

06225075

MODEL 700TM N24

Model **SM5**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smith[®]

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

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

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

MODEL 700™ H24

SERIAL NO.
C6225075

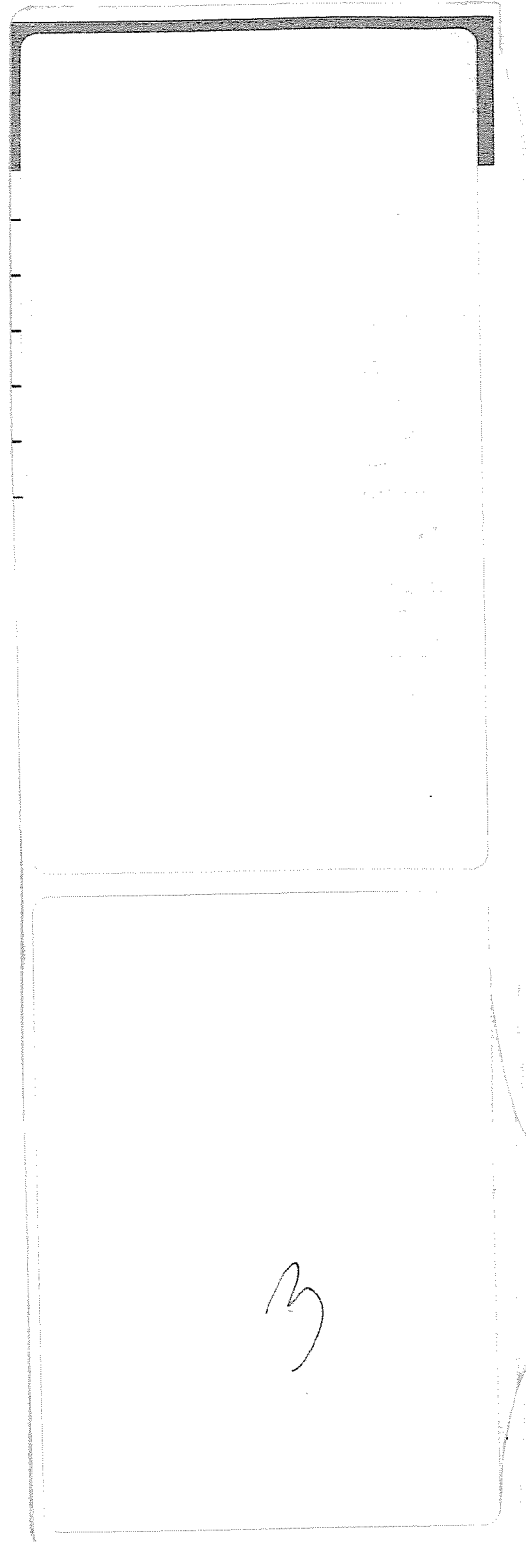
ORDER NO.
5716

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

20

UPC
0 47700 25716 7

5716 C6225075



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225075

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9	88	RW
600	Proof	12 9	88	RW
607	Check Headspace	12 9	88	RW
610	Dis-assemble Gun	12 9	88	RW
612	Magnaflux Barrel Action		12-22-88	RFC.
	Magnaflux Bolt		1-3-89	RFC.
615	Rollmark Caliber		12/22/88	RW/C.
617	Drill and Tap Sight Holes	1 3	89	FB
618	Polish Barrel	12 2	88	WJT
620	Apply Coatings (Barrel Action)		1-18-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/2/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/2/89	RW
	C) Inspect Ejector Hole for Chamfer		2/2/89	RW
	D) Oil Firing Pin Ass'y		2/2/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/89	RS

op. #	BARBER - M24 0048355 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			33rd 89	JSS
	G) Safety Off Force	3	3	3			3rd 89	JSS
	H) Trigger Pull Test & Retainability						28rd 89	JSS
	I) Firing Pin Indent	.0215	.0215	.0215			33rd 89	JSS
	J) Assemble Stock						2/9/89	RW
	K) Assemble Swivel Studs						153rd 89	JSS
	L) Attach Front and Rear Sight Assemblies						2/9/89	RW
	M) Iron Sight Alignment						2/9/89	RW
	N) Detach Front & Rear Sights & place in numbered container						2/9/89	RW
	O) Attach Scope to Rifle						93rd 89	JSS
	P) Detach & Attach Scope 20 Times						93rd 89	JSS
640	Gallery Target & Test	66	88				2/14/89	AC
	A) Time							AC
	B) Malfunctions				NONE			AC
	C) Pierced Primers				NONE			AC
	D) Optical Clarity of Scope				OK		2/14/89	AC
645	Inspect for Live Ammo				NONE		2/14/89	AC
655	Final Inspection							
	A) Headspace						153rd 89	JSS
	B) Trigger Pull	2.23	2.37	2.35	2.36	2.36	153rd 89	JSS
	C) Function						153rd 89	JSS
660	Pack						3/72	W.B.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#SERIAL NO. C6225075DATE 4-11-80TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.41		2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.39		2.56	
PULL #3	2.39	2.42		2.50	
PULL #4	2.45	2.49		2.52	
PULL #5	2.44	2.43		2.53	
TOTAL	11.93	12.14		12.64	
AVG.	2.386	2.428		2.528	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.38		
PULL #2	3.43	3.36		
PULL #3	3.42	3.33		
PULL #4	3.31	3.35		
PULL #5	3.34	3.30		
TOTAL	16.90	16.72		
AVG.	3.38	3.344		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.29		
PULL #2	4.20	4.31		
PULL #3	4.24	4.30		
PULL #4	4.29	4.19		
PULL #5	4.16	4.38		
TOTAL	21.23	21.45		
AVG.	4.29	4.29		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225075
17 Feb 1989

CENTROIDAL DISTANCES

0 TO 1	.150047
1 TO 2	.0863134
1 TO 3	.425011
1 TO 4	.494328
1 TO 5	.1922

3.4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0348
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0361536
THE AMR FOR THIS RIFLE IS: .7038

17 Feb 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6225075

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 2.8003

VS= 2.037

GS= 3.417

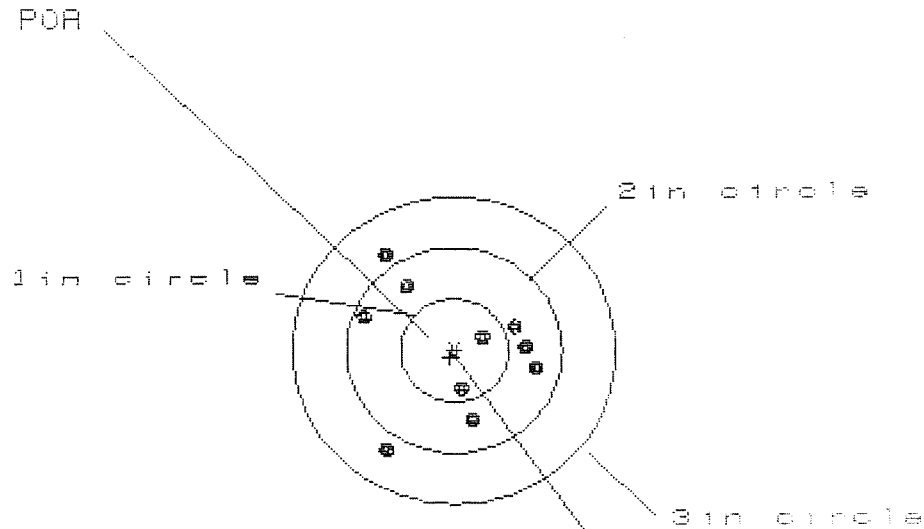
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.424	.961	.808
MINIMUM X	-1.379	-1.220	-.823
MAXIMUM Y	.853	.722	.801
MINIMUM Y	-1.184	-.991	-.912
CENTROID X	.125	-.034	.119
CENTROID Y	.083	.214	.135
POA TO CENTROID in.	.150	.217	.180
MIN RADIUS	.188	.128	.136
MEAN RADIUS	.932	.806	.727
MAX RADIUS	1.852	1.377	1.069
HORIZONTAL SPREAD	2.803	2.181	1.631
VERTICAL SPREAD	2.037	1.713	1.713
EXTREME SPREAD	3.417	2.431	1.878
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.562

VS = 1.869

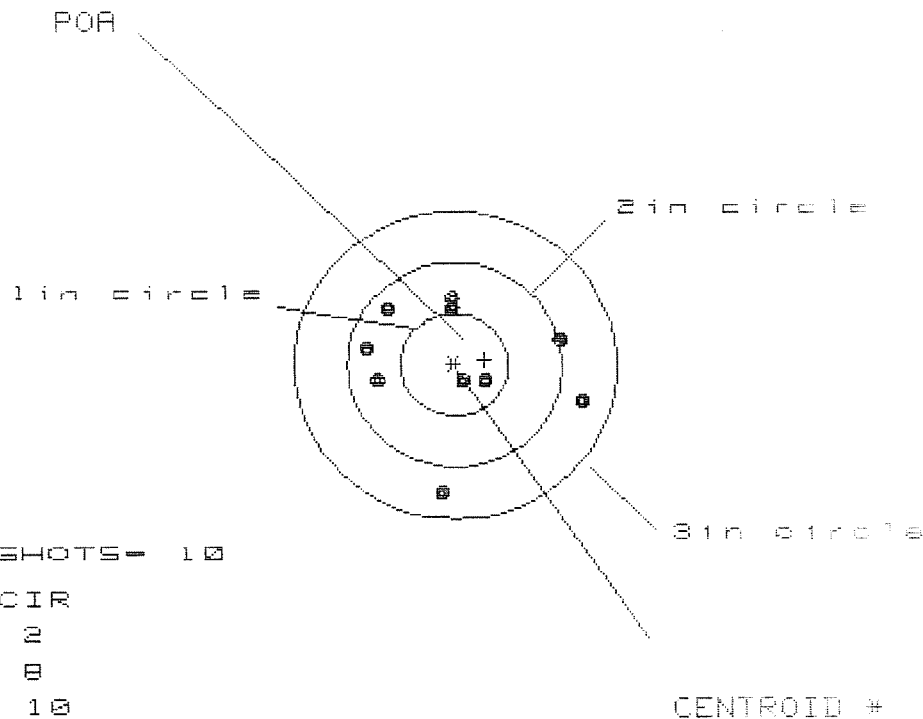
GS = 1.869

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.722	.652	.569
MINIMUM X	:	-.840	-.910	-.993
MAXIMUM Y	:	.918	.813	.622
MINIMUM Y	:	-.951	-.755	-.654
CENTROID X	:	.040	.110	.193
CENTROID Y	:	.068	.173	.072
POA TO CENTROID in.	:	.079	.205	.206
MIN RADIUS	:	.316	.206	.202
MEAN RADIUS	:	.730	.668	.593
MAX RADIUS	:	1.142	1.049	1.032
HORIZONTAL SPREAD	:	1.562	1.562	1.562
VERTICAL SPREAD	:	1.869	1.568	1.276
EXTREME SPREAD	:	1.869	1.734	1.634
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.950

VS = 1.893

GS = 1.993

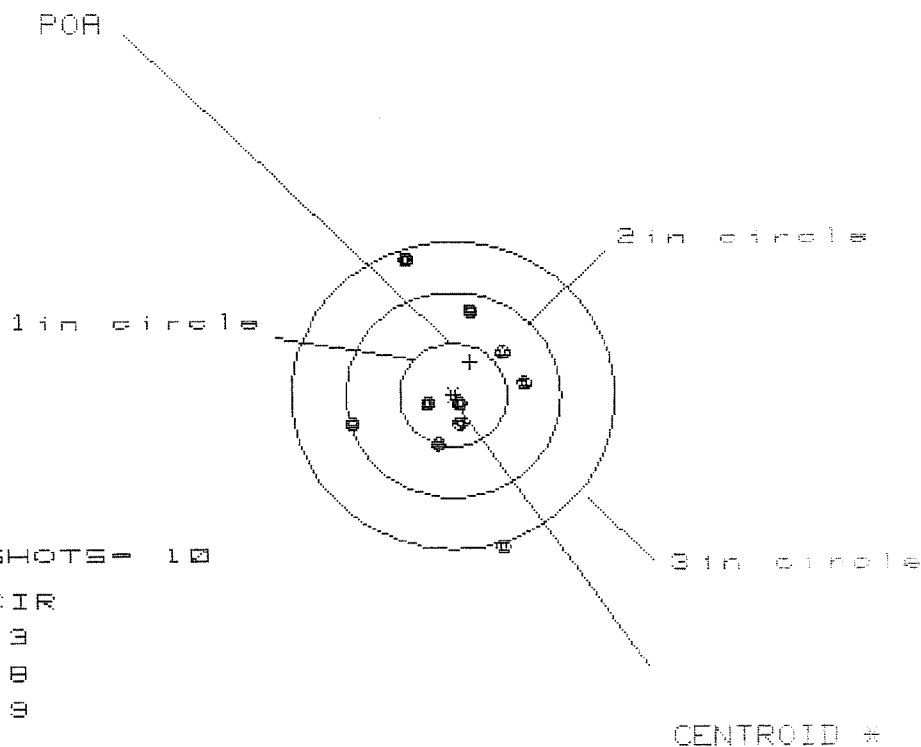
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.111	1.056
MINIMUM X	:	-.822	-.839	-.700
MAXIMUM Y	:	.614	.471	.416
MINIMUM Y	:	-1.280	-.443	-.358
CENTROID X	:	-.278	-.261	-.400
CENTROID Y	:	-.052	.090	.145
POA TO CENTROID in.	:	.283	.276	.425
MIN RADIUS	:	.141	.277	.344
MEAN RADIUS	:	.739	.668	.588
MAX RADIUS	:	1.289	1.196	1.056
HORIZONTAL SPREAD	:	1.950	1.950	1.756
VERTICAL SPREAD	:	1.893	.914	.774
EXTREME SPREAD	:	1.993	1.993	1.759
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.540

VS= 2.753

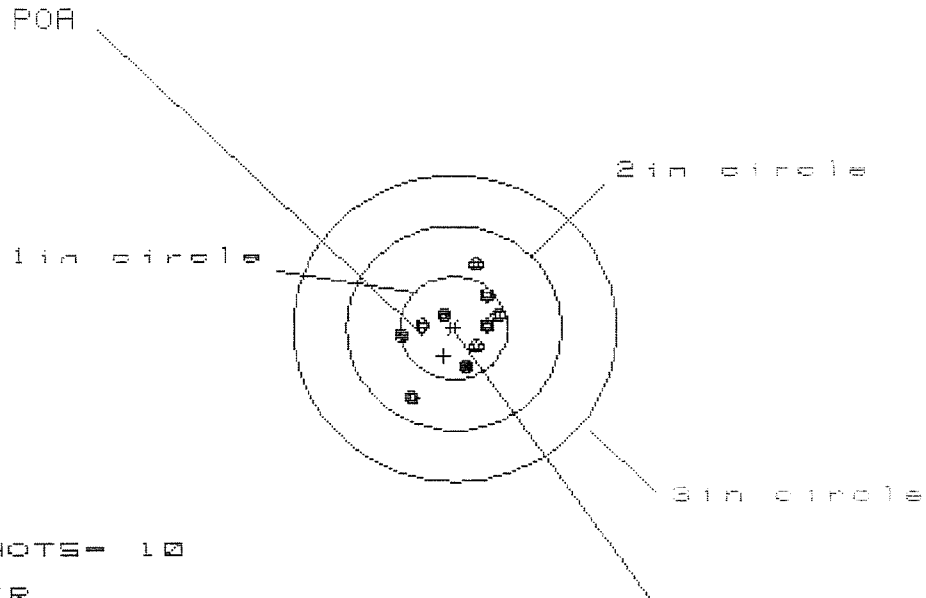
GS= 2.898

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.612	.663	.613
MINIMUM X	:	-.928	-.877	-.927
MAXIMUM Y	:	1.306	1.145	.787
MINIMUM Y	:	-1.447	-.651	-.508
CENTROID X	:	-.157	-.208	-.158
CENTROID Y	:	-.323	-.162	-.305
POA TO CENTROID in.	:	.359	.263	.344
MIN RADIUS	:	.096	.264	.113
MEAN RADIUS	:	.706	.639	.524
MAX RADIUS	:	1.517	1.212	.963
HORIZONTAL SPREAD	:	1.540	1.540	1.540
VERTICAL SPREAD	:	2.753	1.796	1.295
EXTREME SPREAD	:	2.898	1.826	1.576
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

1 in = 7

2 in = 10

3 in = 10

HS = .907

VS = 1.220

GS = 1.374

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.374	.324	.342
MINIMUM X	:	-.533	-.583	-.565
MAXIMUM Y	:	.597	.528	.316
MINIMUM Y	:	-.623	-.422	-.356
CENTROID X	:	.096	.146	.128
CENTROID Y	:	.273	.342	.276
POA TO CENTROID in.	:	.289	.372	.304
MIN RADIUS	:	.216	.212	.210
MEAN RADIUS	:	.412	.364	.337
MAX RADIUS	:	.765	.603	.572
HORIZONTAL SPREAD	:	.907	.907	.907
VERTICAL SPREAD	:	1.220	.950	.672
EXTREME SPREAD	:	1.374	.995	.928
NUMBER IN ONE INCH CIRCLE	=		7	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	