606
VERTICAL SPREAD	:	3.286	2.733	2.223
EXTREME SPREAD	:	3.861	2.734	2.292
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.604

VS= 2.359

GS= 2.873

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.153	.992	.840
MINIMUM X	-1.451	-.867	-.743
MAXIMUM Y	1.365	.833	.936
MINIMUM Y	-.994	-.842	-.739
CENTROID X	.131	.292	.168
CENTROID Y	-.077	-.229	-.332
POA TO CENTROID in.	.152	.371	.372
MIN RADIUS	.171	.387	.379
MEAN RADIUS	.963	.827	.755
MAX RADIUS	1.992	1.291	1.195
HORIZONTAL SPREAD	2.604	1.859	1.583
VERTICAL SPREAD	2.359	1.675	1.675
EXTREME SPREAD	2.873	2.245	1.899
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		