

C6522244

MODEL 700TM M24

Model **SMS**TM

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

ENGINEER

ENGINEER

23

8/6/90

8/6/90

8/6/90

MOD.		GA. CAL.	GUN #
#	TEST	DATE	MALFUNCTION/DEFECT
	1st		Mag. loads harder 5th rd
	2nd		100100 10 10 10000 10 10 10000 10 10
	3rd		
	4th		

ASSEM. #

RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522244

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/90	KA
600	Proof		6/25/90	KA
607	Check Headspace		6/25/90	KA
610	Dis-assemble Gun		6/25/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	SL
617	Drill and Tap Sight Holes		7/11/90	LB
618	Polish Barrel <i>PB</i>		7/13/90	WB
620	Apply Coatings (Barrel Action)		7/23/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/24/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/26/90	KA
	C) Inspect Ejector Hole for Chamfer		7/26/90	KA
	D) Oil Firing Pin Ass'y		7/26/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/90	KA

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	7/12/90	JH		
	G) Safety Off Force	3	3	3	7/27/90	JH		
	H) Trigger Pull Test & Retainability				8/22/90	JH		
	I) Firing Pin Indent	.023	.023	.023	7/27/90	JH		
	J) Assemble Stock				7/27/90	KH		
	K) Assemble Swivel Studs				8/22/90	JS		
	L) Attach Front and Rear Sight Assemblies				7/27/90	KH		
	M) Iron Sight Alignment				7/27/90	KH		
	N) Detach Front & Rear Sights & place in numbered container				7/27/90	KH		
	O) Attach Scope to Rifle				7/27/90	KH		
	P) Detach & Attach Scope 20 Times				7/27/90	KS		
640	Gallery Target & Test				7-30-90	DH		
	A) Time				"	DH		
	B) Malfunctions				"	DH		
	C) Pierced Primers				"	DH		
	D) Optical Clarity of Scope				"	DH		
645	Inspect for Live Ammo				7-30-90	DH		
655	Final Inspection							
	A) Headspace				8/22/90	JS		
	B) Trigger Pull	2.36	2.27	2.37	2.37	2.40	8/22/90	JH
	C) Function						8/22/90	JS
660	Pack						8/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6522244

DATE 8/22/90

TESTER J. L.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.26	2.40	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.25	2.33	2.27	
PULL #3	2.11	2.21	2.34	2.37	
PULL #4	2.20	2.20	2.32	2.37	
PULL #5	2.21	2.22	2.30	2.40	
TOTAL	11.00	11.14	11.69	11.77	
AVG.	2.2	2.228	2.338	2.354	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.43		
PULL #2	3.37	3.44		
PULL #3	3.35	3.44		
PULL #4	3.38	3.44		
PULL #5	3.41	3.43		
TOTAL	16.91	17.18		
AVG.	3.382	3.436		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.44		4.45
PULL #2	4.36	4.42		4.44
PULL #3	4.42	4.35		4.44
PULL #4	4.42	4.44		4.37
PULL #5	4.43	4.47		4.48
TOTAL	22.08	22.12		22.18
AVG.	4.416	4.424		4.436

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522244
30 Jul 1990

CENTROIDAL DISTANCES

0 TO 1	.370601
1 TO 2	.398664
1 TO 3	.585671
1 TO 4	.157433
1 TO 5	.31737

⁴
351 <----POA

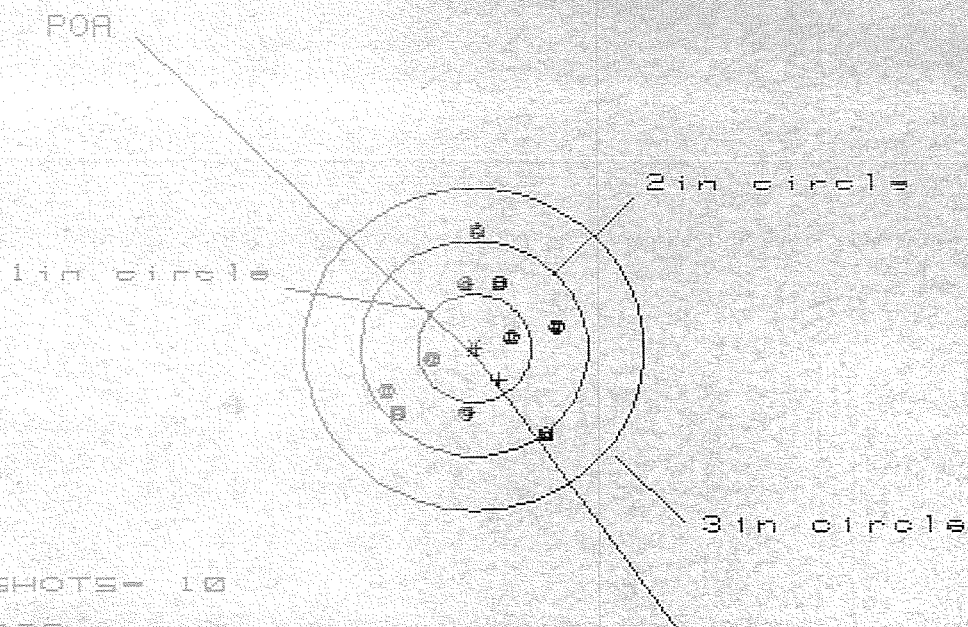
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3768
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1202
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .395508
THE AMR FOR THIS RIFLE IS: .6068

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522244

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.478

VS= 1.896

GS= 1.965

CENTROID #

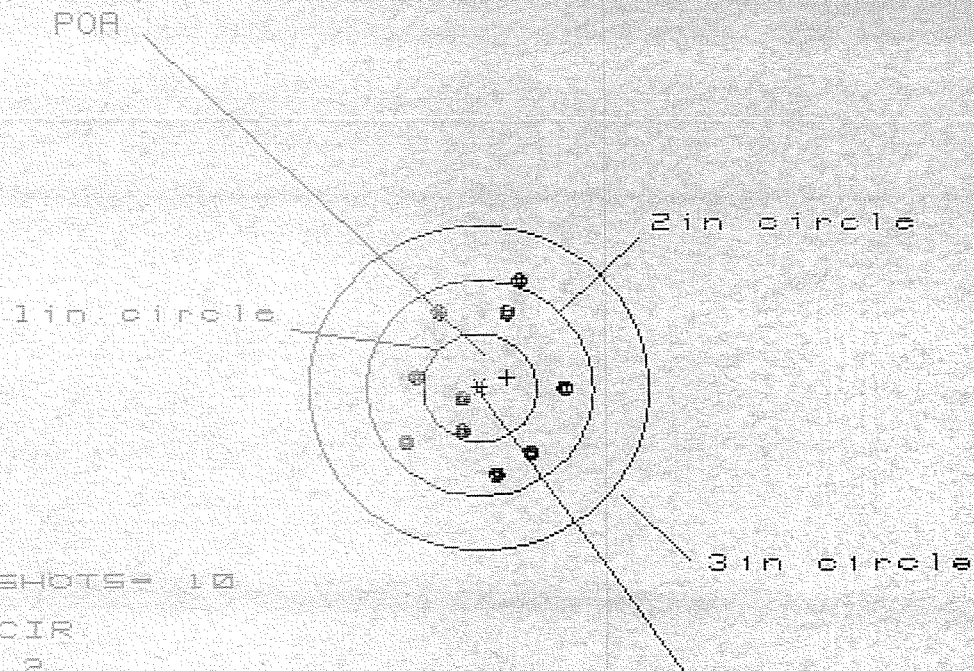
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.708	.714	.788
MINIMUM X	-.770	-.764	-.690
MAXIMUM Y	1.069	.726	.638
MINIMUM Y	-.827	-.709	-.609
CENTROID X	-.223	-.229	-.303
CENTROID Y	.296	.178	.266
POA TO CENTROID in.	.371	.290	.403
MIN RADIUS	.332	.329	.249
MEAN RADIUS	.715	.674	.631
MAX RADIUS	1.070	.919	.834
HORIZONTAL SPREAD	1.478	1.478	1.478
VERTICAL SPREAD	1.896	1.435	1.247
EXTREME SPREAD	1.965	1.612	1.612
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522244

CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.410

VS= 1.786

GS= 1.806

CENTROID #

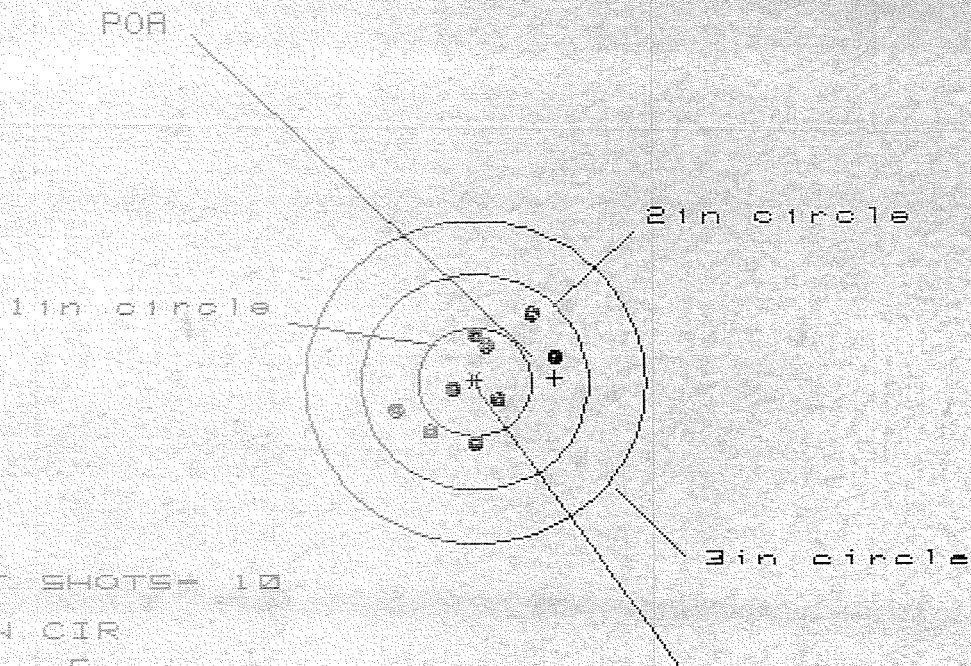
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.709	.751	.668
MINIMUM X	:	-.701	-.659	-.554
MAXIMUM Y	:	.970	.802	.756
MINIMUM Y	:	-.817	-.709	-.755
CENTROID X	:	-.246	-.288	-.205
CENTROID Y	:	-.102	-.210	-.165
POA TO CENTROID in.	:	.267	.356	.263
MIN RADIUS	:	.189	.105	.195
MEAN RADIUS	:	.675	.610	.603
MAX RADIUS	:	1.039	.869	.818
HORIZONTAL SPREAD	:	1.410	1.410	1.222
VERTICAL SPREAD	:	1.786	1.511	1.511
EXTREME SPREAD	:	1.806	1.543	1.543
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522244

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.428

VS= 1.220

GS= 1.494

CENTROID #

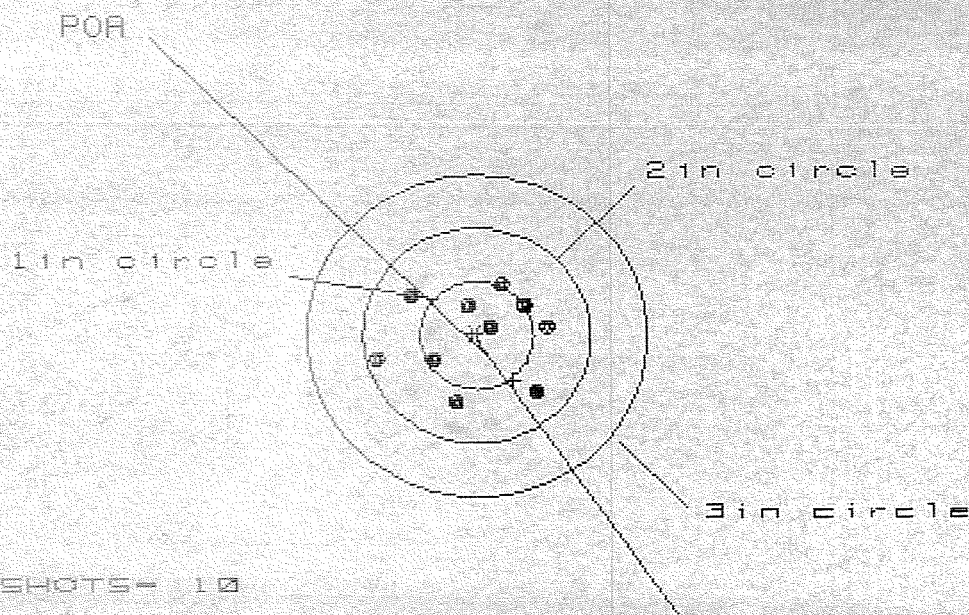
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.746	.799	.319
MINIMUM X	:	-.682	-.629	-.529
MAXIMUM Y	:	.612	.515	.548
MINIMUM Y	:	-.608	-.540	-.506
CENTROID X	:	-.702	-.755	-.854
CENTROID Y	:	-.041	-.109	-.143
POA TO CENTROID in.	:	.704	.763	.866
MIN RADIUS	:	.157	.119	.042
MEAN RADIUS	:	.486	.442	.374
MAX RADIUS	:	.772	.841	.563
HORIZONTAL SPREAD	:	1.428	1.428	.849
VERTICAL SPREAD	:	1.220	1.055	1.055
EXTREME SPREAD	:	1.494	1.494	1.055
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	10		
NUMBER IN THREE INCH CIRCLE	=	10		

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522244

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 4

2in = 10

3in = 10

HS= 1.530

VS= 1.165

GS= 1.555

CENTROID #

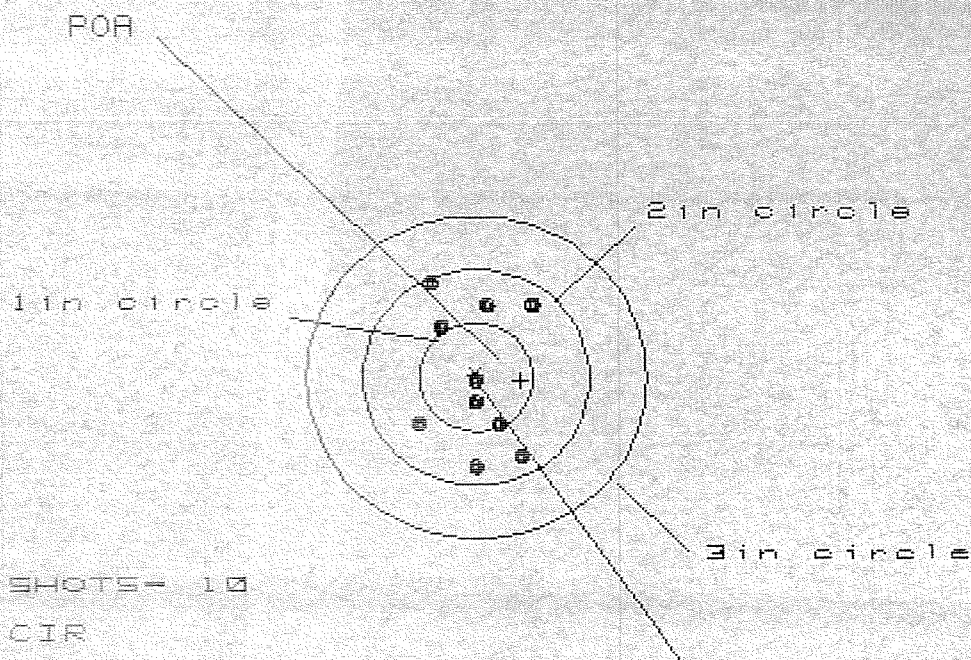
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.654	.557	.612
MINIMUM X	:	-.876	-.628	-.573
MAXIMUM Y	:	.501	.476	.408
MINIMUM Y	:	-.664	-.689	-.757
CENTROID X	:	-.320	-.223	-.278
CENTROID Y	:	.420	.445	.513
POA TO CENTROID in.	:	.528	.498	.584
MIN RADIUS	:	.168	.103	.076
MEAN RADIUS	:	.564	.510	.471
MAX RADIUS	:	.905	.735	.781
HORIZONTAL SPREAD	:	1.530	1.185	1.185
VERTICAL SPREAD	:	1.165	1.165	1.165
EXTREME SPREAD	:	1.555	1.414	1.238
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	10		
NUMBER IN THREE INCH CIRCLE	=	10		

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522244

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 4

2in = 10

3in = 10

HS= .941

VS= 1.727

GS= 1.834

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.450	.410	.457
MINIMUM X	:	-.491	-.531	-.484
MAXIMUM Y	:	.906	.756	.675
MINIMUM Y	:	-.821	-.720	-.801
CENTROID X	:	-.393	-.353	-.400
CENTROID Y	:	.028	-.073	.008
POA TO CENTROID in.	:	.394	.360	.400
MIN RADIUS	:	.025	.108	.033
MEAN RADIUS	:	.594	.543	.511
MAX RADIUS	:	.978	.860	.815
HORIZONTAL SPREAD	:	.941	.941	.941
VERTICAL SPREAD	:	1.727	1.476	1.476
EXTREME SPREAD	:	1.834	1.553	1.553
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	10		
NUMBER IN THREE INCH CIRCLE	=	10		




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

MODEL 700™ H24

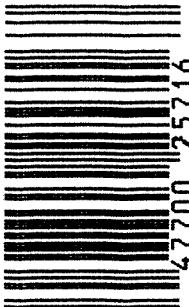
39

SERIAL NO.
C6522244

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6522244