

C6522192

MODEL 700TH M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



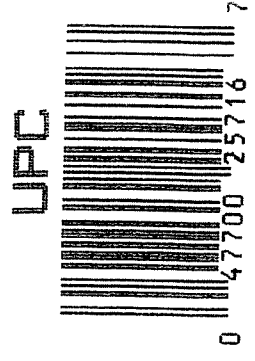
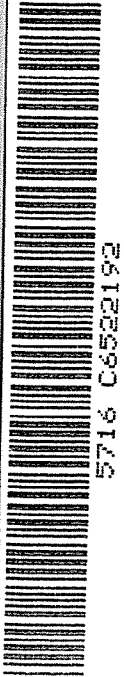

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

SERIAL NO.
C6522192

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

ORDER NO.
5716



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522192
5 Sep 1990

CENTROIDAL DISTANCES

0	TO	1	.394657
1	TO	2	.495435
1	TO	3	.281684
1	TO	4	.792571
1	TO	5	.497097

4
138 <----POA

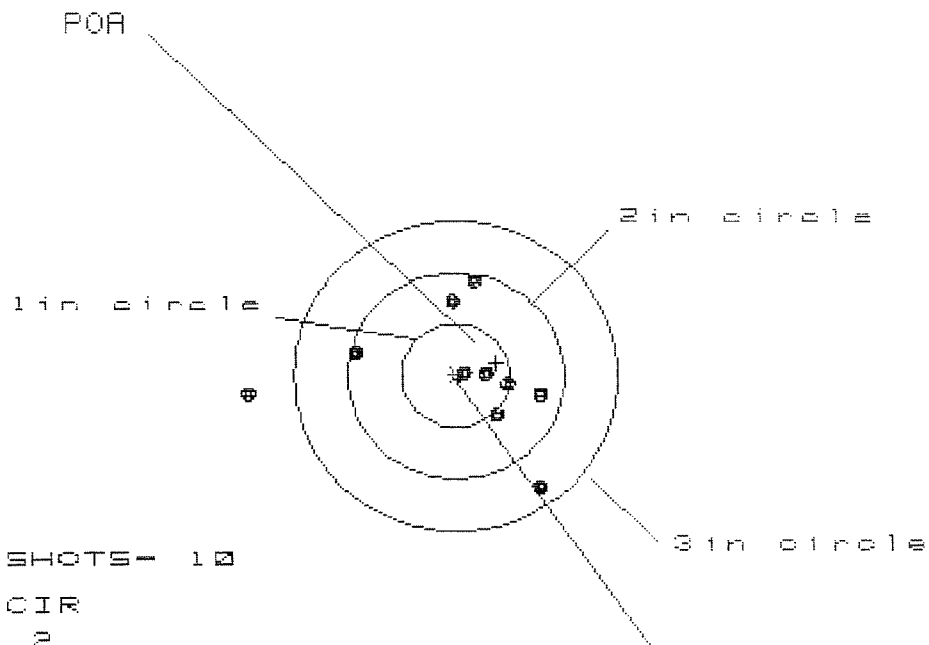
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1082
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142025
THE AMR FOR THIS RIFLE IS: .833

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522192

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 8

3 in - 9

HS= 2.678

VS= 1.975

GS= 2.830

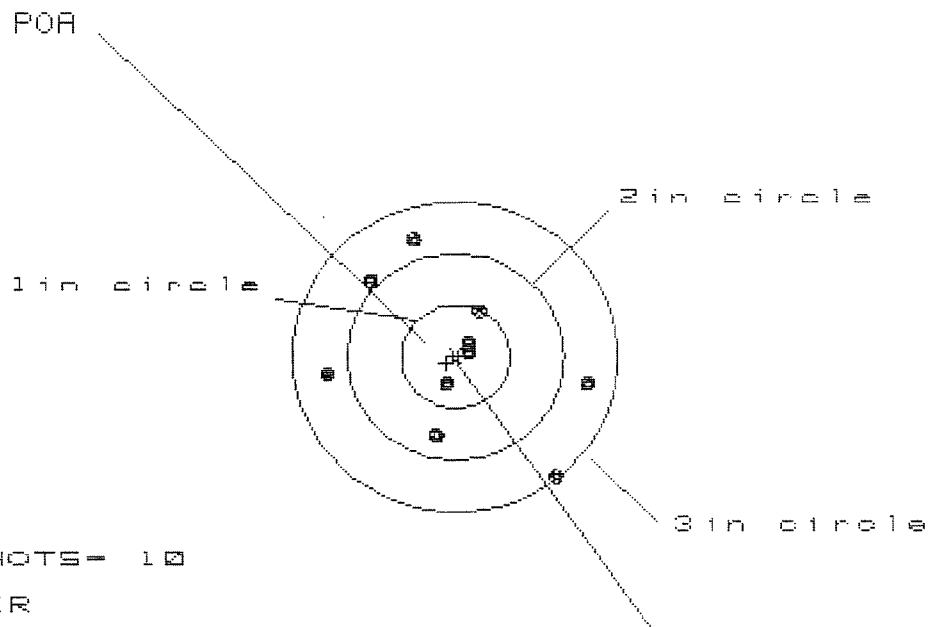
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.761	.548	.594
MINIMUM X	:	-1.917	-1.142	-1.073
MAXIMUM Y	:	.889	.870	.732
MINIMUM Y	:	-1.086	-1.105	-.497
CENTROID X	:	-.375	-.162	-.231
CENTROID Y	:	-.123	-.104	.034
POA TO CENTROID in.	:	.395	.193	.233
MIN RADIUS	:	.058	.069	.184
MEAN RADIUS	:	.797	.613	.559
MAX RADIUS	:	1.924	1.233	1.077
HORIZONTAL SPREAD	:	2.678	1.690	1.667
VERTICAL SPREAD	:	1.975	1.975	1.229
EXTREME SPREAD	:	2.830	2.156	1.712
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522192

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 10

HS= 2.387

VS= 2.282

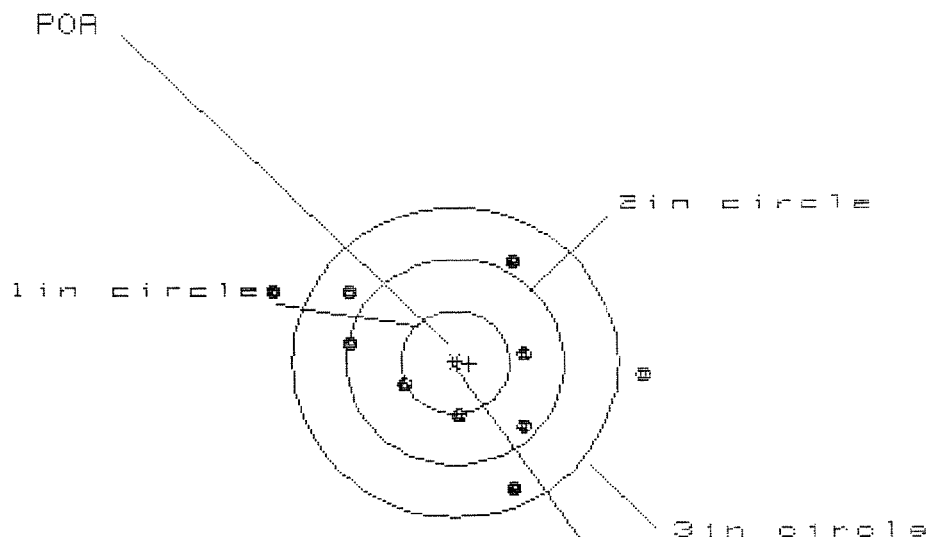
GS= 2.608

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.202	1.385	.478
MINIMUM X	:	-1.185	-1.082	-.919
MAXIMUM Y	:	1.164	1.040	.986
MINIMUM Y	:	-1.118	-.902	-.956
CENTROID X	:	.085	-.018	-.181
CENTROID Y	:	.061	.185	.239
POA TO CENTROID in.	:	.104	.186	.300
MIN RADIUS	:	.119	.224	.396
MEAN RADIUS	:	.810	.745	.692
MAX RADIUS	:	1.453	1.375	.989
HORIZONTAL SPREAD	:	2.387	2.387	1.397
VERTICAL SPREAD	:	2.282	1.942	1.942
EXTREME SPREAD	:	2.608	2.395	1.946
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522192

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.310

VS= 2.201

CS= 3.400

CENTROID #

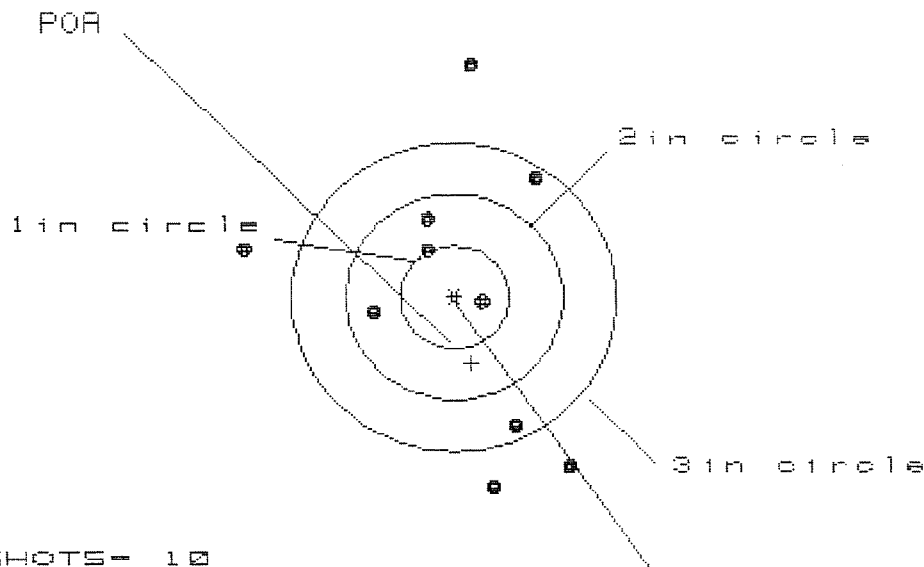
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.680	1.499	.612
MINIMUM X	:	-1.630	-1.139	-.952
MAXIMUM Y	:	1.008	1.081	1.074
MINIMUM Y	:	-1.192	-1.120	-1.127
CENTROID X	:	-.130	.051	-.136
CENTROID Y	:	.016	-.056	-.049
POA TO CENTROID in.	:	.131	.076	.145
MIN RADIUS	:	.480	.440	.414
MEAN RADIUS	:	1.046	.949	.869
MAX RADIUS	:	1.755	1.500	1.265
HORIZONTAL SPREAD	:	3.310	2.638	1.564
VERTICAL SPREAD	:	2.201	2.201	2.201
EXTREME SPREAD	:	3.400	2.738	2.398
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522192

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.021

VS= 4.126

GS= 4.129

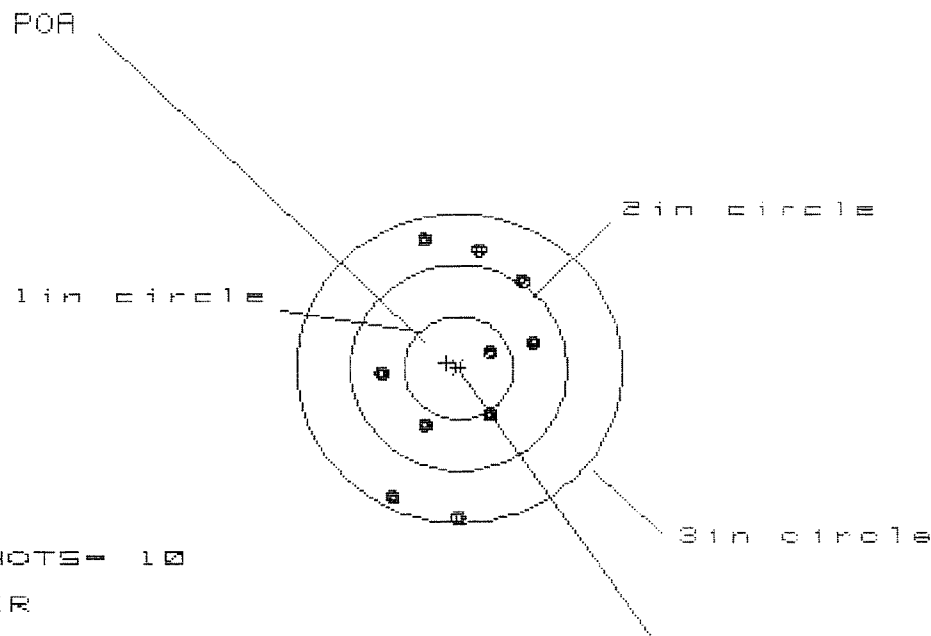
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	1.086	.844
MINIMUM X	:	-1.953	-1.935	-.922
MAXIMUM Y	:	2.239	1.395	1.479
MINIMUM Y	:	-1.887	-1.638	-1.554
CENTROID X	:	-.157	-.175	.067
CENTROID Y	:	.639	.390	.306
POA TO CENTROID in.	:	.658	.428	.313
MIN RADIUS	:	.273	.323	.252
MEAN RADIUS	:	1.311	1.218	1.111
MAX RADIUS	:	2.245	2.049	1.585
HORIZONTAL SPREAD	:	3.021	3.021	1.766
VERTICAL SPREAD	:	4.126	3.033	3.033
EXTREME SPREAD	:	4.129	3.651	3.070
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522192

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.410

VS= 2.654

GS= 2.678

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.675	.677	.602
MINIMUM X	:	-.735	-.733	-.808
MAXIMUM Y	:	1.216	1.056	.881
MINIMUM Y	:	-1.438	-1.398	-.860
CENTROID X	:	.117	.115	.190
CENTROID Y	:	-.052	.108	.283
POA TO CENTROID in.	:	.128	.158	.341
MIN RADIUS	:	.342	.284	.249
MEAN RADIUS	:	.930	.864	.763
MAX RADIUS	:	1.438	1.520	.974
HORIZONTAL SPREAD	:	1.410	1.410	1.410
VERTICAL SPREAD	:	2.654	2.454	1.741
EXTREME SPREAD	:	2.678	2.535	1.812
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. _____

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1					MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2					
PULL #3					
PULL #4					
PULL #5					
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522192

DATE 8/30/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.50	2.40	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.48	2.45	2.44	
PULL #3	2.50	2.49	2.46	2.45	
PULL #4	2.47	2.45	2.43	2.36	
PULL #5	2.49	2.45	2.40	2.44	
TOTAL	12.13	12.37	12.14	11.98	
AVG.	2.426	2.474	2.428	2.396	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.38		
PULL #2	3.43	3.43		
PULL #3	3.37	3.32		
PULL #4	3.30	3.37		
PULL #5	3.23	3.35		
TOTAL	16.69	16.85		
AVG.	3.338	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.24		4.18
PULL #2	4.25	4.08		4.08
PULL #3	4.23	4.28		4.23
PULL #4	4.20	4.30		4.29
PULL #5	4.24	4.27		4.30
TOTAL	21.16	21.17		21.08
AVG.	4.232	4.234		4.216

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522192

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	00	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	CS
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/12/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	EA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/90	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/30/90	WLB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			8/30/90	WLB
	H) Trigger Pull Test & Retainability						9/30/90	9/1
	I) Firing Pin Indent	.0215	.0215	.0215			8/30/90	WLB
	J) Assemble Stock						9/4/90	RW
	K) Assemble Swivel Studs						9/6/90	928
	L) Attach Front and Rear Sight Assemblies						9/4/90	RW
	M) Iron Sight Alignment						9/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	RW
	O) Attach Scope to Rifle						9/4/90	RW
	P) Detach & Attach Scope 20 Times						9/4/90	RW
640	Gallery Target & Test						9-4-90	K
	A) Time						9-4-90	K
	B) Malfunctions						9-4-90	K
	C) Pierced Primers						9-4-90	K
	D) Optical Clarity of Scope						9-4-90	K
645	Inspect for Live Ammo						9-4-90	K
655	Final Inspection							
	A) Headspace						9/6/90	928
	B) Trigger Pull	2.29	2.44	2.45	2.36	2.44	9-5-90	8/1
	C) Function						9/6/90	928
660	Pack						9/20/90	1F