

C6611616

MODEL 700TH M24

Model SMSTH

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

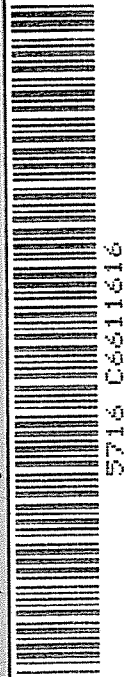
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6611616

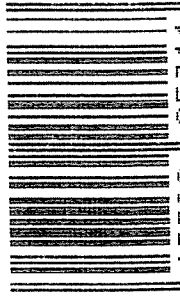
ORDER NO.
5716

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



5716 C6611616

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611616

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	CC
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/16/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-16-91	AC
	G) Safety Off Force	3	3	3			4-16-91	AC
	H) Trigger Pull Test & Retainability						4/14/91	JK
	I) Firing Pin Indent	.022	.022	.022			4-16-91	AC
	J) Assemble Stock						4/17/91	RW
	K) Assemble Swivel Studs						5-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/17/91	RW
	M) Iron Sight Alignment						4/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	RW
	O) Attach Scope to Rifle						4/17/91	RW
	P) Detach & Attach Scope 20 Times						4/17/91	RW
640	Gallery Target & Test						4/18/91	NF
	A) Time							NF
	B) Malfunctions							NF
	C) Pierced Primers							NF
	D) Optical Clarity of Scope							NF
645	Inspect for Live Ammo						4/18/91	NF
655	Final Inspection							
	A) Headspace						5-13-91	D/H
	B) Trigger Pull	2.59	2.22	2.26	2.30	2.30	5/10/91	JK
	C) Function						5-13-91	D/H
660	Pack						6-20-91	NF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Ream Ejector Hole + New Ejector 100 Rd Test Needed	RW
TEST		4/19
TGT		191
PROOF	100 Rd test 5291 shot DH OK	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD.		GA. CAL.	GUN #
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	4/8	Ejector Sticks	RW
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6611616

DATE 4/16/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.32	2.35	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.30	2.24	2.22	
PULL #3	2.44	2.22	2.36	2.26	
PULL #4	2.36	2.31	2.46	2.30	
PULL #5	2.27	2.24	2.28	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.39		
PULL #2	3.30	3.39		
PULL #3	3.26	3.29		
PULL #4	3.19	3.17		
PULL #5	3.18	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.24		4.45
PULL #2	4.26	4.34		4.47
PULL #3	4.20	4.35		4.49
PULL #4	4.25	4.43		4.50
PULL #5	4.22	4.41		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611616
18 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.06
1 TO	2	.0890225
1 TO	3	.252958
1 TO	4	.200823
1 TO	5	.082801

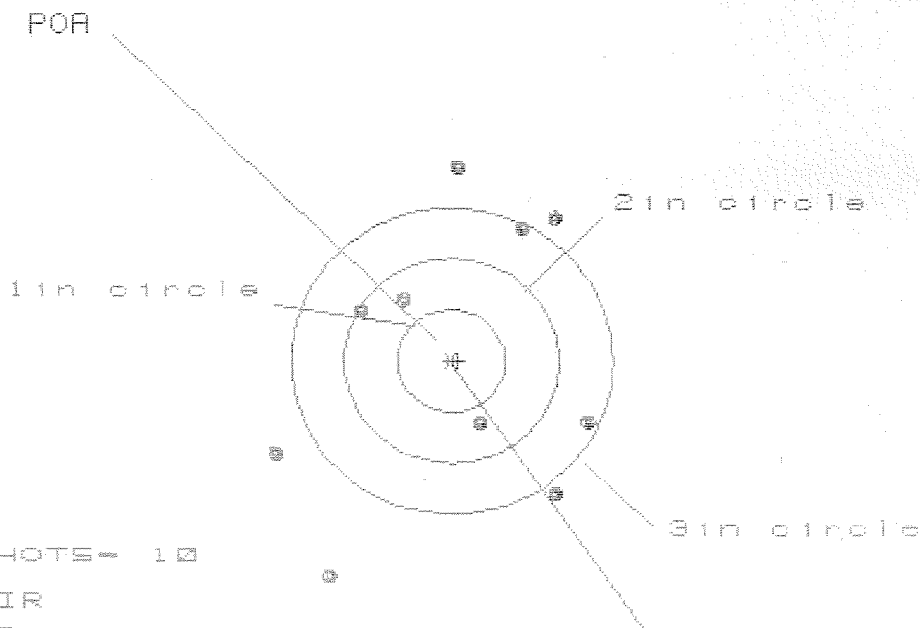
3
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .031
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0310413
THE AMR FOR THIS RIFLE IS: .9492

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611616

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 5

CENTROID *

HS= 2.874

VS= 3.944

GS= 4.114

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	1.085	.861
MINIMUM X	-1.662	-1.789	-1.179
MAXIMUM Y	1.865	1.634	1.489
MINIMUM Y	-2.079	-1.515	-1.560
CENTROID X	-.060	.067	.291
CENTROID Y	.000	.231	.376
POA TO CENTROID in.	.060	.241	.475
MIN RADIUS	.643	.664	.813
MEAN RADIUS	1.454	1.328	1.214
MAX RADIUS	2.374	2.131	1.778
HORIZONTAL SPREAD	2.874	2.874	2.040
VERTICAL SPREAD	3.944	3.149	3.149
EXTREME SPREAD	4.114	3.446	3.294
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	5	

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611616

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.977

VS= 2.201

GS= 2.406

PATTERN #

2

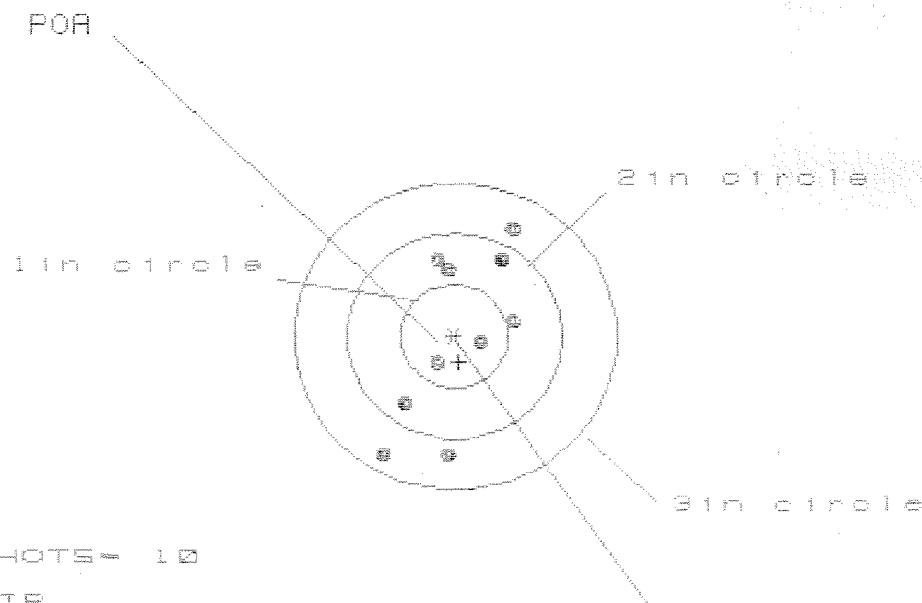
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.022	.915	.904
MINIMUM X	-.956	-.892	-.903
MAXIMUM Y	.953	.816	.673
MINIMUM Y	-1.248	-1.142	-1.040
CENTROID X	-.037	.069	.080
CENTROID Y	-.086	-.192	-.049
POA TO CENTROID in.	.094	.204	.094
MIN RADIUS	.104	.057	.092
MEAN RADIUS	.818	.756	.684
MAX RADIUS	1.350	1.146	1.055
HORIZONTAL SPREAD	1.977	1.807	1.807
VERTICAL SPREAD	2.201	1.958	1.713
EXTREME SPREAD	2.406	1.975	1.913
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.216

VS = 2.201

GS = 2.489

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.516	.439	.418
MINIMUM X	-.700	-.582	-.603
MAXIMUM Y	1.009	.879	.714
MINIMUM Y	-1.192	-1.322	-.941
CENTROID X	-.038	.039	.059
CENTROID Y	.252	.382	.547
POA TO CENTROID in.	.255	.384	.550
MIN RADIUS	.265	.252	.366
MEAN RADIUS	.785	.700	.600
MAX RADIUS	1.358	1.331	1.117
HORIZONTAL SPREAD	1.216	1.021	1.021
VERTICAL SPREAD	2.201	2.201	1.655
EXTREME SPREAD	2.489	2.281	1.945
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611616

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.413

VS= 2.326

GS= 2.511

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.186	1.229
MINIMUM X	:	-1.146	-1.227	-1.184
MAXIMUM Y	:	1.079	.943	.770
MINIMUM Y	:	-1.247	-1.383	-1.798
CENTROID X	:	.137	.218	.175
CENTROID Y	:	.039	.176	.349
POA TO CENTROID in.	:	.142	.281	.390
MIN RADIUS	:	.452	.384	.258
MEAN RADIUS	:	1.029	.954	.871
MAX RADIUS	:	1.434	1.427	1.308
HORIZONTAL SPREAD	:	2.413	2.413	2.413
VERTICAL SPREAD	:	2.326	2.326	1.568
EXTREME SPREAD	:	2.511	2.511	2.430
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 10

3 in = 10

HS= 1.471

VS= 1.645

GS= 1.716

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.595	.620	.599
MINIMUM X	-.876	-.851	-.773
MAXIMUM Y	.989	.727	.651
MINIMUM Y	-.736	-.635	-.711
CENTROID X	.006	-.019	-.097
CENTROID Y	-.050	-.151	-.076
POA TO CENTROID in.	.050	.152	.123
MIN RADIUS	.246	.319	.319
MEAN RADIUS	.660	.625	.592
MAX RADIUS	.937	.866	.822
HORIZONTAL SPREAD	1.471	1.471	1.372
VERTICAL SPREAD	1.645	1.362	1.362
EXTREME SPREAD	1.716	1.553	1.524
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	