

C6522252

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

REP'D 7-31-90

ASSEM.

TEST INIT. ACTION TO CORRECT

#

PROOF

TEST

TGT

PROOF

TEST

TGT

PROOF

TEST

TGT

PROOF

TEST

TGT

ADJUSTED
MAG BOX

ENGINEER

ENGINEER

23

8/6/90

K2

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Mag. loads loads 5 $\frac{1}{4}$ Rd.</i>	<i>OKS</i>
	2nd	<i>OK JMT</i>	
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522252

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5-26-90	KA
600	Proof		6-26-90	KA
607	Check Headspace		7/26/90	KA
610	Dis-assemble Gun		6/26/90	KA
612	Magnaflux Barrel Action		7/10/90	KP
	Magnaflux Bolt		7/10/90	KP
615	Rollmark Caliber		7/10/90	LS
617	Drill and Tap Sight Holes		7/11/90	EB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/27/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/27/90	KA
	C) Inspect Ejector Hole for Chamfer		7/27/90	KA
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/90	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/26/90	921
	G) Safety Off Force	2	2	2			7/26/90	921
	H) Trigger Pull Test & Retainability						8/20/90	921
	I) Firing Pin Indent	.0225	.0225	.0225			7/26/90	921
	J) Assemble Stock						7/27/90	KS
	K) Assemble Swivel Studs						8/24/90	921
	L) Attach Front and Rear Sight Assemblies						7/27/90	KS
	M) Iron Sight Alignment						7/27/90	KS
	N) Detach Front & Rear Sights & place in numbered container						7/27/90	KS
	O) Attach Scope to Rifle						7/27/90	KS
	P) Detach & Attach Scope 20 Times						7/27/90	KS
640	Gallery Target & Test						7-30-90	AC
	A) Time						7-30-90	AC
	B) Malfunctions						7-30-90	AC
	C) Pierced Primers						7-30-90	AC
	D) Optical Clarity of Scope						7-30-90	AC
645	Inspect for Live Ammo						7-30-90	AC
655	Final Inspection							
	A) Headspace						8/24/90	921
	B) Trigger Pull	2.46	2.46	2.40	2.38	2.48	8/20/90	921
	C) Function						8/24/90	921
660	Pack						7/20/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO C6522252

DATE 8/20/90

TESTER J2

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	² 2.50	² 2.49	² 2.40	² 2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.43	2.42	2.46	
PULL #3	2.45	2.40	2.46	2.40	
PULL #4	2.47	2.46	2.44	2.38	
PULL #5	2.49	2.42	2.49	2.48	
TOTAL	12.34	12.20	12.21	12.18	
AVG.	2.468	2.44	2.442	2.436	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	¹ 3.39	¹ 3.28		
PULL #2	3.50	3.33		
PULL #3	3.24	3.19		
PULL #4	3.24	3.27		
PULL #5	3.20	3.09		
TOTAL	16.57	16.16		
AVG.	3.314	3.232		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	¹ 4.19	¹ 4.32		¹ 4.28
PULL #2	4.17	4.36		4.42
PULL #3	4.15	4.37		4.33
PULL #4	4.26	4.34		4.27
PULL #5	4.34	4.30		4.37
TOTAL	21.10	21.69		21.67
AVG.	4.22	4.338		4.334

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522252
1: JUL 1990

CENTROIDAL DISTANCES

1 TO	1	.116559
1 TO	2	.497993
1 TO	3	.836962
1 TO	4	.315571
1 TO	5	.640488

$\bar{x} = \frac{1}{5} \sum_{i=1}^5 x_i$ (----POA)

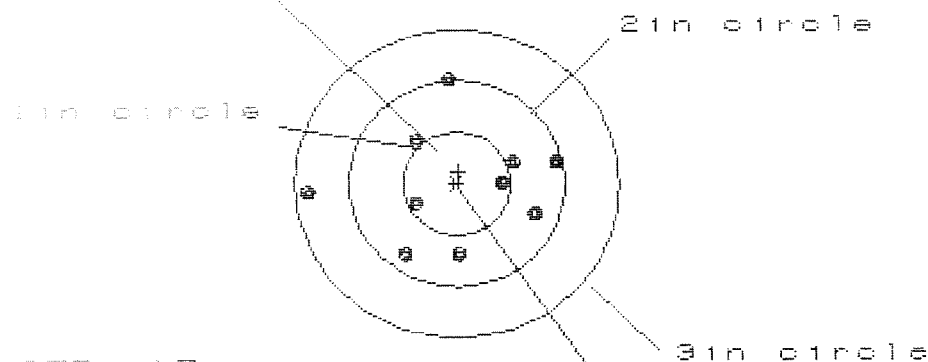
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .235
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .247796
THE AVE FOR THIS RIFLE IS: .689

01 12 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6522252

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

GS= 2.309

VS= 1.705

GS= 2.323

CENTROID #

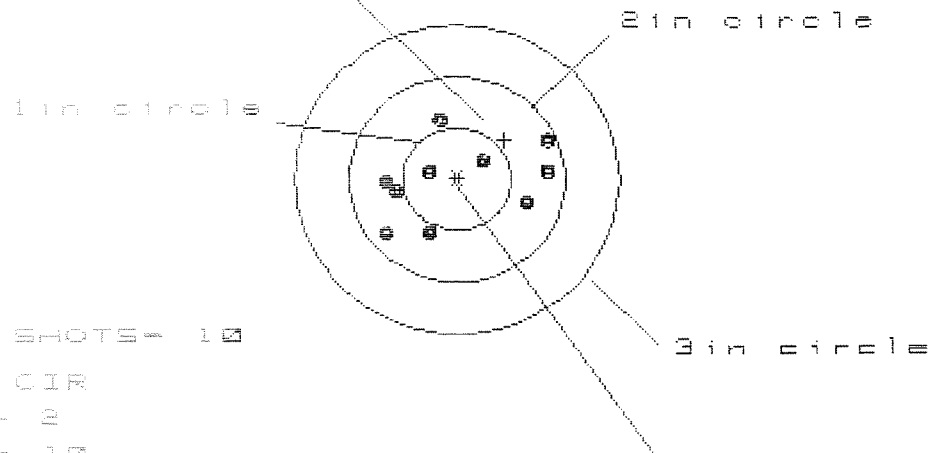
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.805	.778
MINIMUM X	:	-1.354	-.658	-.685
MAXIMUM Y	:	1.009	1.004	.563
MINIMUM Y	:	-.696	-.701	-.576
CENTROID X	:	-.019	.132	.159
CENTROID Y	:	-.115	-.110	-.236
FOR TO CENTROID in.	:	.116	.172	.284
MIN RADIUS	:	.392	.310	.302
MEAN RADIUS	:	.772	.688	.634
MAX RADIUS	:	1.354	1.028	.877
HORIZONTAL SPREAD	:	2.309	1.463	1.463
VERTICAL SPREAD	:	1.705	1.705	1.138
EXTREME SPREAD	:	2.323	1.733	1.709
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

POA



% OF SHOTS - 10

IN CIR

1 in = 2

2 in = 10

3 in = 10

ME = 1.487

VE = 1.145

GE = 1.727

CENTROID *

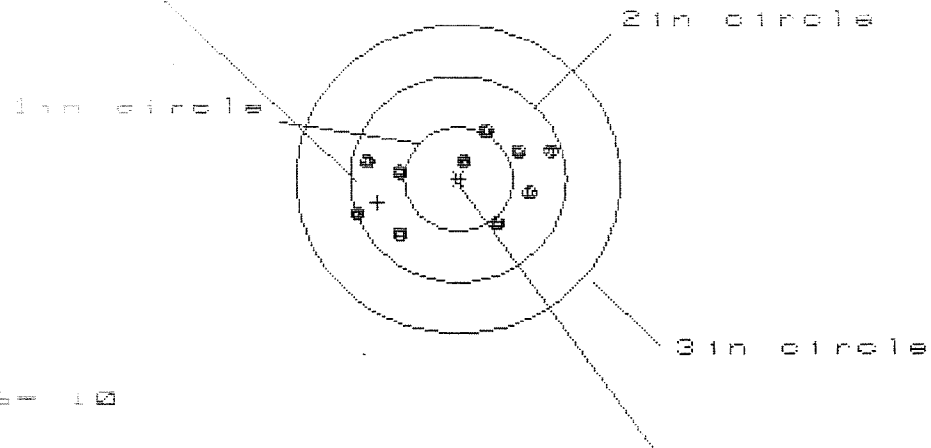
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.832	.922	.816
MINIMUM X	:	-.655	-.565	-.450
MAXIMUM Y	:	.613	.660	.672
MINIMUM Y	:	-.532	-.485	-.473
CENTROID X	:	-.440	-.530	-.645
CENTROID Y	:	-.381	-.428	-.441
POA TO CENTROID in.	:	.582	.681	.781
MIN RADIUS	:	.294	.234	.166
MEAN RADIUS	:	.628	.582	.515
MAX RADIUS	:	.913	.927	.829
HORIZONTAL SPREAD	:	1.487	1.487	1.266
VERTICAL SPREAD	:	1.145	1.145	1.145
EXTREME SPREAD	:	1.727	1.584	1.299
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 10

3in = 10

HS = 1.886

VS = .993

GS = 1.911

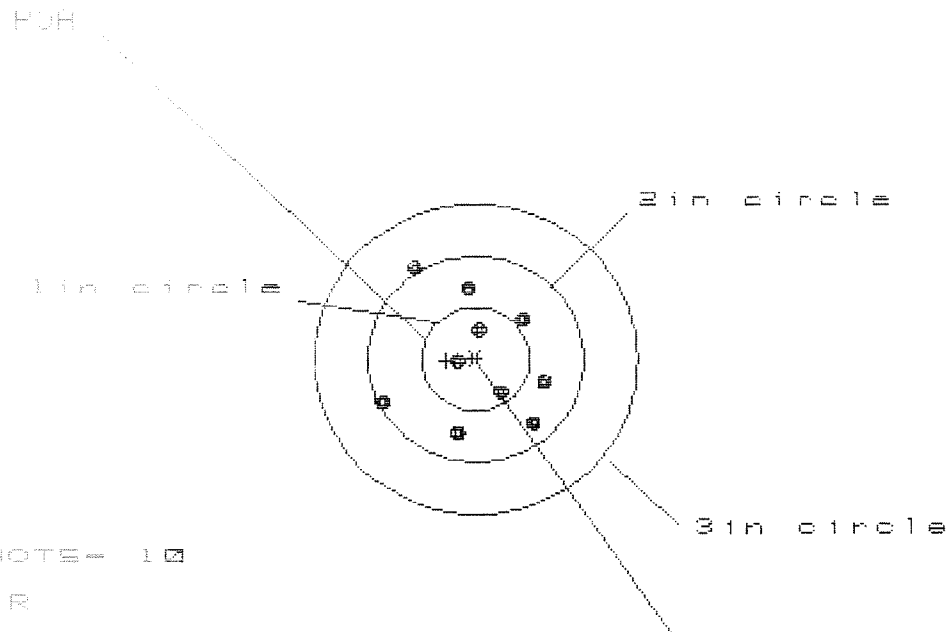
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.891	.789	.621
MINIMUM X	-.915	-.963	-.864
MAXIMUM Y	.475	.433	.459
MINIMUM Y	-.518	-.560	-.534
CENTROID X	.744	.846	.747
CENTROID Y	.229	.271	.245
POB TO CENTROID in.	.779	.888	.786
MIN RADIUS	.190	.135	.174
MEAN RADIUS	.659	.603	.583
MAX RADIUS	.989	.976	.884
HORIZONTAL SPREAD	1.806	1.752	1.485
VERTICAL SPREAD	.993	.993	.993
EXTREME SPREAD	1.911	1.753	1.523
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.509

VS= 1.573

GS= 1.850

CENTROID *

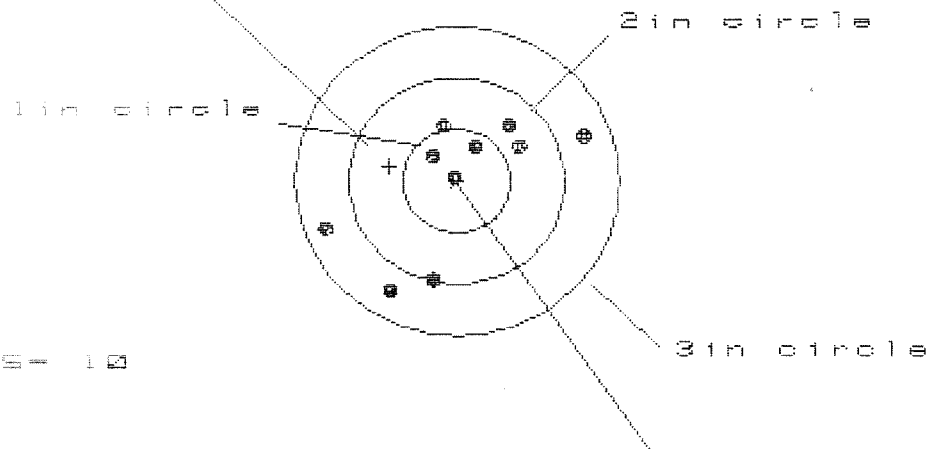
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.650	.586	.471
MINIMUM X	:	-.859	-.923	-.385
MAXIMUM Y	:	.881	.772	.732
MINIMUM Y	:	-.692	-.594	-.634
CENTROID X	:	.269	.333	.448
CENTROID Y	:	.014	-.084	-.044
POB TO CENTROID in.	:	.270	.343	.450
MIN RADIUS	:	.215	.249	.241
MEAN RADIUS	:	.642	.588	.532
MAX RADIUS	:	1.050	.976	.779
HORIZONTAL SPREAD	:	1.509	1.509	.856
VERTICAL SPREAD	:	1.573	1.366	1.366
EXTREME SPREAD	:	1.850	1.564	1.417
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.427

VS= 1.589

GS= 2.603

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.062	.547
MINIMUM X	:	-1.229	-.756	-.623
MAXIMUM Y	:	.544	.493	.548
MINIMUM Y	:	-1.045	-1.096	-1.041
CENTROID X	:	.621	.757	.624
CENTROID Y	:	-.140	-.089	-.144
POB TO CENTROID in.	:	.636	.762	.641
MIN RADIUS	:	.017	.132	.020
MEAN RADIUS	:	.744	.670	.606
MAX RADIUS	:	1.310	1.331	1.214
HORIZONTAL SPREAD	:	2.427	1.818	1.170
VERTICAL SPREAD	:	1.589	1.589	1.589
EXTREME SPREAD	:	2.603	2.377	1.909
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

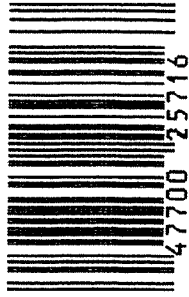
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6522252	39
ORDER NO. 5716	



5716 C6522252

UPC



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