

C6522122

MODEL 700<sup>TH</sup> M24

Model **SMS** <sup>TN</sup>

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522122

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 25     | 90       | RW   |
| 600          | Proof                                                          | 9 25     | 90       | RW   |
| 607          | Check Headspace                                                | 9 25     | 90       | RW   |
| 610          | Dis-assemble Gun                                               | 9 25     | 90       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 9-26-90  | KR   |
|              | Magnaflux Bolt                                                 |          | 9-26-90  | KR   |
| 615          | Rollmark Caliber                                               |          | 9-26-90  | JS   |
| 617          | Drill and Tap Sight Holes                                      |          | 9/27/90  | FB   |
| 618          | Polish Barrel AB                                               |          | 10/1/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-5-90  | TH   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/8/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/8/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/8/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/8/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/12/90 | JS   |

| op. #        | BARBER - M24 0004111<br>OP. NAME                            | READINGS |       |       | DATE     | INIT       |
|--------------|-------------------------------------------------------------|----------|-------|-------|----------|------------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/2    | 4 1/2 | 4 1/2 | 10/15/90 | WLB        |
|              | G) Safety Off Force                                         | 2 1/4    | 2 1/4 | 2 1/2 | 10/15/90 | WLB        |
|              | H) Trigger Pull Test & Retainability                        |          |       |       | 10/12/90 | JLL        |
|              | I) Firing Pin Indent                                        | .0215    | .0205 | .021  | 10/15/90 | WLB        |
|              | J) Assemble Stock                                           |          |       |       | 10/17/90 | RW         |
|              | K) Assemble Swivel Studs                                    |          |       |       | 2 NOV 90 | YDS        |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 10/17/90 | RW         |
|              | M) Iron Sight Alignment                                     |          |       |       | 10/17/90 | RW         |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 10/17/90 | RW         |
|              | O) Attach Scope to Rifle                                    |          |       |       | 10/18/90 | RW         |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       | 10/18/90 | RW         |
| 640          | Gallery Target & Test                                       |          |       |       | 10/24/90 | NF         |
|              | A) Time                                                     |          |       |       | "        | NF         |
|              | B) Malfunctions                                             |          |       |       | "        | NF         |
|              | C) Pierced Primers                                          |          |       |       | "        | NF         |
|              | D) Optical Clarity of Scope                                 |          |       |       | "        | NF         |
| 645          | Inspect for Live Ammo                                       |          |       |       | 10/24/90 | NF         |
| 655          | Final Inspection                                            |          |       |       | 2 NOV 90 | YDS        |
|              | A) Headspace                                                |          |       |       |          |            |
|              | B) Trigger Pull                                             | 208      | 209   | 209   | 23/22    | 208/90 YDS |
|              | C) Function                                                 |          |       |       | 208/90   | YDS        |
| 660          | Pack                                                        |          |       |       | 12/18/90 | NF         |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C16522122

DATE 10-12-90

TESTER JJ

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.28             | 2.14                     | 2.35                           | 208 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.38             | 2.26                     | 2.40                           | 229 |                                                                        |
| PULL #3 | 2.33             | 2.39                     | 2.20                           | 229 |                                                                        |
| PULL #4 | 2.37             | 2.31                     | 2.30                           | 231 |                                                                        |
| PULL #5 | 2.13             | 2.29                     | 2.38                           | 221 |                                                                        |
| TOTAL   | 11.49            | 10.39                    | 11.63                          |     |                                                                        |
| AVG.    | 2.298            | 2.278                    | 2.326                          |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.37             | 3.48                     |  |          |
| PULL #2 | 3.50             | 3.49                     |  |          |
| PULL #3 | 3.35             | 3.40                     |  |          |
| PULL #4 | 3.44             | 3.32                     |  |          |
| PULL #5 | 3.51             | 3.19                     |  |          |
| TOTAL   | 17.17            | 16.88                    |  |          |
| AVG.    | 3.434            | 3.376                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.20             | 4.34                     |                                | 4.21                                 |
| PULL #2 | 4.41             | 4.30                     |                                | 4.28                                 |
| PULL #3 | 4.25             | 4.32                     |                                | 4.17                                 |
| PULL #4 | 4.28             | 4.29                     |                                | 4.15                                 |
| PULL #5 | 4.39             | 4.24                     |                                | 4.21                                 |
| TOTAL   | 21.53            | 21.49                    |                                | 21.02                                |
| AVG.    | 4.306            | 4.298                    |                                | 4.204                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6522122  
25 Oct 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .228537 |
| 1 TO | 2 | .186775 |
| 1 TO | 3 | .404678 |
| 1 TO | 4 | .144838 |
| 1 TO | 5 | .50887  |

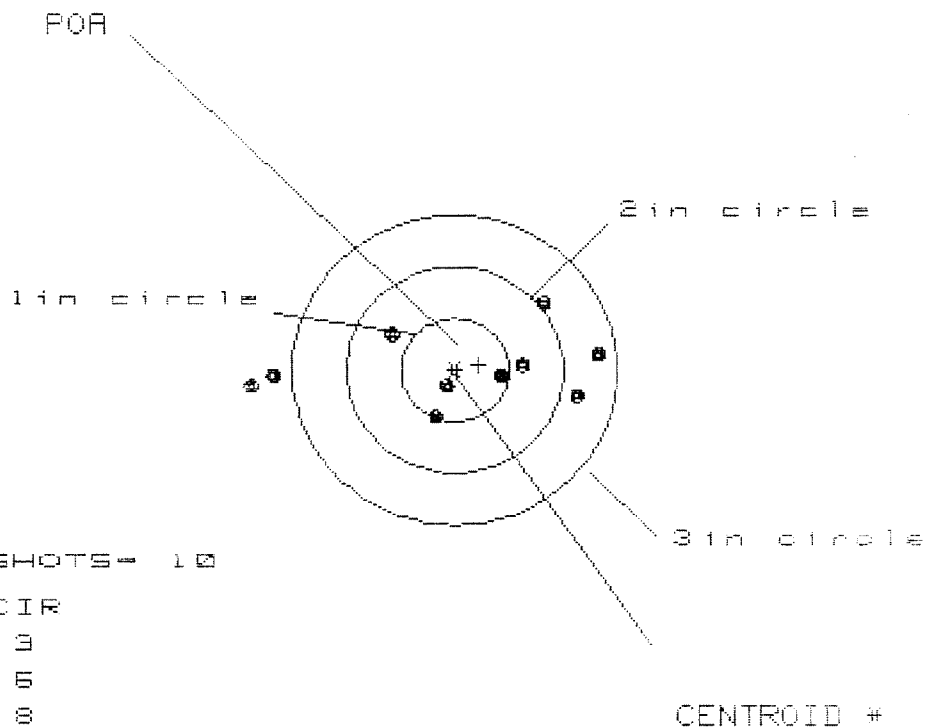
3  
#5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.042  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0002  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0420005  
THE AMR FOR THIS RIFLE IS: .9106

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522122

## CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.247

VS= 1.014

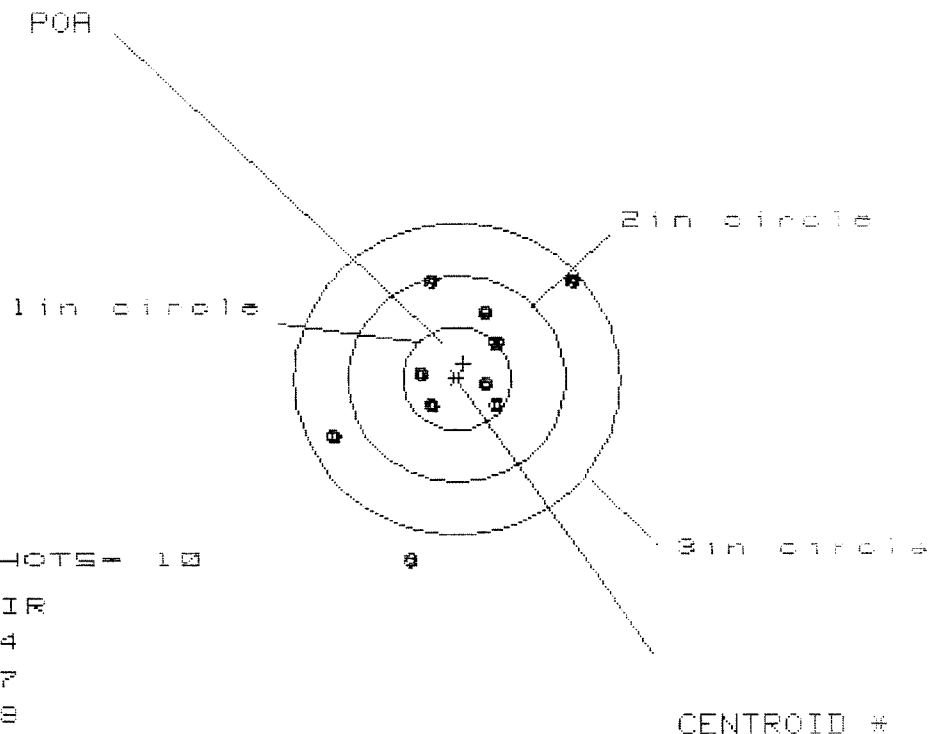
GS= 3.267

| PATTERN #                   | : | 1      | 2      | 3     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.366  | 1.158  | .927  |
| MINIMUM X                   | : | -1.881 | -1.841 | -.994 |
| MAXIMUM Y                   | : | .602   | .581   | .570  |
| MINIMUM Y                   | : | -.412  | -.433  | -.444 |
| CENTROID X                  | : | -.223  | -.014  | .217  |
| CENTROID Y                  | : | -.050  | -.029  | -.018 |
| POA TO CENTROID in.         | : | .228   | .032   | .217  |
| MIN RADIUS                  | : | .150   | .272   | .115  |
| MEAN RADIUS                 | : | .940   | .801   | .625  |
| MAX RADIUS                  | : | 1.891  | 1.844  | 1.059 |
| HORIZONTAL SPREAD           | : | 3.247  | 2.999  | 1.921 |
| VERTICAL SPREAD             | : | 1.014  | 1.014  | 1.014 |
| EXTREME SPREAD              | : | 3.267  | 3.008  | 1.935 |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |        |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.219

VS= 2.650

GS= 3.056

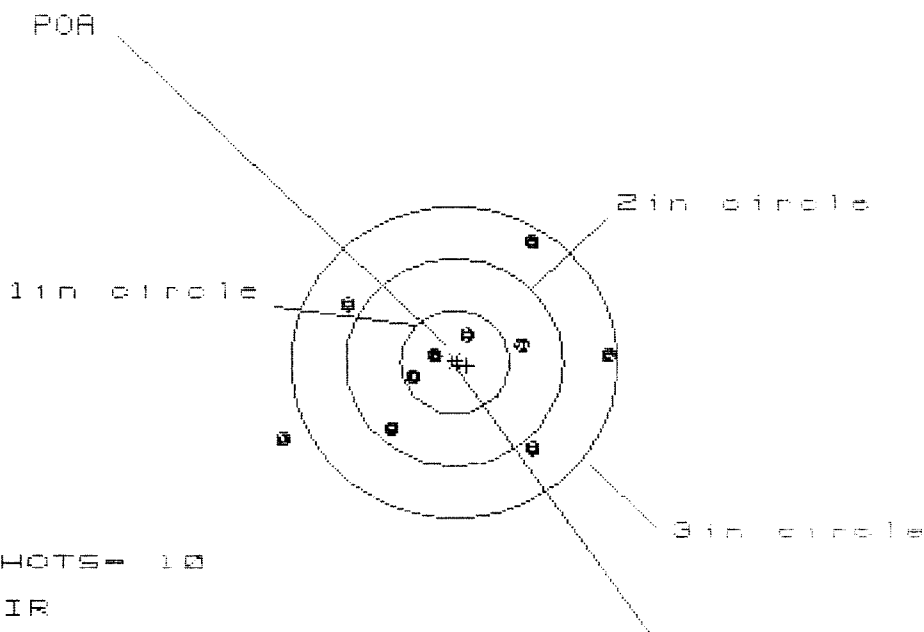
CENTROID #

| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.077  | 1.027  | .487   |
| MINIMUM X                   | : | -1.142 | -1.192 | -1.064 |
| MAXIMUM Y                   | : | .928   | .737   | .829   |
| MINIMUM Y                   | : | -1.722 | -.744  | -.652  |
| CENTROID X                  | : | -.064  | -.014  | -.142  |
| CENTROID Y                  | : | -.148  | .043   | -.049  |
| POA TO CENTROID in.         | : | .161   | .045   | .150   |
| MIN RADIUS                  | : | .233   | .324   | .246   |
| MEAN RADIUS                 | : | .802   | .684   | .607   |
| MAX RADIUS                  | : | 1.780  | 1.405  | 1.248  |
| HORIZONTAL SPREAD           | : | 2.219  | 2.219  | 1.551  |
| VERTICAL SPREAD             | : | 2.650  | 1.481  | 1.481  |
| EXTREME SPREAD              | : | 3.056  | 2.667  | 1.848  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.988

VS= 1.942

GS= 3.102

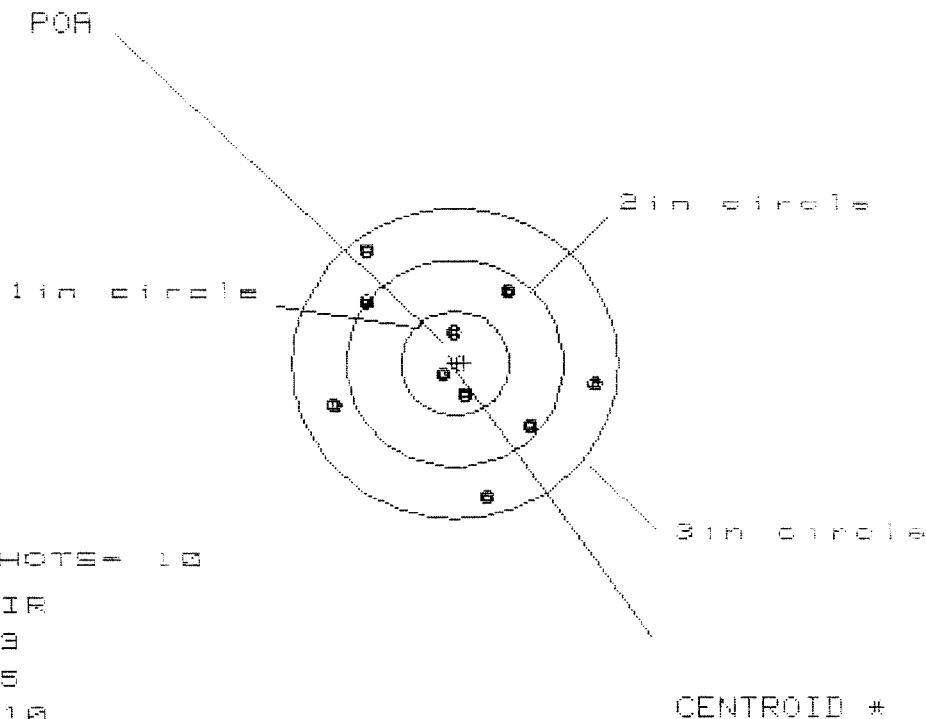
CENTROID #

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.446  | 1.275  | .733  |
| MINIMUM X                   | : | -1.542 | -1.115 | -.956 |
| MAXIMUM Y                   | : | 1.133  | 1.047  | 1.044 |
| MINIMUM Y                   | : | -.808  | -.895  | -.898 |
| CENTROID X                  | : | -.115  | .056   | -.103 |
| CENTROID Y                  | : | .034   | .121   | .124  |
| POA TO CENTROID in.         | : | .120   | .133   | .161  |
| MIN RADIUS                  | : | .211   | .202   | .210  |
| MEAN RADIUS                 | : | .901   | .807   | .725  |
| MAX RADIUS                  | : | 1.725  | 1.275  | 1.276 |
| HORIZONTAL SPREAD           | : | 2.988  | 2.390  | 1.689 |
| VERTICAL SPREAD             | : | 1.942  | 1.942  | 1.942 |
| EXTREME SPREAD              | : | 3.102  | 2.444  | 2.174 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 5

3 in = 10

HS = 2.344

VS = 2.374

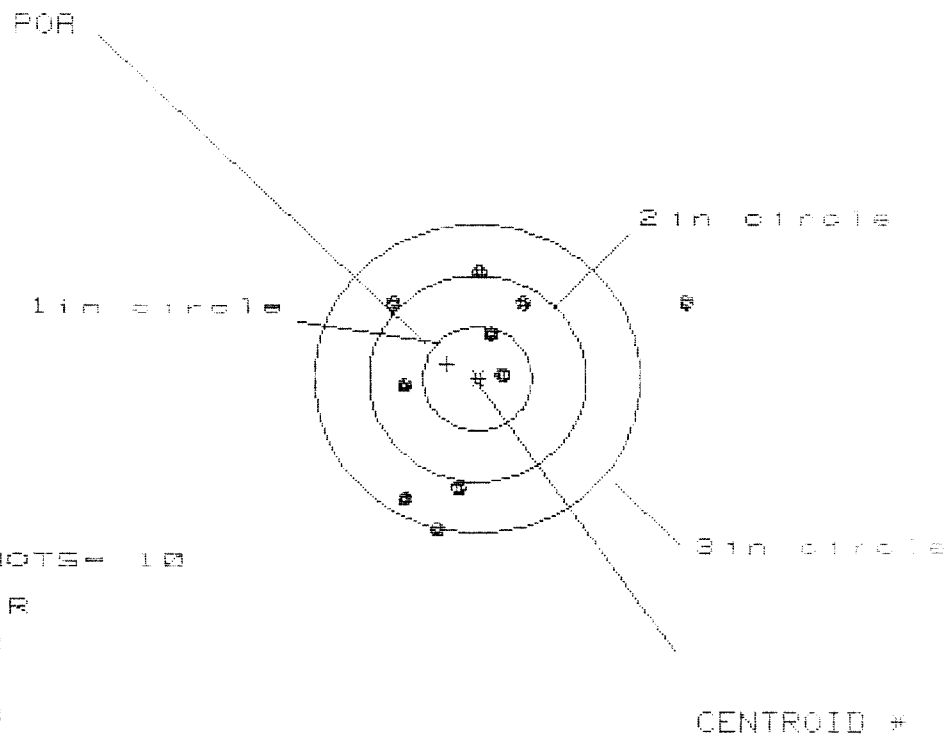
GS = 2.613

| PATTERN #                     | 4      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.278  |
| MINIMUM X                     | -1.066 |
| MAXIMUM Y                     | 1.108  |
| MINIMUM Y                     | -1.266 |
| CENTROID X                    | -.086  |
| CENTROID Y                    | -.003  |
| POA TO CENTROID in.           | .086   |
| MIN RADIUS                    | .164   |
| MEAN RADIUS                   | .866   |
| MAX RADIUS                    | 1.359  |
| HORIZONTAL SPREAD             | 2.344  |
| VERTICAL SPREAD               | 2.374  |
| EXTREME SPREAD                | 2.613  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |
| NUMBER IN TWO INCH CIRCLE =   | 5      |
| NUMBER IN THREE INCH CIRCLE = | 10     |

25 Oct 1988

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## CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 4

3 in = 8

IS = 2.701

VS = 2.563

GS = 3.269

| PATTERN #                     | 5      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.921  |
| MINIMUM X                     | -1.780 |
| MAXIMUM Y                     | 1.071  |
| MINIMUM Y                     | -1.492 |
| CENTROID X                    | .278   |
| CENTROID Y                    | -.138  |
| POA TO CENTROID in.           | .310   |
| MIN RADIUS                    | .186   |
| MEAN RADIUS                   | 1.044  |
| MAX RADIUS                    | 2.074  |
| HORIZONTAL SPREAD             | 2.701  |
| VERTICAL SPREAD               | 2.563  |
| EXTREME SPREAD                | 3.269  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |
| NUMBER IN TWO INCH CIRCLE =   | 4      |
| NUMBER IN THREE INCH CIRCLE = | 8      |



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

**Remington®**

**MODEL 700™ H24**

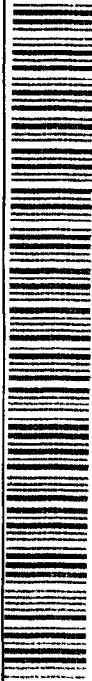
**SERIAL NO.**  
C6522122

**ORDER NO.**  
**5716**

**Ø1**

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

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



5716 C6522122

