

C6522213

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522213

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	GB
617	Drill and Tap Sight Holes		8/10/90	KB
618	Polish Barrel <i>R13</i>		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/6/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/6/90	WB
	C) Inspect Ejector Hole for Chamfer		9/6/90	WB
	D) Oil Firing Pin Ass'y		9/6/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/6/90	WB
	G) Safety Off Force	3	3	3			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	WB
	I) Firing Pin Indent	.024	.0245	.0245			9/6/90	WB
	J) Assemble Stock						9/7/90	KS
	K) Assemble Swivel Studs						9/13/90	KS
	L) Attach Front and Rear Sight Assemblies						9/7/90	KS
	M) Iron Sight Alignment						9/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	KS
	O) Attach Scope to Rifle						9/7/90	KS
	P) Detach & Attach Scope 20 Times						9/7/90	KS
640	Gallery Target & Test						9-10-90	DH
	A) Time						9-10-90	DH
	B) Malfunctions						9-10-90	DH
	C) Pierced Primers						9-10-90	DH
	D) Optical Clarity of Scope						9-10-90	DH
645	Inspect for Live Ammo						9-10-90	DH
655	Final Inspection							
	A) Headspace						9/13/90	KS
	B) Trigger Pull	2.30	2.29	2.26	2.32	2.33	9-12-90	KS
	C) Function						9/13/90	KS
660	Pack						9/20/90	NF

MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	MALFUNCTION/DEFECT		
TEST	1st	safety hits stock		KS
	2nd	REPAIRED		KS 9/10/90
	3rd			
	4th			
		FUNCTION		RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522213

DATE 9/6/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.40	2.66	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.34	2.70	2.29	
PULL #3	2.47	2.46	2.72	2.26	
PULL #4	2.44	2.41	2.70	2.32	
PULL #5	2.46	2.50	2.69	2.33	
TOTAL	12.31	12.11	13.47	11.50	
AVG.	2.46	2.42	2.69	2.3	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.18		
PULL #2	3.18	3.16		
PULL #3	3.10	3.22		
PULL #4	3.12	3.22		
PULL #5	3.14	3.14		
TOTAL	15.72	15.92		
AVG.	3.14	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.09		4.28 ³
PULL #2	4.10	4.00		4.18
PULL #3	4.04	4.05		4.17
PULL #4	4.10	4.04		4.24
PULL #5	4.07	4.10		4.26
TOTAL	20.40	20.28		21.13
AVG.	4.08	4.05		4.22

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522213
10 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.0899444
1 TO	2	.519065
1 TO	3	.174195
1 TO	4	.515396
1 TO	5	.482412

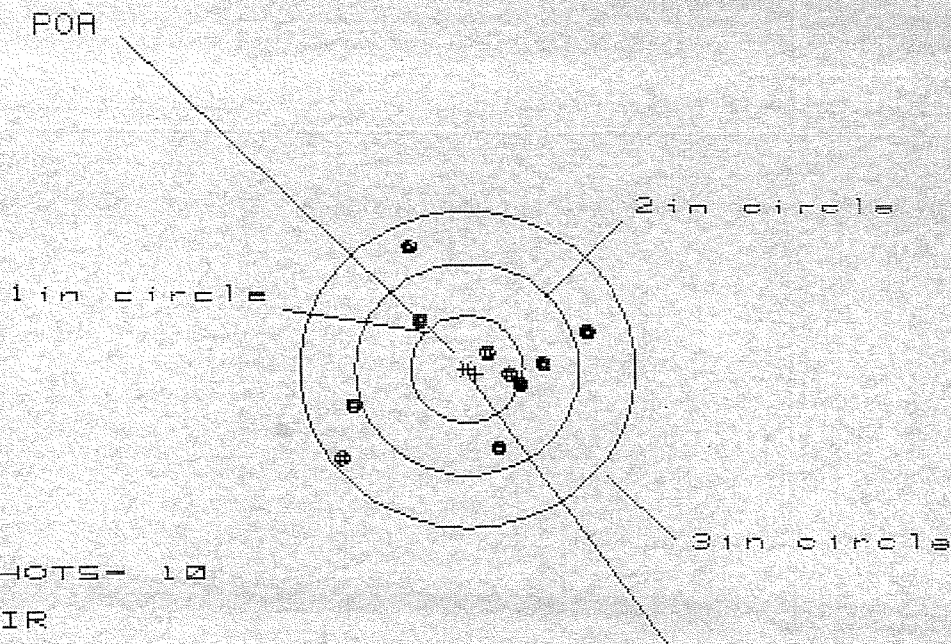
5
2 4
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.101
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .238266
THE AMR FOR THIS RIFLE IS: .8416

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522213

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.231

VS= 1.920

GS= 2.509

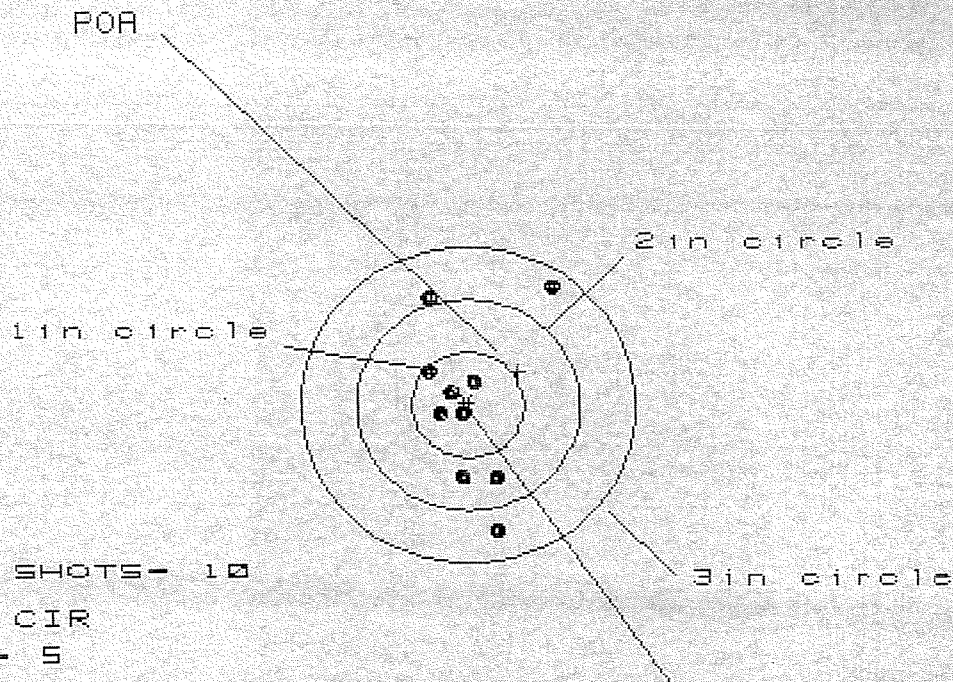
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	.955	.871
MINIMUM X	-1.149	-1.108	-1.192
MAXIMUM Y	1.110	1.020	.444
MINIMUM Y	-.810	-.864	-.737
CENTROID X	-.079	.048	.132
CENTROID Y	.043	.133	.006
POA TO CENTROID in.	.090	.142	.132
MIN RADIUS	.276	.127	.168
MEAN RADIUS	.806	.700	.609
MAX RADIUS	1.406	1.220	1.221
HORIZONTAL SPREAD	2.231	2.063	2.063
VERTICAL SPREAD	1.920	1.884	1.181
EXTREME SPREAD	2.509	2.160	2.160
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

10 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.044

VS= 2.264

GS= 2.312

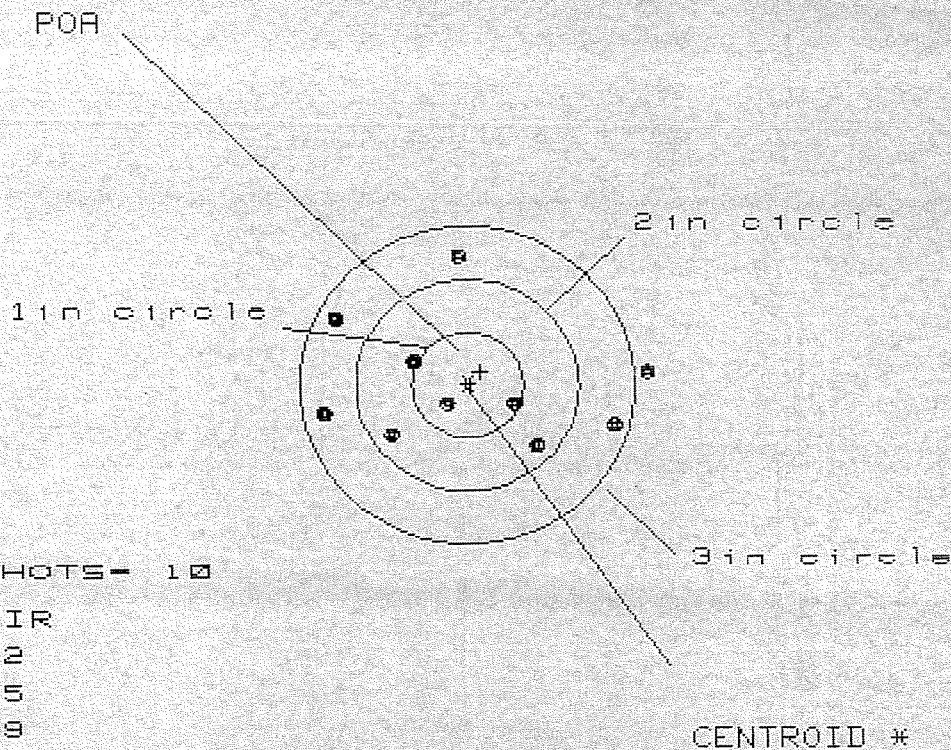
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.703	.328	.367
MINIMUM X	:	-.341	-.263	-.224
MAXIMUM Y	:	1.074	1.110	.976
MINIMUM Y	:	-1.190	-1.071	-.741
CENTROID X	:	-.451	-.529	-.568
CENTROID Y	:	-.319	-.438	-.304
POA TO CENTROID in.	:	.552	.687	.644
MIN RADIUS	:	.138	.016	.084
MEAN RADIUS	:	.627	.535	.444
MAX RADIUS	:	1.284	1.141	1.002
HORIZONTAL SPREAD	:	1.044	.591	.591
VERTICAL SPREAD	:	2.264	2.181	1.717
EXTREME SPREAD	:	2.312	2.255	1.739
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Sep 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.818

VS= 1.749

GS= 2.842

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.570	1.463	.957
MINIMUM X	:	-1.248	-1.074	-.891
MAXIMUM Y	:	1.201	1.209	1.161
MINIMUM Y	:	-.548	-.540	-.588
CENTROID X	:	-.117	-.291	-.474
CENTROID Y	:	-.127	-.135	-.087
POA TO CENTROID in.	:	.172	.321	.482
MIN RADIUS	:	.304	.216	.187
MEAN RADIUS	:	.961	.868	.770
MAX RADIUS	:	1.571	1.513	1.194
HORIZONTAL SPREAD	:	2.818	2.537	1.848
VERTICAL SPREAD	:	1.749	1.749	1.749
EXTREME SPREAD	:	2.842	2.677	2.146
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 2.391

VS= 2.627

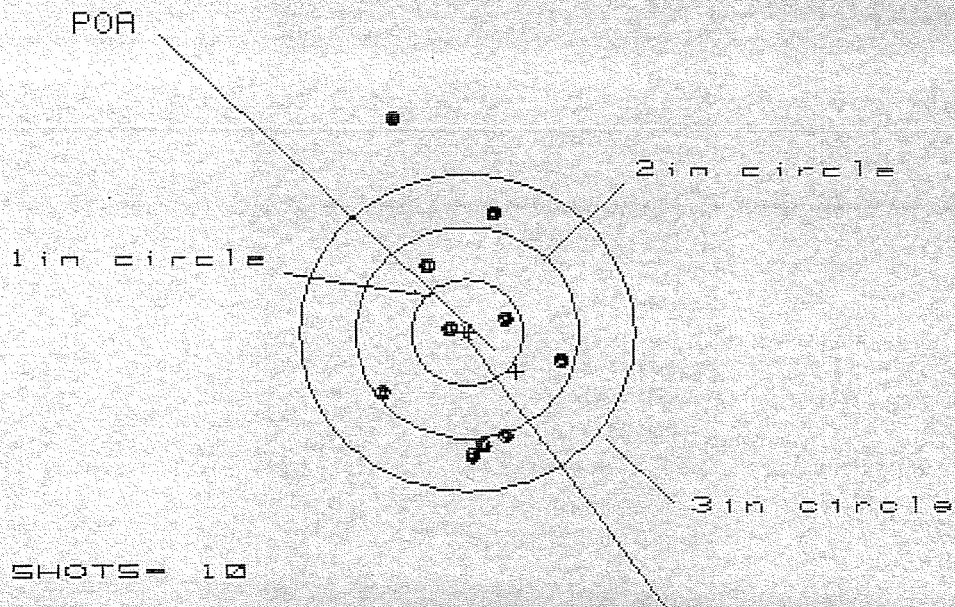
GS= 2.980

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.892	.725	.672
MINIMUM X	:	-1.499	-.698	-.751
MAXIMUM Y	:	1.139	1.050	.853
MINIMUM Y	:	-1.488	-1.577	-.745
CENTROID X	:	.008	.175	.228
CENTROID Y	:	-.465	-.376	-.179
POA TO CENTROID in.	:	.465	.415	.290
MIN RADIUS	:	.104	.208	.073
MEAN RADIUS	:	.828	.728	.605
MAX RADIUS	:	1.699	1.633	1.012
HORIZONTAL SPREAD	:	2.391	1.423	1.423
VERTICAL SPREAD	:	2.627	2.627	1.598
EXTREME SPREAD	:	2.980	2.818	1.858
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.601

VS= 3.270

GS= 3.352

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.790	.809
MINIMUM X	:	-.732	-.811	-.791
MAXIMUM Y	:	2.074	1.417	1.065
MINIMUM Y	:	-1.196	-.965	-.788
CENTROID X	:	-.440	-.361	-.380
CENTROID Y	:	.363	.132	-.045
POA TO CENTROID in.	:	.570	.384	.383
MIN RADIUS	:	.203	.363	.484
MEAN RADIUS	:	.986	.829	.739
MAX RADIUS	:	2.192	1.426	1.155
HORIZONTAL SPREAD	:	1.601	1.601	1.601
VERTICAL SPREAD	:	3.270	2.382	1.853
EXTREME SPREAD	:	3.352	2.391	1.899
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6522213

ORDER NO.
5716

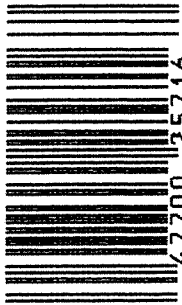
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