

C6522341

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]


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

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

MODEL 700TM H24	SERIAL NO. C6522341
	ORDER NO. 5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee. 01


5716 C6522341

UPC


0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522341
16 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.405183
1 TO	2	.129958
1 TO	3	.641346
1 TO	4	.312872
1 TO	5	.307319

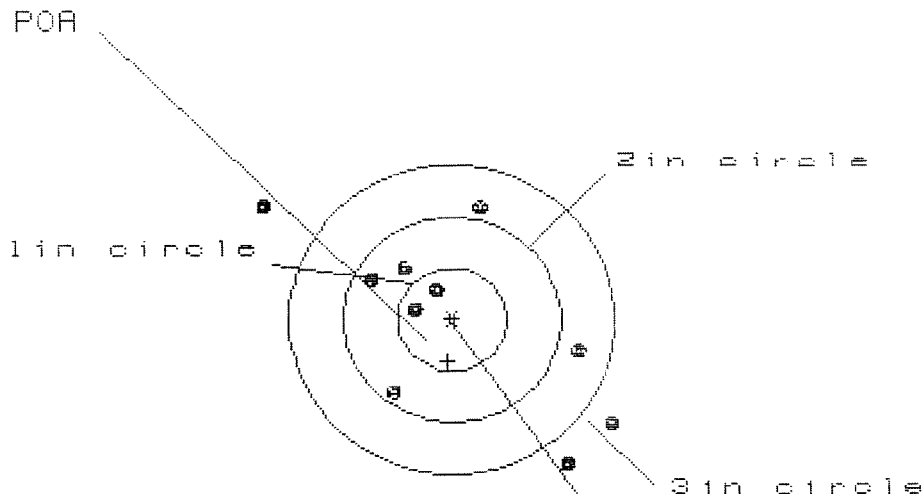
W
M
C----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1364
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136465
THE AMR FOR THIS RIFLE IS: 1.109

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522341

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.237

VS= 2.544

GS= 3.840

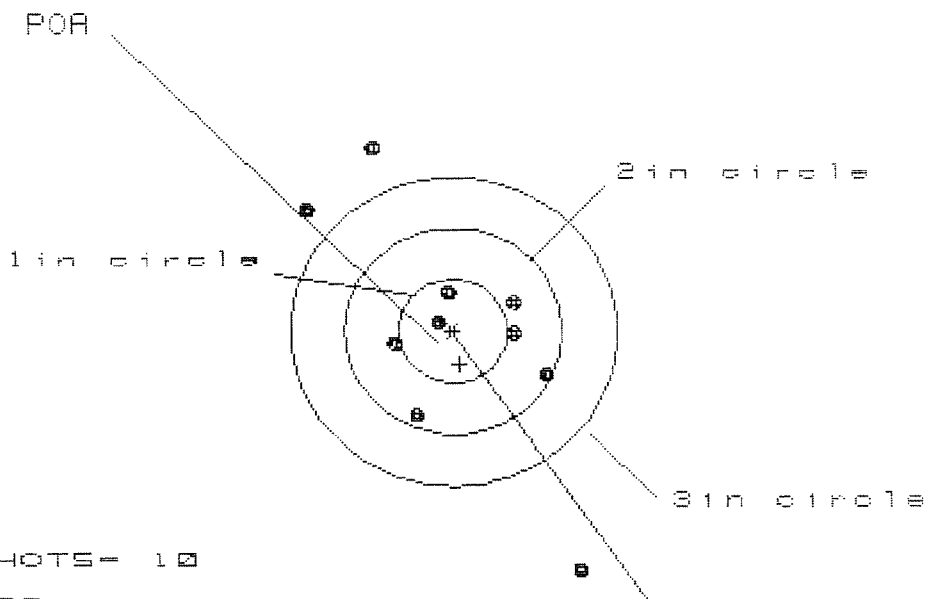
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.488	1.293	1.109
MINIMUM X	-1.749	-.923	-.761
MAXIMUM Y	1.142	1.261	1.152
MINIMUM Y	-1.402	-1.283	-1.392
CENTROID X	.042	.237	.075
CENTROID Y	.403	.284	.393
POA TO CENTROID in.	.406	.370	.400
MIN RADIUS	.294	.495	.316
MEAN RADIUS	1.097	1.031	.900
MAX RADIUS	2.052	1.560	1.730
HORIZONTAL SPREAD	3.237	2.216	1.870
VERTICAL SPREAD	2.544	2.544	2.544
EXTREME SPREAD	3.840	2.677	2.677
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522341

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

HS= 2.536

VS= 4.099

GS= 4.525

CENTROID #

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.204
MINIMUM X	:	-1.332
MAXIMUM Y	:	1.777
MINIMUM Y	:	-2.322
CENTROID X	:	-.058
CENTROID Y	:	.320
POA TO CENTROID in.	:	.325
MIN RADIUS	:	.194
MEAN RADIUS	:	1.038
MAX RADIUS	:	2.615
HORIZONTAL SPREAD	:	2.536
VERTICAL SPREAD	:	4.099
EXTREME SPREAD	:	4.525
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	7
NUMBER IN THREE INCH CIRCLE =	:	7

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522341

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 5

HS = 2.039

VS = 3.703

GS = 3.841

CENTROID *

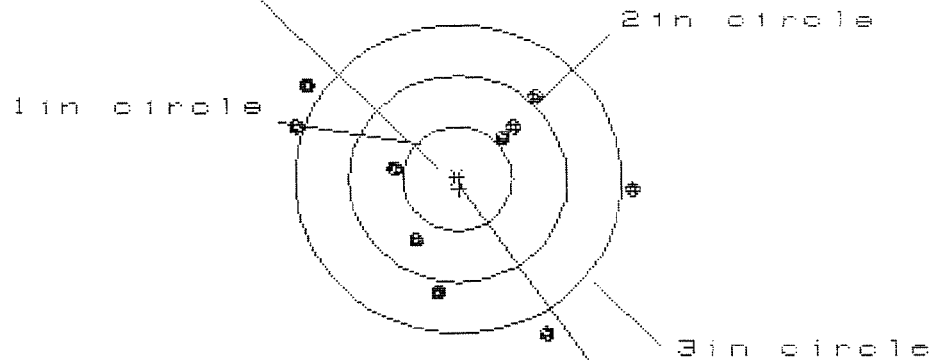
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.166	1.203	1.269
MINIMUM X	:	-.873	-.836	-.770
MAXIMUM Y	:	2.277	2.376	1.968
MINIMUM Y	:	-1.426	-1.173	-.876
CENTROID X	:	-.048	-.085	-.151
CENTROID Y	:	-.232	-.485	-.782
POA TO CENTROID in.	:	.237	.492	.796
MIN RADIUS	:	.582	.327	.023
MEAN RADIUS	:	1.430	1.253	.982
MAX RADIUS	:	2.300	2.435	2.055
HORIZONTAL SPREAD	:	2.039	2.039	2.039
VERTICAL SPREAD	:	3.703	3.549	2.844
EXTREME SPREAD	:	3.841	3.743	3.068
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522341

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.135

VS= 2.440

GS= 3.253

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.614	1.699	1.538
MINIMUM X	:	-1.521	-1.436	-1.598
MAXIMUM Y	:	.909	.739	.754
MINIMUM Y	:	-1.531	-1.215	-1.122
CENTROID X	:	-.013	-.098	.064
CENTROID Y	:	.095	.265	.172
POA TO CENTROID in.	:	.095	.282	.184
MIN RADIUS	:	.607	.514	.502
MEAN RADIUS	:	1.131	1.053	.984
MAX RADIUS	:	1.714	1.721	1.643
HORIZONTAL SPREAD	:	3.135	3.135	3.135
VERTICAL SPREAD	:	2.440	1.954	1.876
EXTREME SPREAD	:	3.253	3.185	3.185
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			6	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522341

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.113

VS= 2.561

GS= 2.844

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.726	.572	.577
MINIMUM X	:	-1.387	-.490	-.485
MAXIMUM Y	:	1.090	1.176	1.003
MINIMUM Y	:	-1.471	-1.385	-1.217
CENTROID X	:	.056	.210	.205
CENTROID Y	:	.096	.010	.183
POA TO CENTROID in.	:	.111	.210	.274
MIN RADIUS	:	.191	.037	.151
MEAN RADIUS	:	.848	.742	.659
MAX RADIUS	:	1.588	1.385	1.347
HORIZONTAL SPREAD	:	2.113	1.062	1.062
VERTICAL SPREAD	:	2.561	2.561	2.220
EXTREME SPREAD	:	2.844	2.561	2.276
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522341

DATE 9/11/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.58	2.59	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.49	2.63	2.32	
PULL #3	2.42	2.47	2.55	2.31	
PULL #4	2.50	2.39	2.60	2.29	
PULL #5	2.37	2.51	2.52	2.19	
TOTAL	12.22	12.44	12.89	11.44	
AVG.	2.44	2.49	2.58	2.288	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.20		
PULL #2	3.18	3.30		
PULL #3	3.07	3.25		
PULL #4	3.18	3.21		
PULL #5	3.20	3.22		
TOTAL	15.83	16.18		
AVG.	3.16	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.06		4.00
PULL #2	4.26	4.16		3.80
PULL #3	4.19	4.35		3.83
PULL #4	4.07	4.37		3.80
PULL #5	4.23	4.27		3.76
TOTAL	20.90	21.21		19.19
AVG.	4.18	4.24		3.82

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522341

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DLB
600	Proof		8-21-90	DLB
607	Check Headspace		8-21-90	DLB
610	Dis-assemble Gun		8-21-90	DLB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS.
617	Drill and Tap Sight Holes		8/23/90	LB
618	Polish Barrel		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/23/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 ont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/4			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/4/90	WB
	I) Firing Pin Indent	.023	.0235	.023			9/4/90	WB
	J) Assemble Stock						9/15/90	RW
	K) Assemble Swivel Studs						9/17/90	WB
	L) Attach Front and Rear Sight Assemblies						9/15/90	RW
	M) Iron Sight Alignment						9/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	RW
	O) Attach Scope to Rifle						9/15/90	RW
	P) Detach & Attach Scope 20 Times						9/15/90	RW
640	Gallery Target & Test						9/16/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9/16/90	AF
655	Final Inspection							
	A) Headspace						9/17/90	WB
	B) Trigger Pull	2-33	2-32	2-31	2-29	2-19	9-17-90	WB
	C) Function						9/17/90	WB
660	Pack						9-19-90	DH