

C6611502

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.

MODEL 700TM M24

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

SERIAL NO.
06611502

ORDER NO.
5716



5716 06611502

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611502**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	GL
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/30/91	K.S.
	D) Oil Firing Pin Ass'y		4/30/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/2/91	GA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-2-91	DH
	G) Safety Off Force	3	3	3			5-2-91	DH
	H) Trigger Pull Test & Retainability						5/2/91	JLP
	I) Firing Pin Indent	.020	.021	.021			5-2-91	DH
	J) Assemble Stock						5/3/91	KS
	K) Assemble Swivel Studs						5-10-91	K
	L) Attach Front and Rear Sight Assemblies						5/3/91	KS
	M) Iron Sight Alignment						5/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/3/91	KS
	O) Attach Scope to Rifle						5/3/91	KS
	P) Detach & Attach Scope 20 Times						5/3/91	KS
640	Gallery Target & Test						5-3-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-3-91	AF
655	Final Inspection							
	A) Headspace						5-10-91	K
	B) Trigger Pull	2.17	2.23	2.25	2.29	2.28	5/9/91	JLP
	C) Function						5-10-91	K
660	Pack						6-17-91	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-6611502

DATE 5/2/91

TESTER [Signature] (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.41	2.40	2.17	MIN. SETTING,
PULL #2	2.36	2.43	2.48	2.23	NO AVG. OF 5
PULL #3	2.41	2.42	2.43	2.25	READINGS ACCEPT-
PULL #4	2.45	2.44	2.38	2.29	ABLE LESS THAN 2#
PULL #5	2.41	2.20	2.38	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.31	3.22			
PULL #2	3.22	3.22			
PULL #3	3.20	3.28			
PULL #4	3.30	3.20			
PULL #5	3.33	3.24			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING- GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.39		4.38
PULL #2	4.38	4.20		4.21
PULL #3	4.26	4.32		4.28
PULL #4	4.18	4.35		4.33
PULL #5	4.36	4.22		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611502
3 May 1991

CENTROIDAL DISTANCES

0 TO	1	.280045
1 TO	2	.719222
1 TO	3	.582626
1 TO	4	.224511
1 TO	5	.150053

3
4
1

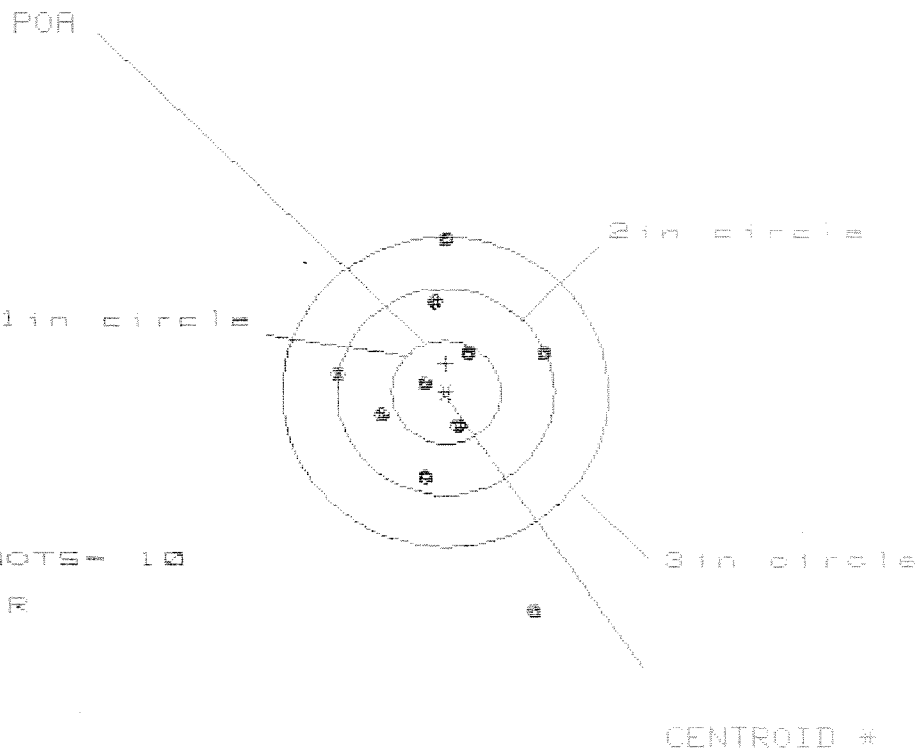
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0542
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .057
THE AMR FOR THIS RIFLE IS: .9800

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611502

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.961

VS= 3.650

GS= 3.738

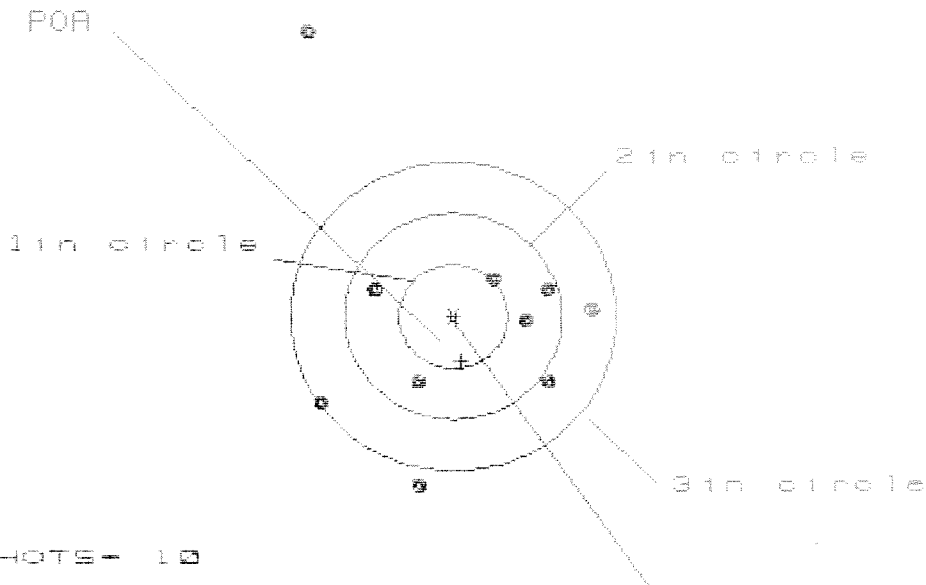
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	1.008	1.015
MINIMUM X	-1.039	-.953	-.946
MAXIMUM Y	1.524	1.288	.786
MINIMUM Y	-2.126	-1.018	-.857
CENTROID X	-.005	-.091	-.098
CENTROID Y	-.280	-.044	-.203
POR TO CENTROID in.	.280	.101	.227
MIN RADIUS	.172	.164	.057
MEAN RADIUS	.988	.744	.647
MAX RADIUS	2.264	1.289	1.071
HORIZONTAL SPREAD	1.961	1.961	1.961
VERTICAL SPREAD	3.650	2.306	1.641
EXTREME SPREAD	3.738	2.309	1.974
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611582

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 5

IS = 2.580

VS = 4.317

GS = 4.440

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.234	1.984	1.825
MINIMUM X	-1.356	-1.349	-1.408
MAXIMUM Y	2.728	.659	.498
MINIMUM Y	-1.589	-1.286	-1.647
CENTROID X	-.073	.077	.136
CENTROID Y	.436	.133	.294
POA TO CENTROID in.	.442	.154	.324
MIN RADIUS	.533	.596	.474
MEAN RADIUS	1.204	.957	.874
MAX RADIUS	3.046	1.434	1.550
HORIZONTAL SPREAD	2.590	2.433	2.433
VERTICAL SPREAD	4.317	1.945	1.145
EXTREME SPREAD	4.440	2.571	2.571
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	5	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS611502

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.618

VS= 3.476

GS= 3.498

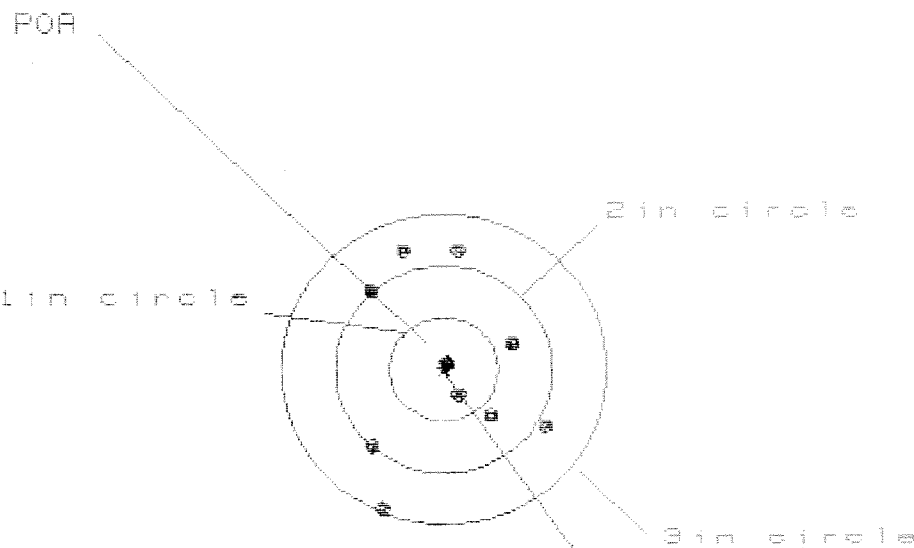
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.633	.656	.644
MINIMUM X	-.985	-.962	-.974
MAXIMUM Y	1.772	1.584	1.395
MINIMUM Y	-1.704	-1.507	-1.103
CENTROID X	.022	-.001	.011
CENTROID Y	.302	.105	.294
POA TO CENTROID in.	.303	.105	.294
MIN RADIUS	.149	.057	.138
MEAN RADIUS	.973	.872	.780
MAX RADIUS	1.783	1.585	1.397
HORIZONTAL SPREAD	1.618	1.618	1.618
VERTICAL SPREAD	3.476	3.091	2.498
EXTREME SPREAD	3.498	3.091	2.504
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611592

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.584

VS= 2.537

GS= 2.635

CENTROID #

PATTERN #	1	4	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.900	.836	.782
MINIMUM X	-.684	-.748	-.901
MAXIMUM Y	1.205	1.057	1.187
MINIMUM Y	-1.332	-.925	-.795
CENTROID X	-.031	.033	.087
CENTROID Y	-.057	.091	-.039
POR TO CENTROID in.	.065	.096	.095
MIN RADIUS	.070	.120	.054
MEAN RADIUS	.065	.083	.072
MAX RADIUS	1.449	1.174	1.187
HORIZONTAL SPREAD	1.584	1.584	1.584
VERTICAL SPREAD	2.537	1.982	1.982
EXTREME SPREAD	2.635	2.137	2.137
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511502

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.523

VS = 2.859

GS = 2.870

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.024
MINIMUM X	-1.499
MAXIMUM Y	1.610
MINIMUM Y	-1.249
CENTROID X	-0.009
CENTROID Y	-0.130
POR TO CENTROID in.	.130
MIN RADIUS	.285
MEAN RADIUS	.954
MAX RADIUS	1.625
HORIZONTAL SPREAD	2.523
VERTICAL SPREAD	2.859
EXTREME SPREAD	2.870
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8