

C6611600

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

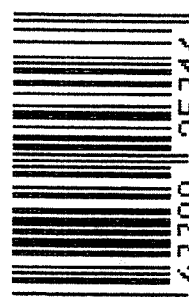
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO. C6611600	ORDER NO. 5716
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UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6611600**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		APR 3 1991	LS
618	Polish Barrel		APR 3 1991	LS
620	Apply Coatings (Barrel Action)		4-19-91	LS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/26/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/26/91	KS
	C) Inspect Ejector Hole for Chamfer		4/26/91	KS
	D) Oil Firing Pin Ass'y		4/26/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/91	98

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	5/1/91	JH
	G) Safety Off Force	4	4	4	5/1/91	JH
	H) Trigger Pull Test & Retainability				4/30/91	JH
	I) Firing Pin Indent	.022	.022	.022	5/1/91	JH
	J) Assemble Stock				5/2/91	KS
	K) Assemble Swivel Studs				5-1-91	DH
	L) Attach Front and Rear Sight Assemblies				5/2/91	KS
	M) Iron Sight Alignment				5/2/91	KS
	N) Detach Front & Rear Sights & place in numbered container				5/2/91	KS
	O) Attach Scope to Rifle				5/2/91	KS
	P) Detach & Attach Scope 20 Times				5/2/91	KS
640	Gallery Target & Test				5-3-91	AC
	A) Time				5-3-91	AC
	B) Malfunctions				5-3-91	AC
	C) Pierced Primers				5-3-91	AC
	D) Optical Clarity of Scope				5-3-91	AC
645	Inspect for Live Ammo				5-3-91	AC
655	Final Inspection					
	A) Headspace				5-11-91	DH
	B) Trigger Pull	2.32	2.30	2.20	2.15 + 2.14	5/19/91 JH
	C) Function				5-11-91	DH
660	Pack				6-18-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611600

DATE 4/30/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.29	2.40	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.35	2.36	2.30	
PULL #3	2.35	2.43	2.48	2.20	
PULL #4	2.30	2.39	2.36	2.15	
PULL #5	2.36	2.38	2.30	2.14	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.33		
PULL #2	3.33	3.20		
PULL #3	3.35	3.31		
PULL #4	3.17	3.31		
PULL #5	3.33	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.52		4.35
PULL #2	4.40	4.30		4.34
PULL #3	4.43	4.46		4.52
PULL #4	4.37	4.39		4.39
PULL #5	4.32	4.48		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611600
3 May 1991

CENTROIDAL DISTANCES

0 TO	1	.119541
1 TO	2	.215081
1 TO	3	.10632
1 TO	4	.268425
1 TO	5	.197449

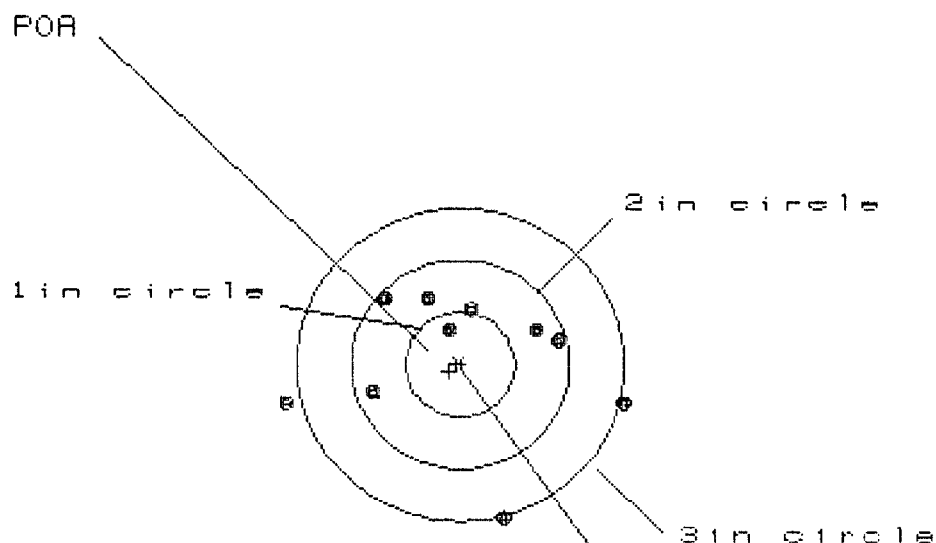
$\bar{x} = .1148$ <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119729
THE AMR FOR THIS RIFLE IS: 1.099

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611600

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 7

HS= 3.099

VS= 2.108

GS= 3.099

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.515	1.339	.846
MINIMUM X	:	-1.584	-.983	-.816
MAXIMUM Y	:	.605	.563	.506
MINIMUM Y	:	-1.503	-1.545	-1.602
CENTROID X	:	.099	.275	.108
CENTROID Y	:	.067	.109	.166
POA TO CENTROID in.	:	.120	.296	.198
MIN RADIUS	:	.332	.376	.239
MEAN RADIUS	:	.968	.879	.777
MAX RADIUS	:	1.630	1.559	1.646
HORIZONTAL SPREAD	:	3.099	2.322	1.662
VERTICAL SPREAD	:	2.108	2.108	2.108
EXTREME SPREAD	:	3.099	2.461	2.383
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	7		

3 May 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 3.600

VS = 2.639

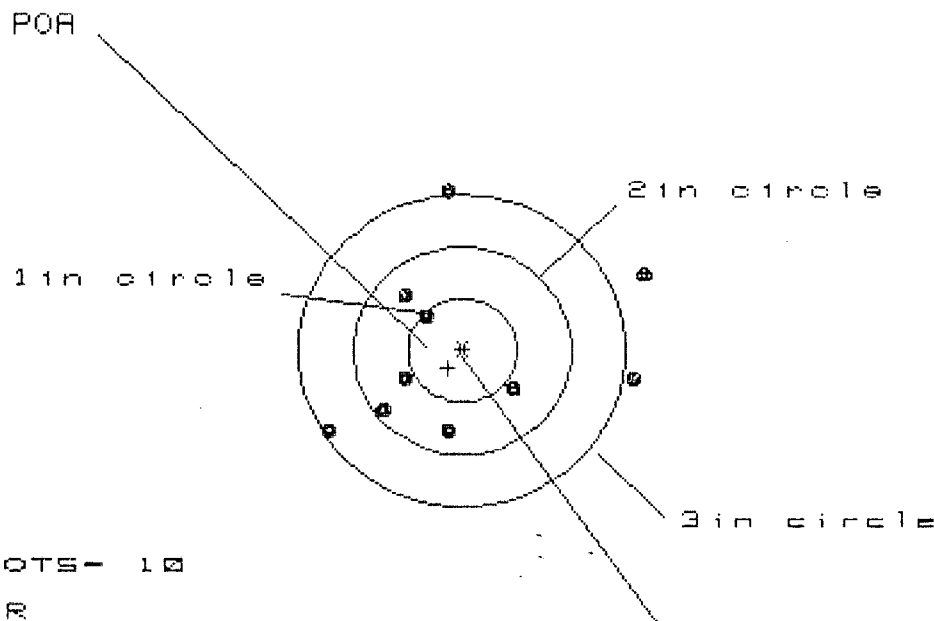
GS = 3.688

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.273	1.512	1.441
MINIMUM X	-1.327	-1.074	-1.145
MAXIMUM Y	1.184	1.243	1.069
MINIMUM Y	-1.455	-1.396	-0.694
CENTROID X	-0.087	-0.340	-0.269
CENTROID Y	-0.041	-0.099	0.075
POA TO CENTROID in.	0.096	0.354	0.279
MIN RADIUS	0.136	0.202	0.081
MEAN RADIUS	1.147	0.989	0.896
MAX RADIUS	2.333	1.688	1.552
HORIZONTAL SPREAD	3.600	2.586	2.586
VERTICAL SPREAD	2.639	2.639	1.762
EXTREME SPREAD	3.688	2.989	2.761
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

3 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 6

HS= 2.895

VS= 2.376

GS= 3.261

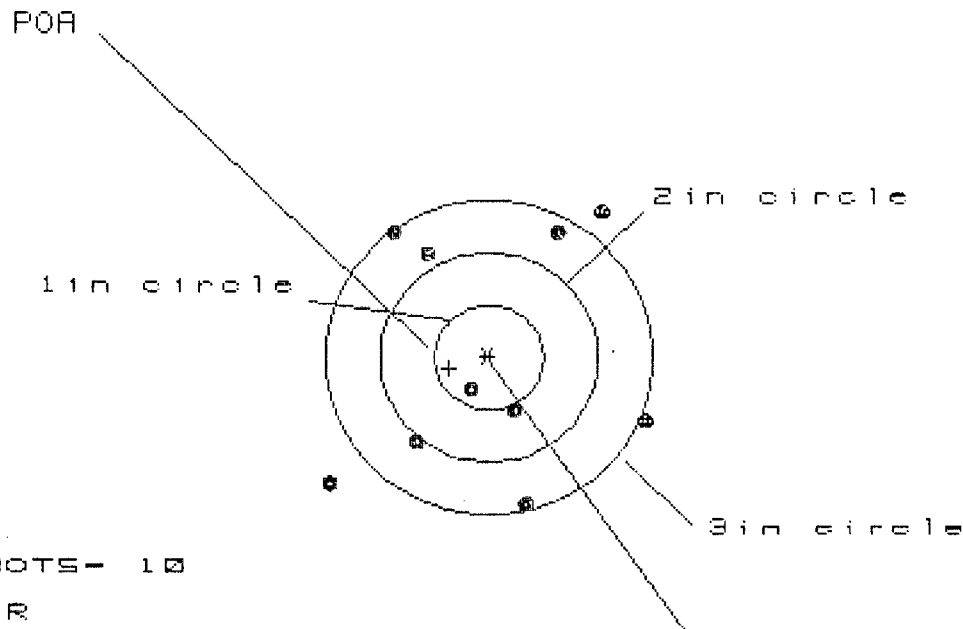
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.623	1.775	.871
MINIMUM X	-1.272	-1.092	-.870
MAXIMUM Y	1.568	1.645	1.617
MINIMUM Y	-.808	-.731	-.759
CENTROID X	.129	-.051	-.273
CENTROID Y	.169	.092	.120
POA TO CENTROID in.	.213	.105	.298
MIN RADIUS	.455	.431	.295
MEAN RADIUS	1.063	.944	.804
MAX RADIUS	1.765	1.789	1.636
HORIZONTAL SPREAD	2.895	2.867	1.741
VERTICAL SPREAD	2.376	2.376	2.376
EXTREME SPREAD	3.261	2.911	2.628
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 2.889

VS= 2.813

GS= 3.577

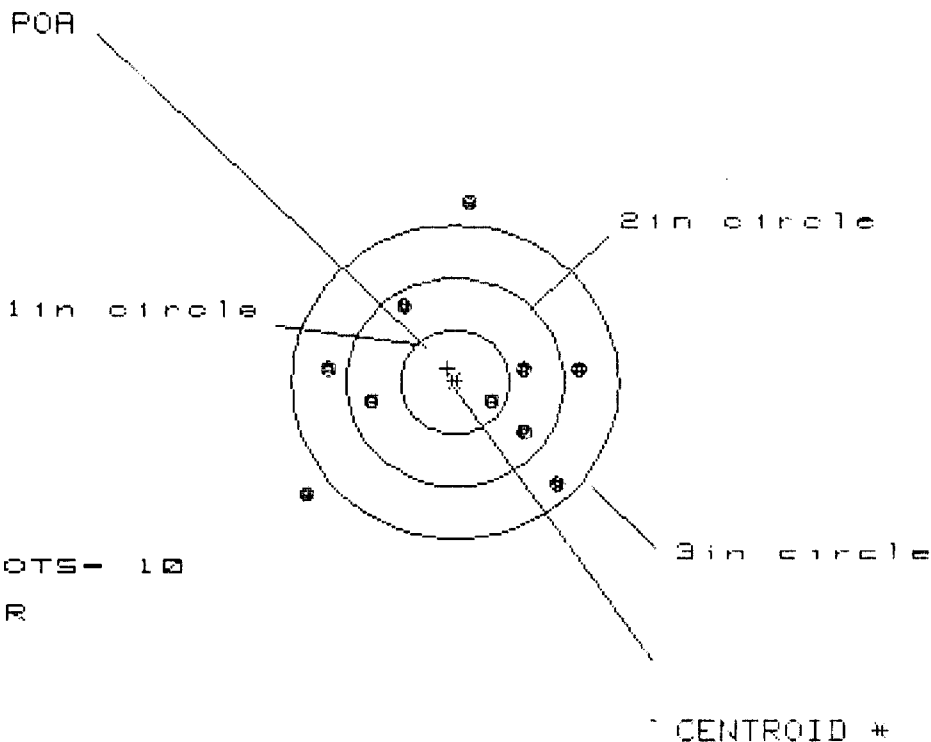
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.425	1.262	1.376
MINIMUM X	-1.464	-0.997	-0.883
MAXIMUM Y	1.363	1.233	1.242
MINIMUM Y	-1.450	-1.580	-1.425
CENTROID X	.365	.528	.414
CENTROID Y	.103	.233	.078
POA TO CENTROID in.	.379	.577	.421
MIN RADIUS	.287	.483	.291
MEAN RADIUS	1.249	1.190	1.109
MAX RADIUS	1.869	1.584	1.503
HORIZONTAL SPREAD	2.889	2.259	2.259
VERTICAL SPREAD	2.813	2.813	2.667
EXTREME SPREAD	3.577	2.920	2.882
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.446

VS= 2.889

GS= 3.258

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.098	1.115	.949
MINIMUM X	:	-1.348	-1.331	-1.353
MAXIMUM Y	:	1.774	.937	.822
MINIMUM Y	:	-1.115	-.918	-.864
CENTROID X	:	.068	.051	.217
CENTROID Y	:	-.128	-.325	-.210
POA TO CENTROID in.	:	.145	.329	.302
MIN RADIUS	:	.397	.374	.227
MEAN RADIUS	:	1.068	.980	.855
MAX RADIUS	:	1.781	1.617	1.365
HORIZONTAL SPREAD	:	2.446	2.446	2.302
VERTICAL SPREAD	:	2.889	1.855	1.686
EXTREME SPREAD	:	3.258	2.756	2.337
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	