

C6636185

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

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

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

MODEL 700TM M24

SERIAL NO.
C6636185

ORDER NO.
5716

20

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



5716 C6636185

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6636185*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	<i>4 8 91</i>		<i>RW</i>
600	Proof	<i>4 8 91</i>		<i>RW</i>
607	Check Headspace	<i>4 8 91</i>		<i>RW</i>
610	Dis-assemble Gun	<i>4 8 91</i>		<i>RW</i>
612	Magnaflux Barrel Action		<i>APR 9 1991</i>	<i>KR</i>
	Magnaflux Bolt		<i>APR 9 1991</i>	<i>LC</i>
615	Rollmark Caliber		<i>APR 9 1991</i>	<i>YB</i>
617	Drill and Tap Sight Holes		<i>APR 19 1991</i>	<i>WB</i>
618	Polish Barrel		<i>APR 19 1991</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>5-10-91</i>	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		<i>5/14/91</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>5/14/91</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>5/14/91</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>5/14/91</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>5/28/91</i>	<i>JA</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/28/91	JH
	G) Safety Off Force	3	3	3			5/28/91	JH
	H) Trigger Pull Test & Retainability						5/28/91	JH
	I) Firing Pin Indent	.0205	.0205	.020			5/28/91	JH
	J) Assemble Stock						5/28/91	RW
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/28/91	RW
	M) Iron Sight Alignment						5/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	RW
	O) Attach Scope to Rifle						5/28/91	RW
	P) Detach & Attach Scope 20 Times						5/28/91	RW
640	Gallery Target & Test						5-31-91	D/H
	A) Time						5-31-91	D/H
	B) Malfunctions						5-31-91	D/H
	C) Pierced Primers						5-31-91	D/H
	D) Optical Clarity of Scope						5-31-91	D/H
645	Inspect for Live Ammo						5-31-91	D/H
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.25	2.28	2.22	2.30	2.34	6/1/91	JH
	C) Function						6-1-91	D/H
660	Pack						6-19-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636185
DATE 5/28/91
TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.18	2.49	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.42	2.36	2.28	
PULL #3	2.55	2.36	3.44	2.22	
PULL #4	2.59	2.38	2.39	2.30	
PULL #5	2.58	2.47	2.46	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.66		
PULL #2	3.57	3.26		
PULL #3	3.57	3.28		
PULL #4	3.65	3.55		
PULL #5	3.65	3.70		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.62		4.62
PULL #2	4.27	4.59		4.62
PULL #3	4.54	4.65		4.66
PULL #4	4.52	4.42		4.55
PULL #5	4.59	4.55		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636185
31 May 1991

CENTROIDAL DISTANCES

0 TO	1	.428964
1 TO	2	.567088
1 TO	3	.393487
1 TO	4	.513425
1 TO	5	.515982

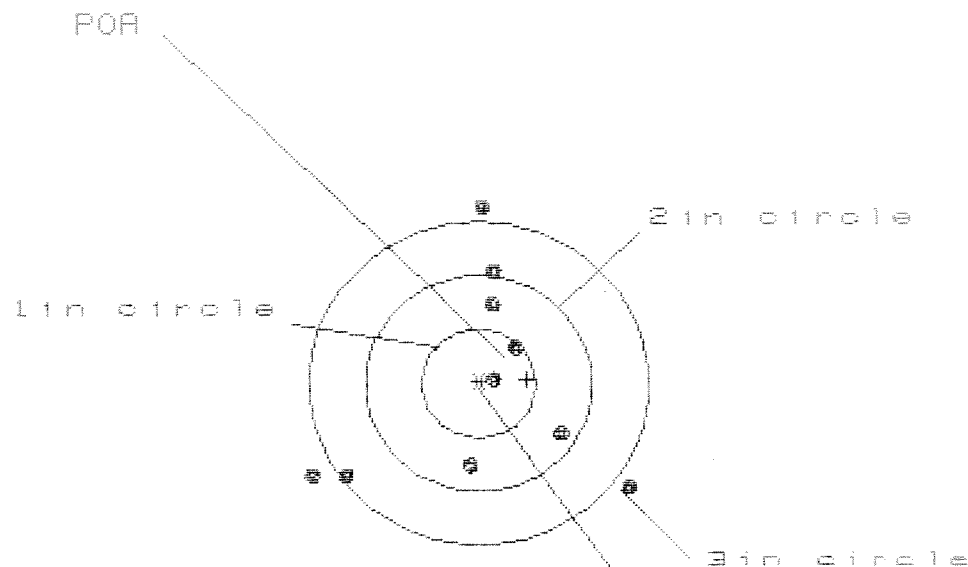
1 1/2 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0384
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0314
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0496036
THE AMR FOR THIS RIFLE IS: .9284

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86361B5

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.796

VS= 2.580

GS= 2.905

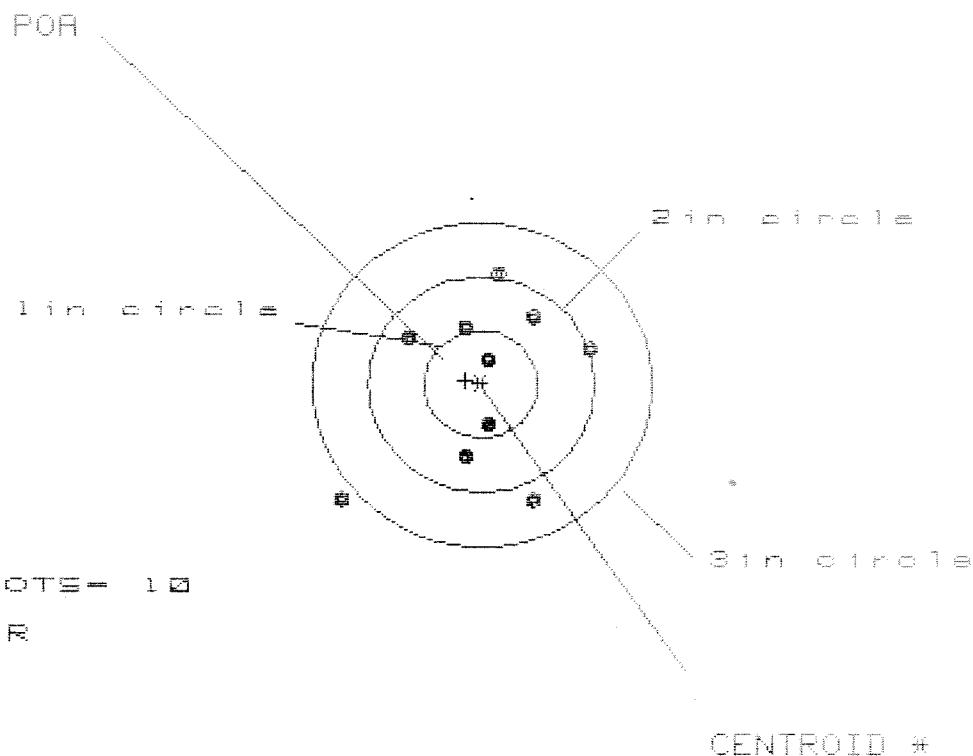
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.160	.678
MINIMUM X	:	-1.472	-1.372	-1.227
MAXIMUM Y	:	1.603	1.504	1.370
MINIMUM Y	:	-.977	-1.076	-1.048
CENTROID X	:	-.427	-.263	-.408
CENTROID Y	:	-.041	.058	.192
POA TO CENTROID in.	:	.429	.269	.451
MIN RADIUS	:	.151	.041	.186
MEAN RADIUS	:	1.048	.928	.855
MAX RADIUS	:	1.718	1.648	1.614
HORIZONTAL SPREAD	:	2.796	2.532	1.905
VERTICAL SPREAD	:	2.580	2.580	2.418
EXTREME SPREAD	:	2.905	2.905	2.698
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.195

VS = 2.077

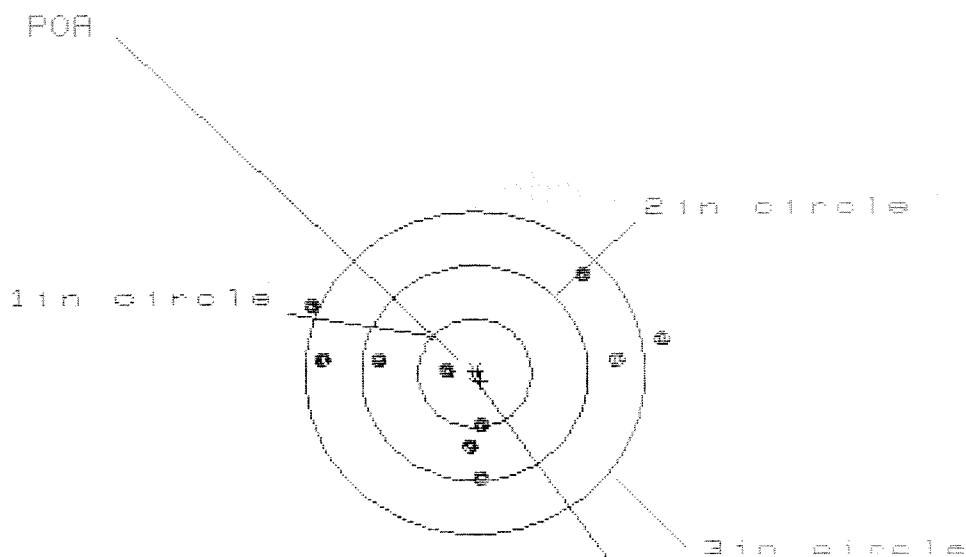
GS = 2.613

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.932	.791	.832
MINIMUM X	:	-1.264	-.785	-.744
MAXIMUM Y	:	1.024	.907	.762
MINIMUM Y	:	-1.053	-1.159	-.954
CENTROID X	:	.140	.281	.240
CENTROID Y	:	-.031	.086	.231
POA TO CENTROID in.	:	.144	.294	.333
MIN RADIUS	:	.260	.157	.039
MEAN RADIUS	:	.814	.699	.602
MAX RADIUS	:	1.645	1.204	.978
HORIZONTAL SPREAD	:	2.195	1.576	1.576
VERTICAL SPREAD	:	2.077	2.066	1.716
EXTREME SPREAD	:	2.613	2.082	1.745
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.013

VS= 1.851

GS= 3.034

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.604	1.403	1.249
MINIMUM X	:	-1.409	-1.231	-1.348
MAXIMUM Y	:	.883	.914	.997
MINIMUM Y	:	-.968	-.937	-.854
CENTROID X	:	-.051	-.229	-.076
CENTROID Y	:	.075	.044	-.039
POA TO CENTROID in.	:	.091	.234	.085
MIN RADIUS	:	.286	.110	.292
MEAN RADIUS	:	1.037	.935	.874
MAX RADIUS	:	1.628	1.461	1.402
HORIZONTAL SPREAD	:	3.013	2.634	2.597
VERTICAL SPREAD	:	1.851	1.851	1.851
EXTREME SPREAD	:	3.034	2.681	2.597
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.392

VS= 2.103

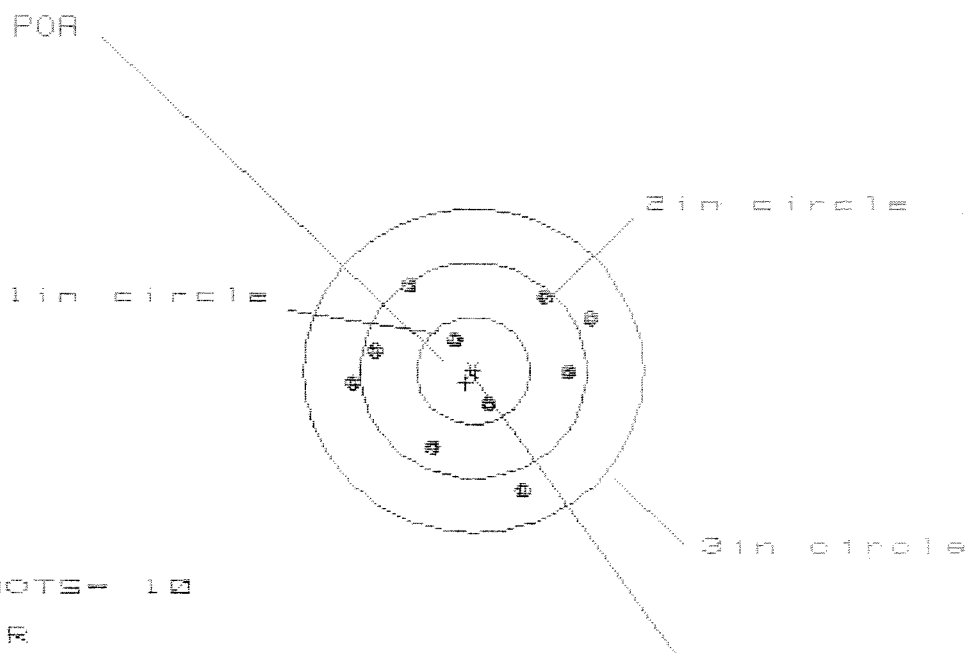
GS= 2.575

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.063	.955
MINIMUM X	:	-1.017	-.865	-.941
MAXIMUM Y	:	1.091	1.073	1.171
MINIMUM Y	:	-1.012	-1.030	-.932
CENTROID X	:	.079	-.073	.035
CENTROID Y	:	.046	.064	-.034
POA TO CENTROID in.	:	.092	.097	.048
MIN RADIUS	:	.317	.183	.262
MEAN RADIUS	:	.891	.826	.767
MAX RADIUS	:	1.383	1.164	1.252
HORIZONTAL SPREAD	:	2.392	1.928	1.896
VERTICAL SPREAD	:	2.103	2.103	2.103
EXTREME SPREAD	:	2.575	2.245	2.245
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.052

VS = 1.908

QS = 2.193

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	1.057	.992
MINIMUM X	:	-1.048	-.995	-.862
MAXIMUM Y	:	.773	.647	.692
MINIMUM Y	:	-1.135	-.884	-.840
CENTROID X	:	.067	.014	-.119
CENTROID Y	:	.108	.235	.191
POA TO CENTROID in.	:	.128	.235	.224
MIN RADIUS	:	.363	.230	.217
MEAN RADIUS	:	.852	.797	.745
MAX RADIUS	:	1.233	1.115	.998
HORIZONTAL SPREAD	:	2.052	2.052	1.854
VERTICAL SPREAD	:	1.908	1.531	1.531
EXTREME SPREAD	:	2.193	2.126	1.855
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	