

C6536118

MODEL 700™ N24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

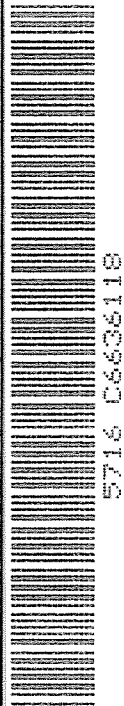
Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

SERIAL NO.
C6636118

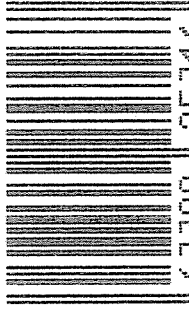
ORDER NO.
5716

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



5716 C6636118

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636118**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	15 8 91		KCK
	Magnaflux Bolt	5 8 91		KCK
615	Rollmark Caliber	5 8 91		CS
617	Drill and Tap Sight Holes	5 15 91		CS
618	Polish Barrel	5 15 91		CS
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)		5-31-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KL
	C) Inspect Ejector Hole for Chamfer		7/15/91	KL
	D) Oil Firing Pin Ass'y		7/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	SE

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			7-17-91	SH
	G) Safety Off Force	5	5	5			7-17-91	SH
	H) Trigger Pull Test & Retainability						7-17-91	SH
	I) Firing Pin Indent	.021	.0215	.021			7-17-91	SH
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-24-91	DH
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						7/23/91	KT
655	Final Inspection							
	A) Headspace						7-24-91	DH
	B) Trigger Pull	2.17	2.23	2.20	2.15	2.17	7-24-91	SH
	C) Function						7-24-91	DH
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636118

DATE 7-17-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.57	2.50	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.65	2.55	2.23	
PULL #3	2.60	2.48	2.43	2.20	
PULL #4	2.56	2.64	2.53	2.15	
PULL #5	2.30	2.53	2.50	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.34		
PULL #2	3.61	3.48		
PULL #3	3.38	3.22		
PULL #4	3.32	3.27		
PULL #5	3.34	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.34		4.37
PULL #2	4.31	4.35		4.18
PULL #3	4.37	4.30		4.32
PULL #4	4.35	4.33		4.31
PULL #5	4.18	4.31		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6536118
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.194201
1 TO	2	.411428
1 TO	3	.245652
1 TO	4	.221813
1 TO	5	.13568

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .003
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00798499

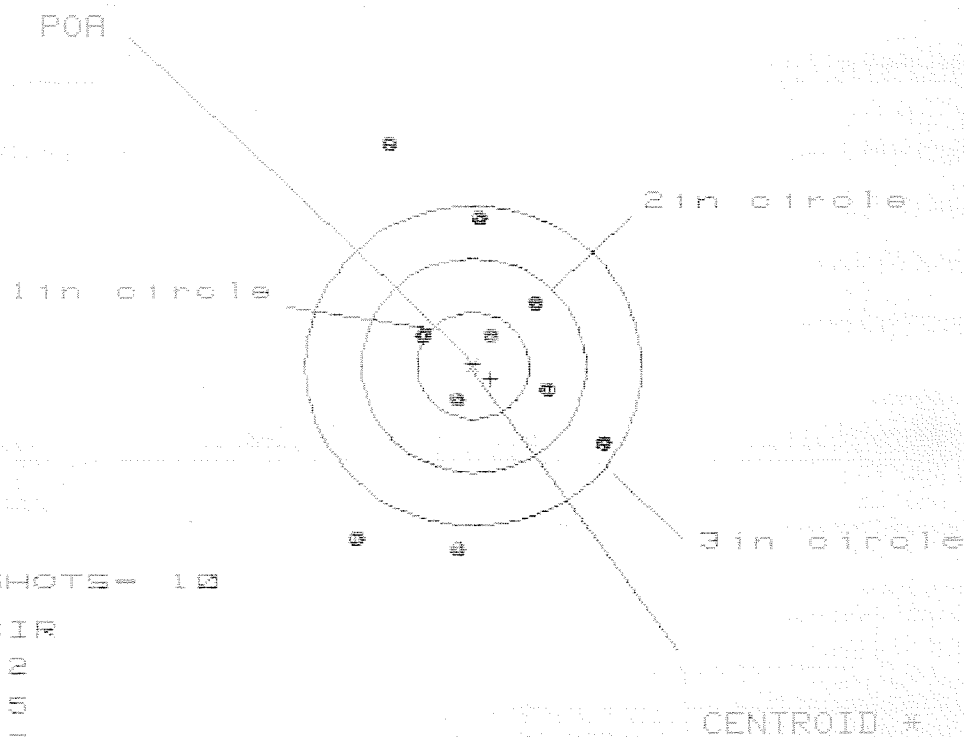
THE AMR FOR THIS RIFLE IS: 1.001

23 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636118

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.142

VS= 3.810

GS= 3.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.123	1.037	.899
MINIMUM X	-1.019	-1.105	-1.716
MAXIMUM Y	2.068	1.651	1.474
MINIMUM Y	-1.742	-1.512	-1.689
CENTROID X	-.155	-.069	.069
CENTROID Y	.117	-.113	.064
POA TO CENTROID in.	.194	.132	.094
MIN RADIUS	.322	.243	.327
MEAN RADIUS	1.135	1.012	.879
MAX RADIUS	2.208	1.795	1.720
HORIZONTAL SPREAD	2.142	2.142	1.615
VERTICAL SPREAD	3.810	3.163	3.163
EXTREME SPREAD	3.868	3.256	3.168
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

23 Jul 1991

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 2.799

VS= 2.496

GS= 3.376

PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.617	1.075	1.146
MINIMUM X	-1.182	-1.002	-.931
MAXIMUM Y	1.332	1.476	1.193
MINIMUM Y	-1.164	-1.016	-.832
CENTROID X	.088	-.092	-.163
CENTROID Y	-.215	-.363	-.547
POA TO CENTROID in.	.232	.374	.571
MIN RADIUS	.456	.586	.404
MEAN RADIUS	1.205	1.076	.978
MAX RADIUS	2.095	1.583	1.394
HORIZONTAL SPREAD	2.799	2.077	2.077
VERTICAL SPREAD	2.496	2.492	2.025
EXTREME SPREAD	3.376	2.705	2.576
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		9	

28 Jul 1991

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.791

VS= 1.528

GS= 2.794

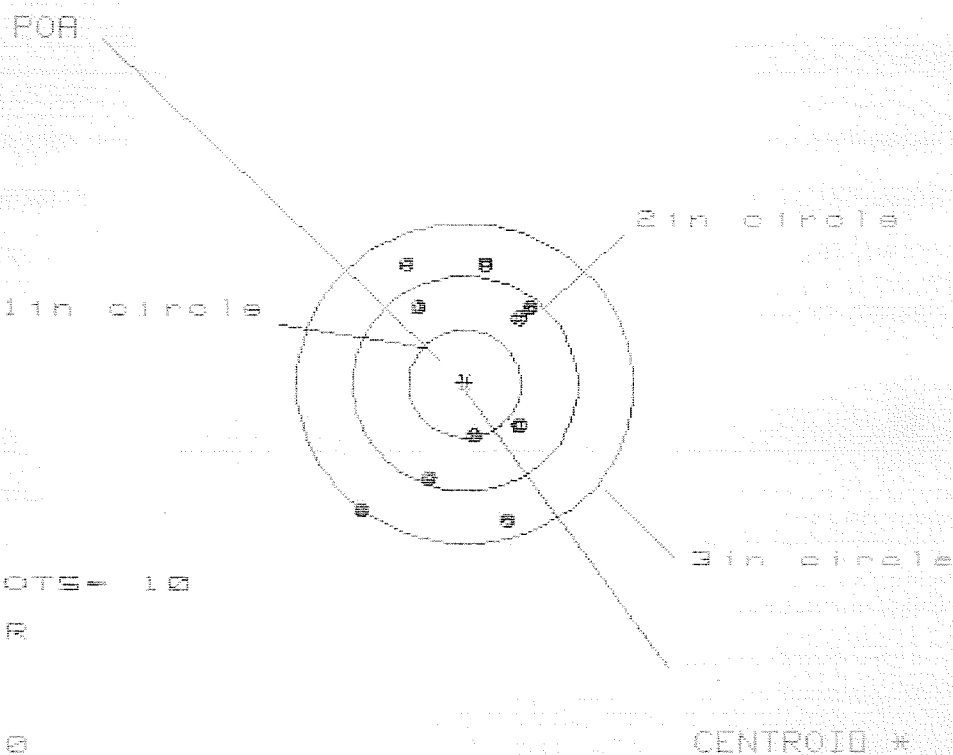
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.527	1.244	1.107
MINIMUM X	:	-1.264	-1.094	-.805
MAXIMUM Y	:	.625	.648	.692
MINIMUM Y	:	-.903	-.880	-.836
CENTROID X	:	.088	-.082	.055
CENTROID Y	:	.081	.058	.014
POA TO CENTROID in.	:	.120	.100	.057
MIN RADIUS	:	.404	.265	.409
MEAN RADIUS	:	.893	.793	.752
MAX RADIUS	:	1.541	1.257	1.116
HORIZONTAL SPREAD	:	2.791	2.338	1.912
VERTICAL SPREAD	:	1.528	1.528	1.528
EXTREME SPREAD	:	2.794	2.399	2.005
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Jul 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.437

VS= 2.441

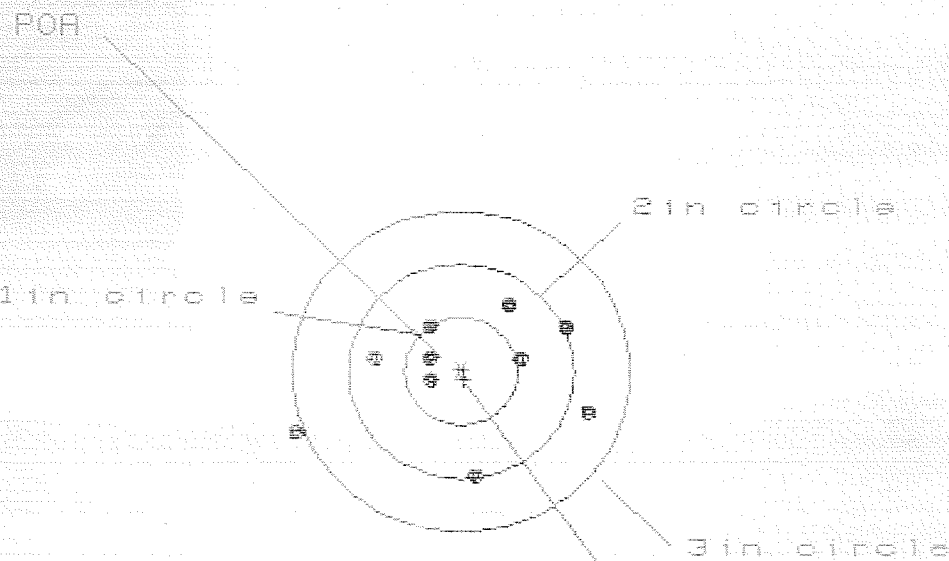
GS= 2.627

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.559	.462	.500
MINIMUM X	-.877	-.666	-.628
MAXIMUM Y	1.123	.989	.807
MINIMUM Y	-1.319	-1.452	-1.148
CENTROID X	.021	.118	.080
CENTROID Y	-.018	.115	.297
POA TO CENTROID in.	.028	.165	.307
MIN RADIUS	.497	.618	.517
MEAN RADIUS	.977	.901	.804
MAX RADIUS	1.490	1.484	1.213
HORIZONTAL SPREAD	1.437	1.128	1.128
VERTICAL SPREAD	2.441	2.441	1.955
EXTREME SPREAD	2.627	2.627	2.012
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

23 Jul 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.551

VS= 1.617

GS= 2.640

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.087	.924	.923
MINIMUM X	-1.465	-.934	-.819
MAXIMUM Y	.667	.602	.549
MINIMUM Y	-.950	-1.015	-1.068
CENTROID X	-.027	.136	.021
CENTROID Y	.072	.137	.190
POA TO CENTROID in.	.077	.193	.191
MIN RADIUS	.275	.355	.286
MEAN RADIUS	.794	.705	.641
MAX RADIUS	1.575	1.018	1.068
HORIZONTAL SPREAD	2.551	1.858	1.742
VERTICAL SPREAD	1.617	1.617	1.617
EXTREME SPREAD	2.640	1.919	1.771
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	