

C6611646

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

DUPONT

MODEL 700™ H24

SERIAL NO.
C6611646

ORDER NO.
5716

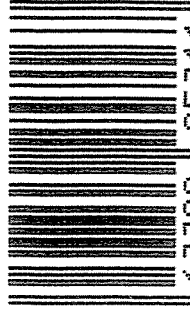
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611646

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611646

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	9 1	Rw
600	Proof	3 25	9 1	Rw
607	Check Headspace	3 25	9 1	Rw
610	Dis-assemble Gun	3 25	9 1	Rw
612	Magnaflux Barrel Action	3 28	9 1	KR
	Magnaflux Bolt	3 28	9 1	cc
615	Rollmark Caliber	3 28	9 1	LS
617	Drill and Tap Sight Holes	APR	3 1991	RB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/11/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/14/91	JP

op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-15-91	DH
	G) Safety Off Force	3	3	3			5-15-91	DH
	H) Trigger Pull Test & Retainability						5-14-91	JLP
	I) Firing Pin Indent	.021	.022	.022			5-15-91	DH
	J) Assemble Stock						5-15-91	RW
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5-15-91	RW
	M) Iron Sight Alignment						5-15-91	RW
	N) Detach Front & Rear Sights & place in numbered container						5-15-91	RW
	O) Attach Scope to Rifle						5-15-91	RW
	P) Detach & Attach Scope 20 Times						5-15-91	RW
640	Gallery Target & Test						5-15-91	DH
	A) Time						5-15-91	DH
	B) Malfunctions						5-15-91	DH
	C) Pierced Primers						5-15-91	DH
	D) Optical Clarity of Scope						5-15-91	DH
645	Inspect for Live Ammo						5-15-91	DH
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.15	2.20	2.18	2.23	2.15	5-20-91	JLP
	C) Function						5-21-91	DH
660	Pack						6-17-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6611646DATE 5-14-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.54	2.50	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.57	2.58	2.20	
PULL #3	2.51	2.60	2.48	2.18	
PULL #4	2.49	2.53	2.46	2.23	
PULL #5	2.47	2.49	2.50	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.35		
PULL #2	3.33	3.48		
PULL #3	3.27	3.39		
PULL #4	3.30	3.34		
PULL #5	3.33	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.47		4.47
PULL #2	4.53	4.40		4.46
PULL #3	4.47	4.41		4.48
PULL #4	4.51	4.43		4.36
PULL #5	4.50	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611646
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.167287
1 TO	2	.528977
1 TO	3	.19801
1 TO	4	.351693
1 TO	5	.566083

34⁴/₅ <----POA

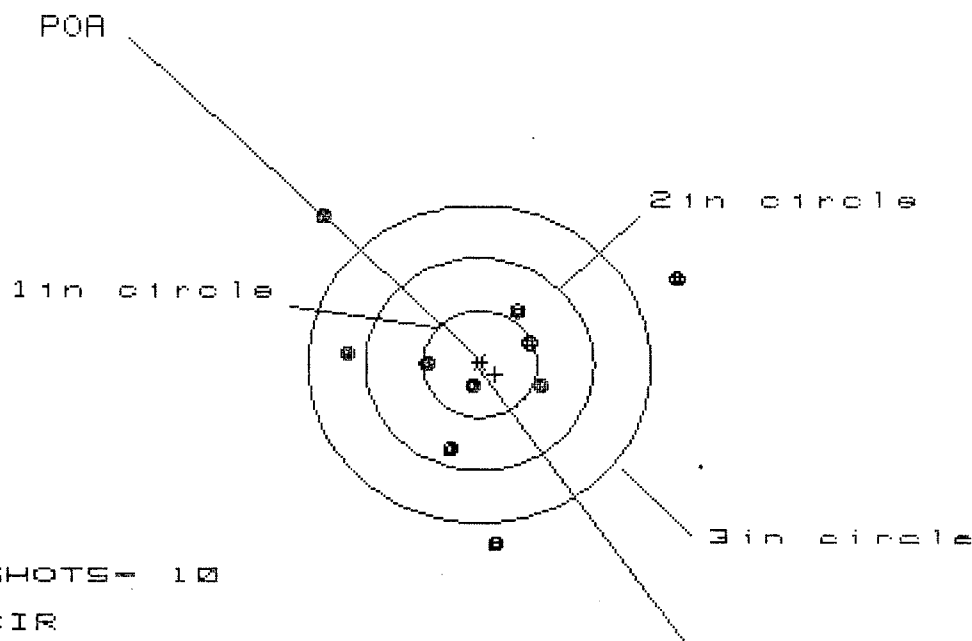
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136471

THE AMR FOR THIS RIFLE IS: 1.062

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611646

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 7

HS - 3.088

VS - 3.147

GS - 3.480

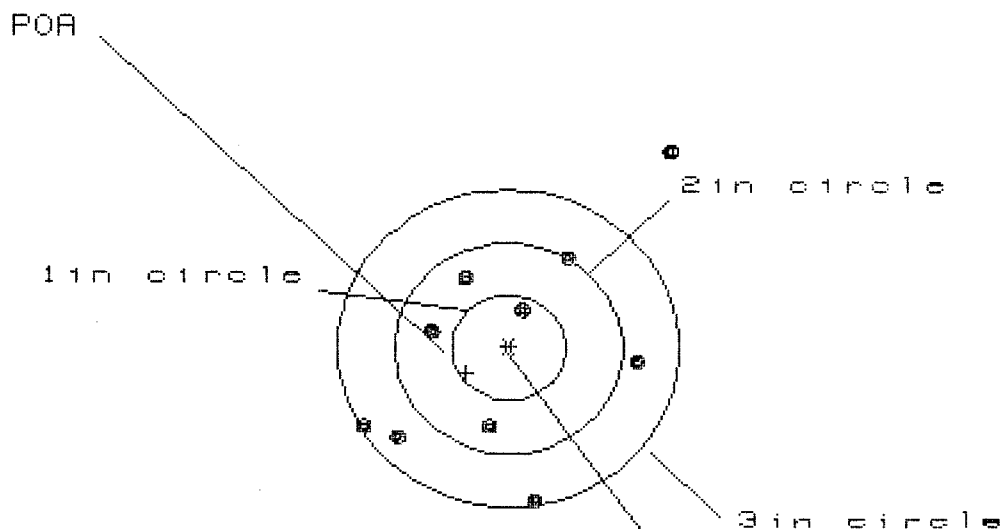
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.751	1.602	.598
MINIMUM X	:	-1.337	-1.332	-1.131
MAXIMUM Y	:	1.426	.970	.785
MINIMUM Y	:	-1.721	-1.563	-1.442
CENTROID X	:	-.137	.012	-.189
CENTROID Y	:	.096	-.062	-.183
POA TO CENTROID in.	:	.167	.063	.263
MIN RADIUS	:	.237	.183	.056
MEAN RADIUS	:	1.012	.889	.750
MAX RADIUS	:	1.955	1.873	1.459
HORIZONTAL SPREAD	:	3.088	2.934	1.729
VERTICAL SPREAD	:	3.147	2.533	2.227
EXTREME SPREAD	:	3.490	3.019	2.271
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.689

VS= 3.229

GS= 3.722

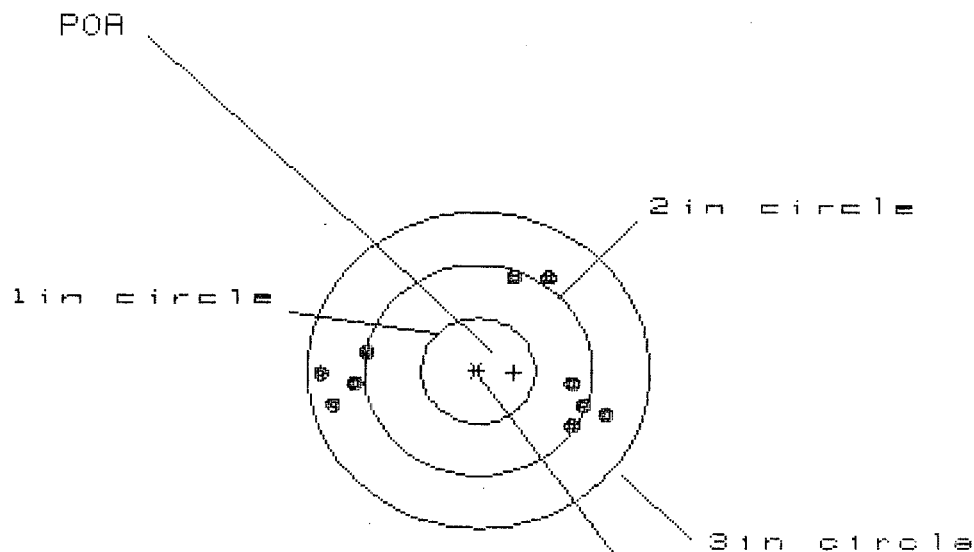
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.419	1.277	1.138
MINIMUM X	:	-1.270	-1.112	-.955
MAXIMUM Y	:	1.834	1.045	.978
MINIMUM Y	:	-1.395	-1.191	-1.258
CENTROID X	:	.372	.214	.353
CENTROID Y	:	.240	.036	.103
POA TO CENTROID in.	:	.443	.217	.368
MIN RADIUS	:	.360	.514	.491
MEAN RADIUS	:	1.113	.963	.922
MAX RADIUS	:	2.319	1.277	1.283
HORIZONTAL SPREAD	:	2.689	2.389	2.093
VERTICAL SPREAD	:	3.229	2.236	2.236
EXTREME SPREAD	:	3.722	2.458	2.254
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 10

HS= 2.537

VS= 1.398

GS= 2.582

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	1.008	.828
MINIMUM X	-1.376	-1.442	-1.383
MAXIMUM Y	.872	.874	.835
MINIMUM Y	-.526	-.524	-.563
CENTROID X	-.319	-.166	.014
CENTROID Y	.018	.016	.055
POA TO CENTROID in.	.320	.167	.057
MIN RADIUS	.824	.673	.505
MEAN RADIUS	1.082	1.023	.921
MAX RADIUS	1.376	1.475	1.398
HORIZONTAL SPREAD	2.537	2.450	2.211
VERTICAL SPREAD	1.398	1.398	1.398
EXTREME SPREAD	2.582	2.454	2.244
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611646

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS- 3.072

VS= 1.612

GS= 3.094

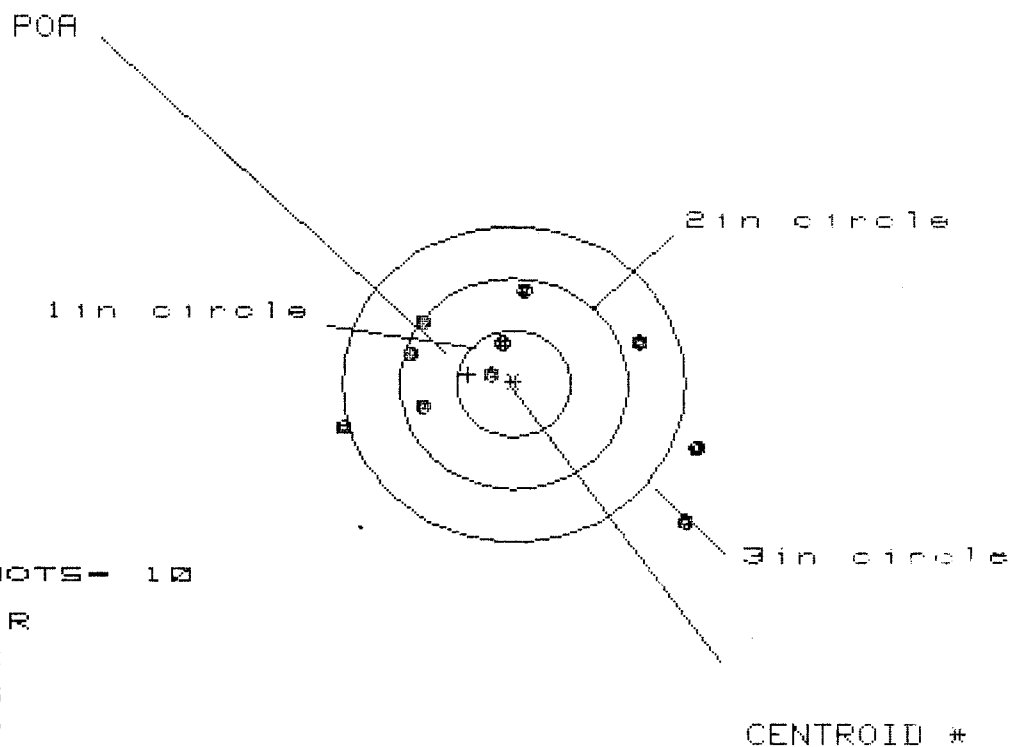
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	1.812	.973
MINIMUM X	:	-1.310	-1.114	-.887
MAXIMUM Y	:	.893	.889	.947
MINIMUM Y	:	-.719	-.723	-.665
CENTROID X	:	.205	.009	-.218
CENTROID Y	:	.178	.182	.124
POA TO CENTROID in.	:	.271	.182	.250
MIN RADIUS	:	.099	.209	.369
MEAN RADIUS	:	1.016	.904	.756
MAX RADIUS	:	1.763	1.872	1.358
HORIZONTAL SPREAD	:	3.072	2.926	1.860
VERTICAL SPREAD	:	1.612	1.612	1.612
EXTREME SPREAD	:	3.094	3.057	2.272
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.186

VS= 2.163

GS= 3.221

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.647	1.819	1.506
MINIMUM X	:	-1.539	-1.367	-1.139
MAXIMUM Y	:	.855	.709	.618
MINIMUM Y	:	-1.308	-.730	-.634
CENTROID X	:	.398	.226	-.002
CENTROID Y	:	-.089	.057	.148
POA TO CENTROID in.	:	.408	.233	.148
MIN RADIUS	:	.205	.105	.278
MEAN RADIUS	:	1.085	.909	.748
MAX RADIUS	:	2.028	1.960	1.510
HORIZONTAL SPREAD	:	3.186	3.186	2.645
VERTICAL SPREAD	:	2.163	1.439	1.252
EXTREME SPREAD	:	3.221	3.191	2.747
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		