

C6649057

MODEL 702TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington[®]

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.

DUPONT
REG. U.S. PAT. & T.M. OFF.

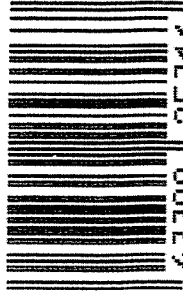
SERIAL NO.
C6649057

ORDER NO.
5716

0.45

5716 C6649057

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649057

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25 9 1		Rw
600	Proof	6 25 9 1		Rw
607	Check Headspace	6 30 9 1		Rw
610	Dis-assemble Gun	6 30 9 1		Rw
612	Magnaflux Barrel Action	JUL 1 1991		KR
	Magnaflux Bolt	JUL 1 1991		KR
615	Rollmark Caliber	JUL 1 1991		LS
617	Drill and Tap Sight Holes	JUL 1 1991		KB
618	Polish Barrel	JUL 2 1991		KB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/29/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/29/91	Rw
	D) Oil Firing Pin Ass'y		8/29/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	BARBER NAME 0031154	READINGS					DATE	INIT
625 cont.	F) Safety On Force	54	6	54			7-6-91	DH
	G) Safety Off Force	3	32	3			7-6-91	DH
	H) Trigger Pull Test & Retainability						7-6-91	DH
	I) Firing Pin Indent	.023	.023	.023			7-6-91	DH
	J) Assemble Stock						9/9/91	RW
	K) Assemble Swivel Studs						9-17-91	DH
	L) Attach Front and Rear Sight Assemblies						9/9/91	RW
	M) Iron Sight Alignment						9/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	RW
	O) Attach Scope to Rifle						9/9/91	RW
	P) Detach & Attach Scope 20 Times						9/9/91	RW
640	Gallery Target & Test						9/9/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						9/9/91	KT
655	Final Inspection							
	A) Headspace						7-12-91	DH
	B) Trigger Pull	253	234	233	238	238	7-14-91	DH
	C) Function						7-12-91	DH
660	Pack						7-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6649057

DATE 9-6-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.64	2.61	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.70	2.59	2.34	
PULL #3	2.32	2.71	2.71	2.33	
PULL #4	2.59	2.62	2.72	2.38	
PULL #5	2.50	2.65	2.78	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.15		
PULL #2	3.18	3.23		
PULL #3	3.08	3.01		
PULL #4	3.09	3.11		
PULL #5	3.15	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.20		4.31
PULL #2	4.16	4.23		4.39
PULL #3	4.12	4.27		4.37
PULL #4	4.14	4.32		4.34
PULL #5	4.20	4.31		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649057
9 Sep 1991

CENTROIDAL DISTANCES

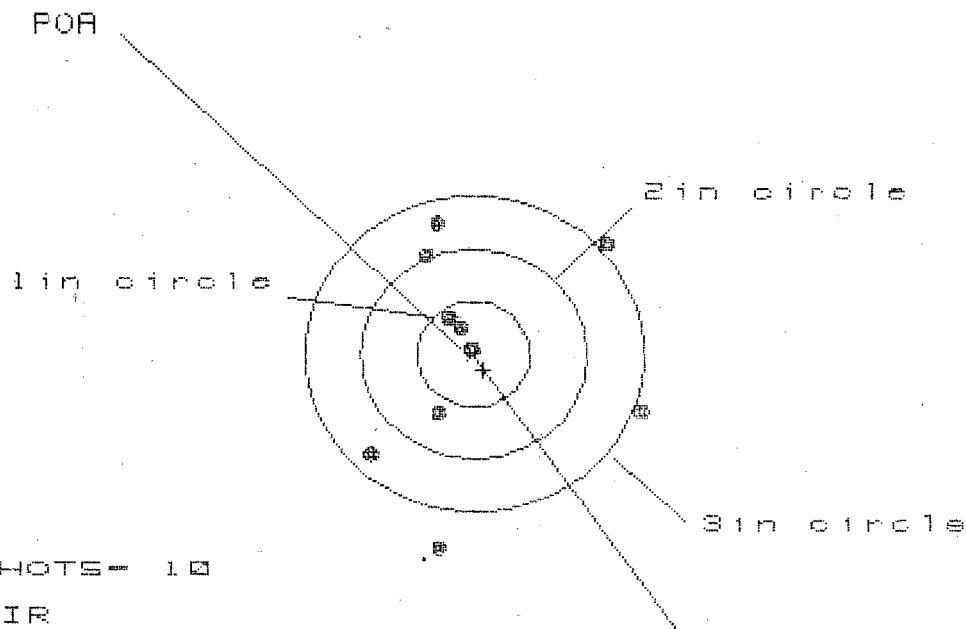
0 TO	1	.170473
1 TO	2	.359221
1 TO	3	.366318
1 TO	4	.213284
1 TO	5	.104695

43 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0124
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0322
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0345031
THE AMR FOR THIS RIFLE IS: .9746

FILE:/PATTERNING/CENTERFIRE_PATT/C6649057

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS= 2.373

VS= 3.062

GS= 3.206

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.469	1.430	1.290
MINIMUM X	-.904	-.943	-.764
MAXIMUM Y	1.246	1.044	.949
MINIMUM Y	-1.816	-1.124	-1.219
CENTROID X	-.081	-.042	-.221
CENTROID Y	.150	.352	.447
POA TO CENTROID in.	.171	.355	.499
MIN RADIUS	.084	.125	.084
MEAN RADIUS	.990	.870	.731
MAX RADIUS	1.849	1.619	1.479
HORIZONTAL SPREAD	2.373	2.373	2.054
VERTICAL SPREAD	3.062	2.168	2.168
EXTREME SPREAD	3.206	2.827	2.827
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49057

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.736

VS = 3.890

GS = 3.893

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.506	1.482	.677
MINIMUM X	:	-1.230	-1.254	-1.069
MAXIMUM Y	:	1.315	1.028	1.039
MINIMUM Y	:	-2.575	-1.056	-1.045
CENTROID X	:	-.033	-.009	-.194
CENTROID Y	:	-.206	.080	.069
POA TO CENTROID in.	:	.209	.080	.206
MIN RADIUS	:	.207	.219	.129
MEAN RADIUS	:	1.136	.956	.882
MAX RADIUS	:	2.585	1.484	1.087
HORIZONTAL SPREAD	:	2.736	2.736	1.746
VERTICAL SPREAD	:	3.890	2.084	2.084
EXTREME SPREAD	:	3.893	2.746	2.084
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/06649057

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.312

VS= 2.954

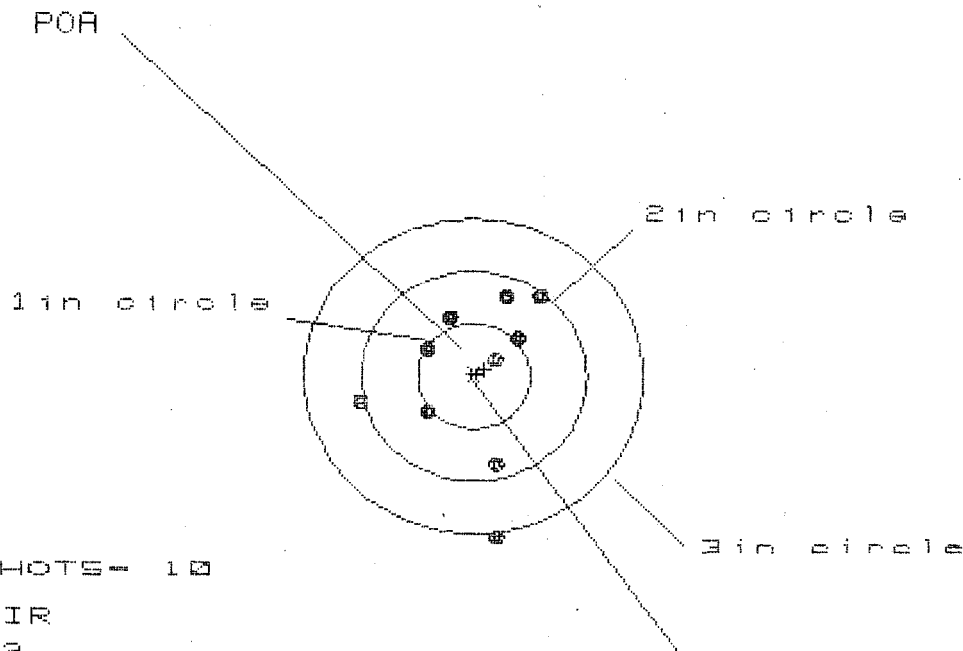
GS= 3.107

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.800	.760	.831
MINIMUM X	:	-.512	-.552	-.481
MAXIMUM Y	:	1.595	.848	.701
MINIMUM Y	:	-1.359	-1.182	-1.206
CENTROID X	:	.194	.234	.163
CENTROID Y	:	-.092	-.269	-.122
POA TO CENTROID in.	:	.215	.357	.203
MIN RADIUS	:	.220	.331	.197
MEAN RADIUS	:	.817	.765	.630
MAX RADIUS	:	1.635	1.310	1.465
HORIZONTAL SPREAD	:	1.312	1.312	1.312
VERTICAL SPREAD	:	2.954	2.030	1.907
EXTREME SPREAD	:	3.107	2.097	2.039
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 1.609

VS = 2.344

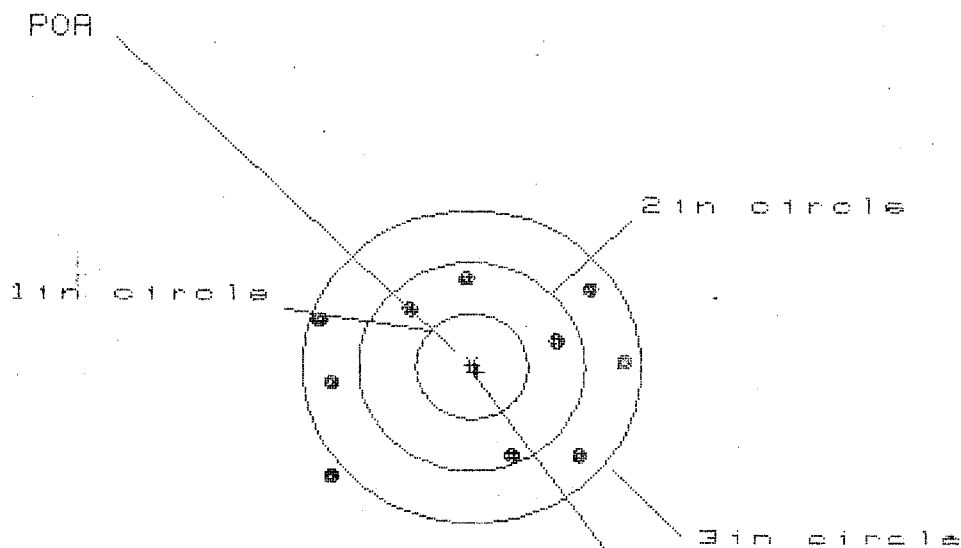
GS = 2.346

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.594	.616	.491
MINIMUM X	:	-1.015	-.993	-.507
MAXIMUM Y	:	.802	.631	.581
MINIMUM Y	:	-1.542	-.986	-1.036
CENTROID X	:	-.092	-.114	.010
CENTROID Y	:	-.063	.108	.158
POA TO CENTROID in.	:	.111	.157	.158
MIN RADIUS	:	.276	.255	.148
MEAN RADIUS	:	.762	.640	.565
MAX RADIUS	:	1.555	1.070	1.045
HORIZONTAL SPREAD	:	1.609	1.609	.999
VERTICAL SPREAD	:	2.344	1.617	1.617
EXTREME SPREAD	:	2.346	1.864	1.618
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 2.620

VS = 1.959

GS = 3.019

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.302	1.159	.976
MINIMUM X	-1.318	-1.461	-1.622
MAXIMUM Y	.885	.766	.804
MINIMUM Y	-1.074	-.970	-.932
CENTROID X	-.050	.093	.276
CENTROID Y	.050	.169	.131
POA TO CENTROID in.	.071	.193	.305
MIN RADIUS	.773	.625	.461
MEAN RADIUS	1.168	1.085	1.005
MAX RADIUS	1.679	1.493	1.642
HORIZONTAL SPREAD	2.620	2.620	2.598
VERTICAL SPREAD	1.959	1.736	1.736
EXTREME SPREAD	3.019	2.644	2.610
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		