

C6636198

MODEL 700™ M24

Model **SMS**™

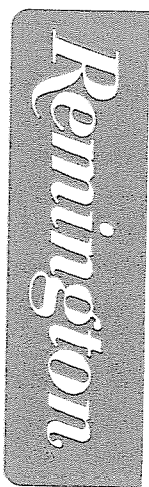
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®

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

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

MODEL 700™ H24

SERIAL NO.
C6636198

ORDER NO.
5716

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

20



5716 C6636198

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636198

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		4/6/91	LG
615	Rollmark Caliber		APR 19 1991	CS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5 1/4			5-23-91	DH
	G) Safety Off Force	3	3	3			5-23-91	DH
	H) Trigger Pull Test & Retainability						5/23/91	DH
	I) Firing Pin Indent	.021	.021	.022			5-23-91	DH
	J) Assemble Stock						5/23/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/23/91	KS
	M) Iron Sight Alignment						5/23/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	KS
	O) Attach Scope to Rifle						5/23/91	KS
	P) Detach & Attach Scope 20 Times						5/23/91	KS
640	Gallery Target & Test						5-24-91	DH
	A) Time						5-24-91	DH
	B) Malfunctions						5-24-91	DH
	C) Pierced Primers						5-24-91	DH
	D) Optical Clarity of Scope						5-24-91	DH
645	Inspect for Live Ammo						5-24-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.76	2.66	2.68	2.67	2.70	6/1/91	JH
	C) Function						6-1-91	DH
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# ± 100#

SERIAL NO. C6636198

DATE 5/23/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.45	2.50	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.46	2.45	2.66	
PULL #3	2.41	2.46	2.48	2.68	
PULL #4	2.40	2.45	2.46	2.61	
PULL #5	2.40	2.48	2.46	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.42		
PULL #2	3.66	3.40		
PULL #3	3.64	3.41		
PULL #4	3.66	3.41		
PULL #5	3.50	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.55		4.64
PULL #2	4.40	4.59		4.40
PULL #3	4.40	4.60		4.37
PULL #4	4.43	4.63		4.34
PULL #5	4.46	4.60		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636198
25 May 1991

CENTROIDAL DISTANCES

0 TO	1	.171292
1 TO	2	.341849
1 TO	3	.266248
1 TO	4	.0347131
1 TO	5	.372392

$\frac{8}{3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1374
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0772
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157603
THE AMR FOR THIS RIFLE IS: .9732

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636198

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 1.949

VS= 3.376

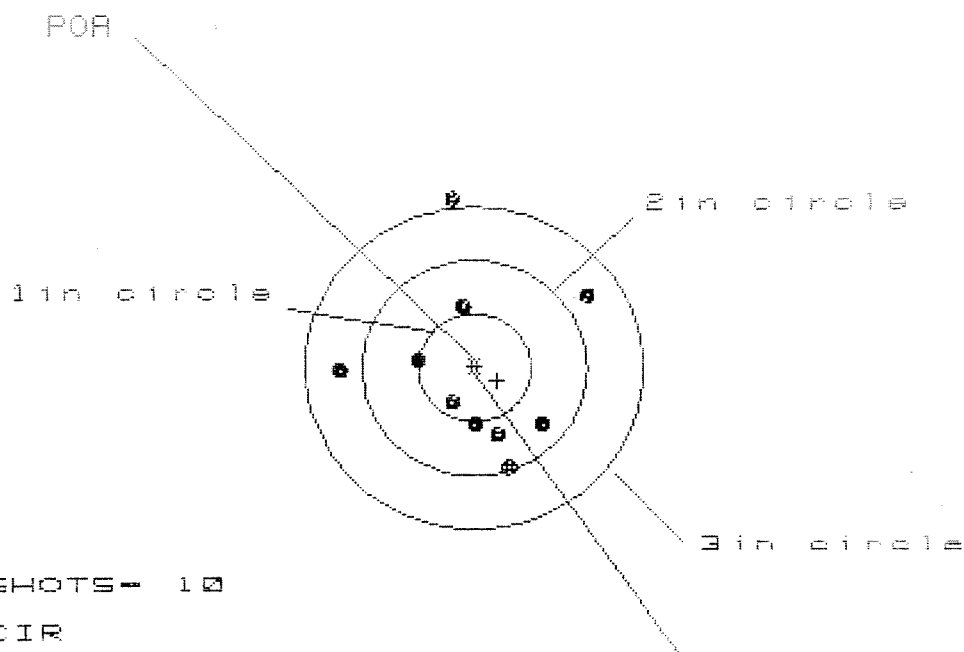
GS= 3.381

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.302	1.259	.844
MINIMUM X	:	-.647	-.690	-.532
MAXIMUM Y	:	1.746	1.375	1.079
MINIMUM Y	:	-1.630	-1.436	-1.264
CENTROID X	:	-.021	.022	-.136
CENTROID Y	:	-.170	-.364	-.536
POA TO CENTROID in.	:	.171	.364	.553
MIN RADIUS	:	.328	.182	.248
MEAN RADIUS	:	1.031	.933	.813
MAX RADIUS	:	1.788	1.864	1.267
HORIZONTAL SPREAD	:	1.949	1.949	1.376
VERTICAL SPREAD	:	3.376	2.811	2.343
EXTREME SPREAD	:	3.381	3.189	2.344
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

25 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.153

VS = 2.489

GS = 2.524

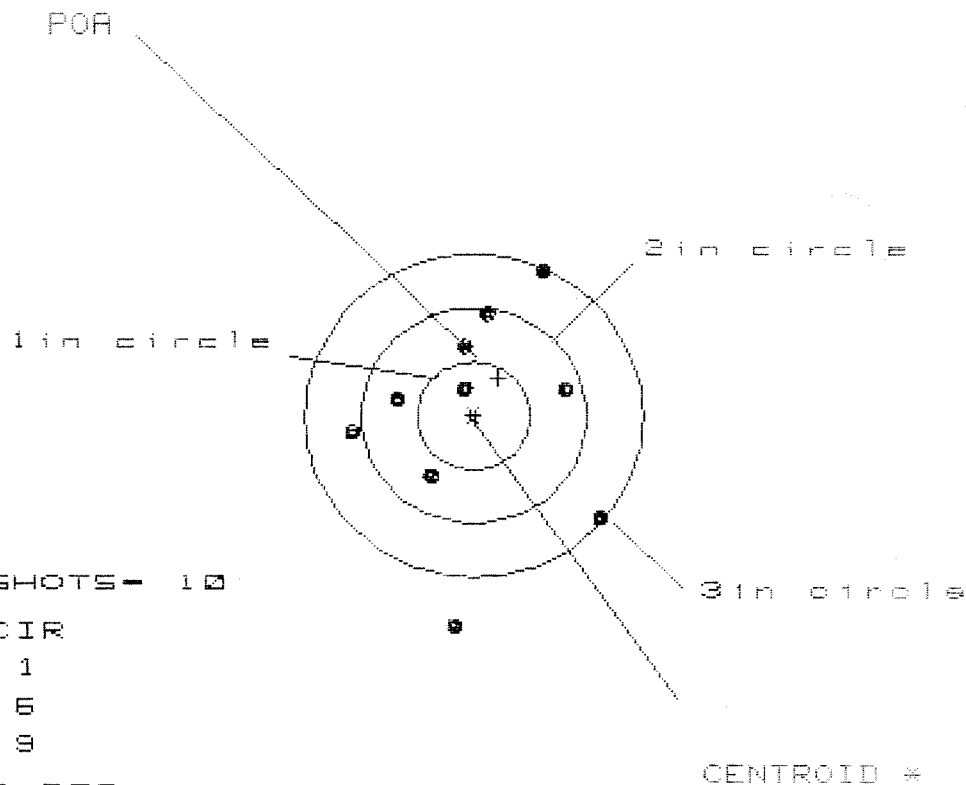
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	.957	.683
MINIMUM X	:	-1.179	-1.196	-1.077
MAXIMUM Y	:	1.592	.874	.895
MINIMUM Y	:	-.897	-.720	-.611
CENTROID X	:	-.202	-.185	-.304
CENTROID Y	:	.120	-.057	-.166
POA TO CENTROID in.	:	.235	.193	.347
MIN RADIUS	:	.395	.259	.097
MEAN RADIUS	:	.835	.705	.595
MAX RADIUS	:	1.600	1.296	1.111
HORIZONTAL SPREAD	:	2.153	2.153	1.760
VERTICAL SPREAD	:	2.489	1.594	1.506
EXTREME SPREAD	:	2.524	2.268	1.839
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 9

HS - 2.207

VS - 3.325

GS - 3.428

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	1.067	1.140
MINIMUM X	:	-1.114	-1.140	-1.067
MAXIMUM Y	:	1.358	1.140	.869
MINIMUM Y	:	-1.967	-1.151	-1.009
CENTROID X	:	-.219	-.193	-.266
CENTROID Y	:	-.348	-.130	-.272
POA TO CENTROID in.	:	.411	.233	.381
MIN RADIUS	:	.265	.102	.181
MEAN RADIUS	:	1.016	.860	.814
MAX RADIUS	:	1.980	1.570	1.522
HORIZONTAL SPREAD	:	2.207	2.207	2.207
VERTICAL SPREAD	:	3.325	2.291	1.878
EXTREME SPREAD	:	3.428	2.342	2.338
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

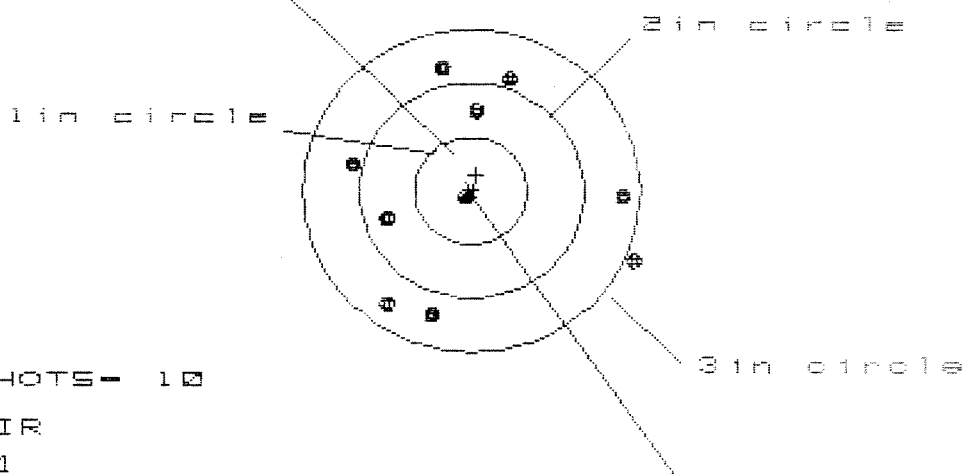
25 May 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.483

VS= 2.265

GS= 2.620

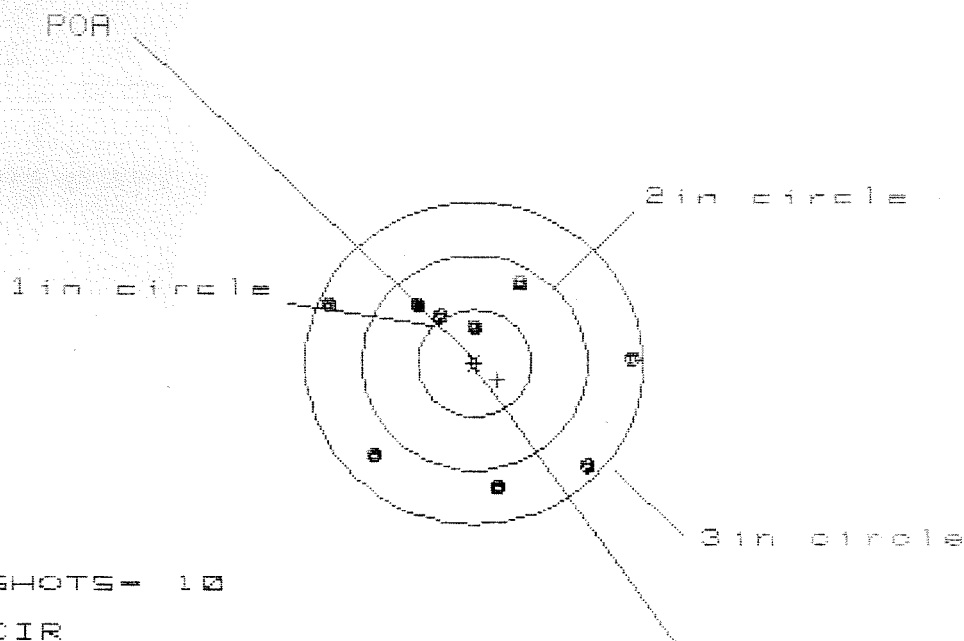
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.456	1.542	.718
MINIMUM X	:	-1.027	-.865	-.673
MAXIMUM Y	:	1.147	1.078	1.069
MINIMUM Y	:	-1.118	-1.187	-1.196
CENTROID X	:	-.044	-.206	-.398
CENTROID Y	:	-.144	-.075	-.066
POA TO CENTROID in.	:	.150	.219	.404
MIN RADIUS	:	.140	.177	.308
MEAN RADIUS	:	1.036	.951	.860
MAX RADIUS	:	1.581	1.543	1.196
HORIZONTAL SPREAD	:	2.483	2.407	1.391
VERTICAL SPREAD	:	2.265	2.265	2.265
EXTREME SPREAD	:	2.620	2.417	2.360
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.588

VS= 1.966

GS= 2.737

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.416	1.111	.972
MINIMUM X	:	-1.272	-1.115	-.928
MAXIMUM Y	:	.785	.784	.848
MINIMUM Y	:	-1.181	-1.182	-1.118
CENTROID X	:	-.201	-.358	-.219
CENTROID Y	:	.156	.157	.093
POA TO CENTROID in.	:	.255	.391	.238
MIN RADIUS	:	.345	.378	.408
MEAN RADIUS	:	.948	.883	.853
MAX RADIUS	:	1.416	1.451	1.304
HORIZONTAL SPREAD	:	2.688	2.226	1.900
VERTICAL SPREAD	:	1.966	1.966	1.966
EXTREME SPREAD	:	2.737	2.652	2.159
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	