

C6649301

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington®

MODEL 700™ H24

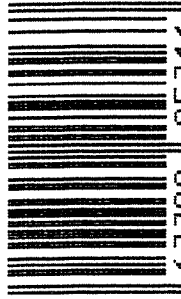
UPPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.	C6649301
ORDER NO.	5716

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

UPC



0 47700 25716 7



5716 C6649301

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	failed	
TEST		
TGT		
PROOF	Needs New Bit	
TEST		
TGT		
PROOF	100 R.I. Test OK 9-13-91 D.H.	
TEST		
TGT		
PROOF		
TEST		
TGT		

MOD. _____ GA. CAL. 1702 GUN # C6649301

#	DATE	MALFUNCTION/DEFECT	ASSEM.
TEST			#
	1st	Shaver loose check head	RW
	2nd	14440 polish face of Boit 100 Rd Test	RW
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649301

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	AW
600	Proof	6 27	9 1	AW
607	Check Headspace	6 27	9 1	AW
610	Dis-assemble Gun	6 27	9 1	AW
612	Magnaflux Barrel Action	JUL	2 1991	K.R.
	Magnaflux Bolt	JUL	2 1991	K.R.
615	Rollmark Caliber	JUL	2 1991	JS
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL	17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-8-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-8-91	JH
	G) Safety Off Force	3	3	3			8-8-91	JH
	H) Trigger Pull Test & Retainability						8-8-91	JH
	I) Firing Pin Indent	.0215	.021	.021			8-8-91	JH
	J) Assemble Stock						8/9/91	RW
	K) Assemble Swivel Studs						7-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/9/91	RW
	M) Iron Sight Alignment						8/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	RW
	O) Attach Scope to Rifle						8/9/91	RW
	P) Detach & Attach Scope 20 Times						8/9/91	RW
640	Gallery Target & Test						8-9-91	AC
	A) Time						8-9-91	AC
	B) Malfunctions						8-9-91	AC
	C) Pierced Primers						8-9-91	AC
	D) Optical Clarity of Scope						8-9-91	AC
645	Inspect for Live Ammo						8-9-91	AC
655	Final Inspection							
	A) Headspace						7-13-91	AC
	B) Trigger Pull	258	231	239	263	260	9/13/91	JH
	C) Function						7-13-91	AC
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649301
DATE 8-8-91
TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.38	2.35	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.39	2.40	2.51	
PULL #3	2.40	2.31	2.43	2.59	
PULL #4	2.35	2.40	2.40	2.63	
PULL #5	2.27	2.39	2.44	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.34		
PULL #2	3.51	3.46		
PULL #3	3.50	3.50		
PULL #4	3.46	3.46		
PULL #5	3.56	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.33		4.22
PULL #2	4.35	4.36		4.44
PULL #3	4.34	4.45		4.29
PULL #4	4.40	4.41		4.48
PULL #5	4.24	4.34		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649301
9 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.557807
1 TO	2	.065
1 TO	3	.546125
1 TO	4	.62404
1 TO	5	.554294

5
4 + <----POA
43

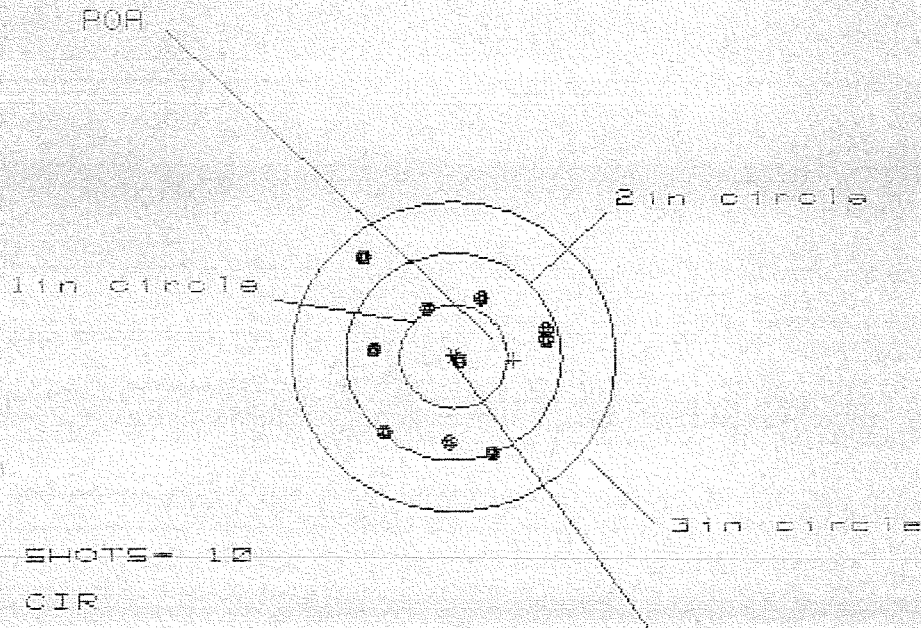
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4862
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1392
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .505734
THE AMR FOR THIS RIFLE IS: .9216

9 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649301

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 1

2in = 9

3in = 10

HS = 1.719

VS = 1.922

GS = 2.279

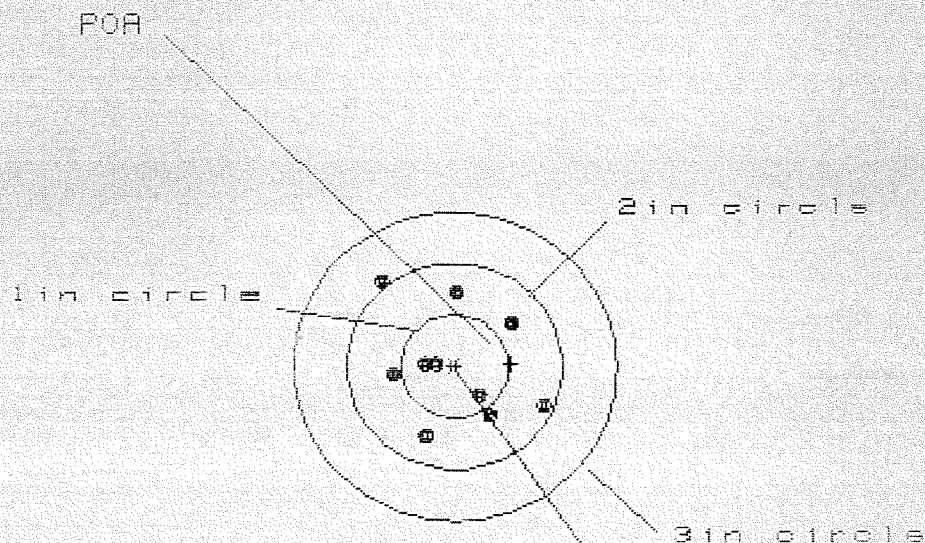
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.895	.804	.842
MINIMUM X	:	-.824	-.806	-.768
MAXIMUM Y	:	1.009	.683	.583
MINIMUM Y	:	-.913	-.801	-.863
CENTROID X	:	-.557	-.466	-.504
CENTROID Y	:	.030	-.082	.018
POA TO CENTROID in.	:	.558	.473	.505
MIN RADIUS	:	.062	.096	.065
MEAN RADIUS	:	.794	.738	.706
MAX RADIUS	:	1.303	.960	1.005
HORIZONTAL SPREAD	:	1.719	1.610	1.610
VERTICAL SPREAD	:	1.922	1.484	1.446
EXTREME SPREAD	:	2.279	1.802	1.882
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

9 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.455

VS= 1.499

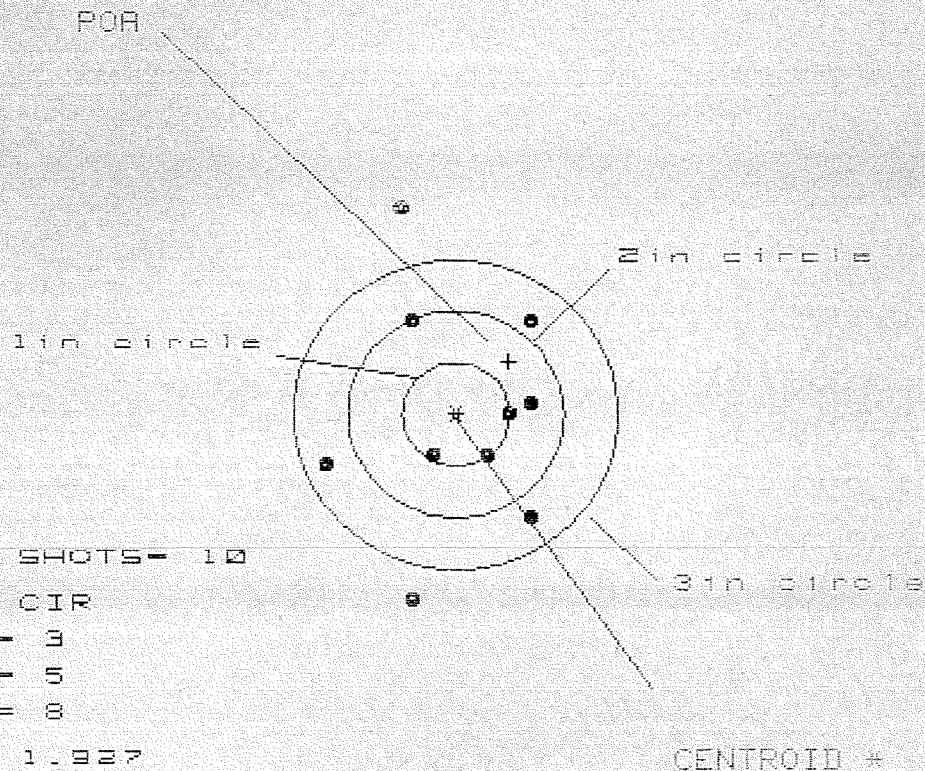
GS= 1.862

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.799	.726	.567
MINIMUM X	:	-.657	-.667	-.577
MAXIMUM Y	:	.792	.823	.787
MINIMUM Y	:	-.787	-.619	-.654
CENTROID X	:	-.524	-.451	-.542
CENTROID Y	:	-.826	-.114	-.079
POA TO CENTROID in.	:	.524	.465	.547
MIN RADIUS	:	.215	.251	.288
MEAN RADIUS	:	.614	.562	.521
MAX RADIUS	:	1.829	.823	.798
HORIZONTAL SPREAD	:	1.456	1.393	1.143
VERTICAL SPREAD	:	1.499	1.442	1.442
EXTREME SPREAD	:	1.862	1.478	1.478
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 1.927

VS = 3.786

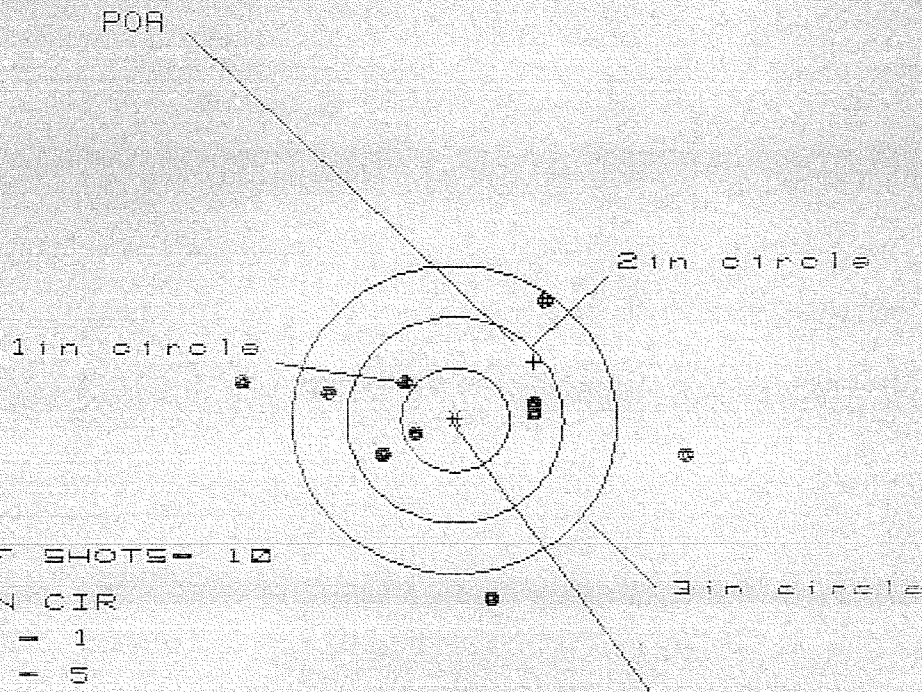
GS = 3.790

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.702	.641	.587
MINIMUM X	:	-1.225	-1.286	-1.340
MAXIMUM Y	:	2.035	1.188	.997
MINIMUM Y	:	-1.751	-1.524	-1.991
CENTROID X	:	-.490	-.429	-.375
CENTROID Y	:	-.512	-.739	-.548
POA TO CENTROID in.	:	.709	.854	.664
MIN RADIUS	:	.479	.283	.369
MEAN RADIUS	:	1.076	.924	.832
MAX RADIUS	:	2.109	1.584	1.421
HORIZONTAL SPREAD	:	1.927	1.927	1.927
VERTICAL SPREAD	:	3.786	2.712	1.988
EXTREME SPREAD	:	3.790	2.916	2.424
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 4.102

VS = 2.936

GS = 4.161

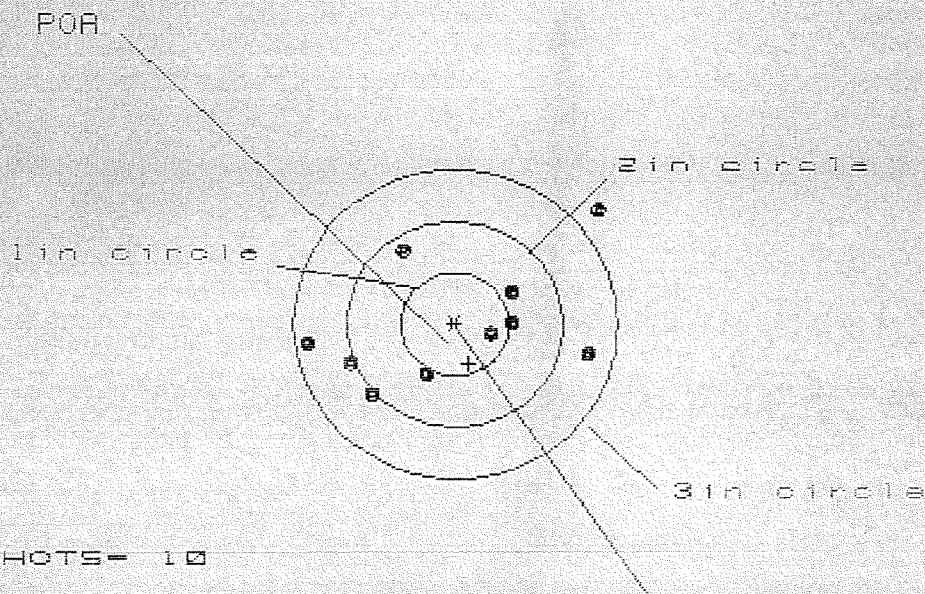
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.109	1.110	.890
MINIMUM X	:	-1.993	-1.759	-1.192
MAXIMUM Y	:	1.168	1.133	1.177
MINIMUM Y	:	-1.768	-1.803	-1.759
CENTROID X	:	-.732	-.966	-.746
CENTROID Y	:	-.569	-.534	-.578
POA TO CENTROID in.	:	.927	1.104	.944
MIN RADIUS	:	.369	.223	.352
MEAN RADIUS	:	1.193	1.053	.970
MAX RADIUS	:	2.132	1.878	1.785
HORIZONTAL SPREAD	:	4.102	2.869	2.082
VERTICAL SPREAD	:	2.936	2.936	2.936
EXTREME SPREAD	:	4.161	3.139	2.994
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.721

VS= 1.800

GS= 2.998

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.393	1.237
MINIMUM X	:	-1.393	-1.245	-.964
MAXIMUM Y	:	1.078	.840	.832
MINIMUM Y	:	-.722	-.602	-.610
CENTROID X	:	-.128	-.276	-.120
CENTROID Y	:	.381	.261	.269
POA TO CENTROID in.	:	.402	.380	.294
MIN RADIUS	:	.295	.384	.286
MEAN RADIUS	:	.931	.838	.767
MAX RADIUS	:	1.711	1.406	1.253
HORIZONTAL SPREAD	:	2.721	2.638	2.201
VERTICAL SPREAD	:	1.800	1.442	1.442
EXTREME SPREAD	:	2.998	2.641	2.203
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	