

C6522264

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522264

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	JS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel AB		7/24/90	LB
620	Apply Coatings (Barrel Action)		7-16-90	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-12-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/14/90	JK
	G) Safety Off Force	3	3	3			8/14/90	JK
	H) Trigger Pull Test & Retainability						9/12/90	JK
	I) Firing Pin Indent	.0225	.0215	.0225			8/14/90	JK
	J) Assemble Stock						8/15/90	RW
	K) Assemble Swivel Studs						9/13/90	JK
	L) Attach Front and Rear Sight Assemblies						8/15/90	RW
	M) Iron Sight Alignment						8/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	RW
	O) Attach Scope to Rifle						8/15/90	RW
	P) Detach & Attach Scope 20 Times						8/15/90	RW
640	Gallery Target & Test						8/15/90	AF
	A) Time						8/15/90	AF
	B) Malfunctions						8/15/90	AF
	C) Pierced Primers						8/15/90	AF
	D) Optical Clarity of Scope						8/15/90	AF
645	Inspect for Live Ammo						8/15/90	AF
655	Final Inspection							
	A) Headspace						9/13/90	JK
	B) Trigger Pull	2.28	2.31	2.29	2.31	2.26	9-12-90	JK
	C) Function						9/13/90	JK
660	Pack						9/19/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522264

DATE 9-12-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.32	2.26	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.34	2.26	2.31	
PULL #3	2.32	2.31	2.33	2.29	
PULL #4	2.34	2.26	2.30	2.31	
PULL #5	2.35	2.24	2.21	2.26	
TOTAL	11.58	11.47	11.36	11.45	
AVG.	2.316	2.294	2.272	2.29	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.42		
PULL #2	3.50	3.45		
PULL #3	3.46	3.49		
PULL #4	3.47	3.49		
PULL #5	3.49	3.50		
TOTAL	17.35	17.35		
AVG.	3.47	3.47		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.14		4.17
PULL #2	4.27	4.21		4.17
PULL #3	4.14	4.16		4.17
PULL #4	4.16	4.22		4.18
PULL #5	4.24	4.16		4.20
TOTAL	20.95	20.89		20.89
AVG.	4.19	4.178		4.178

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522264
16 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.123976
1 TO	2	.246018
1 TO	3	.210723
1 TO	4	.0470956
1 TO	5	.310821

54 <----POA

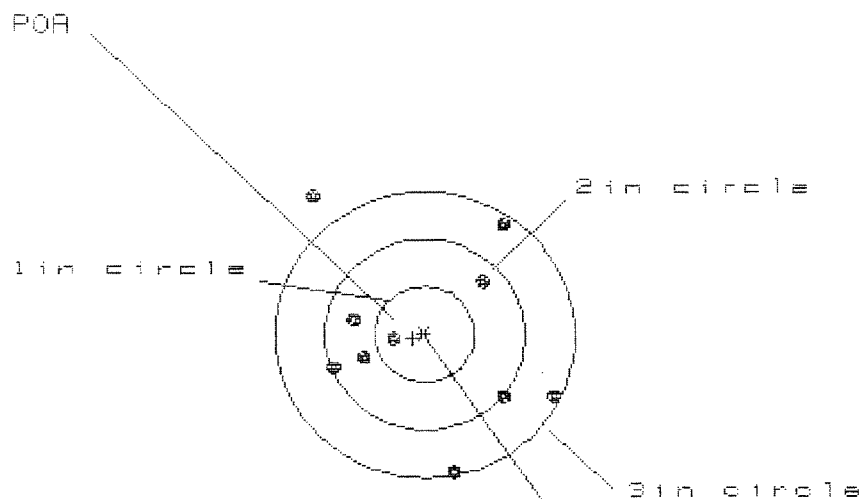
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0594
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0598348

THE AMR FOR THIS RIFLE IS: .8796

15 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08522264

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.465

VS = 2.856

GS = 3.237

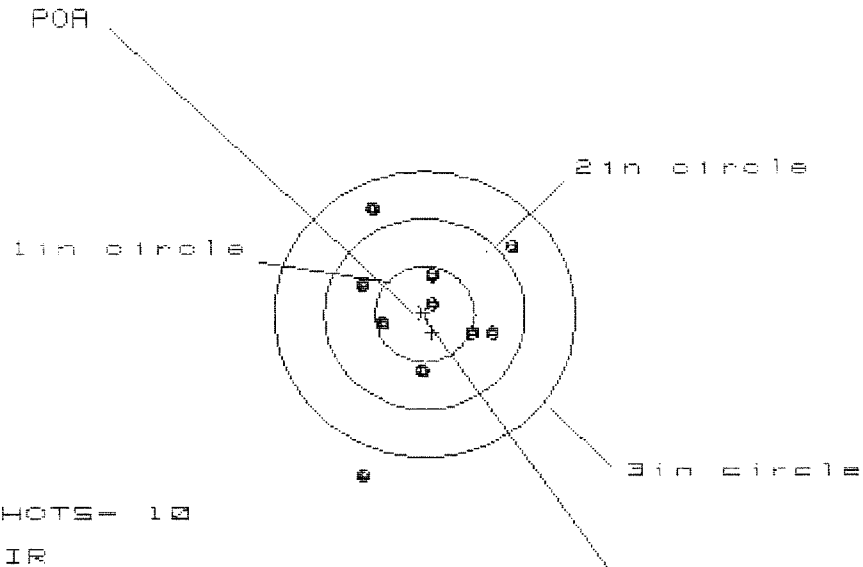
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.300	1.171	.831
MINIMUM X	:	-1.165	-1.081	-.935
MAXIMUM Y	:	1.441	1.307	1.244
MINIMUM Y	:	-1.415	-1.255	-1.318
CENTROID X	:	.117	.246	.100
CENTROID Y	:	.041	-.119	-.057
POA TO CENTROID in.	:	.124	.273	.115
MIN RADIUS	:	.342	.485	.329
MEAN RADIUS	:	1.080	.998	.929
MAX RADIUS	:	1.853	1.475	1.497
HORIZONTAL SPREAD	:	2.465	2.252	1.766
VERTICAL SPREAD	:	2.856	2.562	2.562
EXTREME SPREAD	:	3.237	2.610	2.610
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522264

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.538

VS= 2.813

GS= 2.821

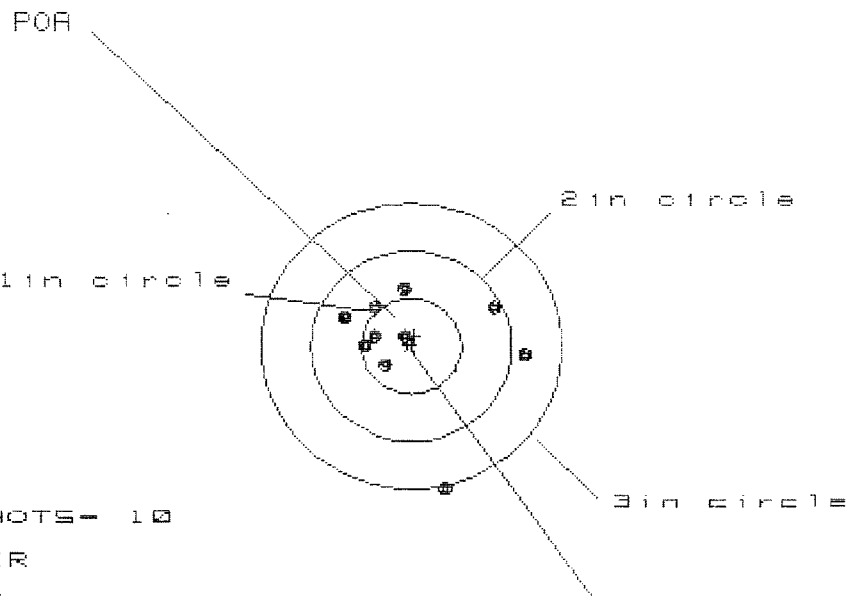
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.911	.843	.764
MINIMUM X	:	-.627	-.695	-.773
MAXIMUM Y	:	1.107	.917	.594
MINIMUM Y	:	-1.706	-.750	-.635
CENTROID X	:	-.078	-.010	.069
CENTROID Y	:	.191	.381	.266
POA TO CENTROID in.	:	.206	.381	.275
MIN RADIUS	:	.176	.038	.102
MEAN RADIUS	:	.769	.626	.559
MAX RADIUS	:	1.812	1.111	.968
HORIZONTAL SPREAD	:	1.538	1.538	1.538
VERTICAL SPREAD	:	2.813	1.667	1.229
EXTREME SPREAD	:	2.821	1.794	1.571
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522264

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.828

VS= 2.068

GS= 2.097

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	1.149	1.024
MINIMUM X	:	-.714	-.679	-.535
MAXIMUM Y	:	.593	.429	.398
MINIMUM Y	:	-1.475	-.391	-.422
CENTROID X	:	-.033	-.068	-.211
CENTROID Y	:	-.107	.057	.088
POA TO CENTROID in.	:	.112	.089	.229
MIN RADIUS	:	.129	.069	.137
MEAN RADIUS	:	.675	.545	.425
MAX RADIUS	:	1.508	1.174	1.037
HORIZONTAL SPREAD	:	1.828	1.828	1.559
VERTICAL SPREAD	:	2.068	.820	.820
EXTREME SPREAD	:	2.097	1.866	1.560
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522284

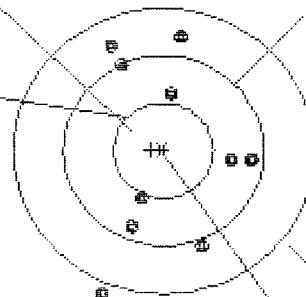
CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.524

VS = 2.679

GS = 2.798

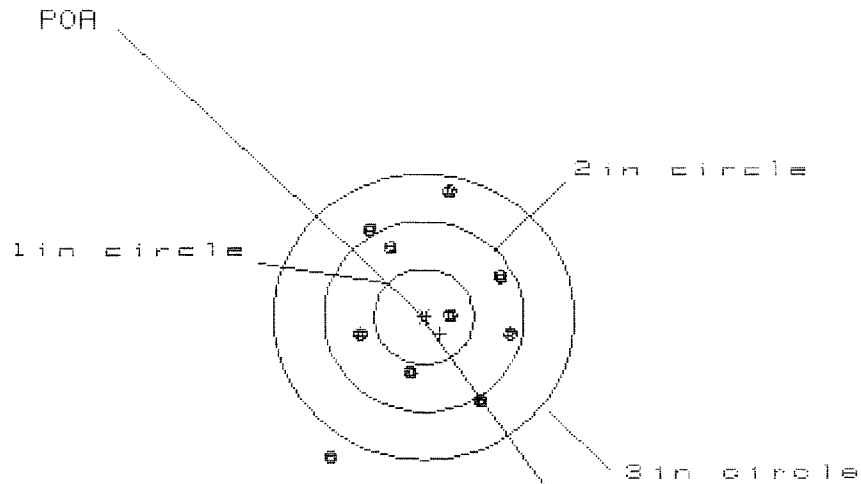
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.882	.810	.822
MINIMUM X	:	-.642	-.598	-.586
MAXIMUM Y	:	1.233	1.072	1.035
MINIMUM Y	:	-1.446	-1.106	-.972
CENTROID X	:	.120	.192	.180
CENTROID Y	:	-.006	.155	.021
POA TO CENTROID in.	:	.120	.246	.181
MIN RADIUS	:	.512	.395	.529
MEAN RADIUS	:	.941	.855	.819
MAX RADIUS	:	1.582	1.137	1.189
HORIZONTAL SPREAD	:	1.524	1.408	1.408
VERTICAL SPREAD	:	2.679	2.178	2.007
EXTREME SPREAD	:	2.798	2.185	2.184
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C85222B4

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.805

VS= 2.842

GS= 3.065

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.877	.774	.788
MINIMUM X	:	-.928	-.782	-.767
MAXIMUM Y	:	1.323	1.154	.933
MINIMUM Y	:	-1.519	-1.026	-.882
CENTROID X	:	-.162	-.059	-.074
CENTROID Y	:	.178	.347	.203
POA TO CENTROID in.	:	.241	.352	.216
MIN RADIUS	:	.285	.219	.194
MEAN RADIUS	:	.933	.821	.765
MAX RADIUS	:	1.780	1.160	1.108
HORIZONTAL SPREAD	:	1.805	1.556	1.556
VERTICAL SPREAD	:	2.842	2.180	1.815
EXTREME SPREAD	:	3.065	2.202	2.090
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®



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

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

MODEL 700™ H24

SERIAL NO.
C6522264

ORDER NO.
5716

Ø1

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



5716 C6522264

UPC



0 47700 25716 7