

CB649144

MODEL 700TM N24

Model SMSTM

Action

Barrel Length

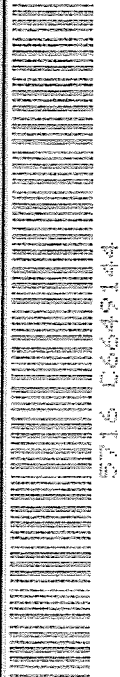
Capacity

Order No. 5716

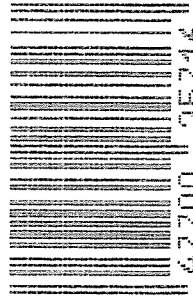
*Includes 1 in chamber.

Remington

Remington REG. U.S. PAT. & TM. OFF. DUPONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TH H24	SERIAL NO. C6649144	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.		



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649144

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GS.
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-1-91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8-1-91	JH
	G) Safety Off Force	3	3	3			8-1-91	JH
	H) Trigger Pull Test & Retainability						8-1-91	JH
	I) Firing Pin Indent	1020	1020	1020			8-1-91	JH
	J) Assemble Stock						8/5/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/5/91	RW
	M) Iron Sight Alignment						8/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/5/91	RW
	O) Attach Scope to Rifle						8/5/91	RW
	P) Detach & Attach Scope 20 Times						8/5/91	RW
640	Gallery Target & Test						8-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-5-91	NF
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.27	2.30	2.20	2.27	2.31	8-6-91	JH
	C) Function						8-6-91	AC
660	Pack						8-1-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6649144

DATE 8-1-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.50	2.48	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.40	2.50	2.30	
PULL #3	2.56	2.47	2.53	2.20	
PULL #4	2.56	2.55	2.50	2.27	
PULL #5	2.49	2.51	2.55	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.64		
PULL #2	3.50	3.58		
PULL #3	3.42	3.60		
PULL #4	3.44	3.66		
PULL #5	3.57	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.52		4.54
PULL #2	4.28	4.35		4.33
PULL #3	4.54	4.55		4.32
PULL #4	4.50	4.64		4.57
PULL #5	4.28	4.69		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649144
5 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0524023
1 TO	2	.228475
1 TO	3	.231458
1 TO	4	.152319
1 TO	5	.130146

31 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0096
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0256632
THE AMR FOR THIS RIFLE IS: .0116

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649144

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.522

VS= 3.070

GS= 3.095

CENTROID *

PATTERN #

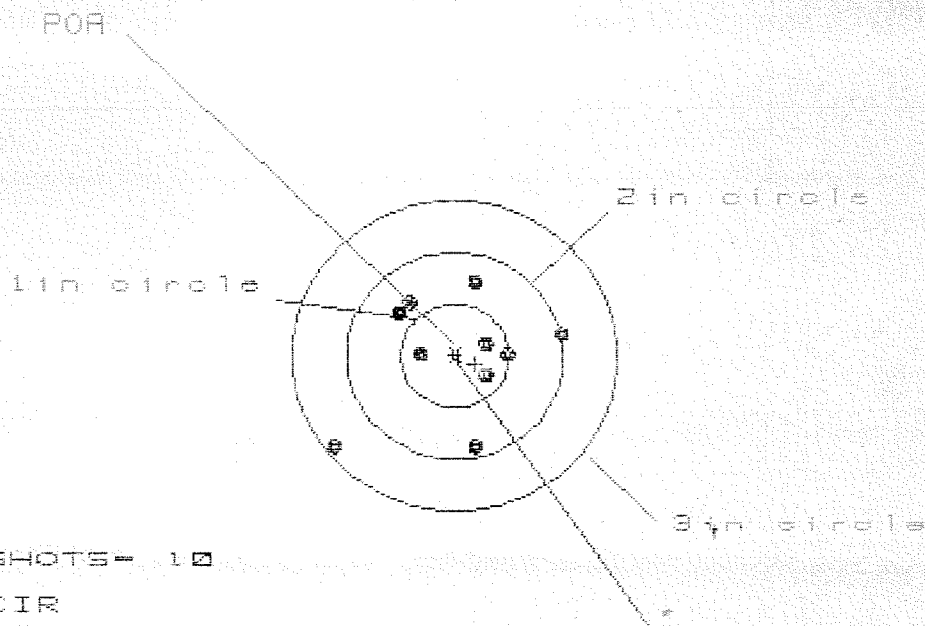
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.738	1.698	.776
MINIMUM X	:	-.784	-.824	-.611
MAXIMUM Y	:	1.327	1.133	1.110
MINIMUM Y	:	-1.743	-1.328	-1.351
CENTROID X	:	.039	.079	-.134
CENTROID Y	:	.035	.229	.252
POA TO CENTROID in.	:	.052	.242	.285
MIN RADIUS	:	.465	.564	.433
MEAN RADIUS	:	1.053	.962	.835
MAX RADIUS	:	1.779	1.708	1.392
HORIZONTAL SPREAD	:	2.522	2.522	1.387
VERTICAL SPREAD	:	3.070	2.461	2.461
EXTREME SPREAD	:	3.095	2.684	2.464
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8649144

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 2.027

VS= 1.614

GS= 2.305

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	.957	.838	.488
MINIMUM X	:	-1.070	-.655	-.550
MAXIMUM Y	:	.704	.603	.614
MINIMUM Y	:	-.910	-.946	-.935
CENTROID X	:	-.185	-.066	-.171
CENTROID Y	:	.080	.181	.170
POA TO CENTROID in.	:	.202	.193	.241
MIN RADIUS	:	.264	.132	.236
MEAN RADIUS	:	.672	.566	.535
MAX RADIUS	:	1.405	.948	.950
HORIZONTAL SPREAD	:	2.027	1.493	1.038
VERTICAL SPREAD	:	1.614	1.549	1.549
EXTREME SPREAD	:	2.305	1.549	1.549
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 7

2 in = 8

3 in = 10

HS= 1.7844

VS= 2.399

GS= 2.480

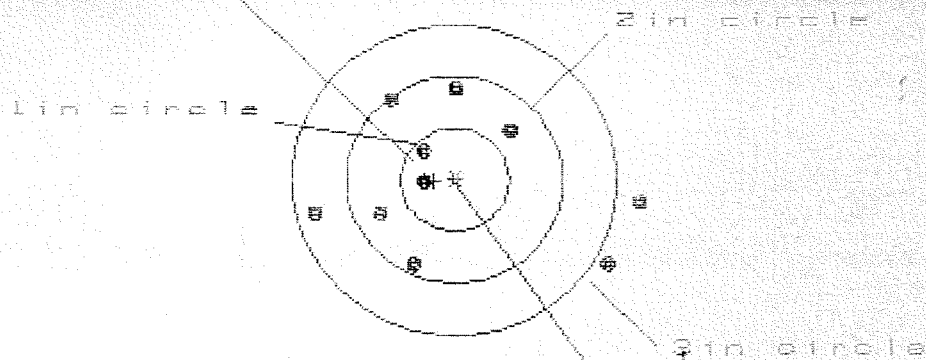
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.417	.437	.287
MINIMUM X	-1.227	-1.207	-.326
MAXIMUM Y	.941	.779	.832
MINIMUM Y	-1.458	-.638	-.585
CENTROID X	-.074	-.094	.057
CENTROID Y	-.167	-.005	-.058
POA TO CENTROID in.	.183	.094	.081
MIN RADIUS	.200	.211	.267
MEAN RADIUS	.658	.566	.437
MAX RADIUS	1.469	1.277	.868
HORIZONTAL SPREAD	1.644	1.644	.612
VERTICAL SPREAD	2.399	1.417	1.417
EXTREME SPREAD	2.480	1.766	1.417
NUMBER IN ONE INCH CIRCLE =	7		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.083

VS= 1.678

GS= 3.084

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.752	1.604	.944
MINIMUM X	:	-1.331	-1.136	-.935
MAXIMUM Y	:	.865	.837	.732
MINIMUM Y	:	-.813	-.841	-.937
CENTROID X	:	.190	-.005	-.285
CENTROID Y	:	.015	.043	.148
POA TO CENTROID in.	:	.190	.043	.253
MIN RADIUS	:	.282	.089	.168
MEAN RADIUS	:	.981	.835	.683
MAX RADIUS	:	1.770	1.811	1.033
HORIZONTAL SPREAD	:	3.083	2.740	1.879
VERTICAL SPREAD	:	1.678	1.678	1.669
EXTREME SPREAD	:	3.084	2.787	2.050
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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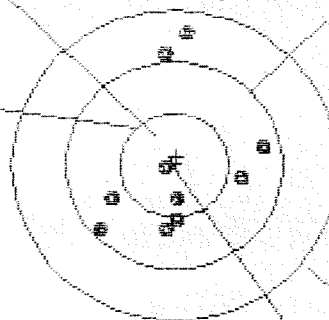
CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.441

VS= 1.903

GS= 2.011

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.779	.797	.784
MINIMUM X	-.662	-.644	-.657
MAXIMUM Y	1.251	1.228	.469
MINIMUM Y	-.652	-.513	-.359
CENTROID X	-.018	-.036	-.023
CENTROID Y	-.002	-.221	-.375
POR TO CENTROID in.	.084	.224	.375
MIN RADIUS	.114	.118	.060
MEAN RADIUS	.694	.590	.470
MAX RADIUS	1.262	1.232	.914
HORIZONTAL SPREAD	1.441	1.441	1.441
VERTICAL SPREAD	1.903	1.741	.828
EXTREME SPREAD	2.011	1.757	1.629
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		