

6522225

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522225

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	5 29	90	RW
610	Dis-assemble Gun	3 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	E.S.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel <i>AB</i>		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/2/90	71
	G) Safety Off Force	3	3	3			8/2/90	81
	H) Trigger Pull Test & Retainability						8/23/90	91
	I) Firing Pin Indent	.023	.023	.0235			8/2/90	81
	J) Assemble Stock						8/6/90	RW
	K) Assemble Swivel Studs						8/29/90	928
	L) Attach Front and Rear Sight Assemblies						8/6/90	RW
	M) Iron Sight Alignment						8/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/90	RW
	O) Attach Scope to Rifle						8/6/90	RW
	P) Detach & Attach Scope 20 Times						8/6/90	RW
640	Gallery Target & Test						8-6-90	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8-6-90	KT
655	Final Inspection							
	A) Headspace						8/29/90	928
	B) Trigger Pull	2.32	2.42	2.40	2.49	2.27	8/23/90	91
	C) Function						8/29/90	928
660	Pack						8/20/90	1F

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6522225

DATE 8/23/90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.27	2.40	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.24	2.42	2.42	
PULL #3	2.35	2.22	2.31	2.40	
PULL #4	2.29	2.26	2.42	2.49	
PULL #5	2.36	2.26	2.35	2.27	
TOTAL	11.68	11.25	11.91	11.90	
AVG.	2.336	2.25	2.382	2.38	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.20		
PULL #2	3.18	3.11		
PULL #3	3.22	3.12		
PULL #4	3.20	3.06		
PULL #5	3.21	3.13		
TOTAL	15.98	15.62		
AVG.	3.196	3.124		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.27		4.35
PULL #2	4.25	4.29		4.30
PULL #3	4.27	4.26		4.32
PULL #4	4.30	4.29		4.33
PULL #5	4.30	4.31		4.30
TOTAL	21.40	21.42		21.60
AVG.	4.28	4.284		4.32

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C652222⁵
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.212038
1 TO	2	.484955
1 TO	3	.221359
1 TO	4	.365274
1 TO	5	.589241

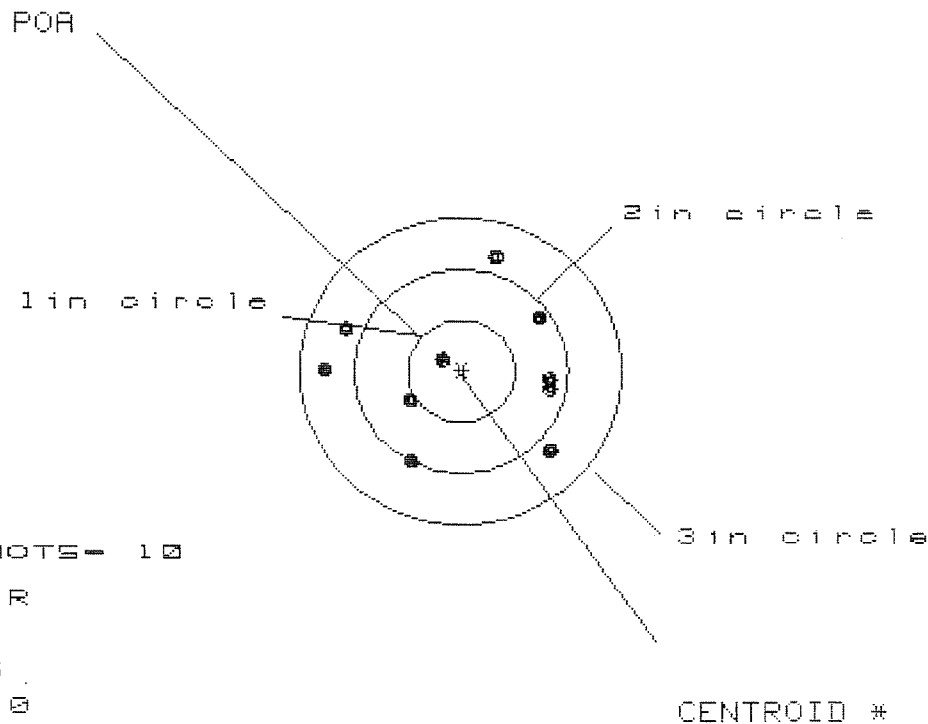
$\frac{4}{5} \cdot .132^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.08
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155378
THE AMR FOR THIS RIFLE IS: .8672

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522285

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.137

VS= 2.032

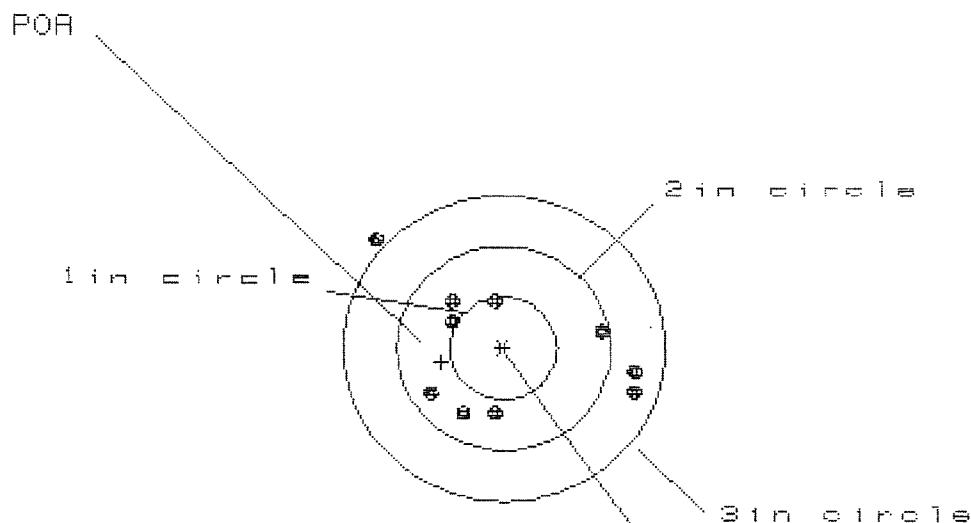
CS= 2.270

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.852	.710	.728
MINIMUM X	:	-1.284	-1.178	-1.159
MAXIMUM Y	:	1.132	1.130	.666
MINIMUM Y	:	-.900	-.902	-.761
CENTROID X	:	.172	.315	.296
CENTROID Y	:	-.124	-.122	-.263
POR TO CENTROID in.	:	.212	.338	.396
MIN RADIUS	:	.202	.332	.384
MEAN RADIUS	:	.897	.849	.806
MAX RADIUS	:	1.285	1.250	1.287
HORIZONTAL SPREAD	:	2.137	1.888	1.888
VERTICAL SPREAD	:	2.032	2.032	1.427
EXTREME SPREAD	:	2.270	2.240	2.240
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522225

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.473

VS= 1.717

GS= 2.876

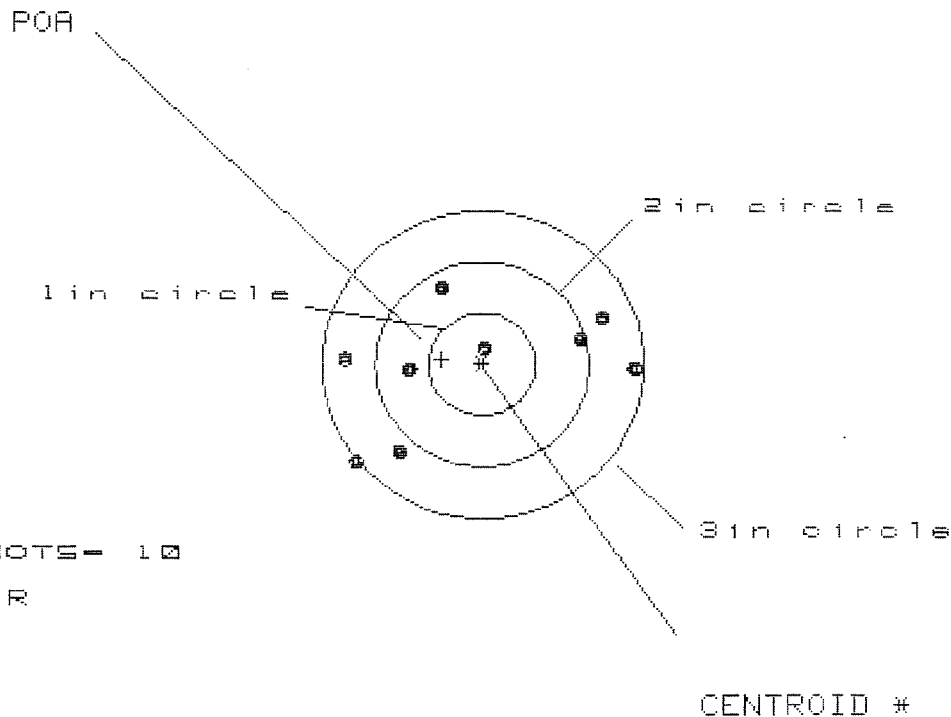
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.256	1.121	1.178
MINIMUM X	:	-1.217	-.788	-.648
MAXIMUM Y	:	1.058	.615	.578
MINIMUM Y	:	-.659	-.541	-.578
CENTROID X	:	.582	.717	.577
CENTROID Y	:	.135	.017	.054
POA TO CENTROID in.	:	.597	.717	.579
MIN RADIUS	:	.497	.538	.531
MEAN RADIUS	:	.884	.809	.736
MAX RADIUS	:	1.613	1.158	1.189
HORIZONTAL SPREAD	:	2.473	1.909	1.826
VERTICAL SPREAD	:	1.717	1.156	1.156
EXTREME SPREAD	:	2.876	1.914	1.841
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0652225

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.671

VS= 1.635

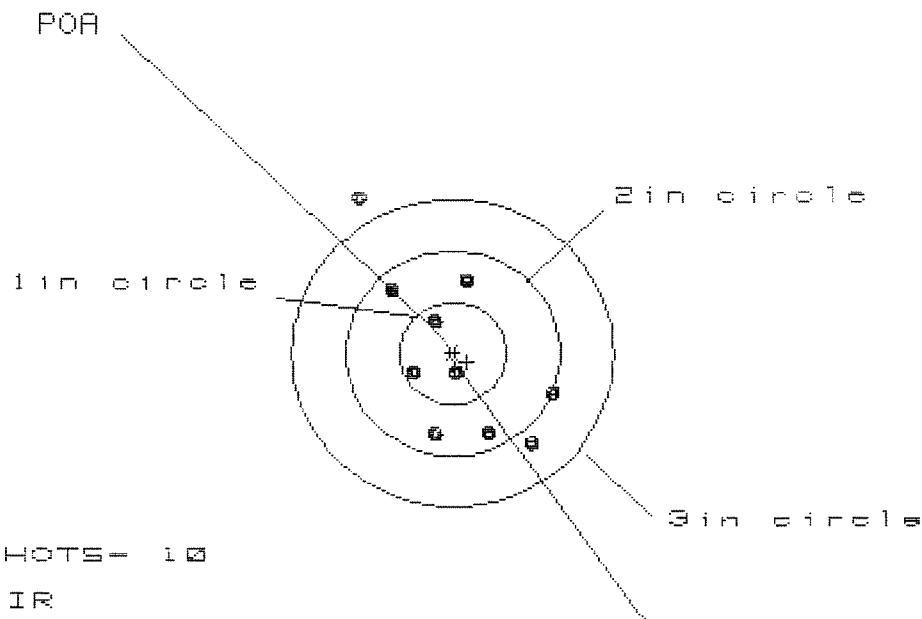
GS= 2.706

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.393	1.262	1.150
MINIMUM X	:	-1.278	-1.409	-1.252
MAXIMUM Y	:	.706	.602	.578
MINIMUM Y	:	-.929	-.909	-.933
CENTROID X	:	.382	.513	.356
CENTROID Y	:	-.054	.050	.074
POA TO CENTROID in.	:	.386	.516	.363
MIN RADIUS	:	.198	.175	.070
MEAN RADIUS	:	1.023	.951	.889
MAX RADIUS	:	1.503	1.412	1.256
HORIZONTAL SPREAD	:	2.671	2.671	2.402
VERTICAL SPREAD	:	1.635	1.511	1.511
EXTREME SPREAD	:	2.706	2.673	2.444
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522225

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.754

VS= 2.384

GS= 2.862

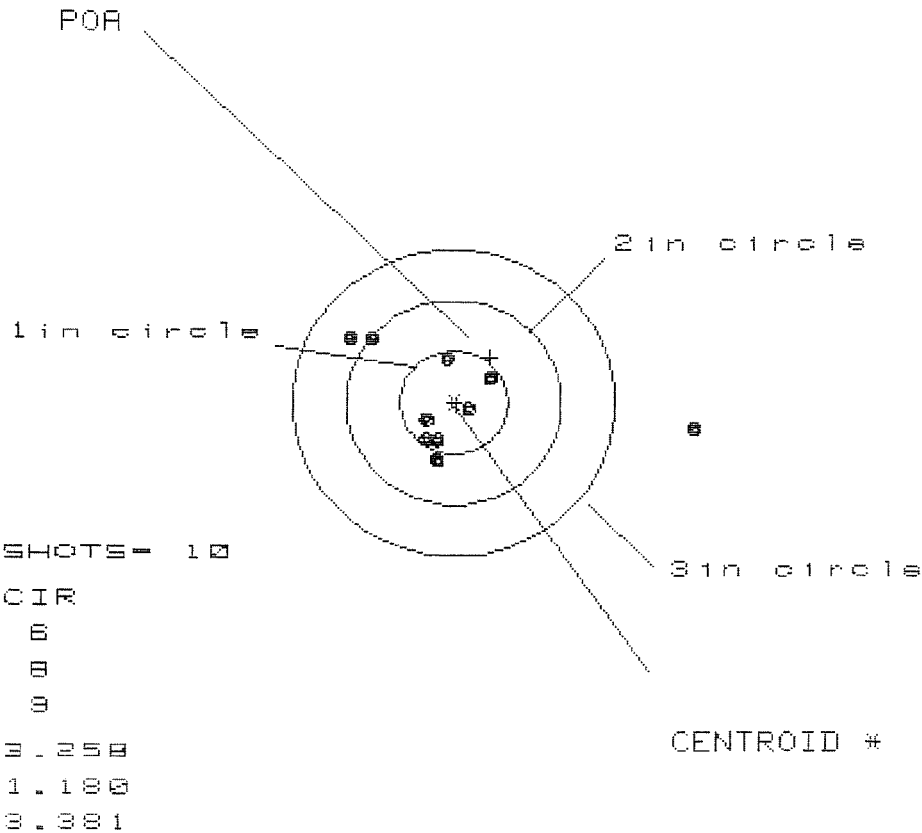
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.896	.801	.880
MINIMUM X	:	-.858	-.623	-.544
MAXIMUM Y	:	1.517	.901	.813
MINIMUM Y	:	-.867	-.698	-.716
CENTROID X	:	-.131	-.036	-.115
CENTROID Y	:	.080	-.089	-.001
POA TO CENTROID in.	:	.154	.096	.115
MIN RADIUS	:	.212	.121	.134
MEAN RADIUS	:	.801	.679	.635
MAX RADIUS	:	1.743	.970	.915
HORIZONTAL SPREAD	:	1.754	1.424	1.424
VERTICAL SPREAD	:	2.384	1.599	1.529
EXTREME SPREAD	:	2.862	1.910	1.688
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522225

CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.253	.608	.514
MINIMUM X	:	-1.005	-.755	-.584
MAXIMUM Y	:	.597	.563	.627
MINIMUM Y	:	-.583	-.617	-.547
CENTROID X	:	-.339	-.589	-.495
CENTROID Y	:	-.437	-.403	-.473
POR TO CENTROID in.	:	.553	.714	.685
MIN RADIUS	:	.171	.211	.190
MEAN RADIUS	:	.731	.541	.464
MAX RADIUS	:	2.274	.941	.857
HORIZONTAL SPREAD	:	3.258	1.363	1.098
VERTICAL SPREAD	:	1.180	1.180	1.174
EXTREME SPREAD	:	3.381	1.432	1.295
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®

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.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6522225

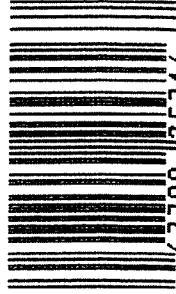
ORDER NO.
5716

Ø1



5716 C6522225

UPC



0 47700 25716 7