

C6636088

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*



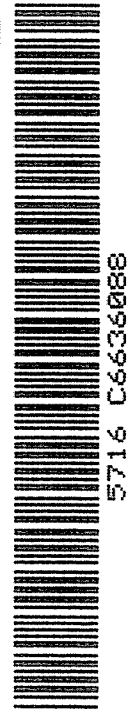

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

**MODEL 700™ H24**

**SERIAL NO. C6636088**

**ORDER NO. 5716**

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



5716 C6636088

UPC



0 47700 25716 7

GUN SERIAL # C6636088

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 5 2 9 1  |         | RW   |
| 600       | Proof                                                    | 5 2 9 1  |         | RW   |
| 607       | Check Headspace                                          | 5 2 9 1  |         | RW   |
| 610       | Dis-assemble Gun                                         | 5 2 9 1  |         | RW   |
| 612       | Magnaflux Barrel Action                                  | 5 8 9 1  |         | KCD  |
|           | Magnaflux Bolt                                           | 5 8 9 1  |         | KCD  |
| 615       | Rollmark Caliber                                         | 5 8 9 1  |         | GB   |
| 617       | Drill and Tap Sight Holes                                | 5 15 9 1 |         | LB   |
| 618       | Polish Barrel                                            | 5 15 9 1 |         | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 5-29-91 | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 5/30/91 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 5/30/91 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 5/30/91 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 5/30/91 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 5/31/91 | JA   |

| Op. #        | Op. Name                                                    | Readings |       |       |      |      | Date    | Init |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |      |      | 5/31/91 | JK   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |      |      | 5/31/91 | JK   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 5/31/91 | JK   |
|              | I) Firing Pin Indent                                        | .022     | .0225 | .0225 |      |      | 5/31/91 | JK   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 5/31/91 | Rev  |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 6-3-91  | N/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 5/31/91 | Rev  |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 5/31/91 | Rev  |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 5/31/91 | Rev  |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 5/31/91 | Rev  |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 5/31/91 | Rev  |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 6-1-91  | NF   |
|              | A) Time                                                     |          |       |       |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 6-1-91  | NF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 6-3-91  | N/H  |
|              | B) Trigger Pull                                             | 2.40     | 2.11  | 2.17  | 2.18 | 2.20 | 6/3/91  | JK   |
|              | C) Function                                                 |          |       |       |      |      | 6-3-91  | N/H  |
| 660          | Pack                                                        |          |       |       |      |      | 6-20-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636088  
DATE 5/31/91  
TESTER JRL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.40             | 2.38                     | 2.48                           | 2.40 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.67                     | 2.55                           | 2.11 |                                                                        |
| PULL #3 | 2.61             | 2.46                     | 2.49                           | 2.17 |                                                                        |
| PULL #4 | 2.47             | 2.36                     | 2.38                           | 2.18 |                                                                        |
| PULL #5 | 2.51             | 2.46                     | 2.50                           | 2.20 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.56             | 3.55                     |  |          |
| PULL #2 | 3.55             | 3.54                     |  |          |
| PULL #3 | 3.67             | 3.55                     |  |          |
| PULL #4 | 3.53             | 3.25                     |  |          |
| PULL #5 | 3.71             | 3.57                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.33             | 4.32                     |                                | 4.16                                 |
| PULL #2 | 4.45             | 4.36                     |                                | 4.34                                 |
| PULL #3 | 4.36             | 4.33                     |                                | 4.49                                 |
| PULL #4 | 4.33             | 4.30                     |                                | 4.31                                 |
| PULL #5 | 4.30             | 4.28                     |                                | 4.34                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

# CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636088

1 Jun 1991

## CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .801414 |
| 1 TO | 2 | .518094 |
| 1 TO | 3 | 1.32959 |
| 1 TO | 4 | .896177 |
| 1 TO | 5 | .944488 |

1  
2  
3  
4  
5  
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1486  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1088  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .164172

THE AMR FOR THIS RIFLE IS: 1.112

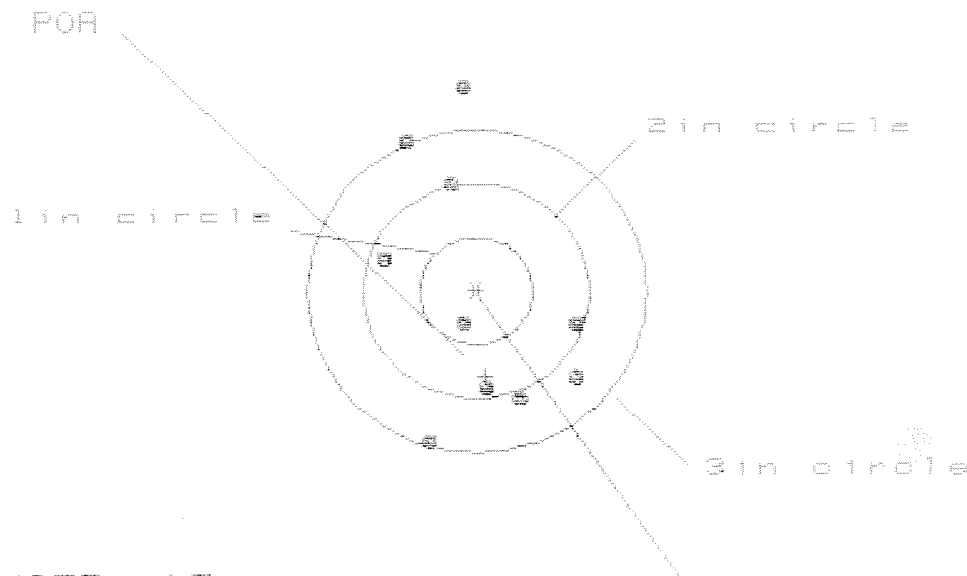


1 Jun 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06635088

# CENTERFIRE PATTERNS

# 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 8

HS= 1.728

VS= 3.311

GS= 3.331

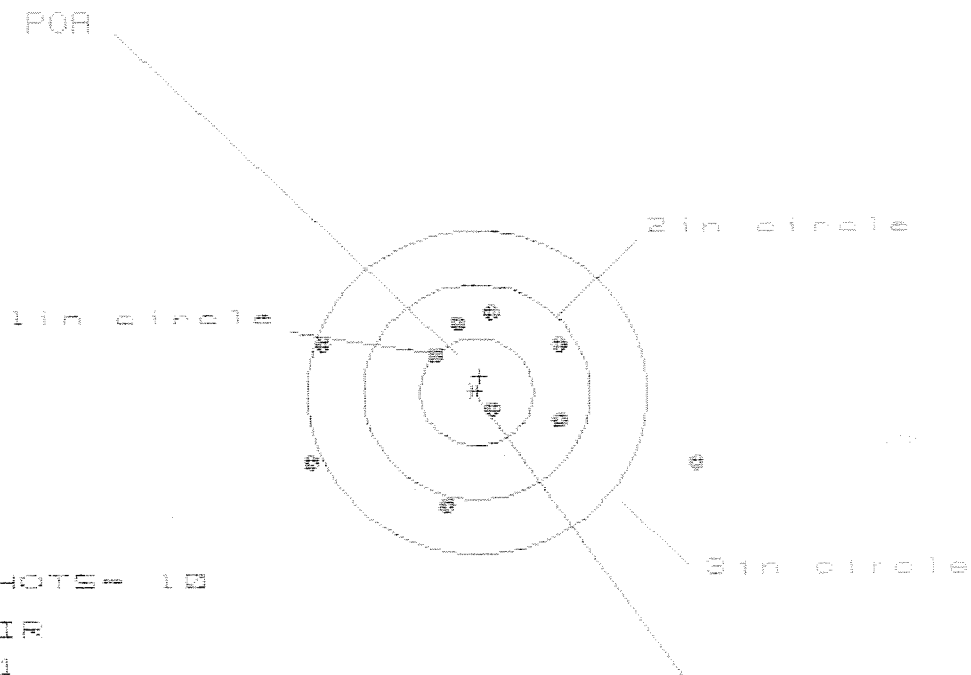
CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .930   | .922   | .841   |
| MINIMUM X                   | : | -.798  | -.806  | -.887  |
| MAXIMUM Y                   | : | 1.885  | 1.595  | 1.422  |
| MINIMUM Y                   | : | -1.426 | -1.217 | -1.017 |
| CENTROID X                  | : | -.084  | -.076  | .005   |
| CENTROID Y                  | : | .797   | .588   | .388   |
| POA TO CENTROID in.         | : | .801   | .592   | .388   |
| MIN RADIUS                  | : | .311   | .144   | .232   |
| MEAN RADIUS                 | : | 1.120  | .986   | .853   |
| MAX RADIUS                  | : | 1.887  | 1.721  | 1.463  |
| HORIZONTAL SPREAD           | : | 1.728  | 1.728  | 1.728  |
| VERTICAL SPREAD             | : | 3.311  | 2.812  | 2.439  |
| EXTREME SPREAD              | : | 3.331  | 2.818  | 2.446  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS = 3.452

VS = 1.815

GS = 3.452

CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | -1.936 | -1.945 | -1.783 |
| MINIMUM X                   | : | -1.516 | -1.301 | -1.282 |
| MAXIMUM Y                   | : | .787   | .716   | .626   |
| MINIMUM Y                   | : | -1.028 | -1.099 | -1.189 |
| CENTROID X                  | : | -.031  | -.246  | -.084  |
| CENTROID Y                  | : | -.146  | -.075  | .015   |
| POA TO CENTROID in.         | : | .149   | .257   | .085   |
| MIN RADIUS                  | : | .210   | .331   | .362   |
| MEAN RADIUS                 | : | .995   | .876   | .763   |
| MAX RADIUS                  | : | 2.037  | 1.488  | 1.309  |
| HORIZONTAL SPREAD           | : | 3.452  | 2.246  | 2.065  |
| VERTICAL SPREAD             | : | 1.815  | 1.815  | 1.815  |
| EXTREME SPREAD              | : | 3.452  | 2.482  | 2.143  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |



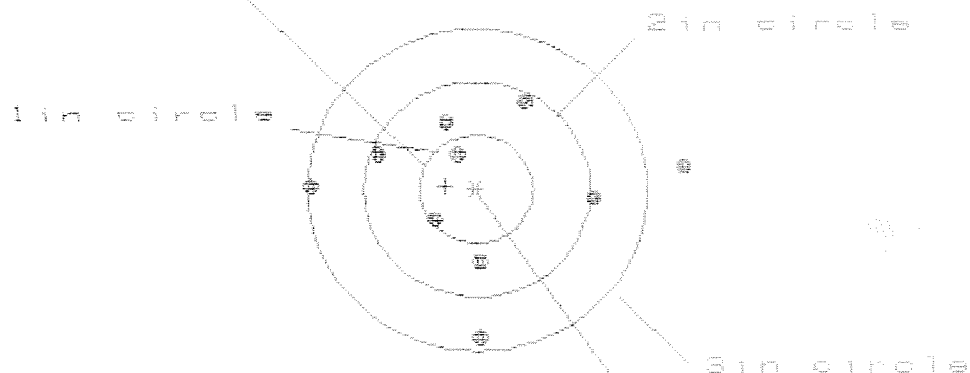
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# CENTERFIRE PATTERNS

# 4

POA



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.255

VS= 2.132

GS= 3.273

CENTROID \*

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.797

1.209

1.051

MINIMUM X

-1.468

-1.269

-.862

MAXIMUM Y

.800

.829

.837

MINIMUM Y

-1.332

-1.303

-1.295

CENTROID X

.273

.074

.232

CENTROID Y

-.025

-.054

-.062

POA TO CENTROID in.

.275

.092

.241

MIN RADIUS

.378

.327

.388

MEAN RADIUS

.966

.841

.794

MAX RADIUS

1.816

1.328

1.298

HORIZONTAL SPREAD

3.265

2.478

1.913

VERTICAL SPREAD

2.132

2.132

2.132

EXTREME SPREAD

3.273

2.479

2.160

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

1 JUN 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8535088

# CENTERFIRE PATTERNS

# 3

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 2

3 in = 6

HS= 2.888

VS= 3.678

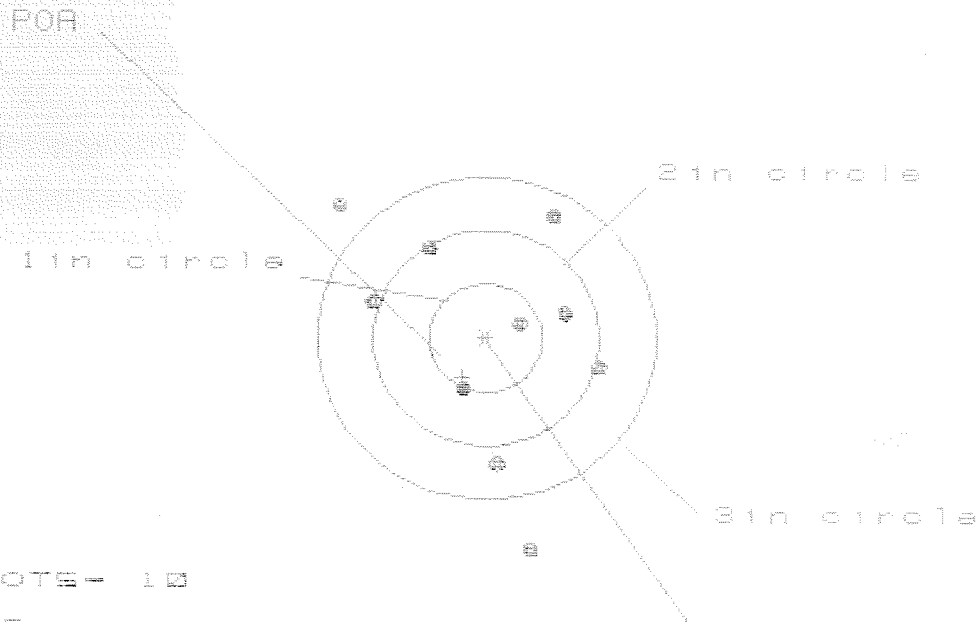
GS= 3.746

| PATTERN #                     | 3      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.317  | 1.391  | 1.517  |
| MINIMUM X                     | -1.552 | -1.478 | -1.352 |
| MAXIMUM Y                     | 1.240  | .970   | .759   |
| MINIMUM Y                     | -2.438 | -1.686 | -1.709 |
| CENTROID X                    | .380   | .306   | .130   |
| CENTROID Y                    | -.449  | -.179  | .032   |
| POA TO CENTROID in.           | .588   | .354   | .183   |
| MIN RADIUS                    | .650   | .660   | .532   |
| MEAN RADIUS                   | 1.399  | 1.213  | 1.064  |
| MAX RADIUS                    | 2.526  | 1.964  | 1.674  |
| HORIZONTAL SPREAD             | 2.869  | 2.869  | 2.869  |
| VERTICAL SPREAD               | 3.678  | 2.656  | 1.468  |
| EXTREME SPREAD                | 3.746  | 3.079  | 3.079  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 2      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 6      |        |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.268

VS= 3.117

GS= 3.573

CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 2      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .962   | 1.011  | .654   |
| MINIMUM X                   | : | -1.306 | -1.257 | -1.162 |
| MAXIMUM Y                   | : | 1.187  | .973   | 1.019  |
| MINIMUM Y                   | : | -1.930 | -1.384 | -1.263 |
| CENTROID X                  | : | .205   | .156   | .313   |
| CENTROID Y                  | : | .367   | .581   | .460   |
| POA TO CENTROID in.         | : | .420   | .602   | .556   |
| MIN RADIUS                  | : | .382   | .396   | .247   |
| MEAN RADIUS                 | : | 1.078  | .971   | .858   |
| MAX RADIUS                  | : | 1.980  | 1.589  | 1.263  |
| HORIZONTAL SPREAD           | : | 2.268  | 2.268  | 2.016  |
| VERTICAL SPREAD             | : | 3.117  | 2.357  | 2.282  |
| EXTREME SPREAD              | : | 3.573  | 2.740  | 2.330  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |