

C6611570

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6611570

ORDER NO.
5716

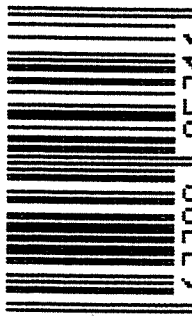
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611570

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611570

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KA
600	Proof		2/1/91	KA
607	Check Headspace		2/1/91	KA
610	Dis-assemble Gun		2/1/91	KA
612	Magnaflux Barrel Action	2 11 91		KCR
	Magnaflux Bolt	2 11 91		KCR
615	Rollmark Caliber	2 11 91		CS
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2/2/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-29/91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-2-91	DH
	G) Safety Off Force	2 1/2	2	2 1/2			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	DH
	I) Firing Pin Indent	.021	.021	.021			4-2-91	DH
	J) Assemble Stock						4/8/91	KS
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/8/91	KS
	M) Iron Sight Alignment						4/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/8/91	KS
	O) Attach Scope to Rifle						4/8/91	KS
	P) Detach & Attach Scope 20 Times						4/8/91	KS
640	Gallery Target & Test						4-9-91	NE
	A) Time						"	NE
	B) Malfunctions						"	NE
	C) Pierced Primers						"	NE
	D) Optical Clarity of Scope						"	NE
645	Inspect for Live Ammo						4-9-91	NE
655	Final Inspection							
	A) Headspace						4-10-91	DH
	B) Trigger Pull	2.50	2.41	2.38	2.40	2.36	4/12/91	OK
	C) Function						4-10-91	DH
660	Pack						6-17-91	NE

MOD. _____ GA. _____ GUN # 1570
 CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
✓	1st	Bolt Handle hits Stock & Safe benches	KS
	4/9		
	2nd		
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611570DATE 4-2-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.48	2.41	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.56	2.49	2.41	
PULL #3	2.48	2.50	2.54	2.38	
PULL #4	2.49	2.52	2.50	2.40	
PULL #5	2.51	2.48	2.46	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.13		
PULL #2	3.19	3.11		
PULL #3	3.06	3.12		
PULL #4	3.15	3.09		
PULL #5	3.05	3.14		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.28		4.05
PULL #2	4.37	4.26		4.09
PULL #3	4.38	4.26		4.08
PULL #4	4.29	4.29		4.09
PULL #5	4.31	4.34		4.12
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611570
9 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.162336
1 TO	2	.375405
1 TO	3	.191254
1 TO	4	.272443
1 TO	5	.126491

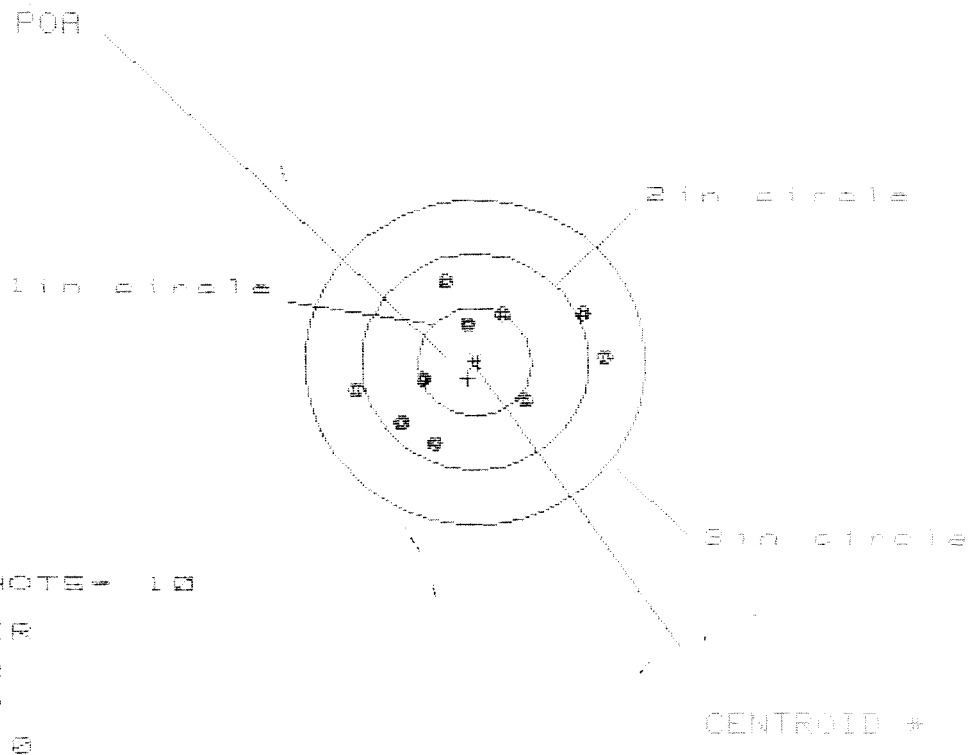
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0 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0244
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0284345
THE AMR FOR THIS RIFLE IS: .7494

Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611570

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.180

VS = 1.560

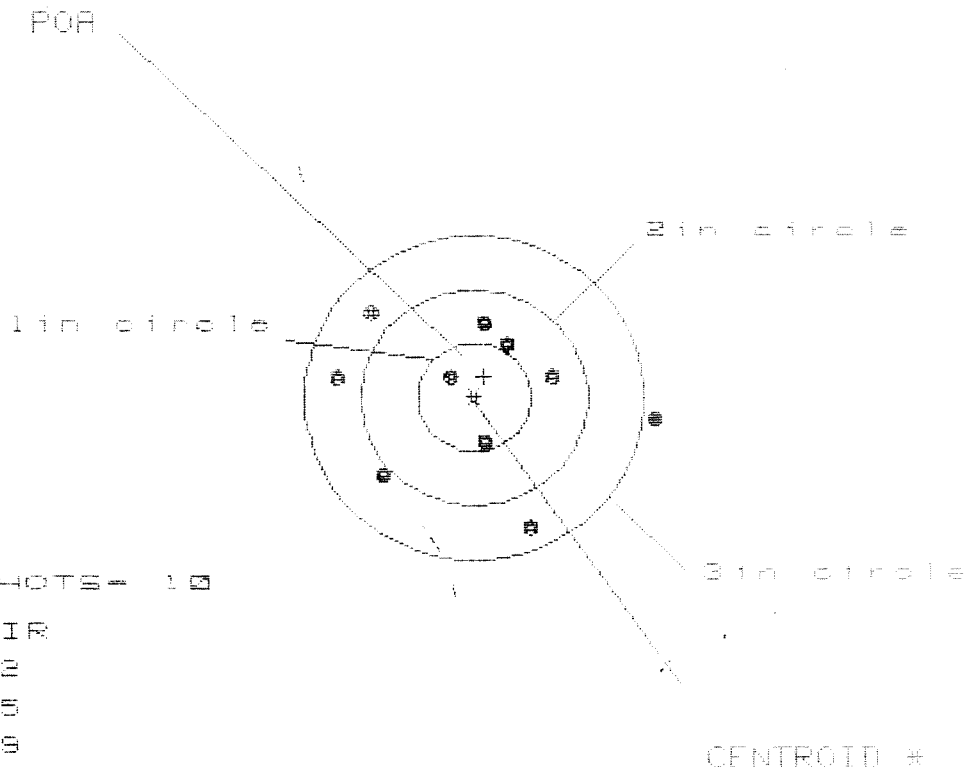
GS = 2.212

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	1.111	.956
MINIMUM X	-1.046	-.920	-.656
MAXIMUM Y	.766	.775	.746
MINIMUM Y	-.794	-.785	-.820
CENTROID X	.057	-.069	.046
CENTROID Y	.152	.143	.178
POR TO CENTROID in.	.163	.159	.184
MIN RADIUS	.346	.319	.318
MEAN RADIUS	.763	.709	.673
MAX RADIUS	1.137	1.199	1.080
HORIZONTAL SPREAD	2.180	2.031	1.652
VERTICAL SPREAD	1.560	1.560	1.560
EXTREME SPREAD	2.212	2.159	1.912
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

9 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.785

VS = 1.987

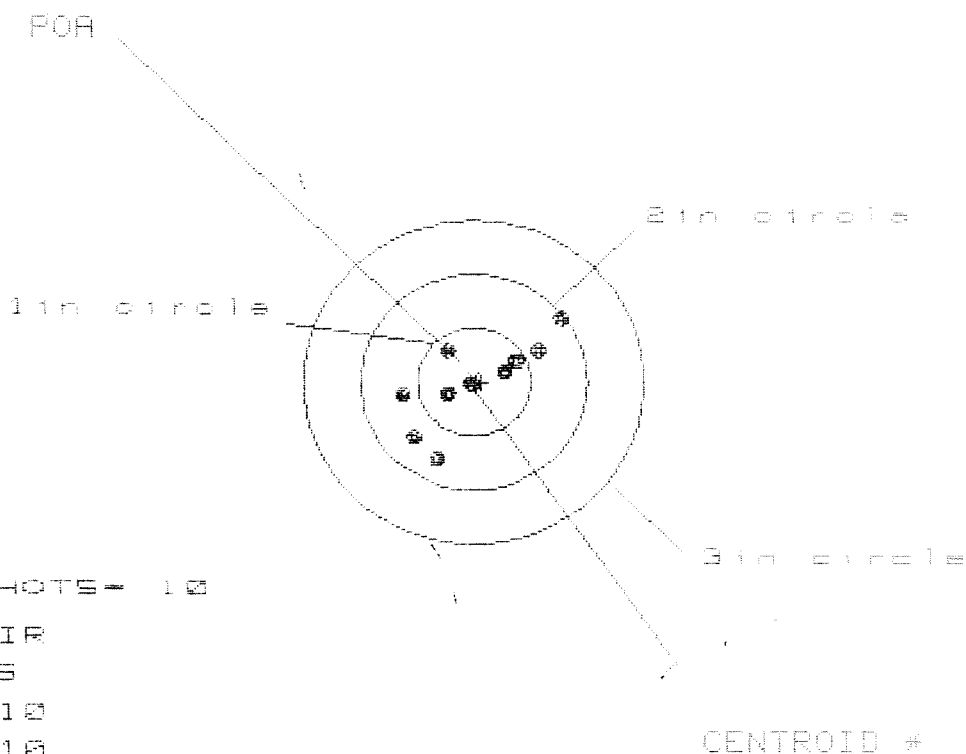
GS = 2.806

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.614	.850	.936
MINIMUM X	-1.171	-.992	-.986
MAXIMUM Y	.748	.730	.573
MINIMUM Y	-1.239	-1.257	-.854
CENTROID X	-.091	-.270	-.356
CENTROID Y	-.193	-.175	-.018
POA TO CENTROID in.	.214	.322	.356
MIN RADIUS	.283	.159	.039
MEAN RADIUS	.914	.820	.717
MAX RADIUS	1.622	1.432	1.008
HORIZONTAL SPREAD	2.785	1.842	1.842
VERTICAL SPREAD	1.987	1.987	1.427
EXTREME SPREAD	2.806	2.466	1.842
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Apr 1991

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CENTERFIRE PATTERNS # 3



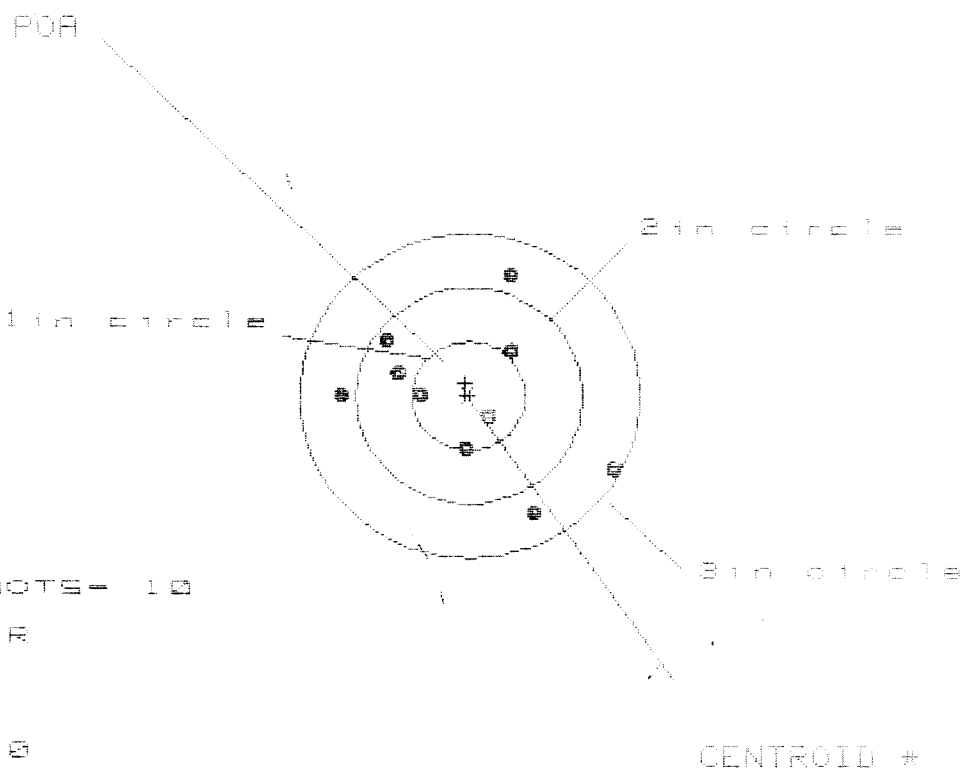
OF SHOTS = 10
 # IN CIR
 1in = 5
 2in = 10
 3in = 10
 HS = 1.356
 VS = 1.227
 GS = 1.659

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.761
MINIMUM X	-.595
MAXIMUM Y	.552
MINIMUM Y	-.675
CENTROID X	-.070
CENTROID Y	.009
POA TO CENTROID in.	.071
MIN RADIUS	.018
MEAN RADIUS	.502
MAX RADIUS	.940
HORIZONTAL SPREAD	1.356
VERTICAL SPREAD	1.227
EXTREME SPREAD	1.659
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	10
NUMBER IN THREE INCH CIRCLE =	10

9 Apr 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.366

VS= 2.269

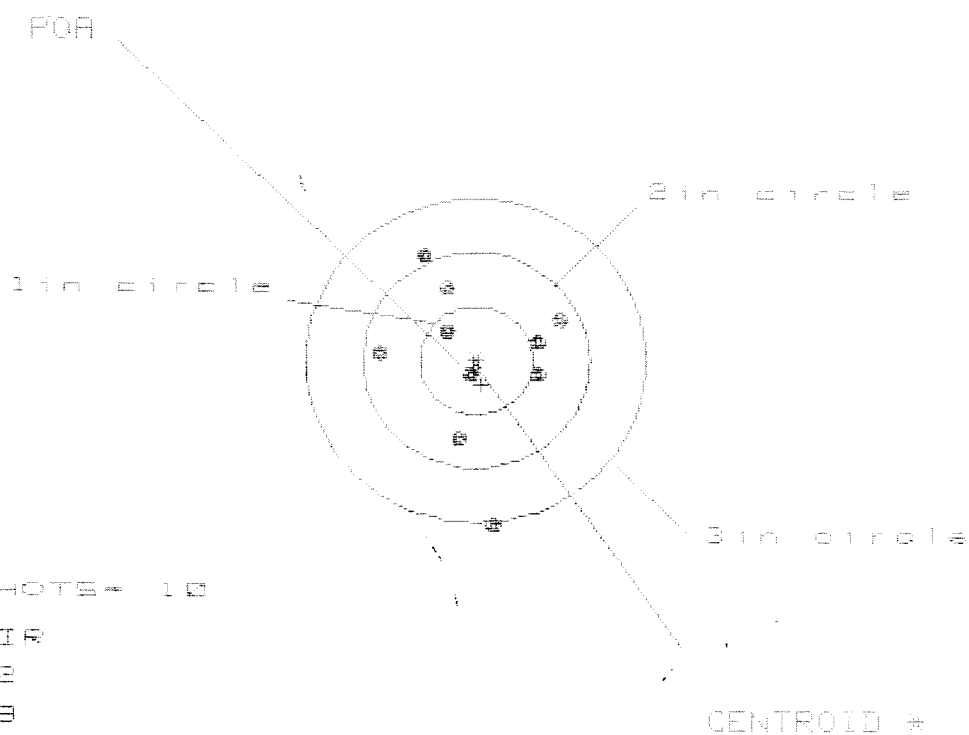
GS= 2.464

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.282	.722	.636
MINIMUM X	:	-1.084	-.941	-.851
MAXIMUM Y	:	1.153	1.080	.932
MINIMUM Y	:	-1.116	-1.189	-.708
CENTROID X	:	.029	-.113	-.203
CENTROID Y	:	-.119	-.046	.102
POA TO CENTROID in.	:	.123	.122	.228
MIN RADIUS	:	.233	.316	.291
MEAN RADIUS	:	.828	.740	.645
MAX RADIUS	:	1.441	1.391	1.128
HORIZONTAL SPREAD	:	2.366	1.663	1.487
VERTICAL SPREAD	:	2.269	2.269	1.640
EXTREME SPREAD	:	2.464	2.276	1.862
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

9 Apr 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.590

VS= 2.542

GS= 2.604

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.746	.762	.711
MINIMUM X	-.844	-.828	-.879
MAXIMUM Y	1.003	.832	.682
MINIMUM Y	-1.539	-.900	-.796
CENTROID X	-.047	-.063	-.012
CENTROID Y	.224	.395	.291
POA TO CENTROID in.	.229	.400	.291
MIN RADIUS	.146	.224	.221
MEAN RADIUS	.740	.639	.594
MAX RADIUS	1.545	.927	.879
HORIZONTAL SPREAD	1.590	1.590	1.590
VERTICAL SPREAD	2.542	1.732	1.398
EXTREME SPREAD	2.604	1.747	1.625
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		