

C6611423

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

Remington[®]

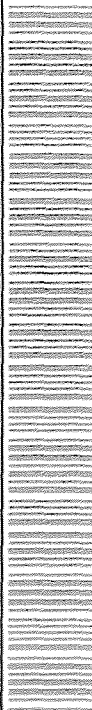
DU PONT
REG. U.S. PAT. & TM. OFF.

MODEL 700[™] H24

SERIAL NO.
C6611423

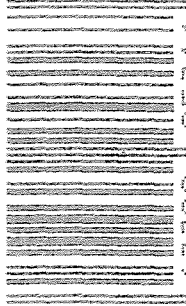
ORDER NO.
5716

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



5716 C6611423

UPC



0 4700 25716 7

GUN SERIAL # C6611423

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GS
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/18/91	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4	4	4	2/18/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4	2 1/4	2 1/4	2/18/91	WB
	H) Trigger Pull Test & Retainability						2/18/91	WB
	I) Firing Pin Indent	.0225	.0225	.0225	.0225	.0225	2/18/91	WB
	J) Assemble Stock						2/19/91	RW
	K) Assemble Swivel Studs						2-22-91	R
	L) Attach Front and Rear Sight Assemblies						2/19/91	RW
	M) Iron Sight Alignment						2/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	RW
	O) Attach Scope to Rifle						2/19/91	RW
	P) Detach & Attach Scope 20 Times						2/19/91	RW
640	Gallery Target & Test						2-20-91	AC
	A) Time						2-20-91	AC
	B) Malfunctions						2-20-91	AC
	C) Pierced Primers						2-20-91	AC
	D) Optical Clarity of Scope						2-20-91	AC
645	Inspect for Live Ammo						2-20-91	AC
655	Final Inspection						2-22-91	A
	A) Headspace						2/21/91	WB
	B) Trigger Pull	2.59	2.48	2.51	2.51	2.54	2/21/91	WB
	C) Function						2-22-91	AC
660	Pack						3-11-91	V

AVERAGE PULL FORCE BETWEEN

INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611423DATE 2/18/91TESTER Q21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.33	2.44	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.47	2.40	2.48	
PULL #3	2.30	2.47	2.46	2.51	
PULL #4	2.30	2.24	2.41	2.51	
PULL #5	2.18	2.53	2.40	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.36	3.25		
PULL #3	3.31	3.21		
PULL #4	3.36	3.27		
PULL #5	3.49	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.28		4.53
PULL #2	4.44	4.50		4.52
PULL #3	4.22	4.42		4.34
PULL #4	4.40	4.45		4.44
PULL #5	4.36	4.47		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611423
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.349185
1 TO	2	.428441
1 TO	3	.161471
1 TO	4	.297121
1 TO	5	.718283

34 <----POA
5

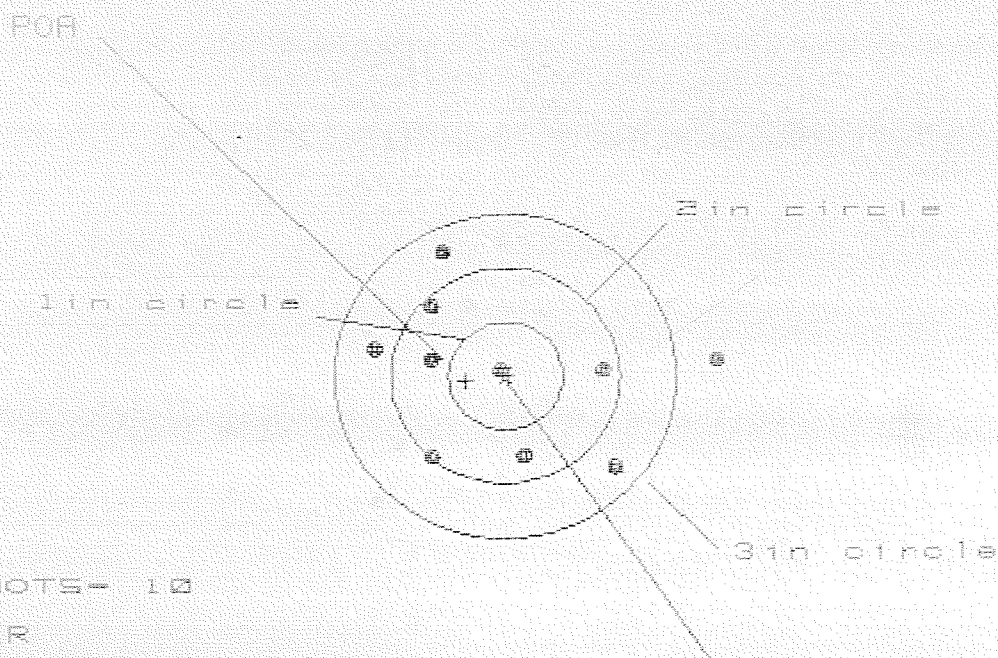
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .294235
THE AMP FOR THIS RIFLE IS: .924

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611423

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.023

VS= 2.062

GS= 3.025

CENTROID *

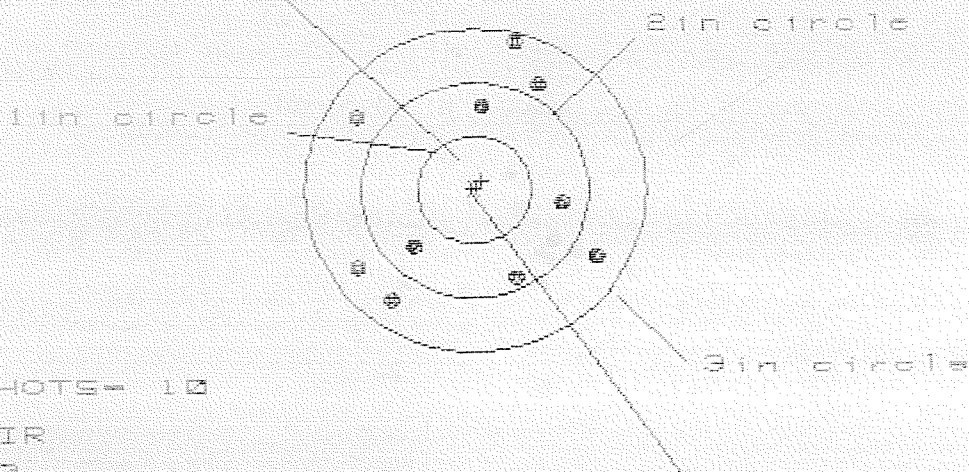
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.830	1.163	1.161
MINIMUM X	:	-1.193	-.990	-.845
MAXIMUM Y	:	1.179	1.195	1.087
MINIMUM Y	:	-.883	-.867	-.880
CENTROID X	:	.347	.144	-.001
CENTROID Y	:	.039	.023	.131
POA TO CENTROID in.	:	.349	.146	.131
MIN RADIUS	:	.023	.188	.326
MEAN RADIUS	:	.987	.878	.789
MAX RADIUS	:	1.835	1.451	1.161
HORIZONTAL SPREAD	:	3.023	2.153	2.005
VERTICAL SPREAD	:	2.062	2.062	1.967
EXTREME SPREAD	:	3.025	2.550	2.038
NUMBER IN ONE INCH CIRCLE =	:	1	5	9
NUMBER IN TWO INCH CIRCLE =	:	5	9	9
NUMBER IN THREE INCH CIRCLE =	:	9	9	9

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FILE:/PATTERNING/CENTERFIRE_PATT/06611423

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS= 2.078

VS= 2.401

GS= 2.643

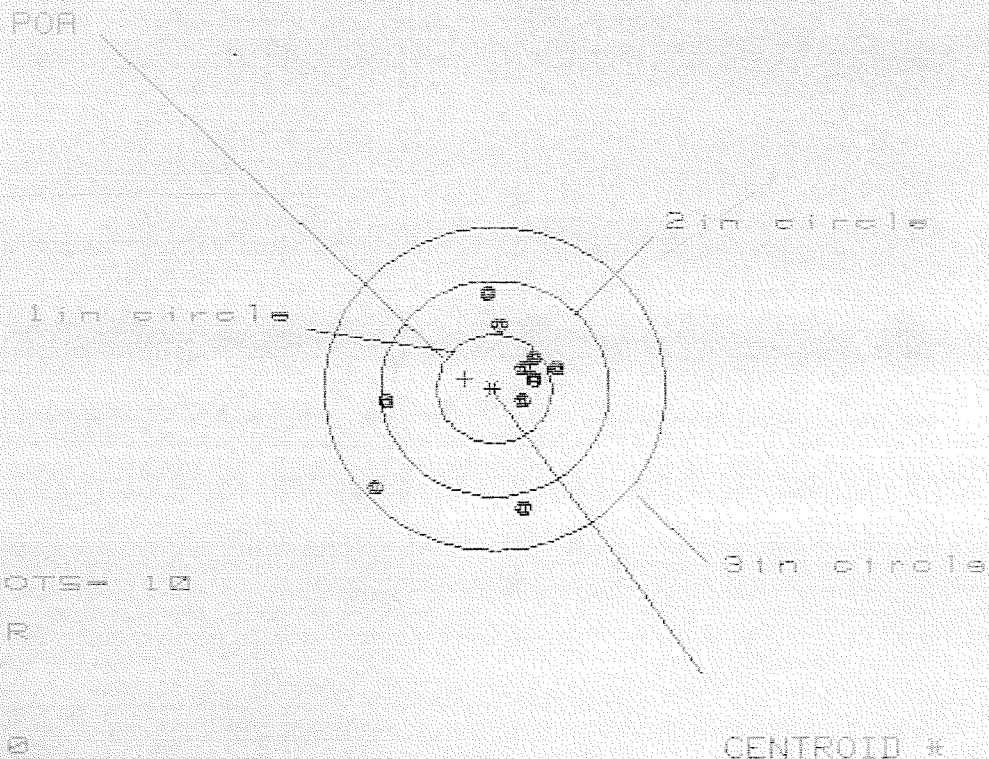
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.084	1.127	.969
MINIMUM X	-.994	-.951	-.810
MAXIMUM Y	1.420	1.131	1.072
MINIMUM Y	-.981	-.824	-.883
CENTROID X	-.064	-.107	-.248
CENTROID Y	-.082	-.239	-.180
POA TO CENTROID in.	.104	.262	.307
MIN RADIUS	.772	.636	.575
MEAN RADIUS	1.074	1.013	.980
MAX RADIUS	1.472	1.295	1.320
HORIZONTAL SPREAD	2.078	2.078	1.779
VERTICAL SPREAD	2.401	1.955	1.955
EXTREME SPREAD	2.643	2.439	2.349
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.592

VS= 2.044

GS= 2.074

PATTERN #

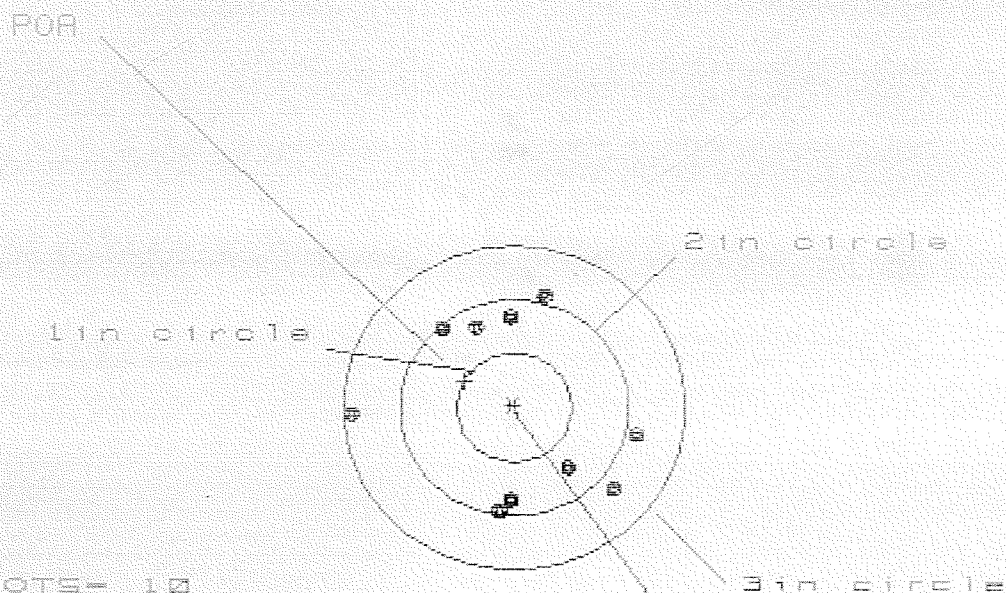
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.521	.402	.423
MINIMUM X	-1.071	-1.025	-1.004
MAXIMUM Y	.911	.811	.657
MINIMUM Y	-1.133	-1.233	-.380
CENTROID X	.254	.373	.352
CENTROID Y	-.093	.007	.161
POA TO CENTROID in.	.270	.373	.387
MIN RADIUS	.284	.135	.137
MEAN RADIUS	.694	.551	.450
MAX RADIUS	1.397	1.244	1.073
HORIZONTAL SPREAD	1.592	1.427	1.427
VERTICAL SPREAD	2.044	2.044	1.037
EXTREME SPREAD	2.074	2.074	1.456
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.481

VS= 2.093

GS= 2.487

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.036	.876	.965
MINIMUM X	:	-1.445	-.782	-.693
MAXIMUM Y	:	1.094	1.083	.985
MINIMUM Y	:	-.999	-1.010	-1.108
CENTROID X	:	.431	.591	.502
CENTROID Y	:	-.246	-.235	-.137
POA TO CENTROID in.	:	.496	.636	.520
MIN RADIUS	:	.603	.602	.731
MEAN RADIUS	:	1.012	.949	.928
MAX RADIUS	:	1.448	1.105	1.132
HORIZONTAL SPREAD	:	2.481	1.658	1.658
VERTICAL SPREAD	:	2.093	2.093	2.093
EXTREME SPREAD	:	2.487	2.167	2.134
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	4	4	4
NUMBER IN THREE INCH CIRCLE	=	10	10	10

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FILE:/PATTERNING/CENTERFIRE_PATT/08611423

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= .876

VS= 2.766

GS= 2.766

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

:

.326

.347

.327

MINIMUM X

:

-.550

-.529

-.549

MAXIMUM Y

:

.988

.798

.617

MINIMUM Y

:

-1.778

-1.384

-1.345

CENTROID X

:

.096

.074

.094

CENTROID Y

:

-.634

-.436

-.263

POA TO CENTROID in.

:

.641

.442

.279

MIN RADIUS

:

.347

.174

.091

MEAN RADIUS

:

.853

.664

.506

MAX RADIUS

:

1.788

1.393

1.453

HORIZONTAL SPREAD

:

.876

.876

.876

VERTICAL SPREAD

:

2.766

2.174

1.962

EXTREME SPREAD

:

2.766

2.204

2.094

NUMBER IN ONE

INCH CIRCLE =

3

NUMBER IN TWO

INCH CIRCLE =

6

NUMBER IN THREE

INCH CIRCLE =

9