

C6522283

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522283

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-31-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/90	WB
	G) Safety Off Force	3	3	3			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	.0235	.024	.024			9/10/90	WB
	J) Assemble Stock						9/10/90	KS
	K) Assemble Swivel Studs						9/15/90	JSB
	L) Attach Front and Rear Sight Assemblies						9/10/90	KS
	M) Iron Sight Alignment						9/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KS
	O) Attach Scope to Rifle						9/10/90	KS
	P) Detach & Attach Scope 20 Times						9/10/90	KS
640	Gallery Target & Test						9-12-90	DH
	A) Time						9-12-90	DH
	B) Malfunctions						9-12-90	DH
	C) Pierced Primers						9-12-90	DH
	D) Optical Clarity of Scope						9-12-90	DH
645	Inspect for Live Ammo						9-12-90	DH
655	Final Inspection							
	A) Headspace						9/15/90	JSB
	B) Trigger Pull	2.50	2.51	2.48	2.43	2.45	9-14-90	JSB
	C) Function						9/15/90	JSB
660	Pack						9/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522283

DATE 9/10/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.22	2.36	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.19	2.28	2.51	
PULL #3	2.25	2.17	2.37	2.48	
PULL #4	2.29	2.12	2.31	2.43	
PULL #5	2.25	2.14	2.27	2.45	
TOTAL	11.40	10.84	11.59	12.37	
AVG.	2.28	2.17	2.32	2.474	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.09		
PULL #2	3.11	3.00		
PULL #3	3.00	3.06		
PULL #4	3.01	3.03		
PULL #5	3.07	3.04		
TOTAL	15.29	15.22		
AVG.	3.06	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.19		4.01
PULL #2	4.33	4.16		3.98
PULL #3	4.12	4.12		4.05
PULL #4	4.00	4.17		4.02
PULL #5	3.90	4.07		4.06
TOTAL	20.64	20.71		20.12
AVG.	4.13	4.14		4.02

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522283
12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.27674
1 TO	2	.678012
1 TO	3	.39785
1 TO	4	.334718
1 TO	5	1.17516

1
1/2 5 (----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .8678
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2888
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .219532
FOI RADIUS FOR THIS RIFLE IS: .8888

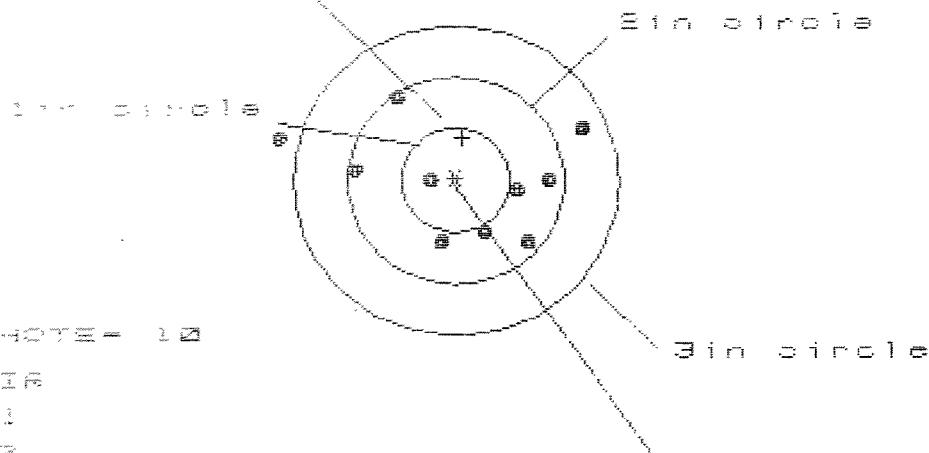
12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522263

CENTERFIRE PATTERNS

2

FOR



* OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

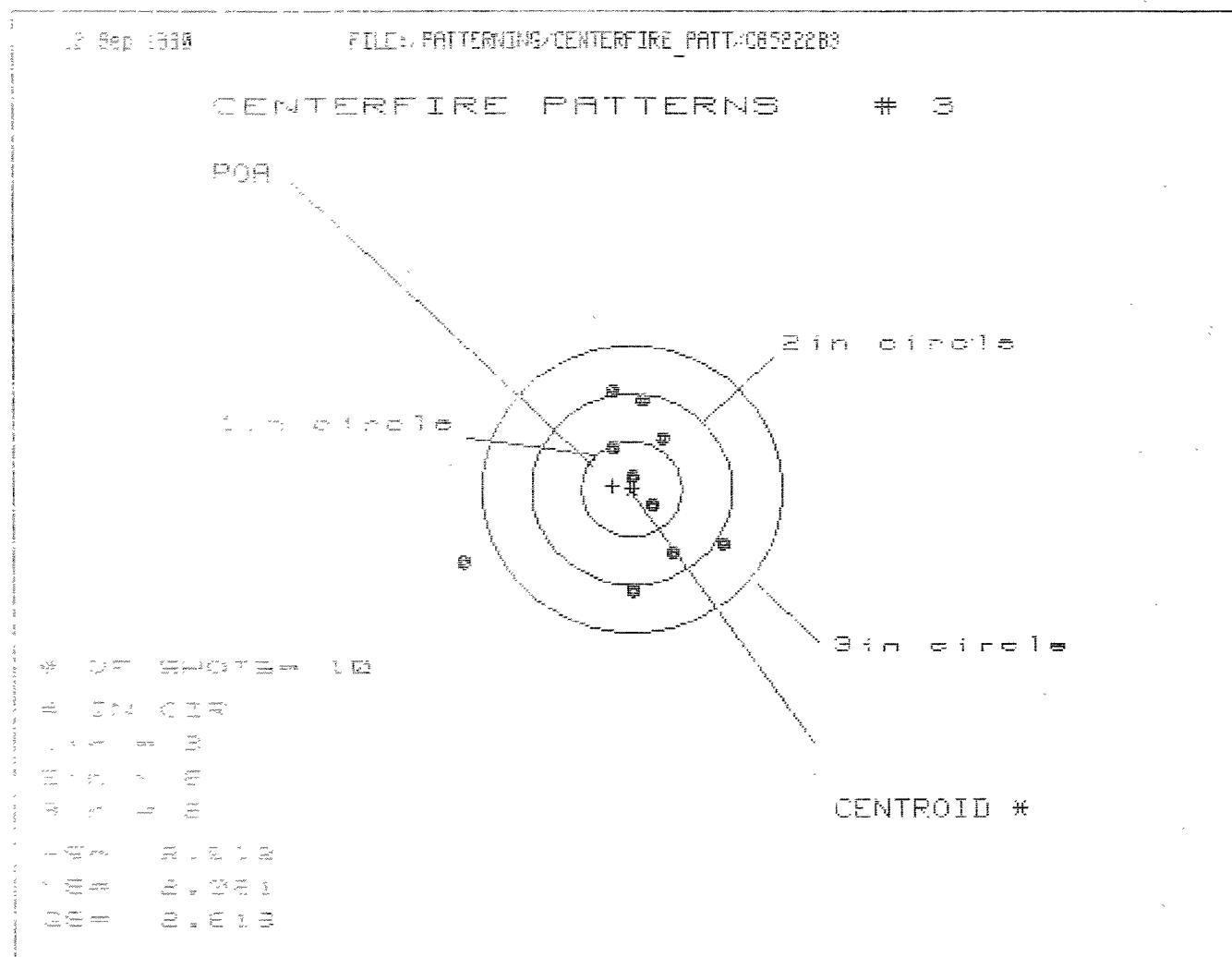
-CM = 0.725

-CY = 1.475

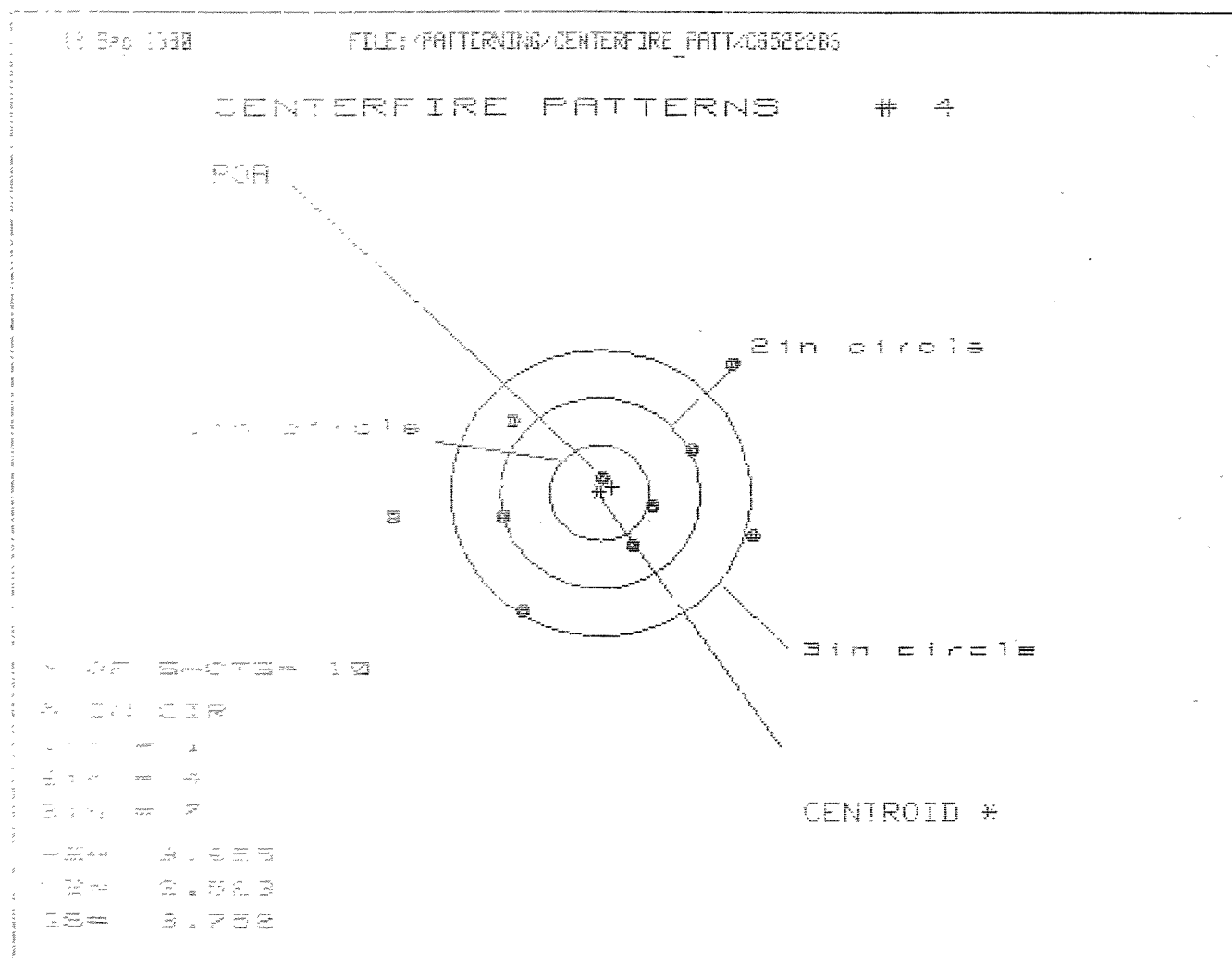
-CM = 2.789

CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.176	.997	.888
MINIMUM X	-1.611	-1.106	-.982
MAXIMUM Y	.858	.900	.966
MINIMUM Y	-.617	-.575	-.509
CENTROID X	-.065	.114	-.010
CENTROID Y	-.410	-.452	-.518
FOR TO CENTROID in.	.415	.466	.518
HIN RADIUS	.288	.350	.375
DEAN RADIUS	.866	.752	.696
OF RADIUS	1.656	1.162	1.142
HORIZONTAL SPREAD	2.787	2.103	1.790
VERTICAL SPREAD	1.475	1.475	1.475
CYCLE SPREAD	2.789	2.142	1.936
WITH IN ONE INCH CIRCLE	=	1	
WITH IN TWO INCH CIRCLE	=	7	
WITH IN THREE INCH CIRCLE	=	9	



PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.926	.738	.355
MINIMUM X	-1.686	-.399	-.307
MAXIMUM Y	1.037	.957	.875
MINIMUM Y	-1.024	-1.104	-1.186
CENTROID X	.190	.378	.286
CENTROID Y	-.034	.046	.128
FOR TO CENTROID IN.	.194	.381	.313
MIN RADIUS	.165	.210	.116
MAX RADIUS	.827	.688	.530
MIN RADIUS	1.835	1.122	1.191
HORIZONTAL SPREAD	2.612	1.137	.662
VERTICAL SPREAD	2.061	2.061	2.061
DIAGONAL SPREAD	2.618	2.071	2.071
SPOTS IN ONE INCH CIRCLE =	3	3	3
SPOTS IN TWO INCH CIRCLE =	6	6	6
SPOTS IN THREE INCH CIRCLE =	9	9	9

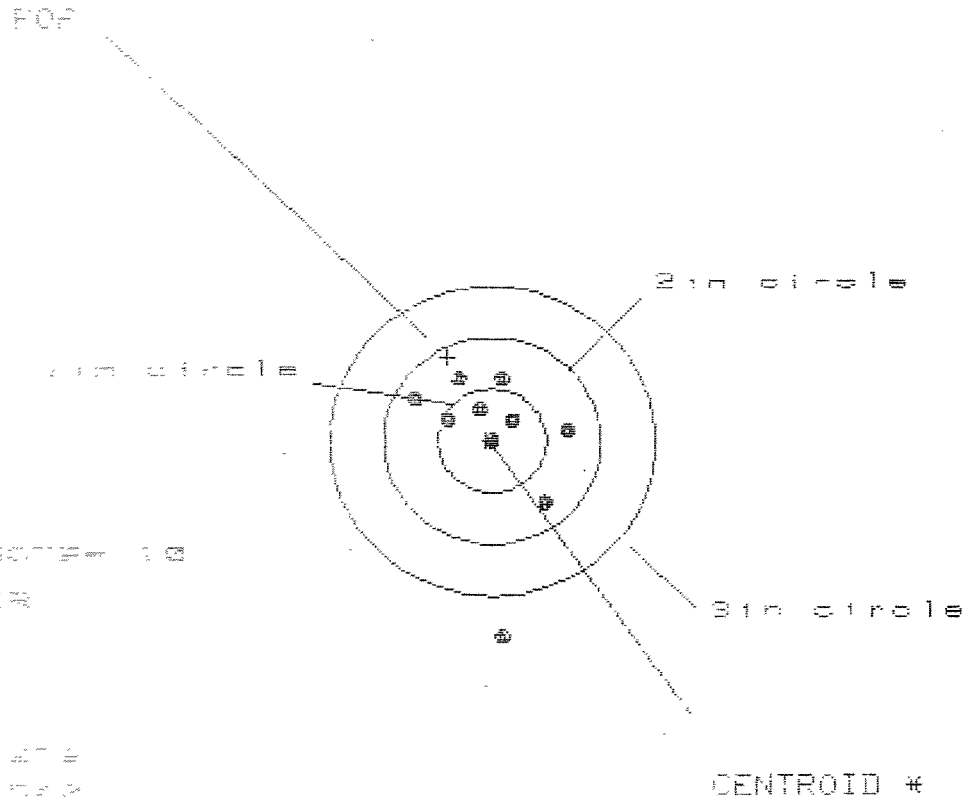


PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.550	1.316	1.448
MINIMUM X	-2.105	-1.208	-1.076
MAXIMUM Y	1.331	1.300	.879
MINIMUM Y	-1.198	-1.229	-1.066
CENTROID X	-1.125	.109	-.023
CENTROID Y	-.062	-.031	-.194
POP TO CENTROID in.	.139	.113	.195
MR. RADIUS	.183	.234	.312
MR. RADIUS	1.146	1.007	.922
MR. RADIUS	2.123	1.673	1.475
HORIZONTAL SPREAD	3.655	2.524	2.524
VERTICAL SPREAD	2.529	2.529	1.945
CIRCULAR SPREAD	3.752	3.234	2.654
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

13 Jul 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C65222B3

CENTERFIRE PATTERNS # 5



N OF SHOTS = 10

N OF CIRCLES

1 in circle

2 in circle

3 in circle

1 in circle

2 in circle

3 in circle

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.644	.660	.570
MINIMUM X	-.732	-.716	-.469
MAXIMUM Y	.637	.415	.437
MINIMUM Y	-1.915	-.772	-.750
CENTROID X	.408	.392	.482
CENTROID Y	-.886	-.594	-.616
POP TO CENTROID in.	.902	.712	.792
MIN RADIUS	.062	.174	.137
MEAN RADIUS	.654	.474	.443
MR. RADIUS	1.920	.921	.855
HORIZONTAL SPREAD	1.376	1.376	1.039
VERTICAL SPREAD	2.942	1.187	1.187
EXTREME SPREAD	2.575	1.545	1.469
NUMBER IN ONE INCH CIRCLE		4	
NUMBER IN TWO INCH CIRCLE		9	
NUMBER IN THREE INCH CIRCLE		9	

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

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

DU PONT

SERIAL NO. C6522283

ORDER NO. 5716

Ø1

5716 C6522283

UPC 0 47700 25716 7