

C6523453

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington



REG. U.S. PAT. & TM. OFF.

MODEL 700™ N24

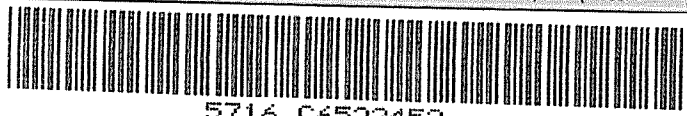
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

01

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

SERIAL NO.
C6523453

ORDER NO.
5716



5716 C6523453

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523453
18 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.562755
1 TO	2	.693387
1 TO	3	.710776
1 TO	4	.718056
1 TO	5	.739926

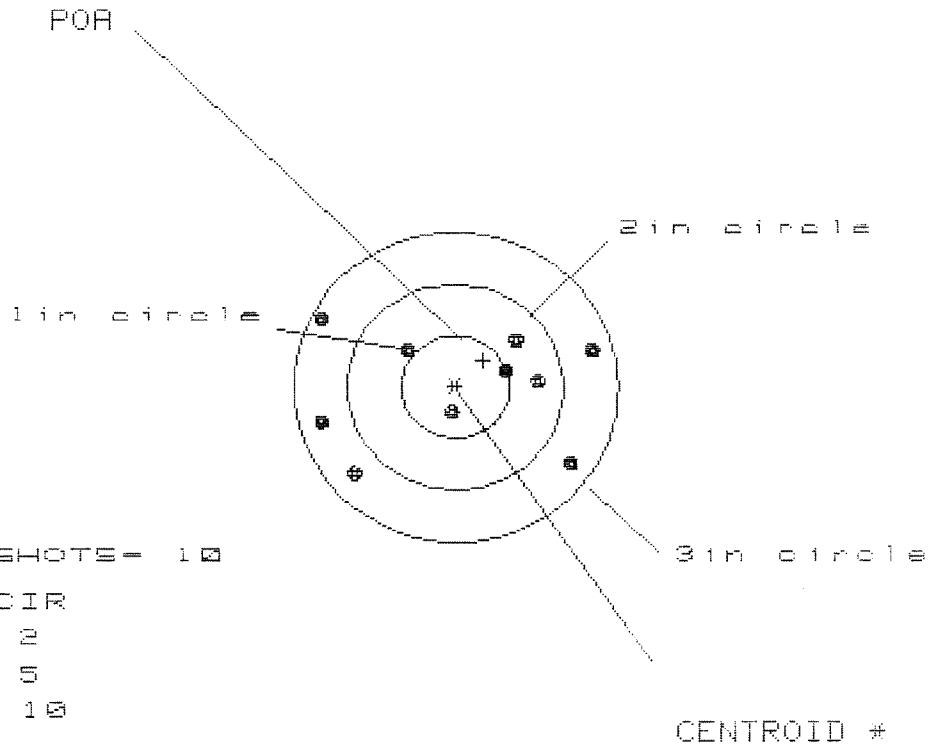
1
5+4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .063
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0976
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116167
THE AMR FOR THIS RIFLE IS: .9264

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523453

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.504

VS = 1.436

GS = 2.665

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.237	1.096	.923
MINIMUM X	:	-1.267	-1.381	-1.231
MAXIMUM Y	:	.615	.554	.517
MINIMUM Y	:	-.821	-.753	-.790
CENTROID X	:	-.260	-.119	.054
CENTROID Y	:	-.261	-.329	-.292
POR TO CENTROID in.	:	.368	.350	.297
MIN RADIUS	:	.226	.262	.261
MEAN RADIUS	:	.925	.857	.757
MAX RADIUS	:	1.409	1.412	1.462
HORIZONTAL SPREAD	:	2.504	2.477	2.154
VERTICAL SPREAD	:	1.436	1.307	1.307
EXTREME SPREAD	:	2.665	2.582	2.458
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8523453

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.573

VS= 1.710

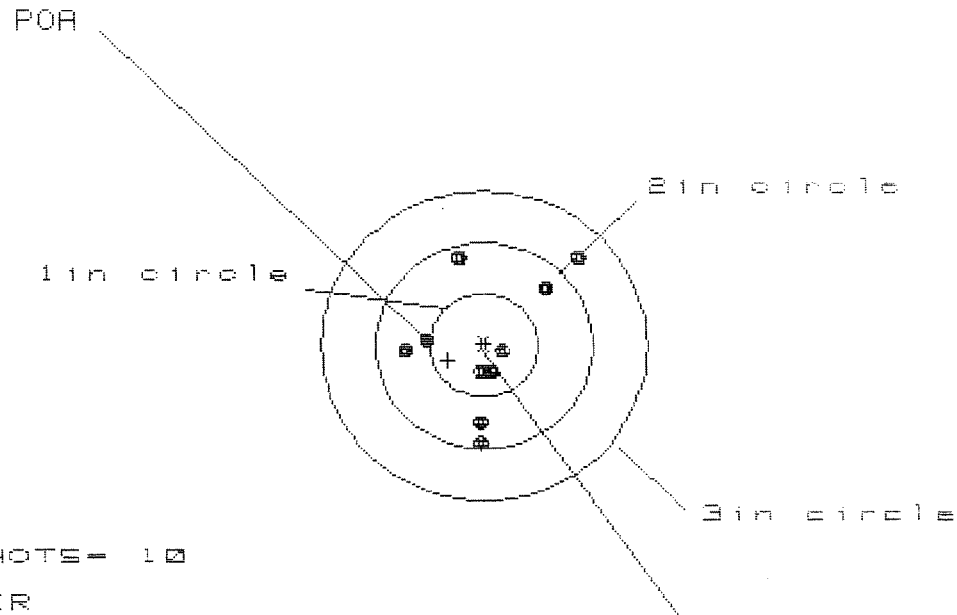
GS= 1.996

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.935	.648	.685
MINIMUM X	:	-.637	-.534	-.577
MAXIMUM Y	:	.931	.875	.792
MINIMUM Y	:	-.779	-.835	-.726
CENTROID X	:	.245	.142	.185
CENTROID Y	:	.007	.063	-.046
POA TO CENTROID in.	:	.246	.155	.190
MIN RADIUS	:	.233	.272	.197
MEAN RADIUS	:	.652	.605	.545
MAX RADIUS	:	1.064	.942	.997
HORIZONTAL SPREAD	:	1.573	1.182	1.182
VERTICAL SPREAD	:	1.710	1.710	1.518
EXTREME SPREAD	:	1.996	1.722	1.714
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.600

VS= 1.783

GS= 1.958

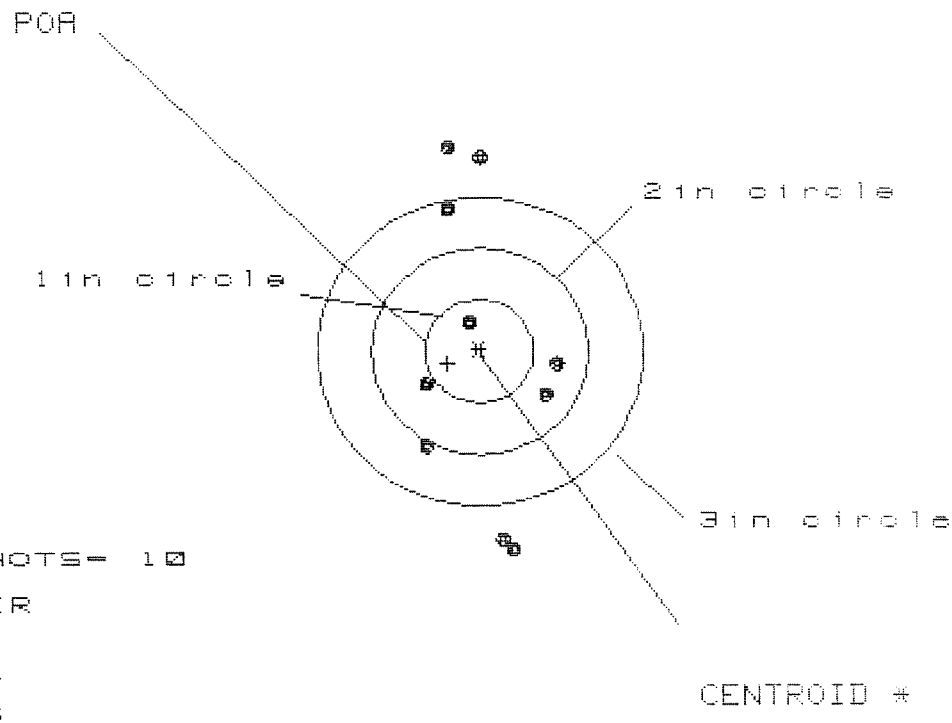
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.613	.621
MINIMUM X	:	-.758	-.664	-.656
MAXIMUM Y	:	.872	.966	.864
MINIMUM Y	:	-.911	-.817	-.778
CENTROID X	:	.332	.238	.230
CENTROID Y	:	.147	.053	.155
POA TO CENTROID in.	:	.363	.244	.277
MIN RADIUS	:	.195	.206	.297
MEAN RADIUS	:	.662	.584	.566
MAX RADIUS	:	1.194	.981	.878
HORIZONTAL SPREAD	:	1.600	1.277	1.277
VERTICAL SPREAD	:	1.783	1.783	1.642
EXTREME SPREAD	:	1.958	1.799	1.653
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 1.198

VS= 3.882

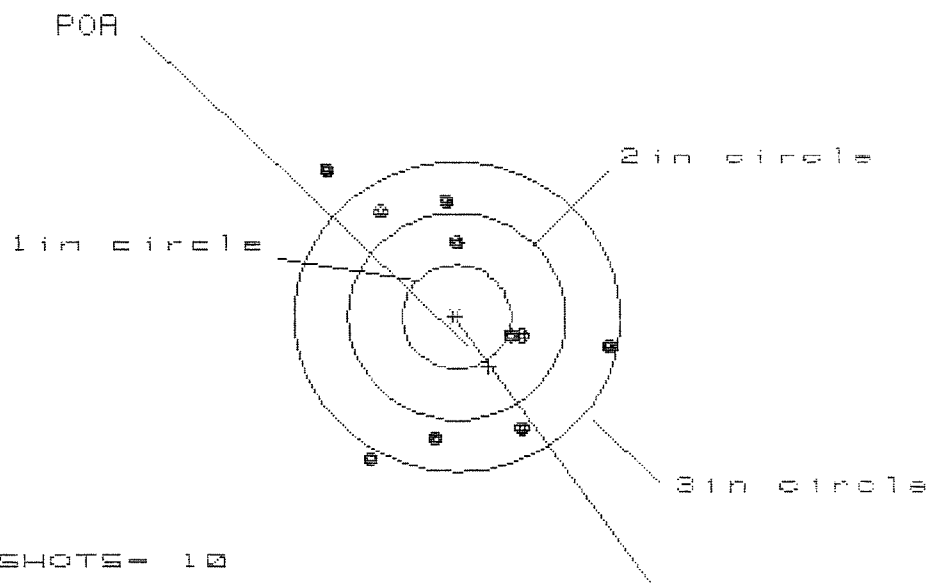
GS= 3.921

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.695	.725	.693
MINIMUM X	:	-.503	-.473	-.505
MAXIMUM Y	:	1.934	1.717	1.900
MINIMUM Y	:	-1.948	-2.004	-1.789
CENTROID X	:	.295	.265	.297
CENTROID Y	:	.117	.334	.119
POA TO CENTROID in.	:	.317	.426	.320
MIN RADIUS	:	.284	.106	.284
MEAN RADIUS	:	1.242	1.157	1.063
MAX RADIUS	:	1.966	2.020	1.900
HORIZONTAL SPREAD	:	1.198	1.198	1.198
VERTICAL SPREAD	:	3.882	3.721	3.689
EXTREME SPREAD	:	3.921	3.756	3.697
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.573

VS = 2.755

GS = 3.101

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.353	1.218	1.095
MINIMUM X	-1.220	-0.986	-1.002
MAXIMUM Y	1.413	1.299	1.150
MINIMUM Y	-1.342	-1.185	-1.162
CENTROID X	-0.297	-0.162	-0.039
CENTROID Y	0.478	0.321	0.470
POA TO CENTROID in.	0.563	0.360	0.471
MIN RADIUS	0.509	0.353	0.267
MEAN RADIUS	1.151	1.038	0.945
MAX RADIUS	1.866	1.542	1.405
HORIZONTAL SPREAD	2.573	2.204	2.097
VERTICAL SPREAD	2.755	2.484	2.312
EXTREME SPREAD	3.101	2.602	2.469
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6523453

DATE 9/13/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.24	2.35	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.29	2.30	2.16	
PULL #3	2.41	2.22	2.27	2.14	
PULL #4	2.38	2.35	2.31	2.18	
PULL #5	2.34	2.15	2.34	2.15	
TOTAL	12.00	11.25	11.57	10.84	
AVG.	2.40	2.25	2.31	2.17	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.15		
PULL #2	3.06	3.17		
PULL #3	3.10	3.15		
PULL #4	3.09	3.08		
PULL #5	3.07	3.05		
TOTAL	15.44	15.60		
AVG.	3.09	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.14		4.30
PULL #2	4.17	4.09		4.36
PULL #3	4.17	4.00		4.35
PULL #4	4.14	3.95		4.27
PULL #5	4.12	4.07		4.35
TOTAL	20.68	20.25		21.63
AVG.	4.14	4.05		4.32

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523453

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/21/90	KCR
	Magnaflux Bolt		8/21/90	KCR
615	Rollmark Caliber		8/21/90	GS
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/28/90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	KS
	C) Inspect Ejector Hole for Chamfer		8/31/90	KS
	D) Oil Firing Pin Ass'y		8/31/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			9/13/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/13/90	WB
	H) Trigger Pull Test & Retainability						9/13/90	WB
	I) Firing Pin Indent	.0225	.0225	.0225			9/13/90	WB
	J) Assemble Stock						9/15/90	KH
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						9/15/90	KH
	M) Iron Sight Alignment						9/15/90	KH
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	KH
	O) Attach Scope to Rifle						9/15/90	KH
	P) Detach & Attach Scope 20 Times						9/15/90	KH
640	Gallery Target & Test						9-18-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						9-18-90	A
655	Final Inspection							
	A) Headspace						9/18/90	RW
	B) Trigger Pull	2.21	2.16	2.14	2.18	2.15	9/18/90	RW
	C) Function						9/18/90	RW
660	Pack						9/20/90	IF