

C6648933

MODEL 700TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington
MODEL 700TH M24

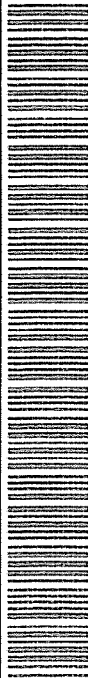
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6648933

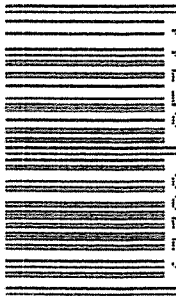
ORDER NO.
5716

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



5716 C6648933

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648933

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/27/91	WB
620	Apply Coatings (Barrel Action)		8-8-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	JS

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-19-91	JH
	G) Safety Off Force	3	3	3			8-19-91	JH
	H) Trigger Pull Test & Retainability						8-19-91	JH
	I) Firing Pin Indent	.0226	.022	.022			8-19-91	JH
	J) Assemble Stock						8-21-91	RW
	K) Assemble Swivel Studs						8-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-21-91	RW
	M) Iron Sight Alignment						8-21-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-21-91	RW
	O) Attach Scope to Rifle						8-21-91	RW
	P) Detach & Attach Scope 20 Times						8-21-91	RW
640	Gallery Target & Test						8-21-91	D/H
	A) Time						8-21-91	D/H
	B) Malfunctions						8-21-91	D/H
	C) Pierced Primers						8-21-91	D/H
	D) Optical Clarity of Scope						8-21-91	D/H
645	Inspect for Live Ammo						8-21-91	D/H
655	Final Inspection						8-22-91	D/H
	A) Headspace						8-21-91	D/H
	B) Trigger Pull	2.34	2.27	2.38	2.34	2.48	8-21-91	D/H
	C) Function						8-22-91	D/H
660	Pack						7-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6648933DATE 8-19-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.38	2.40	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.48	2.44	2.27	
PULL #3	2.53	2.48	2.49	2.38	
PULL #4	2.59	2.60	2.55	2.34	
PULL #5	2.48	2.46	2.48	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.69	3.57		
PULL #2	3.56	3.63		
PULL #3	3.59	3.68		
PULL #4	3.90	3.71		
PULL #5	3.60	3.70		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.29		4.28
PULL #2	4.17	4.28		4.27
PULL #3	4.22	4.35		4.27
PULL #4	4.45	4.20		4.32
PULL #5	4.25	4.14		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648933
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.454324
1 TO	2	.318002
1 TO	3	.167003
1 TO	4	.629484
1 TO	5	.874216

3421 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0692
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0724928
THE AMR FOR THIS RIFLE IS: .8854

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648933

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.627

VS= 1.914

GS= 2.731

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.455

1.393

.623

-1.172

-1.010

-.836

1.033

.961

.898

-.881

-.953

-1.016

.439

.277

.103

.117

.189

.252

.454

.395

.272

.499

.434

.257

.976

.884

.795

1.592

1.481

1.018

2.627

2.403

1.459

1.914

1.914

1.914

2.731

2.461

1.919

1

6

9

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648933

CENTERFIRE PATTERNS # 2

POB

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HE = 2.175

VE = 2.444

GS = 3.225

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.885

.741

.538

MINIMUM X

-1.290

-.834

-.741

MAXIMUM Y

1.172

1.295

1.151

MINIMUM Y

-1.272

-1.149

-.698

CENTROID X

.134

.278

.185

CENTROID Y

.027

-.096

.048

POB TO CENTROID IN.

.137

.294

.191

MIN RADIUS

.308

.213

.322

MEAN RADIUS

.836

.704

.636

MAX RADIUS

1.701

1.367

1.172

HORIZONTAL SPREAD

2.175

1.575

1.279

VERTICAL SPREAD

2.444

2.444

1.849

EXTREME SPREAD

3.225

2.520

1.849

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

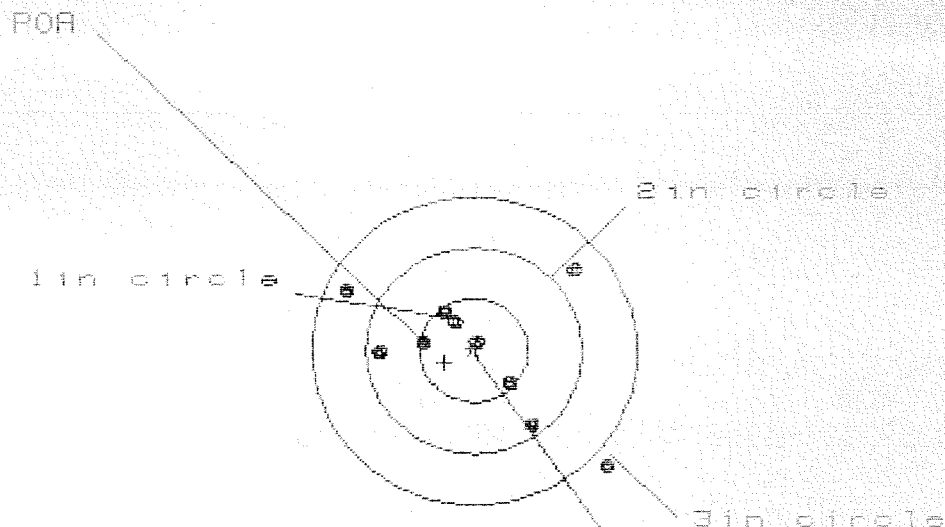
NUMBER IN THREE INCH CIRCLE =

8

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648933

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.416

VS= 1.892

GS= 2.924

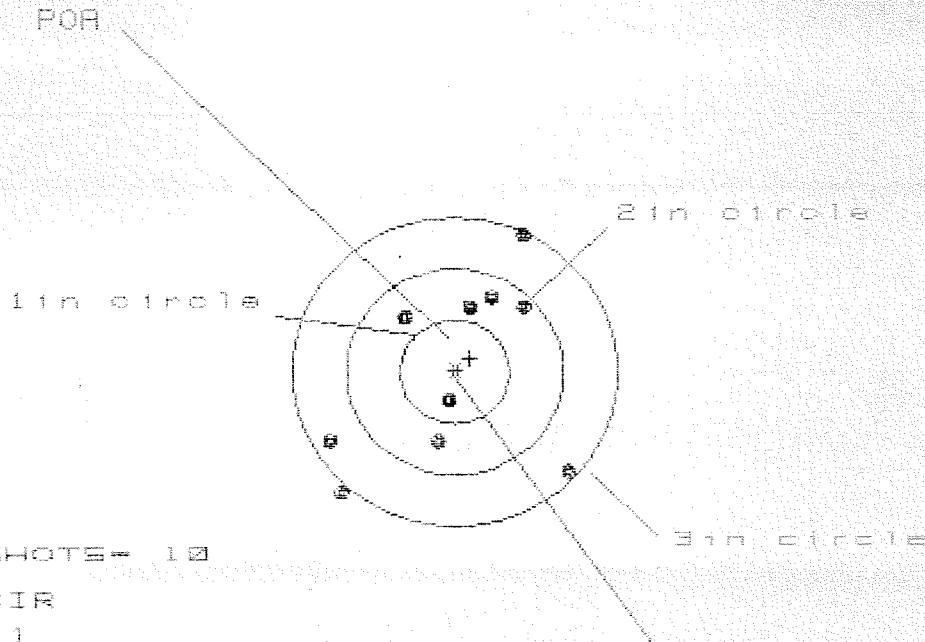
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.226	1.092	.960
MINIMUM X	-1.190	-1.054	-.961
MAXIMUM Y	.798	.677	.731
MINIMUM Y	-1.094	-.822	-.768
CENTROID X	.272	.136	.268
CENTROID Y	.118	.239	.185
POA TO CENTROID in.	.297	.275	.326
MIN RADIUS	.090	.137	.025
MEAN RADIUS	.778	.643	.588
MAX RADIUS	1.643	1.285	1.207
HORIZONTAL SPREAD	2.416	2.146	1.821
VERTICAL SPREAD	1.892	1.499	1.499
EXTREME SPREAD	2.924	2.160	1.989
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B333

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 3

HS= 2.244

VS= 2.544

GS= 3.052

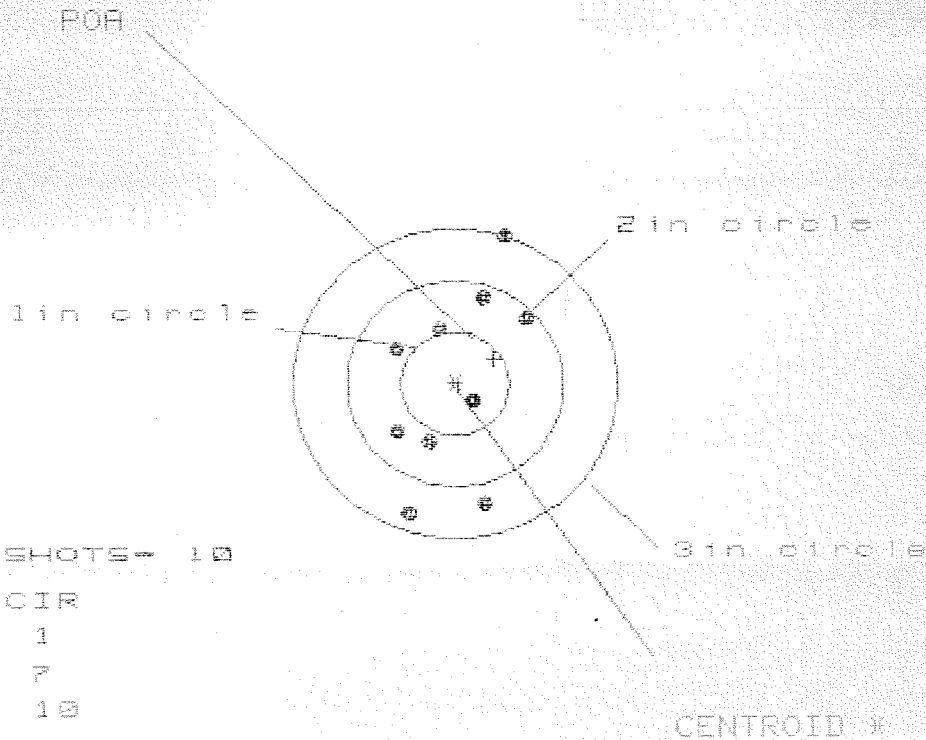
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.059	.944	1.011
MINIMUM X	-1.185	-1.300	-1.233
MAXIMUM Y	1.338	1.204	.715
MINIMUM Y	-1.206	-1.085	-.934
CENTROID X	-.140	-.025	-.092
CENTROID Y	-.130	.004	-.146
POA TO CENTROID in.	.191	.025	.173
MIN RADIUS	.302	.458	.294
MEAN RADIUS	.985	.900	.847
MAX RADIUS	1.588	1.544	1.409
HORIZONTAL SPREAD	2.244	2.244	2.244
VERTICAL SPREAD	2.544	2.289	1.650
EXTREME SPREAD	3.052	2.743	2.258
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B933

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.255

VS= 2.651

GS= 2.805

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.785	.758	.710
MINIMUM X	-.550	-.497	-.545
MAXIMUM Y	1.392	.993	.855
MINIMUM Y	-1.259	-1.104	-1.156
CENTROID X	-.359	-.412	-.364
CENTROID Y	-.240	-.395	-.257
POA TO CENTROID in.	.432	.571	.445
MIN RADIUS	.237	.204	.227
MEAN RADIUS	.852	.769	.713
MAX RADIUS	1.472	1.170	1.180
HORIZONTAL SPREAD	1.255	1.255	1.255
VERTICAL SPREAD	2.651	2.097	2.011
EXTREME SPREAD	2.805	2.223	2.012
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		