

C6522221

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



2.04

2.16

2.16

2.11

2.05

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522221

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR.
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	KR
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel <i>RB</i>		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/22/90	<i>WB</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/6/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/6/90	WB
	C) Inspect Ejector Hole for Chamfer		9/6/90	WB
	D) Oil Firing Pin Ass'y		9/6/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	WB
	I) Firing Pin Indent	.020 .022	.020 .022	.0205 .022			9/6/90	WB
	J) Assemble Stock						9/7/90	KS
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						9/7/90	KS
	M) Iron Sight Alignment						9/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	KS
	O) Attach Scope to Rifle						9/7/90	KS
	P) Detach & Attach Scope 20 Times						9/7/90	KS
640	Gallery Target & Test						9-10-90	AC
	A) Time						9-10-90	AC
	B) Malfunctions						9-10-90	AC
	C) Pierced Primers						9-10-90	AC
	D) Optical Clarity of Scope						9-10-90	AC
645	Inspect for Live Ammo						9-10-90	AC
655	Final Inspection							
	A) Headspace						9/11/90	JS
	B) Trigger Pull	2.39	2.35	2.29	2.33	2.32	9/10/90	WB
	C) Function						9/11/90	JS
660	Pack						9-18-90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522221

DATE 9/6/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.51	2.56	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.30	2.62	2.35	
PULL #3	2.55	2.52	2.67	2.29	
PULL #4	2.38	2.52	2.64	2.33	
PULL #5	2.54	2.53	2.60	2.32	
TOTAL	12.50	12.38	13.09	11.68	
AVG.	2.50	2.47	2.62	2.33	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.21		
PULL #2	3.07	3.22		
PULL #3	3.13	3.07		
PULL #4	3.11	3.15		
PULL #5	3.14	3.13		
TOTAL	15.55	15.78		
AVG.	3.11	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.27		4.21
PULL #2	4.22	4.23		4.19
PULL #3	4.26	4.11		4.18
PULL #4	4.18	4.23		4.14
PULL #5	4.16	4.12		4.05
TOTAL	21.08	20.96		20.77
AVG.	4.21	4.19		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522221
10 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.521061
1 TO	2	.484517
1 TO	3	.66897
1 TO	4	.611788
1 TO	5	.746294

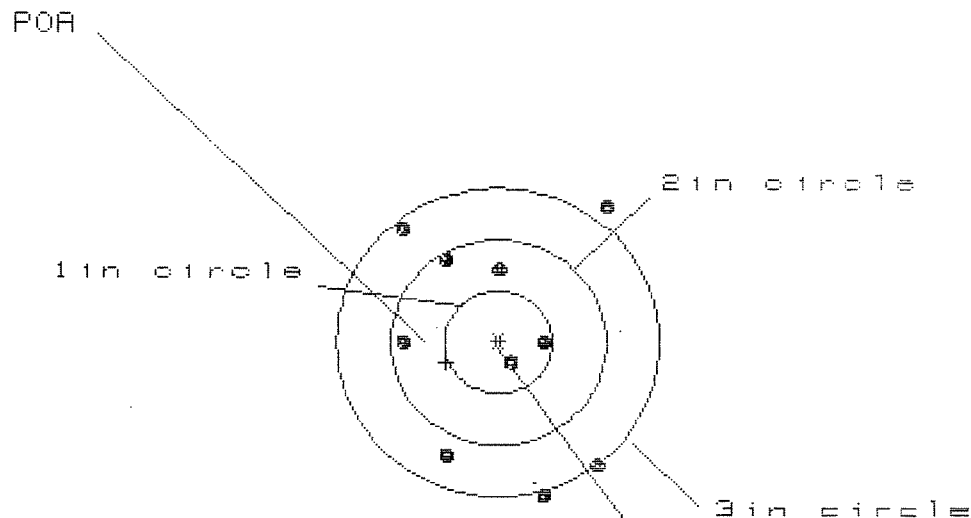
3 1
2 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0156
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117441
THE AMR FOR THIS RIFLE IS: 1.065

10 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522221

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.923

VS= 2.736

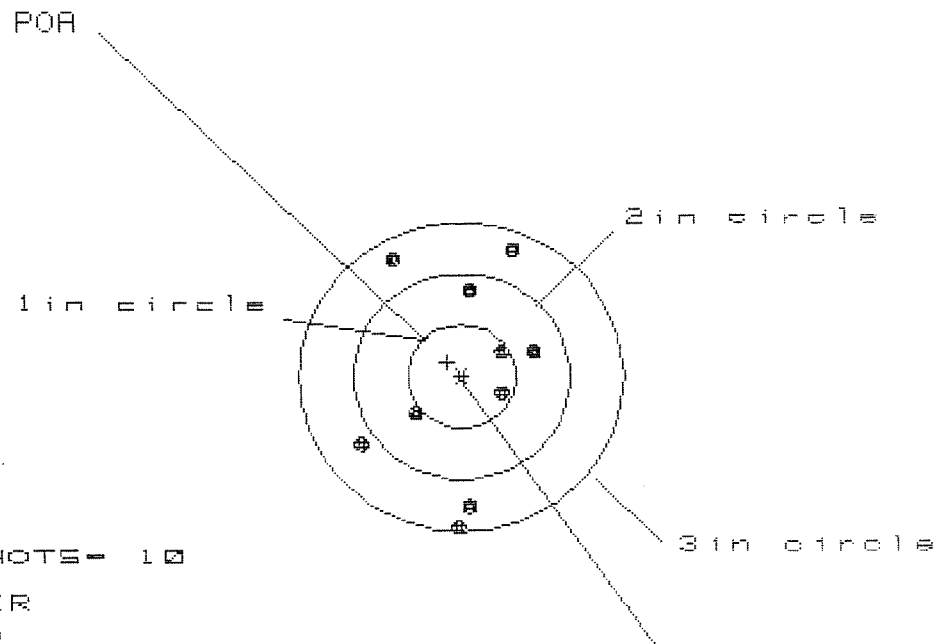
GS= 2.902

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.990	1.046	1.111
MINIMUM X	-.933	-.823	-.758
MAXIMUM Y	1.287	1.212	1.048
MINIMUM Y	-1.449	-1.306	-1.176
CENTROID X	.484	.374	.309
CENTROID Y	.193	.050	.214
POA TO CENTROID in.	.522	.378	.376
MIN RADIUS	.199	.185	.320
MEAN RADIUS	1.037	.970	.904
MAX RADIUS	1.623	1.463	1.617
HORIZONTAL SPREAD	1.923	1.869	1.869
VERTICAL SPREAD	2.736	2.518	2.224
EXTREME SPREAD	2.902	2.902	2.902
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522221

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.667

VS= 2.675

GS= 2.719

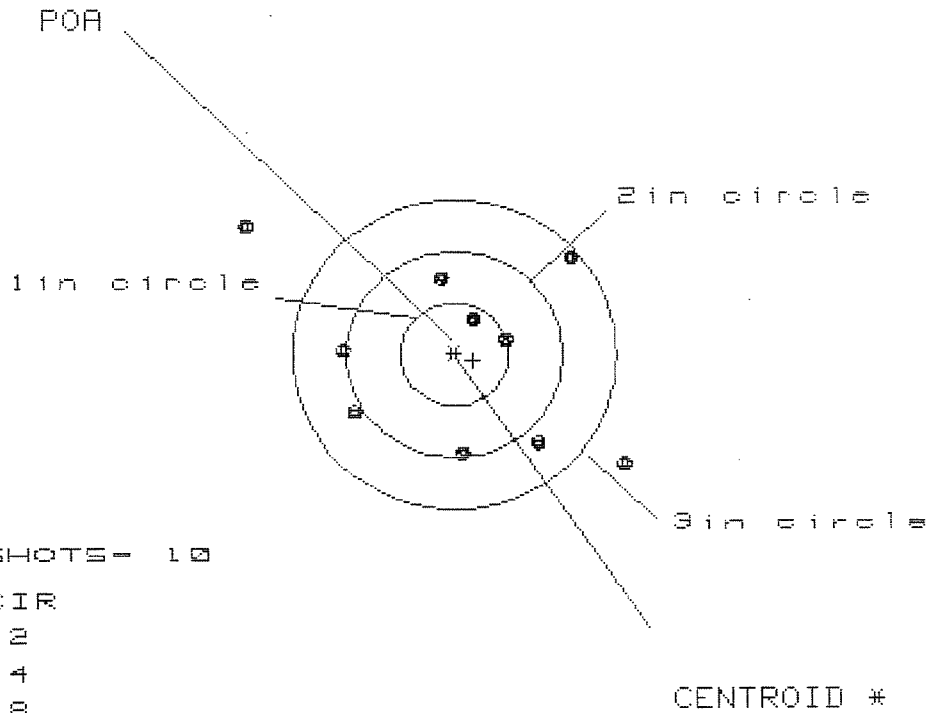
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.701	.695	.748
MINIMUM X	:	-.966	-.972	-.919
MAXIMUM Y	:	1.265	1.109	1.158
MINIMUM Y	:	-1.410	-1.376	-1.238
CENTROID X	:	.133	.139	.086
CENTROID Y	:	-.141	.015	-.123
POA TO CENTROID in.	:	.194	.140	.150
MIN RADIUS	:	.375	.337	.425
MEAN RADIUS	:	.937	.873	.833
MAX RADIUS	:	1.411	1.378	1.276
HORIZONTAL SPREAD	:	1.667	1.667	1.667
VERTICAL SPREAD	:	2.675	2.485	2.396
EXTREME SPREAD	:	2.719	2.510	2.485
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522221

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.541

VS= 2.372

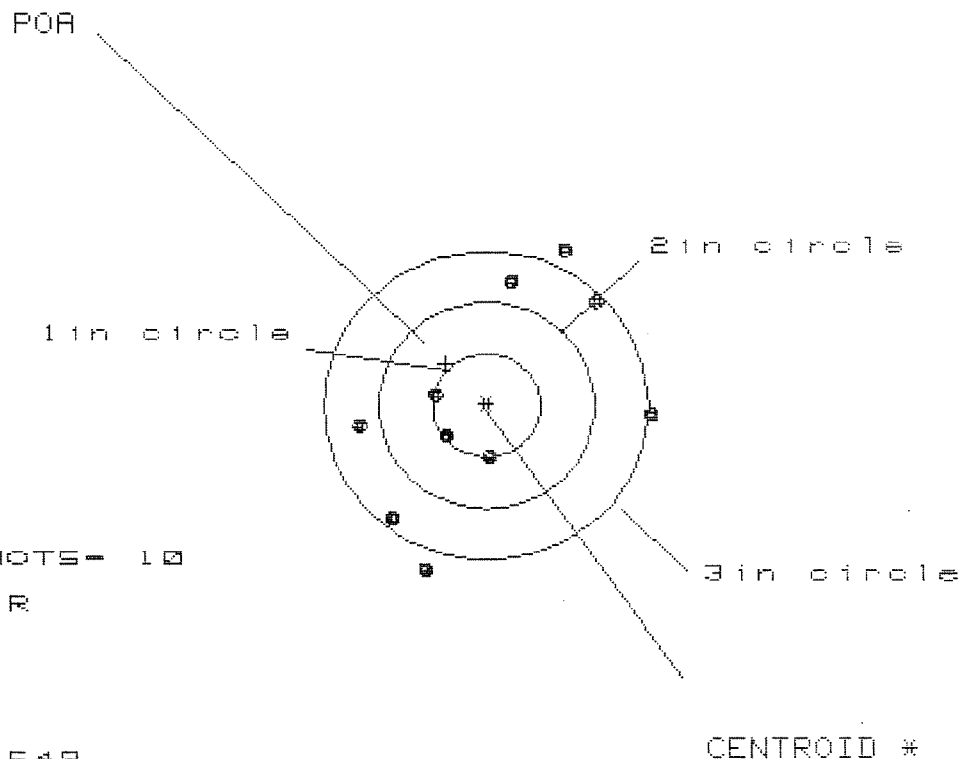
GS= 4.262

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.394	.994
MINIMUM X	:	-1.932	-1.225	-1.051
MAXIMUM Y	:	1.280	1.073	.954
MINIMUM Y	:	-1.092	-.950	-.926
CENTROID X	:	-.171	.044	-.130
CENTROID Y	:	.057	-.085	.034
POA TO CENTROID in.	:	.180	.095	.135
MIN RADIUS	:	.366	.340	.370
MEAN RADIUS	:	1.146	1.003	.898
MAX RADIUS	:	2.318	1.687	1.378
HORIZONTAL SPREAD	:	3.541	2.619	2.045
VERTICAL SPREAD	:	2.372	2.023	1.880
EXTREME SPREAD	:	4.262	2.847	2.469
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522221

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.649

VS= 3.150

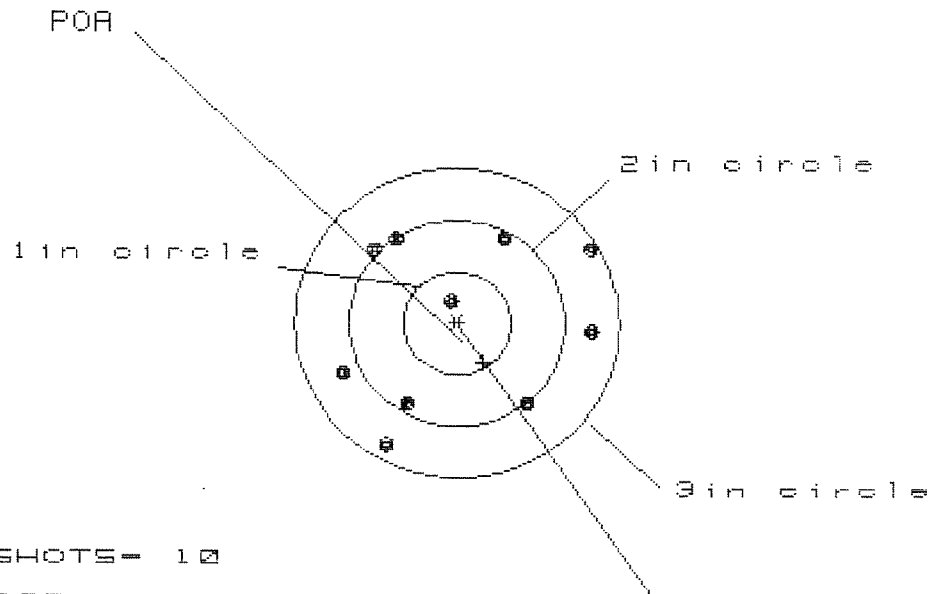
GS= 3.407

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.475
MINIMUM X	-1.174
MAXIMUM Y	1.554
MINIMUM Y	-1.596
CENTROID X	.375
CENTROID Y	-.409
POA TO CENTROID in.	.555
MIN RADIUS	.453
MEAN RADIUS	1.157
MAX RADIUS	1.708
HORIZONTAL SPREAD	2.649
VERTICAL SPREAD	3.150
EXTREME SPREAD	3.407
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	8

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522221

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.351

VS= 1.987

GS= 2.657

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.281	1.414	1.354
MINIMUM X	-1.070	-.937	-.997
MAXIMUM Y	.817	.902	.767
MINIMUM Y	-1.170	-1.085	-.869
CENTROID X	-.239	-.372	-.312
CENTROID Y	.378	.293	.428
POA TO CENTROID in.	.448	.474	.530
MIN RADIUS	.283	.354	.218
MEAN RADIUS	1.046	.996	.950
MAX RADIUS	1.425	1.415	1.364
HORIZONTAL SPREAD	2.351	2.351	2.351
VERTICAL SPREAD	1.987	1.987	1.636
EXTREME SPREAD	2.657	2.383	2.383
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522221
17 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.137644
1 TO	2	.518623
1 TO	3	.197517
1 TO	4	.217993
1 TO	5	.318198

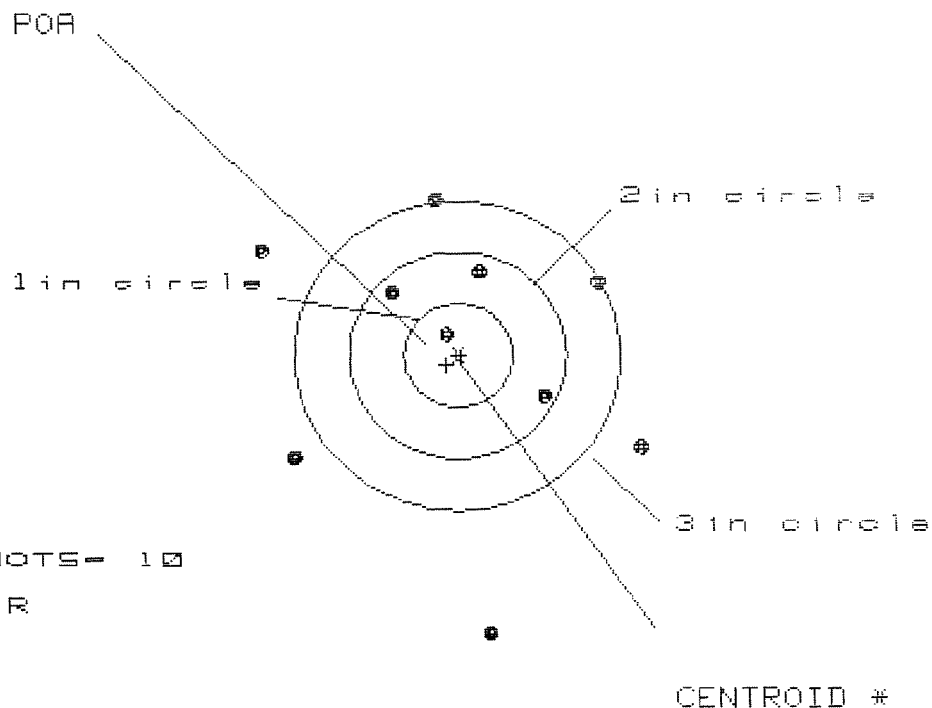
2 3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0818
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0907943
THE AMR FOR THIS RIFLE IS: 1.131

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522221.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 3.437

VS= 4.212

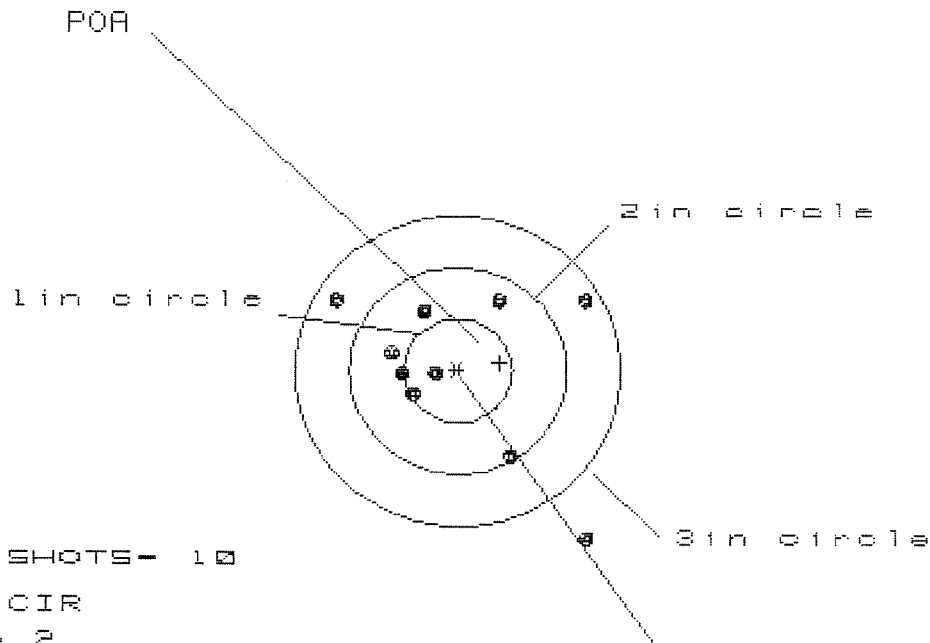
GS= 4.312

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.656	1.692	1.473
MINIMUM X	-1.781	-1.745	-1.663
MAXIMUM Y	1.508	1.287	1.302
MINIMUM Y	-2.704	-1.277	-1.182
CENTROID X	.105	.069	.288
CENTROID Y	.089	.390	.295
POA TO CENTROID in.	.138	.396	.412
MIN RADIUS	.262	.050	.246
MEAN RADIUS	1.418	1.193	1.119
MAX RADIUS	2.724	2.074	2.040
HORIZONTAL SPREAD	3.437	3.437	3.136
VERTICAL SPREAD	4.212	2.484	2.484
EXTREME SPREAD	4.312	3.956	3.239
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

17 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08522221.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.340

VS= 2.243

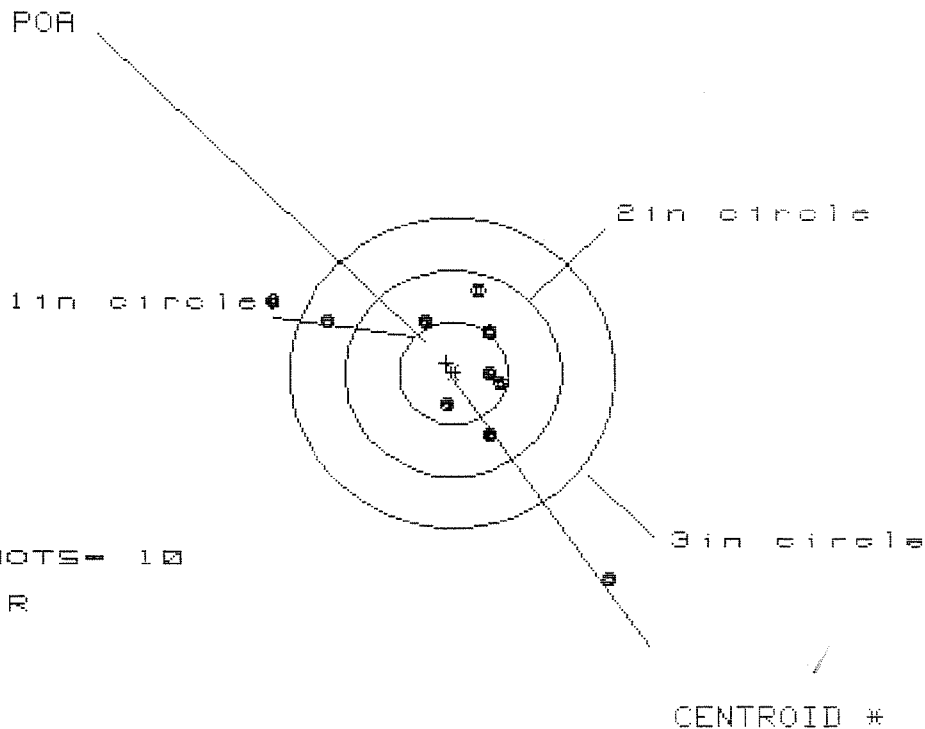
GS= 3.165

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.223	1.351	.758
MINIMUM X	:	-1.117	-.989	-.820
MAXIMUM Y	:	.670	.495	.555
MINIMUM Y	:	-1.573	-.963	-.983
CENTROID X	:	-.386	-.514	-.683
CENTROID Y	:	-.078	.097	.037
POA TO CENTROID in.	:	.394	.523	.684
MIN RADIUS	:	.220	.245	.189
MEAN RADIUS	:	.076	.712	.570
MAX RADIUS	:	1.950	1.434	1.179
HORIZONTAL SPREAD	:	2.340	2.340	1.578
VERTICAL SPREAD	:	2.243	1.458	1.458
EXTREME SPREAD	:	3.165	2.340	2.124
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522221.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.102

VS= 2.767

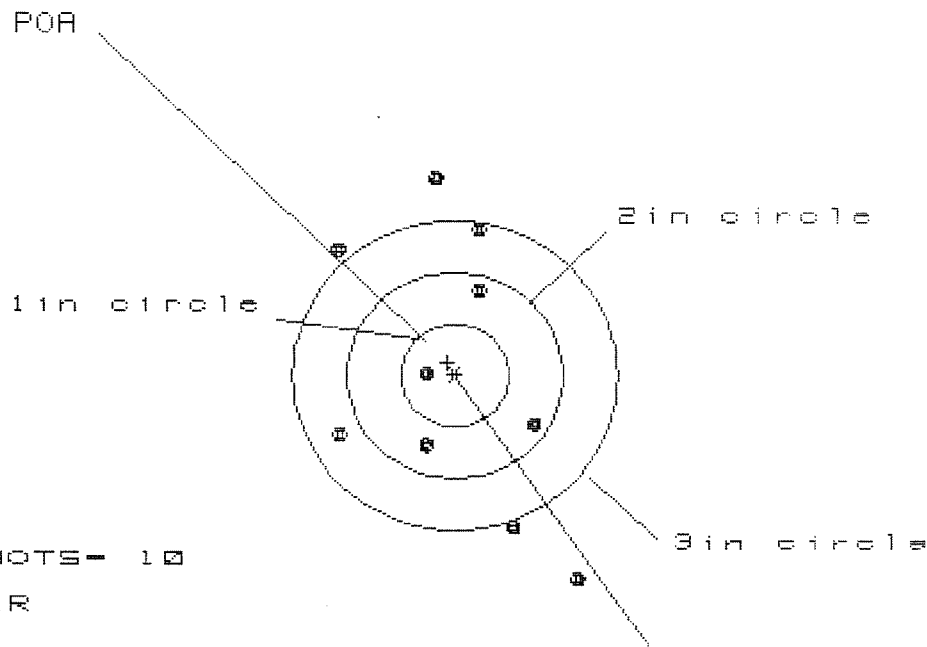
GS= 4.101

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.411
MINIMUM X	-1.691
MAXIMUM Y	.792
MINIMUM Y	-1.975
CENTROID X	.063
CENTROID Y	-.104
FOR TO CENTROID in.	.122
MIN RADIUS	.281
MEAN RADIUS	.907
MAX RADIUS	2.427
HORIZONTAL SPREAD	3.102
VERTICAL SPREAD	2.767
EXTREME SPREAD	4.101
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522221.1

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS = 2.220

VS = 3.906

GS = 4.133

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.149	.907	.897
MINIMUM X	-1.071	-.943	-.953
MAXIMUM Y	1.885	1.661	1.362
MINIMUM Y	-2.021	-1.729	-1.522
CENTROID X	.069	-.059	-.050
CENTROID Y	-.126	.098	-.109
POA TO CENTROID in.	.144	.115	.120
MIN RADIUS	.290	.258	.171
MEAN RADIUS	1.292	1.158	1.072
MAX RADIUS	2.325	1.857	1.662
HORIZONTAL SPREAD	2.220	1.850	1.850
VERTICAL SPREAD	3.906	3.390	2.884
EXTREME SPREAD	4.133	3.472	3.144
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	6	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06582221.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 1.871

VS= 3.593

GS= 3.926

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.762	.839	.792
MINIMUM X	:	-1.109	-1.032	-1.079
MAXIMUM Y	:	2.368	1.989	1.402
MINIMUM Y	:	-1.225	-.962	-.713
CENTROID X	:	-.048	-.125	-.078
CENTROID Y	:	-.190	-.453	-.702
POA TO CENTROID in.	:	.196	.470	.706
MIN RADIUS	:	.147	.182	.236
MEAN RADIUS	:	1.164	.965	.790
MAX RADIUS	:	2.468	2.025	1.550
HORIZONTAL SPREAD	:	1.871	1.871	1.871
VERTICAL SPREAD	:	3.593	2.951	2.115
EXTREME SPREAD	:	3.926	3.192	2.658
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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

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

MODEL 700™ H24

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

SERIAL NO.
C6522221

ORDER NO.
5716

Ø1

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