

C6636137

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

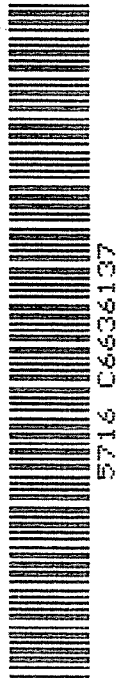
Capacity

Order No. **5715**

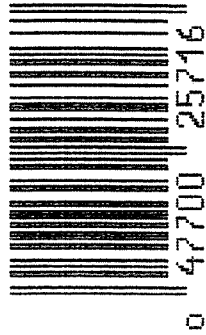
*Includes 1 in chamber.

Remington

Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM M24		SERIAL NO. C6636137	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636137

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28 91		RW
600	Proof	3 28 91		RW
607	Check Headspace	3 28 91		RW
610	Dis-assemble Gun	3 28 91		RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	LC
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WLB
620	Apply Coatings (Barrel Action)		4-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/23/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/23/91	JH
	G) Safety Off Force	4	4	4			4/23/91	JH
	H) Trigger Pull Test & Retainability						4/23/91	JH
	I) Firing Pin Indent	.0225	.0225	.0225			4/23/91	JH
	J) Assemble Stock						4/30/91	RW
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/30/91	RW
	M) Iron Sight Alignment						4/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	RW
	O) Attach Scope to Rifle						4/30/91	RW
	P) Detach & Attach Scope 20 Times						4/30/91	RW
640	Gallery Target & Test						4-30-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-30-91	NF
655	Final Inspection							
	A) Headspace						5-1-91	D/H
	B) Trigger Pull	2.61	2.55	2.61	2.61	2.60	5/10/91	JH
	C) Function						5-1-91	D/H
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636137

DATE 4/23/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.53	2.52	2.61	MIN. SETTING,
PULL #2	2.57	2.45	2.50	2.55	NO AVG. OF 5
PULL #3	2.50	2.46	2.48	2.61	READINGS ACCEPT-
PULL #4	2.59	2.49	2.48	2.61	ABLE LESS THAN 2#
PULL #5	2.58	2.59	2.53	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.28		
PULL #2	3.46	3.39		
PULL #3	3.46	3.37		
PULL #4	3.40	3.34		
PULL #5	3.48	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.43		4.37
PULL #2	4.29	4.45		4.38
PULL #3	4.25	4.37		4.34
PULL #4	4.37	4.43		4.32
PULL #5	4.36	4.39		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636137
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.271649
1 TO	2	.361448
1 TO	3	.204025
1 TO	4	.281325
1 TO	5	.475001

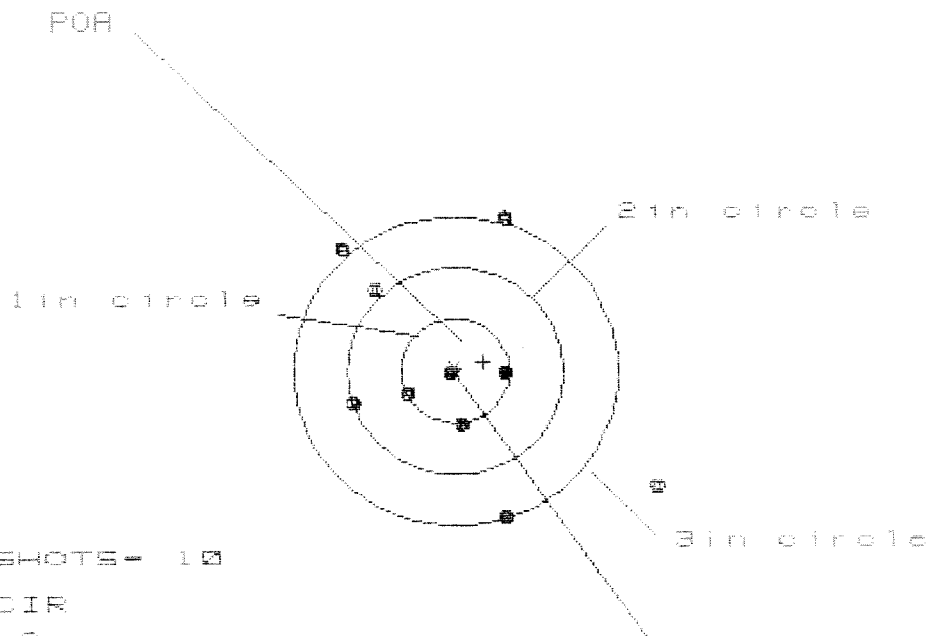
135 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0666
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0198
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0694369
THE AMR FOR THIS RIFLE IS: 1.108

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883B137

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.971

VS= 2.835

GS= 3.774

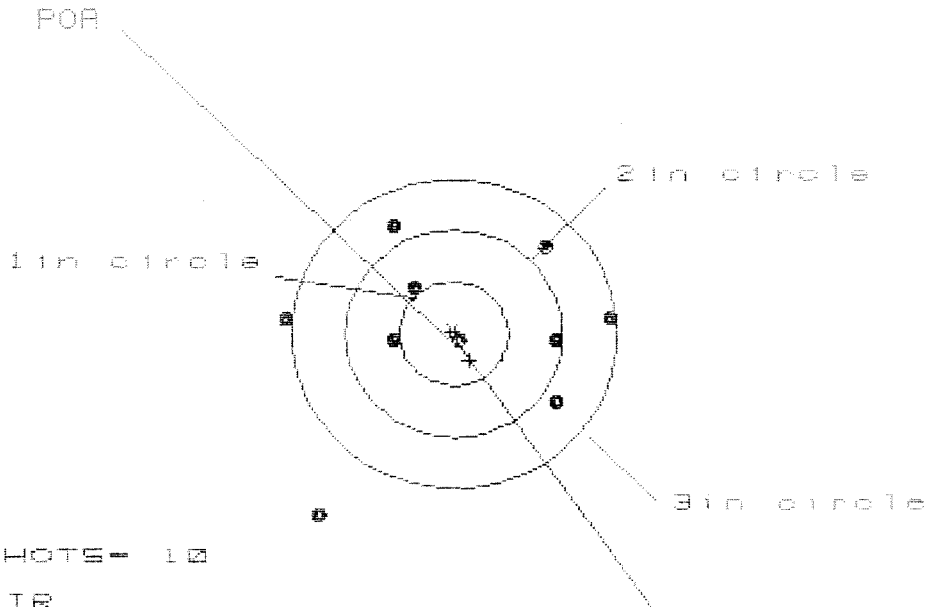
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.884	.709	.599
MINIMUM X	-1.087	-.878	-.826
MAXIMUM Y	1.468	1.344	1.480
MINIMUM Y	-1.367	-1.491	-1.355
CENTROID X	-.257	-.466	-.356
CENTROID Y	-.088	.036	-.100
POA TO CENTROID in.	.271	.467	.370
MIN RADIUS	.085	.164	.037
MEAN RADIUS	1.045	.912	.614
MAX RADIUS	2.189	1.637	1.597
HORIZONTAL SPREAD	2.971	1.587	1.425
VERTICAL SPREAD	2.835	2.835	2.835
EXTREME SPREAD	3.774	3.012	2.835
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636137

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.983

VS = 2.788

GS = 3.262

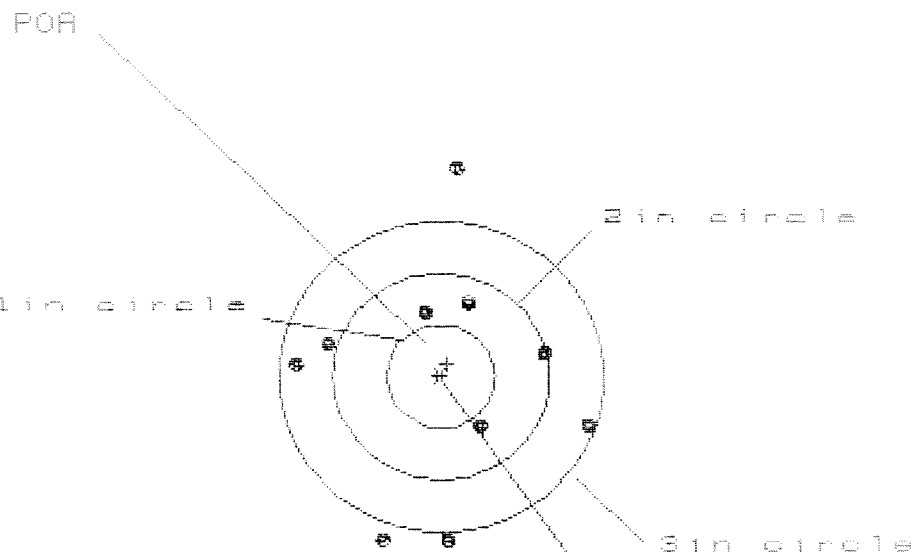
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.455
MINIMUM X	-1.528
MAXIMUM Y	1.052
MINIMUM Y	-1.736
CENTROID X	-.143
CENTROID Y	.255
POA TO CENTROID in.	.292
MIN RADIUS	.079
MEAN RADIUS	1.069
MAX RADIUS	2.125
HORIZONTAL SPREAD	2.983
VERTICAL SPREAD	2.788
EXTREME SPREAD	3.262
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.595

VS= 3.571

GS= 3.622

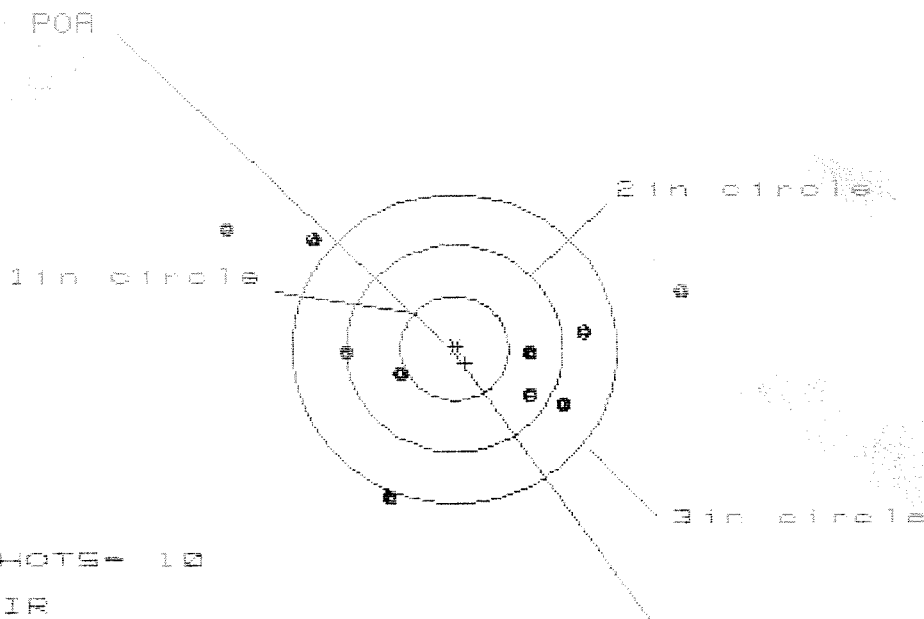
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.330	1.342	1.280
MINIMUM X	-1.365	-1.353	-1.415
MAXIMUM Y	2.010	.943	.776
MINIMUM Y	-1.561	-1.337	-1.478
CENTROID X	-.056	-.068	-.007
CENTROID Y	-.123	-.347	-.180
POA TO CENTROID in.	.135	.353	.130
MIN RADIUS	.574	.426	.500
MEAN RADIUS	1.196	1.105	1.038
MAX RADIUS	2.013	1.424	1.478
HORIZONTAL SPREAD	2.695	2.695	2.695
VERTICAL SPREAD	3.571	2.280	2.254
EXTREME SPREAD	3.622	2.762	2.762
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	7	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 4.203

VS= 2.637

GS= 4.247

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.060	1.822	1.145
MINIMUM X	-2.143	-1.548	-1.320
MAXIMUM Y	1.150	1.170	1.253
MINIMUM Y	-1.487	-1.359	-1.276
CENTROID X	-.095	.143	-.085
CENTROID Y	.142	.014	-.069
POA TO CENTROID in.	.171	.144	.109
MIN RADIUS	.567	.433	.506
MEAN RADIUS	1.323	1.147	1.054
MAX RADIUS	2.432	1.940	1.821
HORIZONTAL SPREAD	4.203	3.370	2.465
VERTICAL SPREAD	2.637	2.529	2.529
EXTREME SPREAD	4.247	3.407	2.903
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 3.077

VS = 2.572

GS = 2.863

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.029	.933	.790
MINIMUM X	:	-1.048	-1.144	-.678
MAXIMUM Y	:	1.454	.896	.821
MINIMUM Y	:	-1.118	-.956	-1.031
CENTROID X	:	.218	.314	.457
CENTROID Y	:	-.087	-.249	-.174
POA TO CENTROID in.	:	.235	.401	.489
MIN RADIUS	:	.136	.201	.333
MEAN RADIUS	:	.909	.816	.746
MAX RADIUS	:	1.593	1.291	1.065
HORIZONTAL SPREAD	:	2.077	2.077	1.468
VERTICAL SPREAD	:	2.572	1.852	1.852
EXTREME SPREAD	:	2.863	2.078	2.046
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=			9