

C661615

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington [®]		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24			SERIAL NO. C6611615
			ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			

20



5716 C6611615

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611615**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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		"	JS
617	Drill and Tap Sight Holes	APR 3 1991		LB
618	Polish Barrel	APR 3 1991		WB
620	Apply Coatings (Barrel Action)		4/19/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/2/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/2/91	K.S.
	D) Oil Firing Pin Ass'y		5/2/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/7/91	JK
	G) Safety Off Force	4	4	4			5/7/91	JK
	H) Trigger Pull Test & Retainability						5/7/91	JK
	I) Firing Pin Indent	.0215	.022	.022			5/7/91	JK
	J) Assemble Stock						5/10/91	KS
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/10/91	KS
	M) Iron Sight Alignment						5/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/10/91	KS
	O) Attach Scope to Rifle						5/10/91	KS
	P) Detach & Attach Scope 20 Times						5/10/91	KS
640	Gallery Target & Test						5/14/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/14/91	KT
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.69	2.43	2.42	2.42	2.42	5/20/91	JK
	C) Function						5-21-91	D/H
660	Pack						6-17-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6611615

DATE 5/7/91

TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.47	2.38	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.55	2.49	2.43	
PULL #3	2.54	2.48	2.53	2.42	
PULL #4	2.34	2.61	2.58	2.42	
PULL #5	2.54	2.51	2.56	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.49		
PULL #2	3.25	3.38		
PULL #3	3.53	3.41		
PULL #4	3.36	3.46		
PULL #5	3.35	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.26		4.33
PULL #2	4.41	4.30		4.30
PULL #3	4.26	4.32		4.30
PULL #4	4.32	4.25		4.25
PULL #5	4.28	4.33		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611615
14 May 1991

CENTROIDAL DISTANCES

0 TO	1	.119436
1 TO	2	.10911
1 TO	3	.105119
1 TO	4	.176182
1 TO	5	.196023

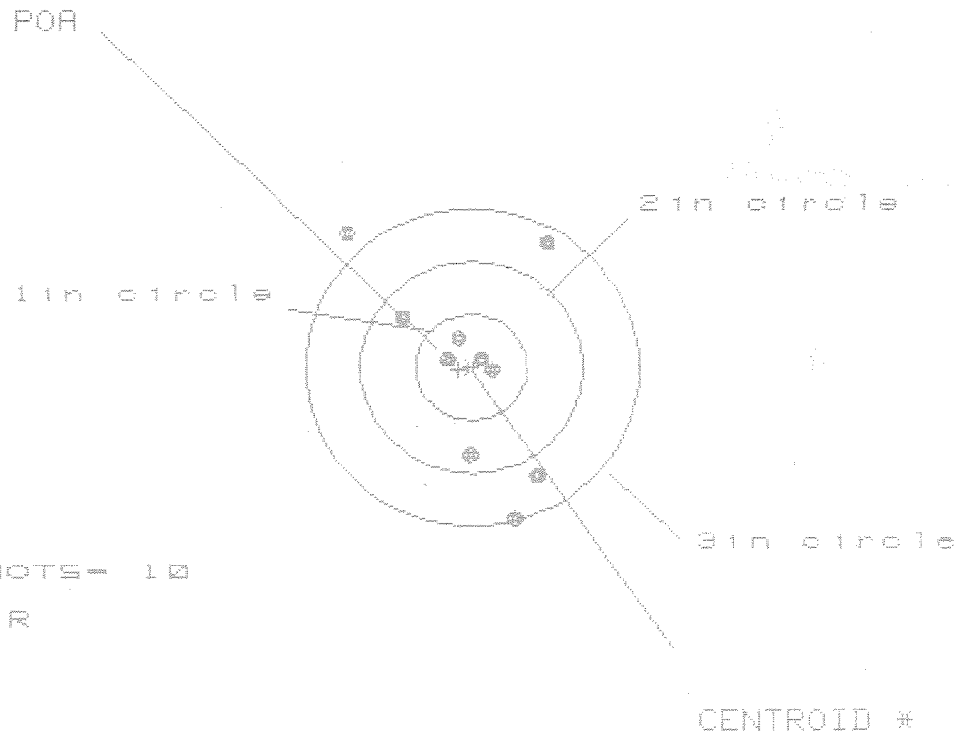
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .035
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0438402
THE AMR FOR THIS RIFLE IS: .9392

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611615

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 1.814

VS= 2.699

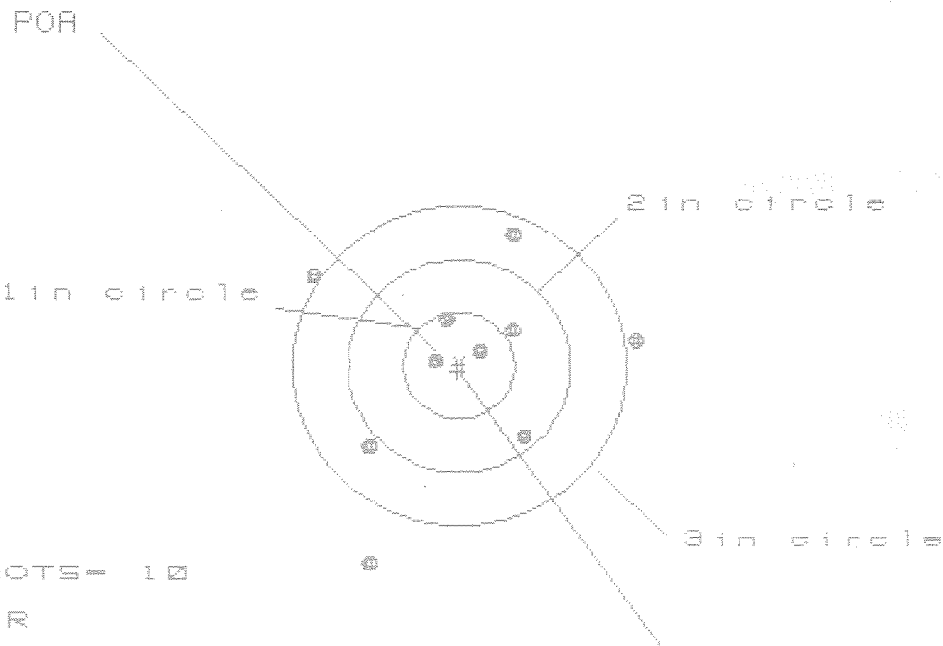
GS= 3.093

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.713	.591	.627
MINIMUM X	:	-1.101	-.733	-.697
MAXIMUM Y	:	1.276	1.360	1.199
MINIMUM Y	:	-1.423	-1.281	-1.032
CENTROID X	:	.117	.239	.203
CENTROID Y	:	.024	-.118	.043
POA TO CENTROID in.	:	.119	.266	.207
MIN RADIUS	:	.111	.090	.052
MEAN RADIUS	:	.809	.726	.613
MAX RADIUS	:	1.685	1.482	1.353
HORIZONTAL SPREAD	:	1.814	1.324	1.324
VERTICAL SPREAD	:	2.699	2.641	2.231
EXTREME SPREAD	:	3.093	2.658	2.234
NUMBER IN ONE INCH CIRCLE =	:	4	6	9
NUMBER IN TWO INCH CIRCLE =	:	6	9	9
NUMBER IN THREE INCH CIRCLE =	:	9	9	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611615

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.901

VS= 3.118

GS= 3.396

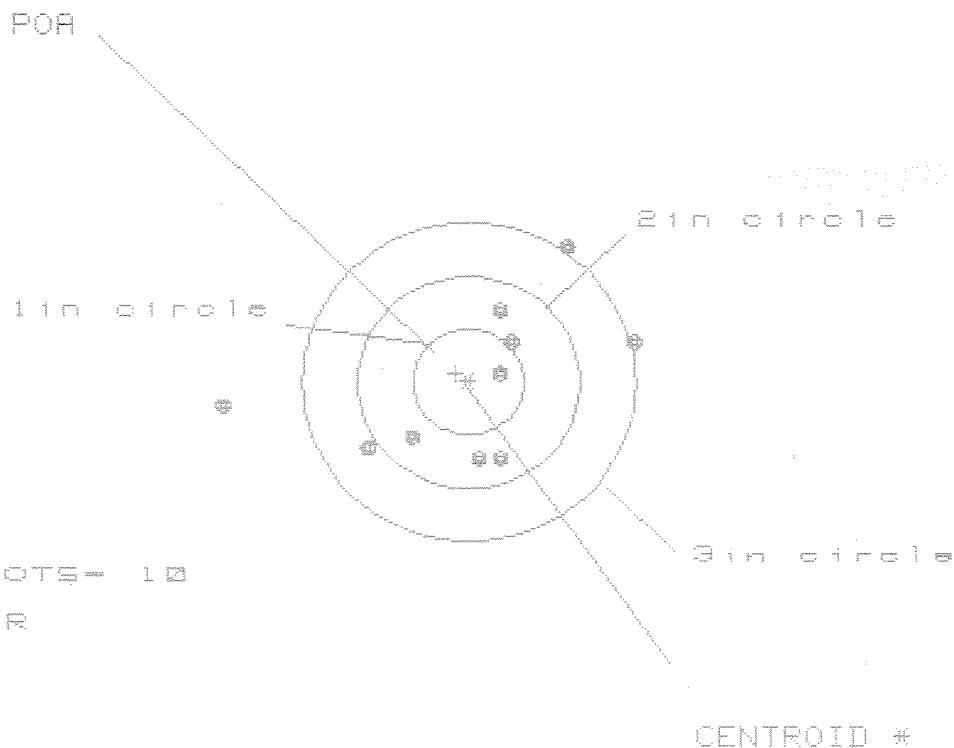
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.553	1.458	1.278
MINIMUM X	-1.348	-1.443	-1.115
MAXIMUM Y	1.243	1.035	1.117
MINIMUM Y	-1.875	-0.960	-0.877
CENTROID X	.013	.108	.288
CENTROID Y	.057	.265	.183
POA TO CENTROID in.	.058	.286	.341
MIN RADIUS	.248	.128	.073
MEAN RADIUS	1.017	.856	.757
MAX RADIUS	2.060	1.588	1.418
HORIZONTAL SPREAD	2.901	2.901	2.392
VERTICAL SPREAD	3.118	1.995	1.995
EXTREME SPREAD	3.396	2.977	2.575
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6811615

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.628

VS= 1.944

GS= 3.675

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.449	1.207	1.284
MINIMUM X	:	-2.179	-1.122	-1.046
MAXIMUM Y	:	1.263	1.237	.794
MINIMUM Y	:	-.681	-.707	-.553
CENTROID X	:	.112	.354	.277
CENTROID Y	:	-.081	-.055	-.209
POA TO CENTROID in.	:	.138	.358	.348
MIN RADIUS	:	.287	.094	.264
MEAN RADIUS	:	1.000	.823	.757
MAX RADIUS	:	2.192	1.379	1.367
HORIZONTAL SPREAD	:	3.628	2.329	2.329
VERTICAL SPREAD	:	1.944	1.944	1.347
EXTREME SPREAD	:	3.675	2.536	2.509
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.238

VS= 2.009

GS= 2.074

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =



10

9

8

.669

.717

.746

-.569

-.521

-.492

.991

.958

.844

-1.018

-.908

-.861

.005

-.043

-.072

.160

.050

.164

.160

.066

.179

.340

.269

.378

.782

.735

.710

1.080

.959

.965

1.238

1.238

1.238

2.009

1.866

1.705

2.074

1.875

1.782

1

8

10

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611615

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 8

HS- 2.516

VS- 3.072

GS- 3.073

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.110

1.040

.945

MINIMUM X

-1.406

-1.476

-1.571

MAXIMUM Y

1.505

1.331

.825

MINIMUM Y

-1.567

-1.116

-.950

CENTROID X

-.072

-.002

.093

CENTROID Y

-.028

.146

-.020

POA TO CENTROID in.

.077

.146

.095

MIN RADIUS

.509

.544

.559

MEAN RADIUS

1.088

1.009

.920

MAX RADIUS

1.688

1.565

1.611

HORIZONTAL SPREAD

2.516

2.516

2.516

VERTICAL SPREAD

3.072

2.447

1.775

EXTREME SPREAD

3.073

2.733

2.733

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8