

C6636053

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington




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

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

MODEL 700™ H24

SERIAL NO. C6636053

ORDER NO. 5716

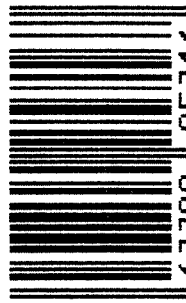
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636053

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636 053

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	KR
	Magnaflux Bolt		APR 9 1991	11
615	Rollmark Caliber		APR 9 1991	GL
617	Drill and Tap Sight Holes		APR 10 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	PA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-16-91	JH
	G) Safety Off Force	4	4	4			5-16-91	JH
	H) Trigger Pull Test & Retainability						5-16-91	JH
	I) Firing Pin Indent	1023	1023	1023			5-16-91	JH
	J) Assemble Stock						5/18/91	RW
	K) Assemble Swivel Studs						5-23-91	DH
	L) Attach Front and Rear Sight Assemblies						5/18/91	RW
	M) Iron Sight Alignment						5/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/18/91	RW
	O) Attach Scope to Rifle						5/18/91	RW
	P) Detach & Attach Scope 20 Times						5/18/91	RW
640	Gallery Target & Test						5-21-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-21-91	AF
655	Final Inspection							
	A) Headspace						5-23-91	DH
	B) Trigger Pull	2.44	2.37	2.40	2.44	2.42	5/23/91	JH
	C) Function						5-23-91	DH
660	Pack						6-20-91	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-6636053

DATE 5-16-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.53	2.48	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.46	2.45	2.37	
PULL #3	2.41	2.47	2.53	2.40	
PULL #4	2.44	2.50	2.48	2.44	
PULL #5	2.43	2.52	2.50	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.49		
PULL #2	3.48	3.52		
PULL #3	3.57	3.54		
PULL #4	3.58	3.54		
PULL #5	3.57	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.53		4.15
PULL #2	4.37	4.51		4.55
PULL #3	4.49	4.55		4.48
PULL #4	4.51	4.60		4.58
PULL #5	4.42	4.46		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636053
22 May 1991

CENTROIDAL DISTANCES

0 TO	1	.270913
1 TO	2	.185311
1 TO	3	.501185
1 TO	4	.506053
1 TO	5	.486738

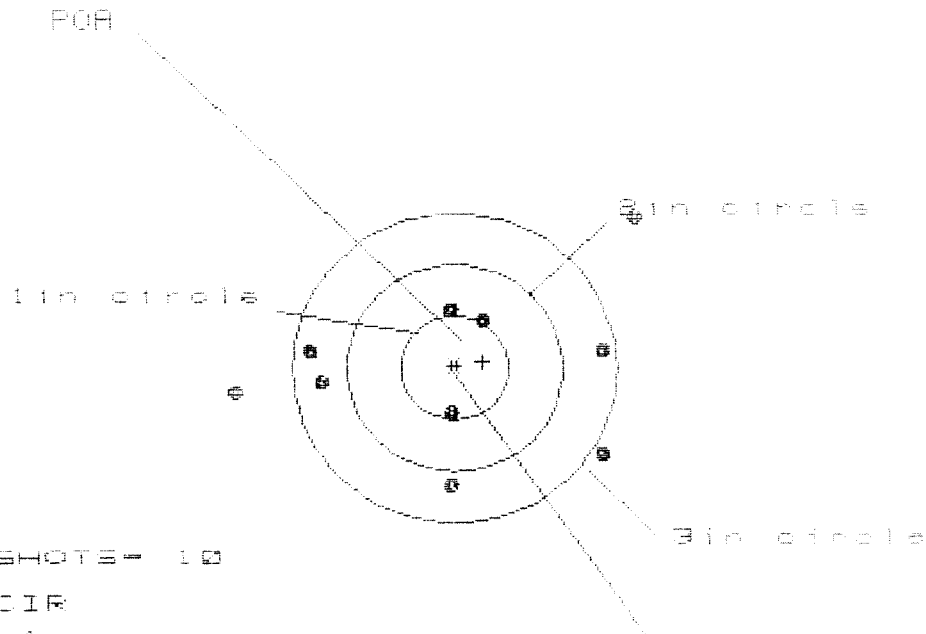
183
54 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.094
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0967256
THE AMR FOR THIS RIFLE IS: 1.12

28 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06536058.1

CENTERFIRE PATTERNS # 1

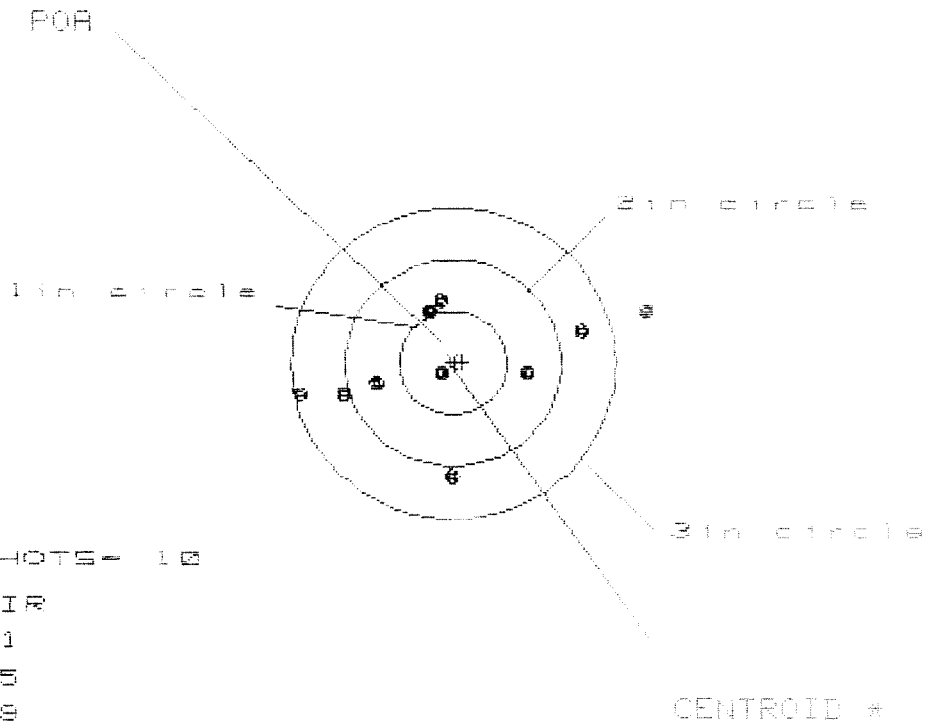


PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.695	1.569	1.042
MINIMUM X	:	-2.065	-1.817	-1.032
MAXIMUM Y	:	1.486	.696	.672
MINIMUM Y	:	-1.159	-.994	-1.063
CENTROID X	:	-.263	-.451	-.224
CENTROID Y	:	-.065	-.236	-.216
POA TO CENTROID in.	:	.271	.506	.311
MIN RADIUS	:	.437	.317	.293
MEAN RADIUS	:	1.246	1.124	1.018
MAX RADIUS	:	2.254	1.820	1.444
HORIZONTAL SPREAD	:	3.700	3.386	2.674
VERTICAL SPREAD	:	2.645	1.680	1.680
EXTREME SPREAD	:	4.099	3.417	2.783
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08686053.)

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.166

VS= 1.741

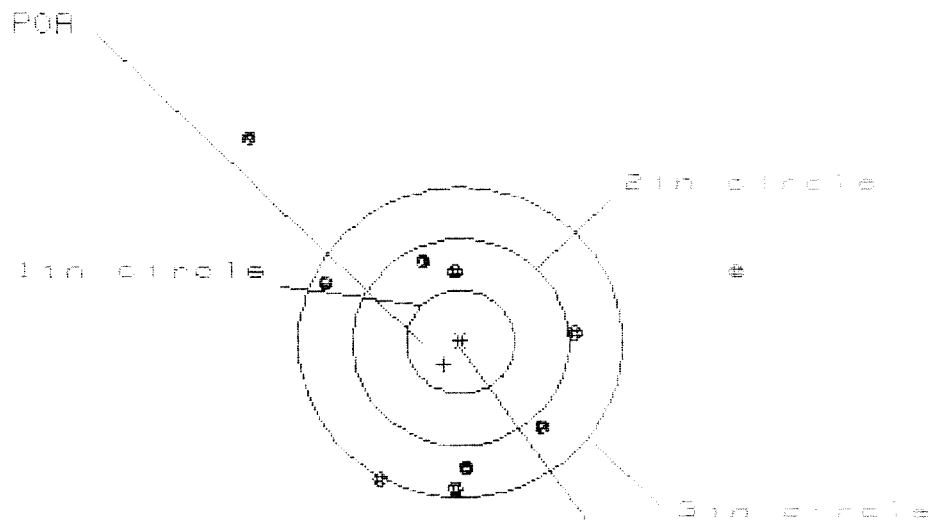
GS= 3.271

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.766	1.360	1.209
MINIMUM X	-1.399	-1.203	-1.003
MAXIMUM Y	.641	.702	.676
MINIMUM Y	-1.100	-1.039	-1.065
CENTROID X	-.087	-.283	-.132
CENTROID Y	-.007	-.068	-.042
POA TO CENTROID in.	.087	.291	.139
MIN RADIUS	.200	.075	.143
MEAN RADIUS	.939	.804	.758
MAX RADIUS	1.851	1.413	1.262
HORIZONTAL SPREAD	3.166	2.563	2.212
VERTICAL SPREAD	1.741	1.741	1.741
EXTREME SPREAD	3.271	2.631	2.296
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06536053.1

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 2

3in = 7

HS = 4.477

VS = 3.390

GS = 4.646

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.562	2.349	1.134
MINIMUM X	-1.915	-1.423	-1.129
MAXIMUM Y	1.938	1.027	1.141
MINIMUM Y	-1.452	-1.236	-1.122
CENTROID X	.152	.365	.071
CENTROID Y	.216	.000	-.114
POA TO CENTROID in.	.264	.365	.134
MIN RADIUS	.635	.757	.855
MEAN RADIUS	1.453	1.288	1.113
MAX RADIUS	2.725	2.520	1.458
HORIZONTAL SPREAD	4.477	3.772	2.263
VERTICAL SPREAD	3.390	2.263	2.263
EXTREME SPREAD	4.646	3.889	2.360
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	7	

22 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06636053.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 2.971

VS = 3.305

GS = 3.870

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.704

.551

.536

MINIMUM X

-1.267

-1.078

-1.093

MAXIMUM Y

1.436

1.228

.784

MINIMUM Y

-1.869

-1.315

-1.162

CENTROID X

.220

.031

.046

CENTROID Y

-.216

-.008

-.161

POA TO CENTROID in.

.308

.002

.168

MIN RADIUS

.363

.463

.356

MEAN RADIUS

.971

.784

.718

MAX RADIUS

2.529

1.321

1.167

HORIZONTAL SPREAD

2.971

1.629

1.629

VERTICAL SPREAD

3.305

2.543

1.946

EXTREME SPREAD

3.870

2.555

1.947

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

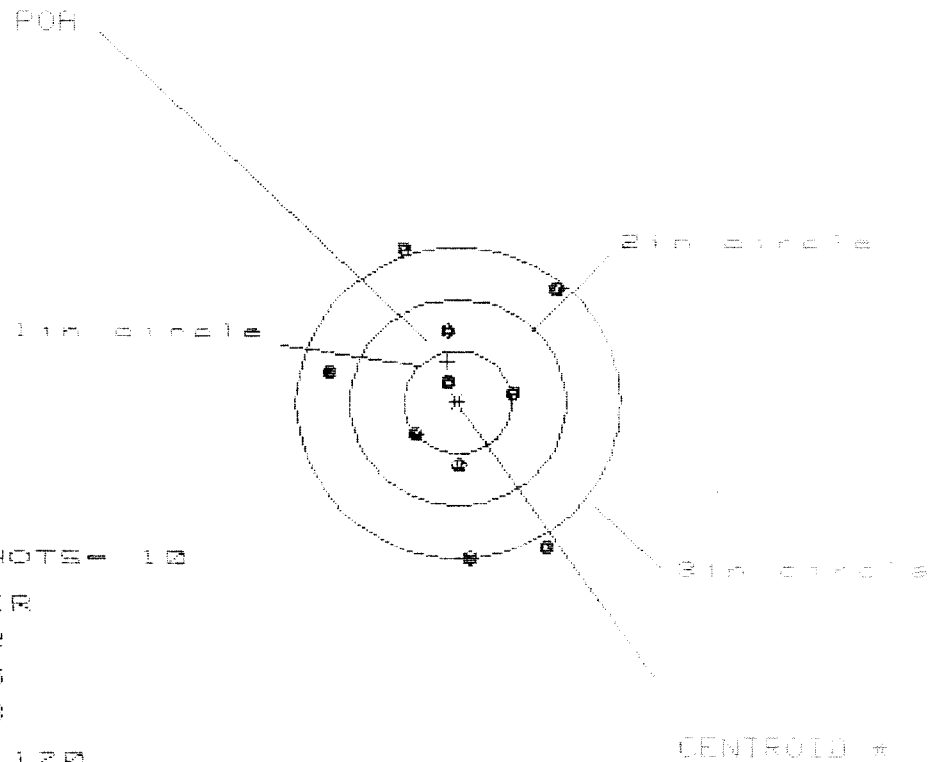
NUMBER IN THREE INCH CIRCLE =

9

22 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06636853.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.170

VS = 2.955

GS = 3.198

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.934
MINIMUM X	-1.236
MAXIMUM Y	1.484
MINIMUM Y	-1.471
CENTROID X	.092
CENTROID Y	-.398
POA TO CENTROID in.	.409
MIN RADIUS	.197
MEAN RADIUS	.989
MAX RADIUS	1.659
HORIZONTAL SPREAD	2.170
VERTICAL SPREAD	2.955
EXTREME SPREAD	3.198
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636853
21 May 1991

CENTROIDAL DISTANCES

0 TO	1	.439355
1 TO	2	.597451
1 TO	3	.428515
1 TO	4	.663738
1 TO	5	.792584

5

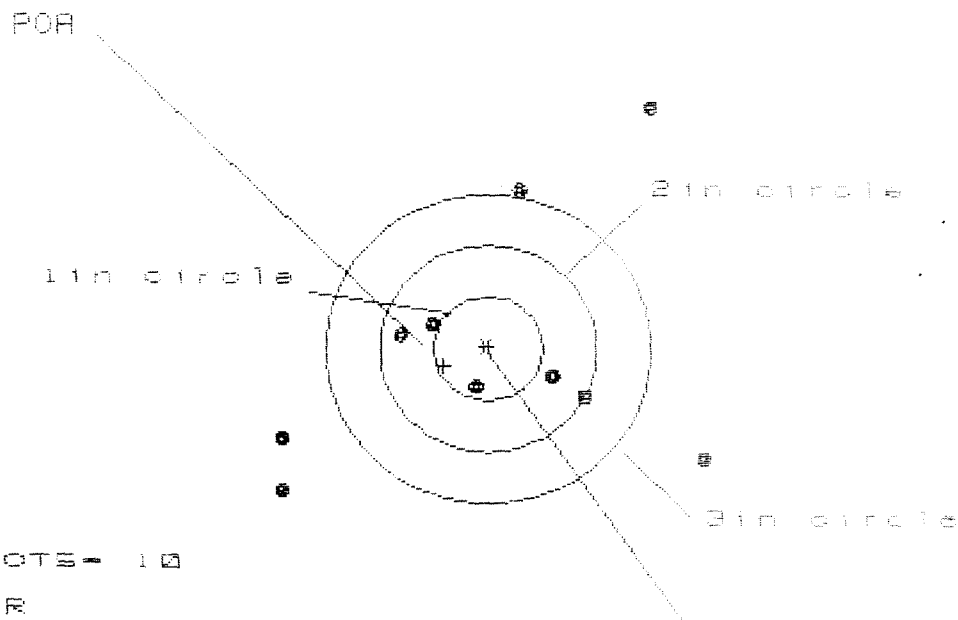
4 1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2416
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241908
THE AMR FOR THIS RIFLE IS: 1.389

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08608093

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 1

2in - 5

3in - 5

HS - 3.230

VS - 3.688

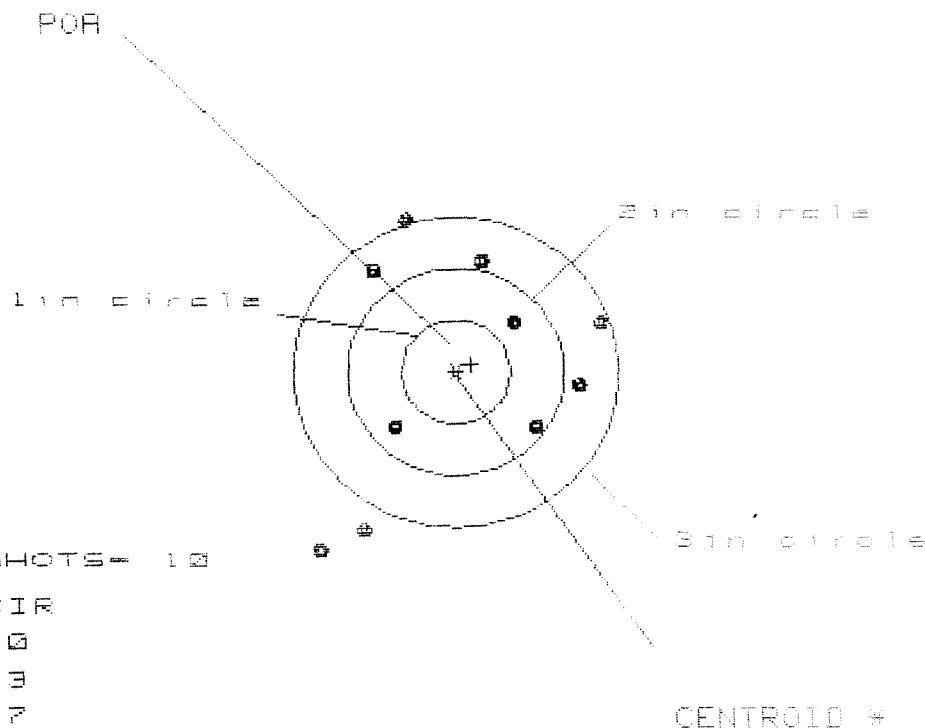
GS - 5.017

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.000	2.166	1.949
MINIMUM X	:	-1.930	-1.764	-1.981
MAXIMUM Y	:	2.368	1.842	1.710
MINIMUM Y	:	-1.320	-1.057	-1.896
CENTROID X	:	.408	.242	.459
CENTROID Y	:	.163	-.100	.032
POA TO CENTROID in.	:	.440	.262	.460
MIN RADIUS	:	.368	.081	.260
MEAN RADIUS	:	1.446	1.260	1.159
MAX RADIUS	:	2.803	2.297	2.145
HORIZONTAL SPREAD	:	3.930	3.930	3.930
VERTICAL SPREAD	:	3.688	2.899	2.606
EXTREME SPREAD	:	5.017	3.932	3.932
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	5		

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0663B053

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.605

VS= 3.217

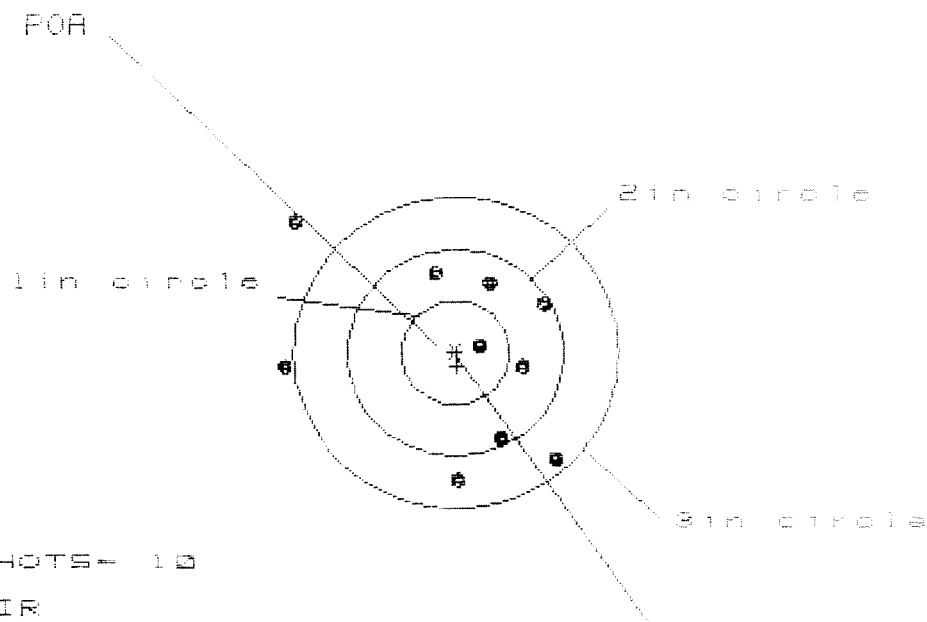
GS= 3.398

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.163	1.037
MINIMUM X	:	-1.298	-1.008	-1.027
MAXIMUM Y	:	1.513	1.323	1.110
MINIMUM Y	:	-1.704	-1.710	-1.973
CENTROID X	:	-.140	.004	.130
CENTROID Y	:	-.075	.115	.320
POA TO CENTROID in.	:	.159	.115	.353
MIN RADIUS	:	.723	.499	.312
MEAN RADIUS	:	1.268	1.128	.975
MAX RADIUS	:	2.142	1.985	1.353
HORIZONTAL SPREAD	:	2.605	2.171	2.064
VERTICAL SPREAD	:	3.217	3.033	2.083
EXTREME SPREAD	:	3.398	3.054	2.429
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636053

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.580

VS= 2.562

GS= 3.403

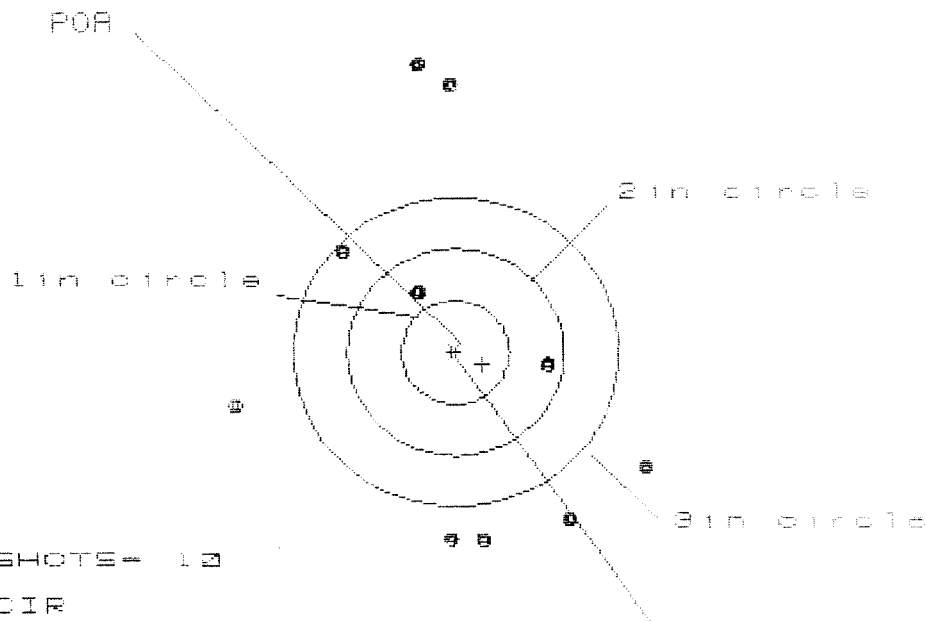
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.957	.795	.571
MINIMUM X	:	-1.623	-1.785	-1.556
MAXIMUM Y	:	1.322	.895	.900
MINIMUM Y	:	-1.240	-1.093	-1.088
CENTROID X	:	-.019	.143	.366
CENTROID Y	:	.127	-.020	-.025
FOR TO CENTROID in.	:	.129	.145	.367
MIN RADIUS	:	.213	.267	.243
MEAN RADIUS	:	1.041	.908	.759
MAX RADIUS	:	1.971	1.786	1.155
HORIZONTAL SPREAD	:	2.580	2.580	1.128
VERTICAL SPREAD	:	2.562	1.988	1.988
EXTREME SPREAD	:	3.403	2.755	2.140
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08836033

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 3

HS = 3.817

VS = 4.633

GS = 4.696

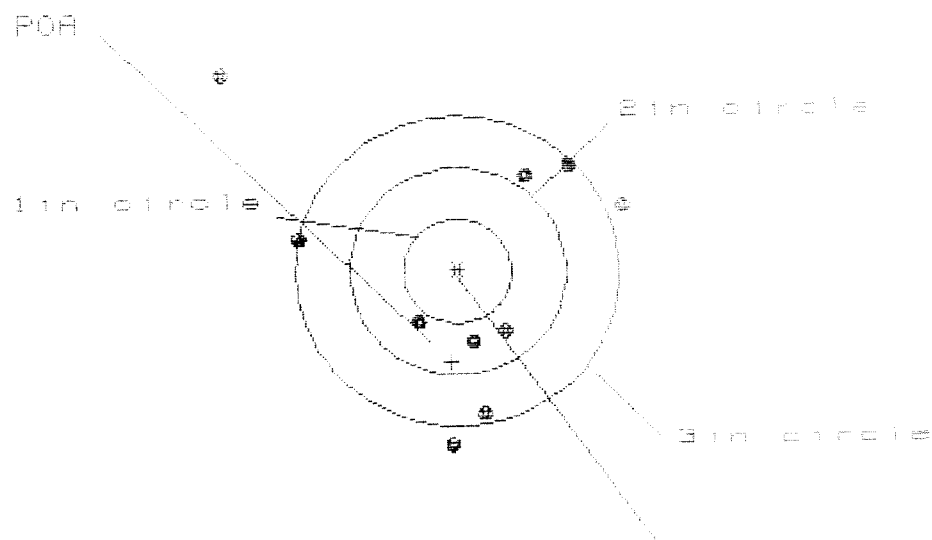
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.742	1.705	1.689
MINIMUM X	:	-2.075	-2.112	-2.128
MAXIMUM Y	:	2.825	2.858	1.615
MINIMUM Y	:	-1.808	-1.495	-1.137
CENTROID X	:	-.254	-.217	-.281
CENTROID Y	:	.115	-.198	-.556
POA TO CENTROID in.	:	.279	.294	.591
MIN RADIUS	:	.691	.837	.989
MEAN RADIUS	:	1.810	1.668	1.478
MAX RADIUS	:	2.844	2.861	2.131
HORIZONTAL SPREAD	:	3.817	3.817	3.817
VERTICAL SPREAD	:	4.633	4.353	2.752
EXTREME SPREAD	:	4.696	4.366	3.853
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		3	

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8596003

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS = 3.779

VS = 3.588

ES = 4.187

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.566	1.320	.954
MINIMUM X	-2.213	-1.740	-1.575
MAXIMUM Y	1.914	1.200	1.309
MINIMUM Y	-1.674	-1.461	-1.352
CENTROID X	.966	.312	.147
CENTROID Y	.878	.665	.556
POA TO CENTROID in.	.880	.735	.575
MIN RADIUS	.567	.446	.337
MEAN RADIUS	1.379	1.137	1.045
MAX RADIUS	2.926	1.820	1.705
HORIZONTAL SPREAD	3.779	3.060	2.528
VERTICAL SPREAD	3.588	2.661	2.661
EXTREME SPREAD	4.187	3.077	2.875
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

MOD. _____ GA. CAL. _____ GUN # 6053

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	5/21	Ejector sticks	RW
	2nd		
	5/22	Peened Ejector Hole Leaded Barrel Re Target	RW
	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		