

C6523429

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

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

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

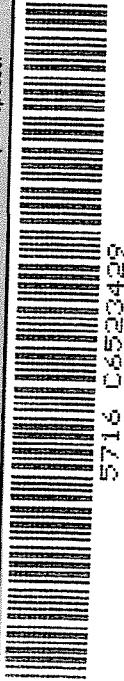
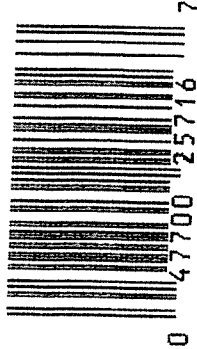
MODEL 700™ H24

SERIAL NO. C6523429

ORDER NO. 5716

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

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523429

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 Action		9/26/90	KR
	Magnaflux Bolt		9/26/90	KR
615	Rollmark Caliber		9/26/90	DL
617	Drill and Tap Sight Holes		9/28/90	WB
618	Polish Barrel <i>R.B.</i>		10/1/90	WB
620	Apply Coatings (Barrel Action)		10/5/90	TJA
	Apply Coating (Bolt)		10/5/90	TJA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/18/90	WB
	G) Safety Off Force	2	2	2			10/18/90	WB
	H) Trigger Pull Test & Retainability						10/18/90	JL
	I) Firing Pin Indent	.021	.021	.021			10/18/90	WB
	J) Assemble Stock						10/26/90	RW
	K) Assemble Swivel Studs						3/18/90	JL
	L) Attach Front and Rear Sight Assemblies						10/26/90	RW
	M) Iron Sight Alignment						10/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	RW
	O) Attach Scope to Rifle						10/26/90	RW
	P) Detach & Attach Scope 20 Times						10/26/90	RW
640	Gallery Target & Test						10-30-90	AC
	A) Time						10-30-90	AC
	B) Malfunctions						10-30-90	AC
	C) Pierced Primers						10-30-90	AC
	D) Optical Clarity of Scope						10-30-90	AC
645	Inspect for Live Ammo						10-30-90	AC
655	Final Inspection							
	A) Headspace						3/18/90	JL
	B) Trigger Pull	242	251	259	240	240	3/18/90	JL
	C) Function						3/18/90	JL
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523429

DATE 10-18-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.40	2.39	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.31	2.29	2.51	
PULL #3	2.39	2.29	2.34	2.57	
PULL #4	2.39	2.38	2.40	2.40	
PULL #5	2.39	2.18	2.34	2.40	
TOTAL	11.9	11.56	11.76		
AVG.	2.38	2.312	2.352		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.40		
PULL #2	3.48	3.29		
PULL #3	3.32	3.23		
PULL #4	3.44	3.19		
PULL #5	3.34	3.34		
TOTAL	16.97	16.45		
AVG.	3.394	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.20		4.25
PULL #2	4.39	4.19		4.41
PULL #3	4.21	4.40		4.24
PULL #4	4.37	4.25		4.27
PULL #5	4.39	4.25		4.35
TOTAL	21.77	21.29		21.52
AVG.	4.354	4.258		4.304

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523429
30 Oct 1990

CENTROIDAL DISTANCES

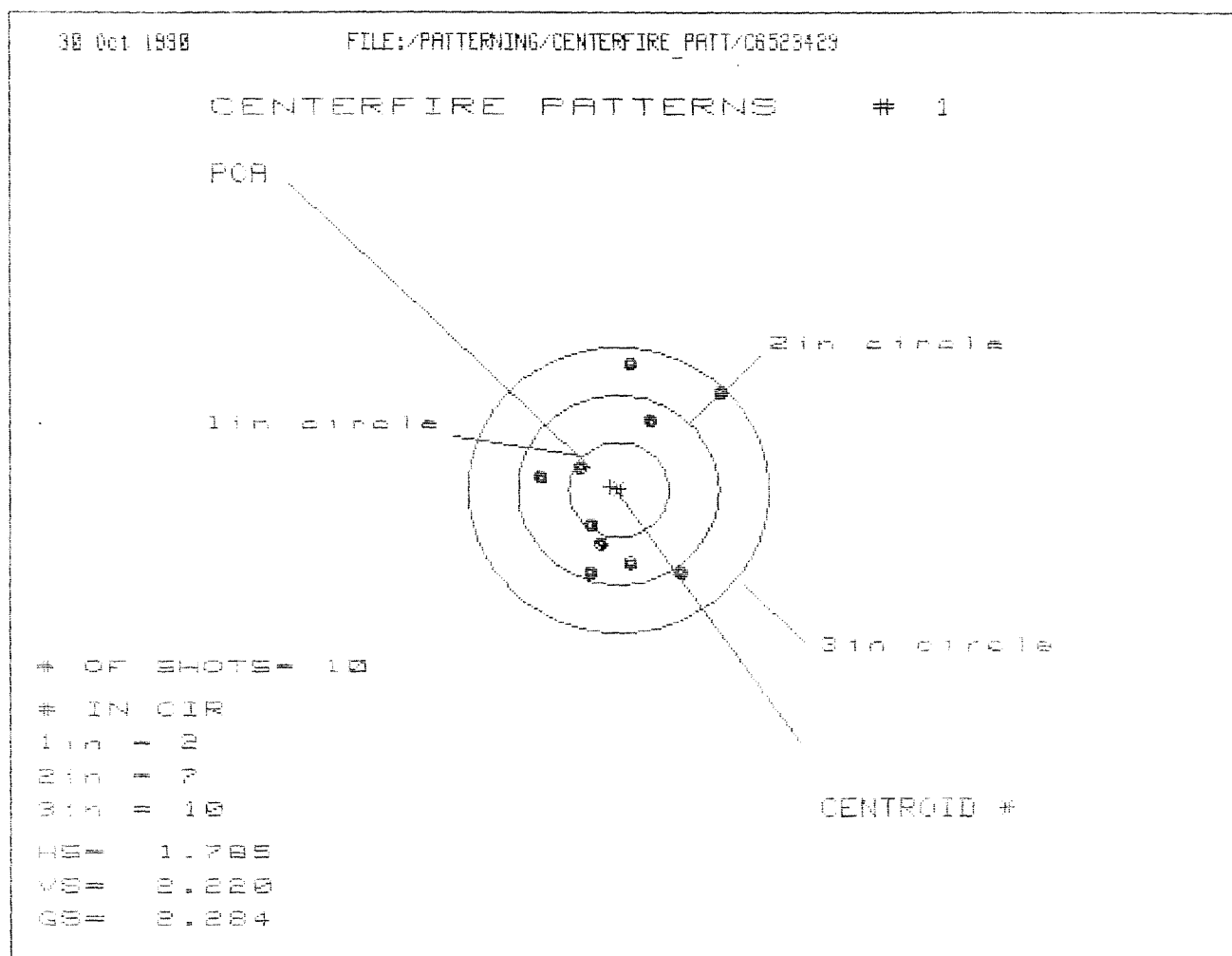
0 TO	1	.088955
1 TO	2	.101514
1 TO	3	.164368
1 TO	4	.339607
1 TO	5	.389401

15

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.02
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1058
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107674

THE AMR FOR THIS RIFLE IS: .872



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.984	.678	.703
MINIMUM X	-.801	-.692	-.667
MAXIMUM Y	1.345	1.456	1.001
MINIMUM Y	-.875	-.764	-.582
CENTROID X	.083	-.026	-.051
CENTROID Y	-.032	-.143	-.325
PCA TO CENTROID IN.	.089	.145	.329
MIN RADIUS	.448	.333	.198
MEAN RADIUS	.861	.762	.626
MAX RADIUS	1.402	1.469	1.082
HORIZONTAL SPREAD	1.785	1.370	1.370
VERTICAL SPREAD	2.220	2.220	1.583
EXTREME SPREAD	2.284	2.266	1.704
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

30 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523429

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.733

VS= 2.169

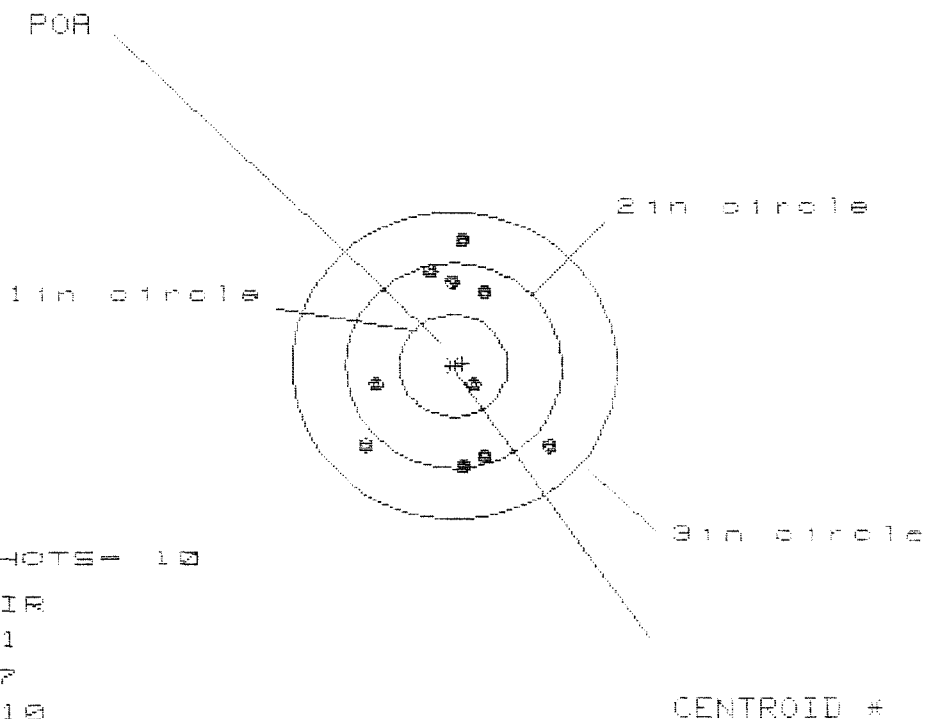
GS= 2.182

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.883	.943
MINIMUM X	:	-.927	-.837	-.777
MAXIMUM Y	:	1.117	1.218	1.058
MINIMUM Y	:	-1.052	-.951	-.799
CENTROID X	:	-.013	-.103	-.163
CENTROID Y	:	.001	-.100	-.252
POA TO CENTROID in.	:	.013	.143	.300
MIN RADIUS	:	.260	.328	.215
MEAN RADIUS	:	.834	.769	.668
MAX RADIUS	:	1.216	1.308	1.085
HORIZONTAL SPREAD	:	1.733	1.720	1.720
VERTICAL SPREAD	:	2.169	2.169	1.857
EXTREME SPREAD	:	2.182	2.169	2.000
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Oct 1980

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 1.722

VS = 2.189

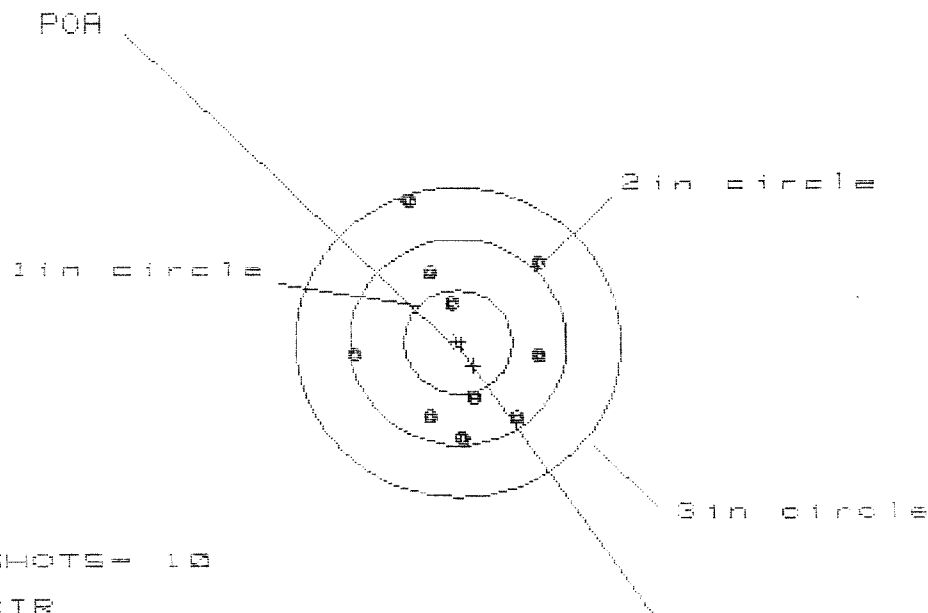
GS = 2.189

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.890	.898	.438
MINIMUM X	-.832	-.824	-.711
MAXIMUM Y	1.203	1.060	1.000
MINIMUM Y	-.986	-.852	-.932
CENTROID X	-.081	-.089	-.202
CENTROID Y	-.021	-.155	-.074
POA TO CENTROID in.	.084	.179	.215
MIN RADIUS	.279	.195	.332
MEAN RADIUS	.904	.855	.826
MAX RADIUS	1.206	1.105	1.013
HORIZONTAL SPREAD	1.722	1.722	1.149
VERTICAL SPREAD	2.189	1.932	1.932
EXTREME SPREAD	2.189	2.029	1.947
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

30 Oct 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.709

VS= 2.223

GS= 2.322

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.714	.661	.720
MINIMUM X	-.995	-1.048	-.965
MAXIMUM Y	1.345	.951	.987
MINIMUM Y	-.878	-.728	-.610
CENTROID X	-.139	-.086	-.169
CENTROID Y	.225	.075	-.043
POA TO CENTROID in.	.264	.114	.174
MIN RADIUS	.350	.377	.300
MEAN RADIUS	.847	.761	.692
MAX RADIUS	1.427	1.158	1.012
HORIZONTAL SPREAD	1.709	1.709	1.685
VERTICAL SPREAD	2.223	1.679	1.597
EXTREME SPREAD	2.322	1.967	1.686
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 0

3 in = 0

HM = 2.614

VM = 1.658

GM = 2.837

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.154	.992	.779
MINIMUM X	-1.460	-.962	-.838
MAXIMUM Y	.928	.879	.957
MINIMUM Y	-.730	-.779	-.761
CENTROID X	.050	.212	.088
CENTROID Y	.356	.405	.327
POR TO CENTROID in.	.360	.457	.339
MIN RADIUS	.523	.434	.547
MEAN RADIUS	.914	.825	.781
MAX RADIUS	1.523	1.170	1.037
HORIZONTAL SPREAD	2.614	1.954	1.617
VERTICAL SPREAD	1.658	1.658	1.658
EXTREME SPREAD	2.837	2.220	1.960
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	0	
NUMBER IN THREE INCH CIRCLE	=	9	