

L6611555

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smeal®

No. 2-152-51

Remington[®]

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

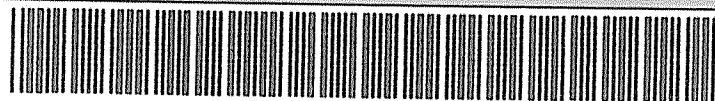
MODEL 700TM M24

SERIAL NO.
C6611555

ORDER NO.
5716

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

20



5716 C6611555

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611555

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		Y
615	Rollmark Caliber	3 28 91		JS
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	6			5-26-91	D/H
	G) Safety Off Force	3	3	3			5-21-91	D/H
	H) Trigger Pull Test & Retainability						5-20-91	D/H
	I) Firing Pin Indent	.020	.021	.020			5-21-91	D/H
	J) Assemble Stock						5/23/91	Rw
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/23/91	Rw
	M) Iron Sight Alignment						5/23/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	Rw
	O) Attach Scope to Rifle						5/23/91	Rw
	P) Detach & Attach Scope 20 Times						5/23/91	Rw
640	Gallery Target & Test						5/23/91	KT
645	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/23/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.13	2.15	2.18	2.18	2.20	6/1/91	D/H
	C) Function						6-1-91	D/H
660	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. CCG11555

DATE 5-20-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.12	2.12	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.10	2.28	2.15	
PULL #3	2.32	2.12	2.27	2.18	
PULL #4	2.28	2.09	2.25	2.18	
PULL #5	2.28	2.09	2.29	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.05		
PULL #2	3.15	3.05		
PULL #3	3.15	3.09		
PULL #4	3.76	3.06		
PULL #5	3.09	3.07		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.54		4.22
PULL #2	4.35	4.56		4.20
PULL #3	4.53	4.56		4.10
PULL #4	4.37	4.55		4.17
PULL #5	4.43	4.57		3.96
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611555
23 May 1991

CENTROIDAL DISTANCES

0 TO 1	.445539
1 TO 2	.42638
1 TO 3	.772447
1 TO 4	.275801
1 TO 5	.708554

$\frac{3}{2} \frac{1}{2}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133471
THE AMR FOR THIS RIFLE IS: .9734

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611555

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.249

VS= 4.339

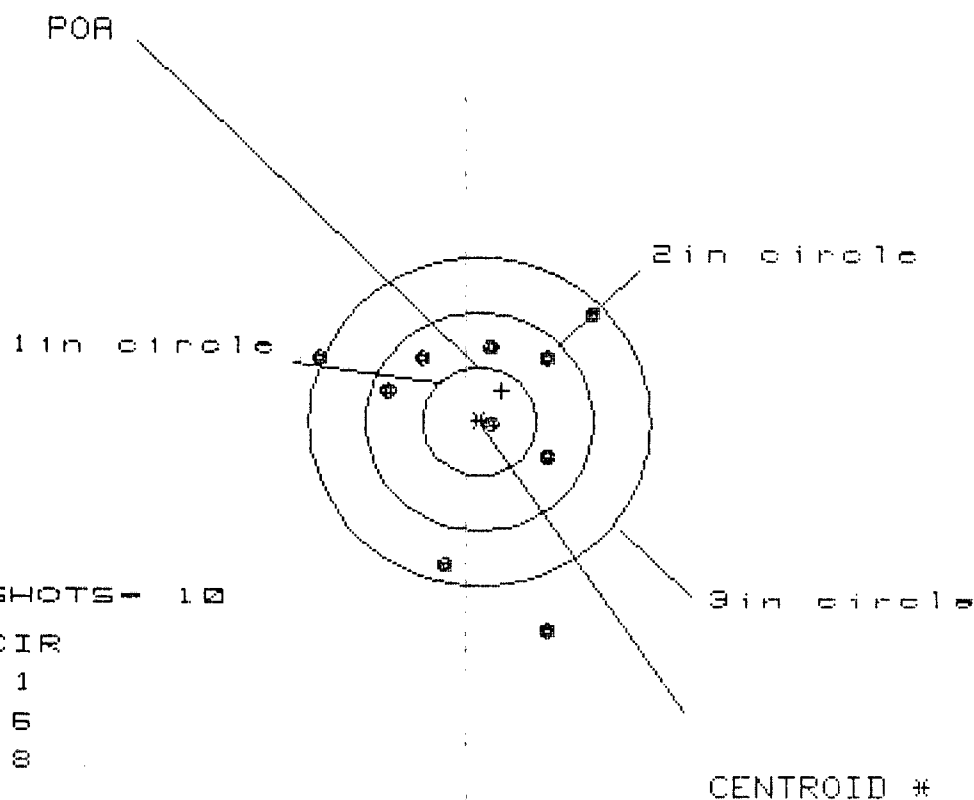
GS= 4.371

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.182	1.188	1.262
MINIMUM X	:	-1.067	-1.061	-.987
MAXIMUM Y	:	2.822	1.500	1.349
MINIMUM Y	:	-1.517	-1.203	-1.010
CENTROID X	:	.219	.213	.139
CENTROID Y	:	-.388	-.702	-.551
POA TO CENTROID in.	:	.446	.733	.568
MIN RADIUS	:	.297	.328	.196
MEAN RADIUS	:	1.160	.971	.890
MAX RADIUS	:	2.823	1.573	1.431
HORIZONTAL SPREAD	:	2.249	2.249	2.249
VERTICAL SPREAD	:	4.339	2.703	2.359
EXTREME SPREAD	:	4.371	2.905	2.620
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611555

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.411

VS= 2.850

GS= 3.205

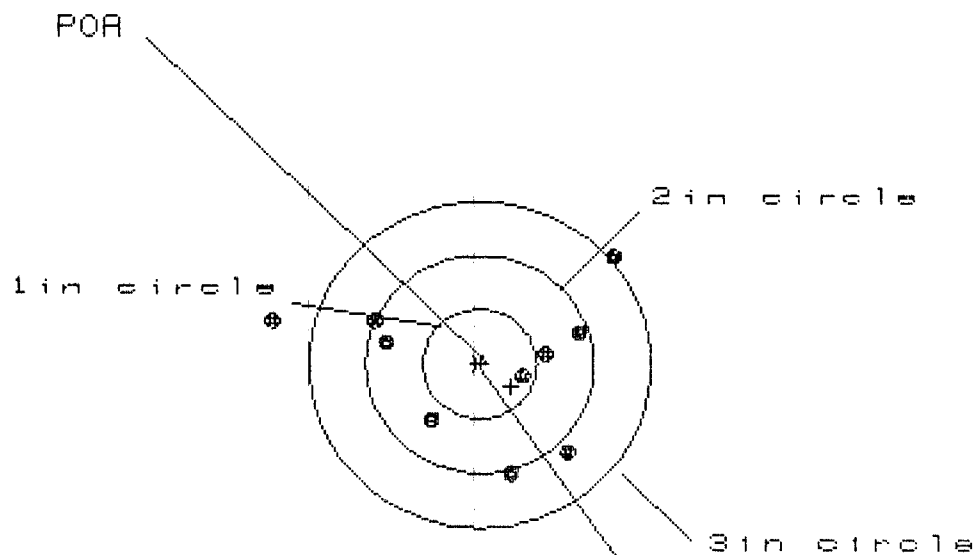
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	1.065	.897
MINIMUM X	:	-1.411	-1.346	-.911
MAXIMUM Y	:	.949	.738	.788
MINIMUM Y	:	-1.901	-1.545	-1.495
CENTROID X	:	-.195	-.260	-.092
CENTROID Y	:	-.206	-.075	-.125
POR TO CENTROID in.	:	.347	.271	.155
MIN RADIUS	:	.093	.287	.195
MEAN RADIUS	:	1.012	.882	.799
MAX RADIUS	:	1.988	1.558	1.539
HORIZONTAL SPREAD	:	2.411	2.411	1.808
VERTICAL SPREAD	:	2.850	2.283	2.283
EXTREME SPREAD	:	3.205	2.609	2.609
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611555

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.924

VS = 2.011

GS = 2.985

CENTROID *

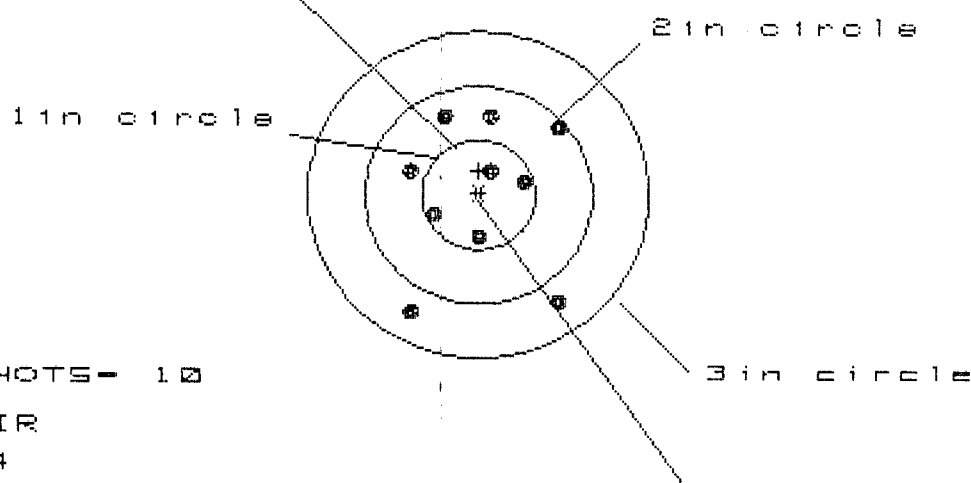
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.143	.945	.759
MINIMUM X	:	-1.781	-1.114	-.995
MAXIMUM Y	:	1.014	1.060	.604
MINIMUM Y	:	-.997	-.951	-.818
CENTROID X	:	-.276	-.078	-.197
CENTROID Y	:	.205	.159	.026
POA TO CENTROID in.	:	.344	.177	.198
MIN RADIUS	:	.374	.171	.310
MEAN RADIUS	:	.990	.854	.787
MAX RADIUS	:	1.829	1.421	1.164
HORIZONTAL SPREAD	:	2.924	2.059	1.754
VERTICAL SPREAD	:	2.011	2.011	1.422
EXTREME SPREAD	:	2.985	2.207	2.063
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611555

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.348

VS= 1.812

GS= 2.139

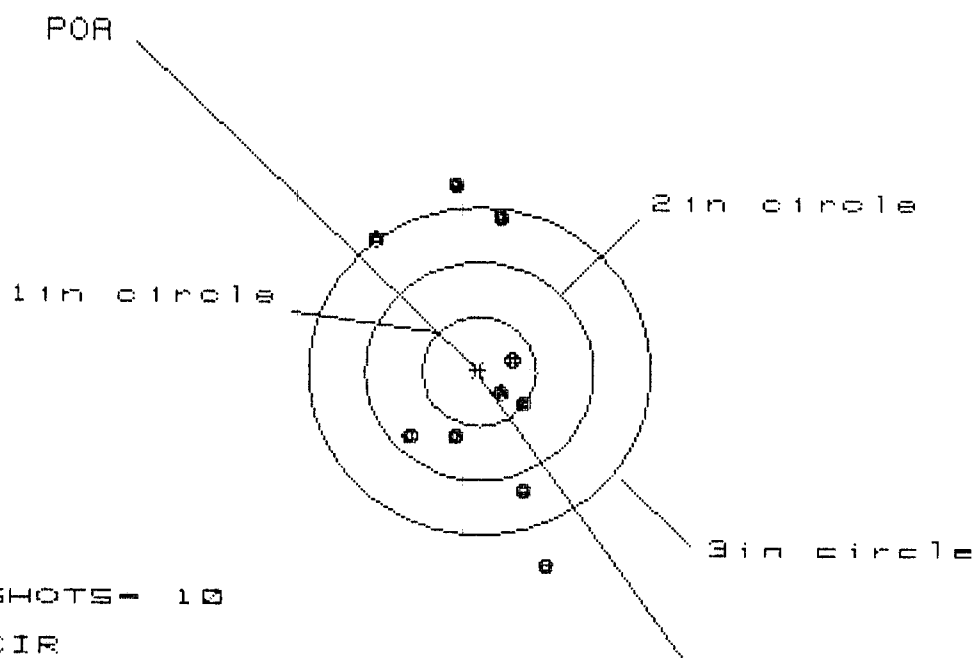
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.732	.664	.693
MINIMUM X	:	-.616	-.617	-.535
MAXIMUM Y	:	.746	.628	.493
MINIMUM Y	:	+1.066	-1.077	-.619
CENTROID X	:	-.002	.066	-.017
CENTROID Y	:	-.223	-.105	.030
POA TO CENTROID in.	:	.223	.124	.034
MIN RADIUS	:	.264	.140	.072
MEAN RADIUS	:	.691	.612	.509
MAX RADIUS	:	1.231	1.265	.792
HORIZONTAL SPREAD	:	1.348	1.281	1.227
VERTICAL SPREAD	:	1.812	1.705	1.112
EXTREME SPREAD	:	2.139	2.012	1.367
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611555

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.502

VS= 3.491

GS= 3.575

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.578	.475	.459
MINIMUM X	:	-.924	-.860	-.876
MAXIMUM Y	:	1.715	1.518	1.352
MINIMUM Y	:	-1.776	-1.271	-1.081
CENTROID X	:	-.188	-.252	-.236
CENTROID Y	:	.192	.389	.199
POR TO CENTROID in.	:	.269	.464	.309
MIN RADIUS	:	.231	.330	.270
MEAN RADIUS	:	1.014	.954	.827
MAX RADIUS	:	1.868	1.523	1.519
HORIZONTAL SPREAD	:	1.502	1.335	1.335
VERTICAL SPREAD	:	3.491	2.789	2.433
EXTREME SPREAD	:	3.575	2.851	2.672
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	