

C6636119

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM H24

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

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

SERIAL NO.
C6636119

ORDER NO.
5716

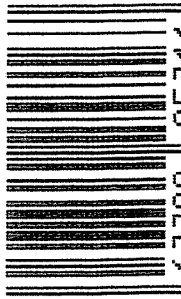
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

06



5716 C6636119

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636119

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	JS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	LB
620	Apply Coatings (Barrel Action)		5-10-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/30/91	JK
	G) Safety Off Force	4	4	4			5/30/91	JK
	H) Trigger Pull Test & Retainability						5/30/91	JK
	I) Firing Pin Indent	.0225	.022	.0215			5/30/91	JK
	J) Assemble Stock						4/3/91	KS
	K) Assemble Swivel Studs						6-14-91	JK
	L) Attach Front and Rear Sight Assemblies						4/3/91	KS
	M) Iron Sight Alignment						4/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/3/91	KS
	O) Attach Scope to Rifle						4/3/91	KS
	P) Detach & Attach Scope 20 Times						4/3/91	KS
640	Gallery Target & Test						6/4/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/4/91	KT
655	Final Inspection							
	A) Headspace						6-14-91	JK
	B) Trigger Pull	2.18	2.20	2.17	2.15	2.16	6-13-91	JK
	C) Function						6-14-91	JK
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636119

DATE 5/30/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.30	2.43	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.49	2.48	2.20	
PULL #3	2.60	2.40	2.44	2.17	
PULL #4	2.38	2.18	2.40	2.15	
PULL #5	2.30	2.46	2.49	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.64	3.45		
PULL #2	3.40	3.39		
PULL #3	3.38	3.50		
PULL #4	3.44	3.45		
PULL #5	3.43	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.29		4.47
PULL #2	4.28	4.26		4.41
PULL #3	4.38	4.27		4.47
PULL #4	4.25	4.32		4.43
PULL #5	4.35	4.33		4.63
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636119
4 Jun 1991

CENTROIDAL DISTANCES

0	TO	1	.782469
1	TO	2	.499235
1	TO	3	.377753
1	TO	4	1.15396
1	TO	5	.597095

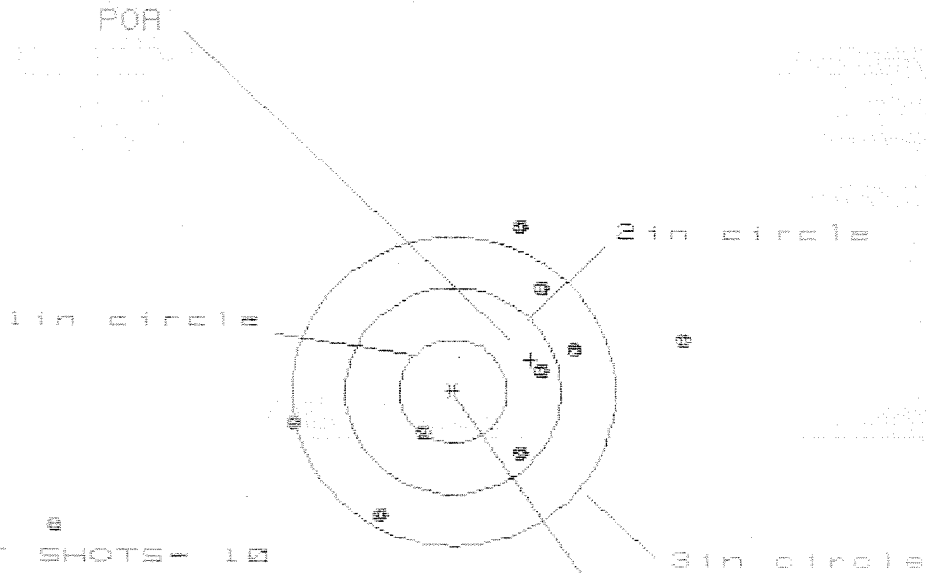
+
32st <----POA
1st

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4448
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0946
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .454749
THE AMR FOR THIS RIFLE IS: 1.184

4 Jun 1991

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CENTERFIRE PATTERNS # 1



HS= 5.815
VS= 2.946
GS= 6.077

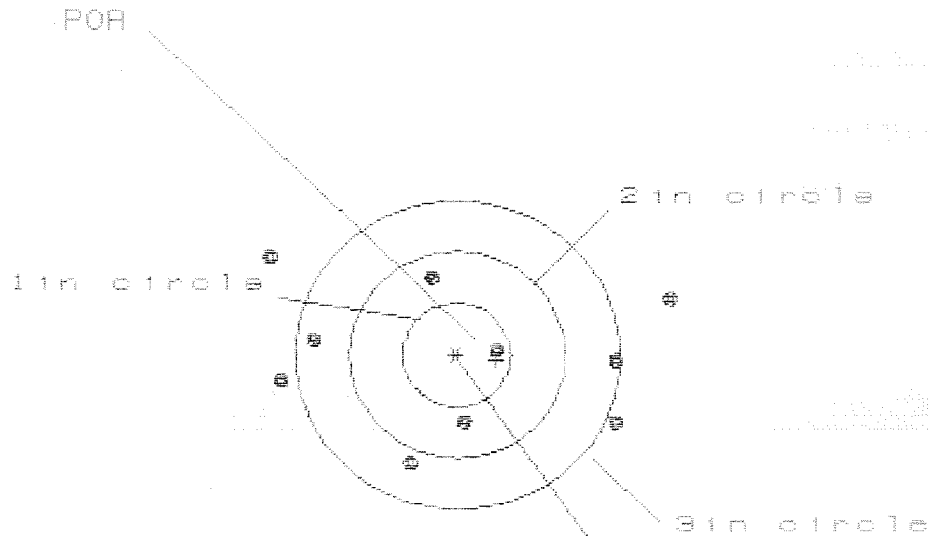
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.182	1.689	1.924
MINIMUM X	-3.713	-1.893	-1.602
MAXIMUM Y	1.649	1.505	1.545
MINIMUM Y	-1.297	-1.368	-1.328
CENTROID X	-.721	-.388	-.519
CENTROID Y	-.384	-.160	-.200
POA TO CENTROID in.	.782	.347	.557
MIN RADIUS	.474	.387	.602
MEAN RADIUS	1.543	1.185	1.137
MAX RADIUS	3.933	1.936	1.721
HORIZONTAL SPREAD	5.815	3.582	2.686
VERTICAL SPREAD	2.946	2.873	2.873
EXTREME SPREAD	6.077	3.656	3.190
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

4 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.591

VS= 1.982

GS= 3.754

CENTROID *

PATTERN #

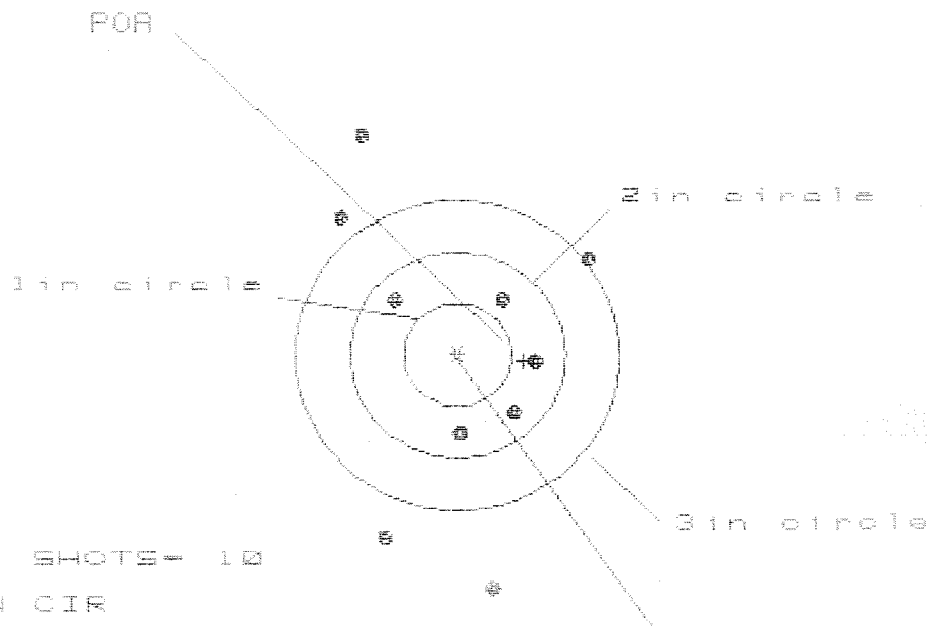
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.986	1.711	1.525
MINIMUM X	-1.705	-1.484	-1.639
MAXIMUM Y	.967	1.033	.952
MINIMUM Y	-1.015	-.949	-.820
CENTROID X	-.365	-.586	-.400
CENTROID Y	-.046	-.020	-.149
POA TO CENTROID in.	.368	.586	.427
MIN RADIUS	.386	.605	.425
MEAN RADIUS	1.301	1.209	1.103
MAX RADIUS	2.073	1.808	1.640
HORIZONTAL SPREAD	3.591	3.195	3.164
VERTICAL SPREAD	1.982	1.982	1.772
EXTREME SPREAD	3.754	3.525	3.172
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636119

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 5

HE= 2.257

VS= 4.415

CS= 4.592

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.230

1.128

1.158

MINIMUM X

-1.037

-1.139

-1.109

MAXIMUM Y

2.126

1.550

1.294

MINIMUM Y

-2.289

-2.053

-1.794

CENTROID X

-.620

-.518

-.548

CENTROID Y

.060

-.176

.081

POA TO CENTROID in.

.623

.547

.554

MIN RADIUS

.696

.497

.627

MEAN RADIUS

1.349

1.214

1.097

MAX RADIUS

2.317

2.067

1.927

HORIZONTAL SPREAD

2.267

2.267

2.267

VERTICAL SPREAD

4.415

3.603

3.087

EXTREME SPREAD

4.592

3.859

3.277

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

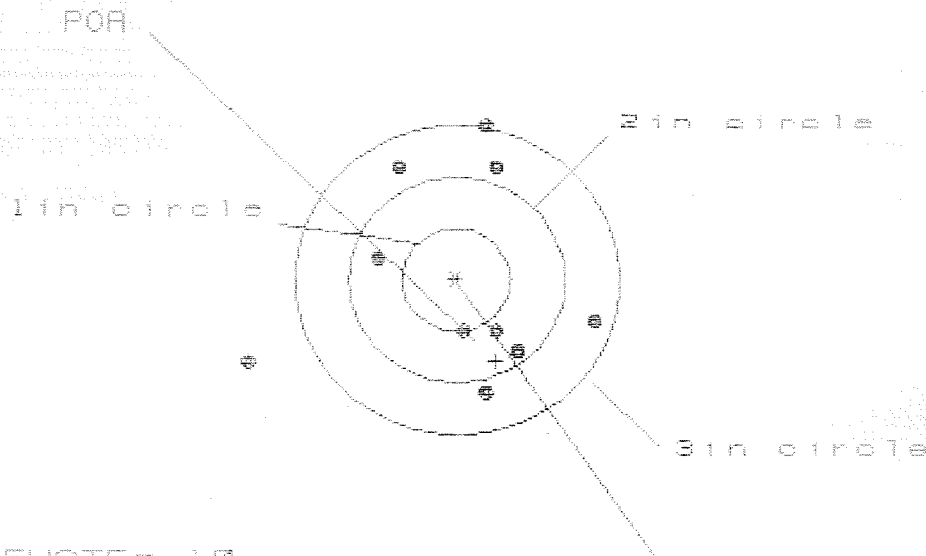
5

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 3.191

VS= 2.609

GS= 3.216

CENTROID %

PATTERN #:

SHOTS (BEST OF)

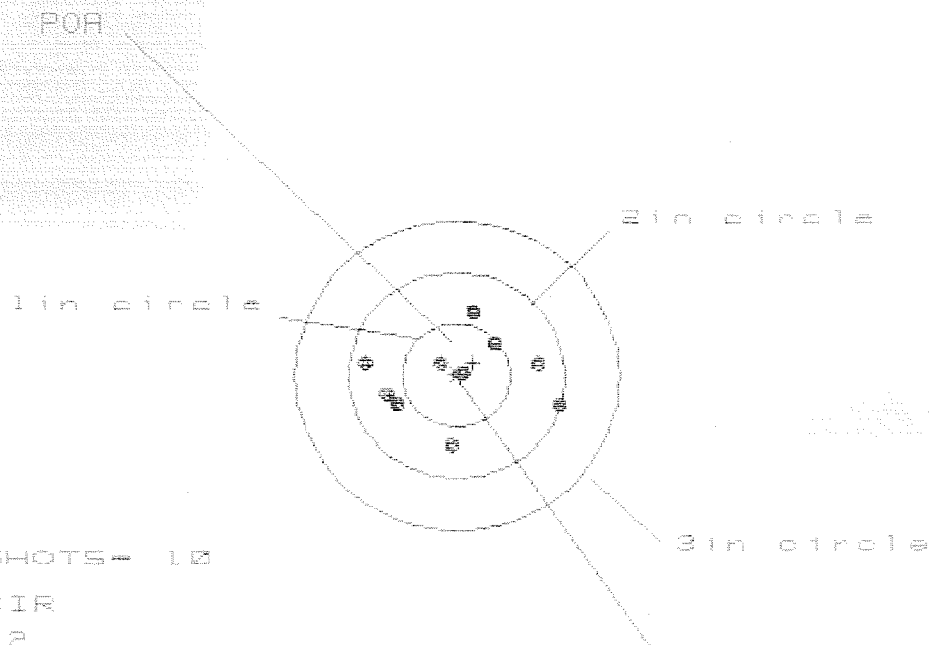
MAXIMUM X	10	9	8
MINIMUM X	-1.281	-1.068	-1.075
MAXIMUM Y	1.472	1.387	1.233
MINIMUM Y	-1.137	-1.222	-1.849
CENTROID X	-.366	-.153	-.160
CENTROID Y	.794	.879	.706
POA TO CENTROID in.	.874	.892	.724
MIN RADIUS	.543	.587	.428
MEAN RADIUS	1.123	1.007	.915
MAX RADIUS	2.059	1.388	1.386
HORIZONTAL SPREAD	3.191	1.996	1.996
VERTICAL SPREAD	2.609	2.609	2.282
EXTREME SPREAD	3.216	2.609	2.346
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.813

VS= 1.324

GS= 1.854

CENTROID #

PATTERN

5

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.958	.818	.726
MINIMUM X	-.845	-.738	-.672
MAXIMUM Y	.661	.633	.648
MINIMUM Y	-.663	-.691	-.676
CENTROID X	-.152	-.259	-.167
CENTROID Y	-.123	-.095	-.110
POA TO CENTROID in.	.195	.276	.200
MIN RADIUS	.089	.086	.102
MEAN RADIUS	.603	.551	.522
MAX RADIUS	.998	.823	.733
HORIZONTAL SPREAD	1.813	1.556	1.398
VERTICAL SPREAD	1.324	1.324	1.324
EXTREME SPREAD	1.854	1.556	1.420
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	