

C6522183

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 6522183

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KJ
600	Proof		6/26/90	KJ
607	Check Headspace		6/26/90	KJ
610	Dis-assemble Gun		6/26/90	KJ
612	Magnaflux Barrel Action		7/10/90	K.R.
	Magnaflux Bolt		7/10/90	K.R.
615	Rollmark Caliber		7/10/90	L.L.
6177	Drill and Tap Sight Holes		7/11/90	RB
618	Polish Barrel RB		7/13/90	WB
6200	Apply Coatings (Barrel Action)		7-23-90	TA
	Apply Coating (Bolt)			
625	Final Assembly		7/30/90	K.A.
	A) Clean inside of Bolt Assembly		7/30/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/30/90	KJ
	C) Inspect Ejector Hole for Chamfer		7/30/90	KJ
	D) Oil Firing Pin Ass'y		7/30/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/90	PC

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/27/90	981
	G) Safety Off Force	3	3	3			7/27/90	980
	H) Trigger Pull Test & Retainability						8/22/90	981
	I) Firing Pin Indent	.0225	.0215	.022			7/27/90	981
	J) Assemble Stock						7/31/90	KA
	K) Assemble Swivel Studs						8/29/90	928
	L) Attach Front and Rear Sight Assemblies						7/31/90	KA
	M) Iron Sight Alignment						7/31/90	KA
	N) Detach Front & Rear Sights & place in numbered container						7/31/90	KA
	O) Attach Scope to Rifle						7/31/90	KA
	P) Detach & Attach Scope 20 Times						7/31/90	KA
640	Gallery Target & Test						8-1-90	AC
	A) Time						8-1-90	AC
	B) Malfunctions						8-1-90	AC
	C) Pierced Primers						8-1-90	AC
	D) Optical Clarity of Scope						8-1-90	AC
645	Inspect for Live Ammo						8-1-90	AC
655	Final Inspection							
	A) Headspace						8/29/90	928
	B) Trigger Pull	242	244	235	243	244	8/20/90	981
	C) Function						1/29/90	928
660	Pack						9/20/90	AF

Stock needs
repair around
trigger guard
area

SWS TRIGGER PULL TEST

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

SERIAL NO 06522183

DATE 8/20/90

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.48	2.45	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.42	2.44	2.44	
PULL #3	2.32	2.41	2.44	2.35	
PULL #4	2.36	2.41	2.51	2.43	
PULL #5	2.37	2.47	2.44	2.44	
TOTAL	11.82	12.11	12.28	12.08	
AVG.	2.364	2.422	2.456	2.416	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.38		
PULL #2	3.28	3.39		
PULL #3	3.34	3.37		
PULL #4	3.34	3.37		
PULL #5	3.33	3.35		
TOTAL	16.71	16.86		
AVG.	3.342	3.372		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.20		4.22
PULL #2	4.22	4.17		4.21
PULL #3	4.18	4.16		4.23
PULL #4	4.22	4.24		4.19
PULL #5	4.20	4.23		4.18
TOTAL	21.08	21.00		21.03
AVG.	4.216	4.2		4.206

CENTROIDAL DISTANCES

Ø TO	1	.0395601
1 TO	2	.530911
1 TO	3	.109275
1 TO	4	.0990051
1 TO	5	.0286531

←----FOR

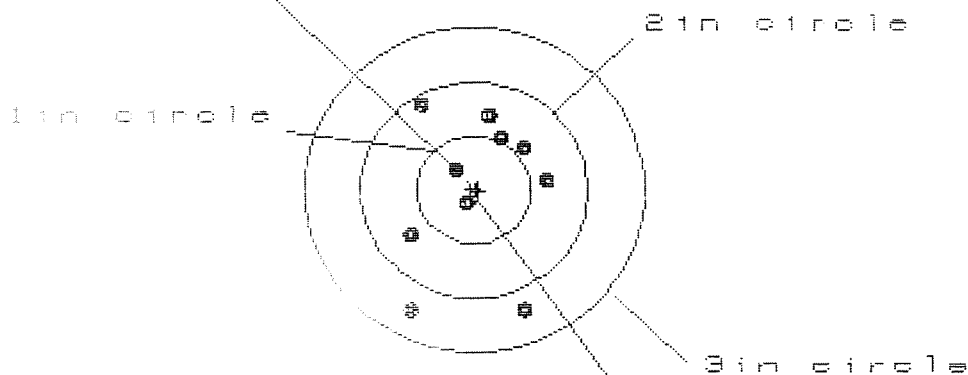
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1 Aug 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B3

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

CE = 1.223

VE = 1.858

CS = 2.154

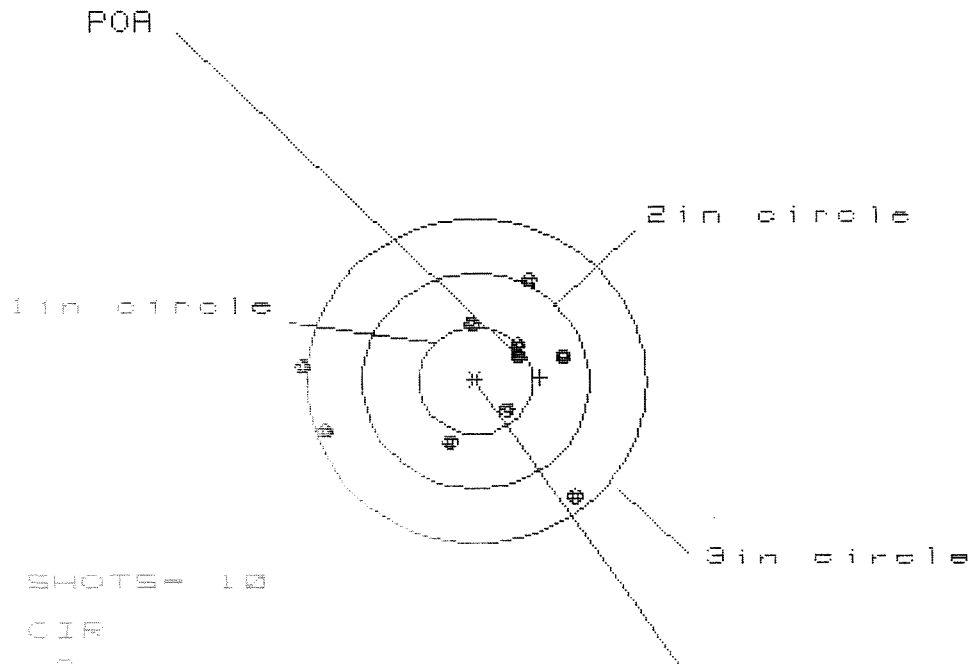
CENTROID #

PATTERN #	1	2	3
SHOTS - BEST OF	10	9	8
MAXIMUM X	1.616	1.542	1.590
MINIMUM X	-1.607	-1.917	-1.975
MAXIMUM Y	1.814	1.611	1.535
MINIMUM Y	1.111	-1.152	-1.675
CENTROID X	-0.211	1.030	-1.012
CENTROID Y	1.011	1.114	1.291
POA TO CENTROID DIST	1.013	1.311	1.292
MIP RADIUS	1.044	1.211	1.190
MEAN RADIUS	1.011	1.011	1.501
MAX RADIUS	1.111	1.111	1.887
HORIZONTAL SPREAD	1.111	1.111	1.165
VERTICAL SPREAD	1.111	1.111	1.210
EXTREME SPREAD	1.111	1.111	1.339
NUMBER IN ONE INCH CIRCLE	2	1	1
NUMBER IN TWO INCH CIRCLE	8	8	7
NUMBER IN THREE INCH CIRCLE	10	9	8

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522183

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

ME= 2.365

VS= 2.005

GS= 2.667

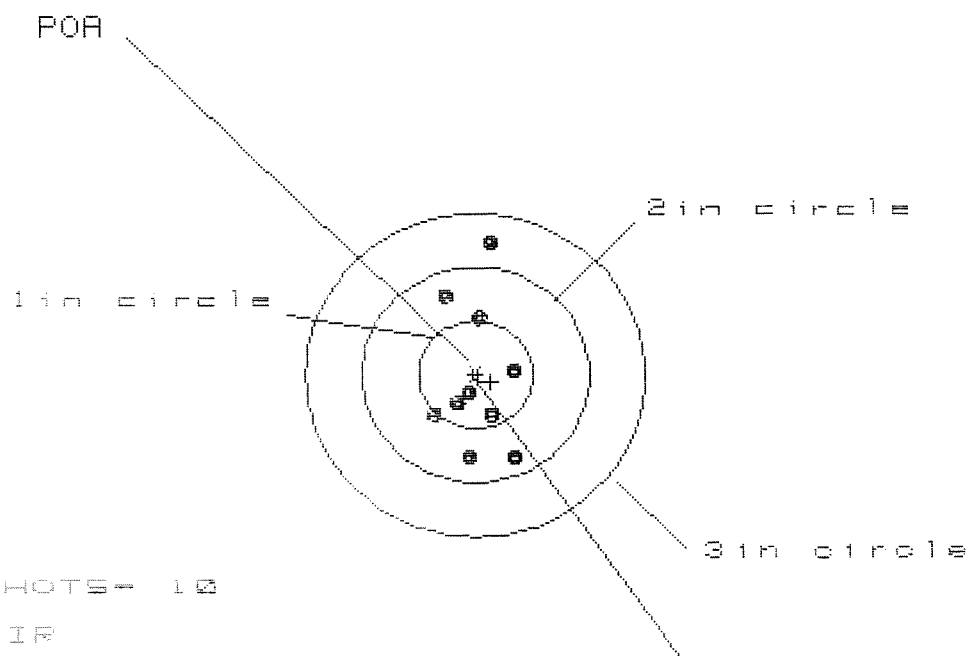
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.846	.678	.490
MINIMUM Y	:	-1.519	-1.505	-.544
MAXIMUM Y	:	.918	.934	.883
MINIMUM X	:	-1.087	-1.071	-1.122
CENTROID X	:	-.567	-.399	-.210
CENTROID Y	:	-.004	-.050	.001
POA TO CENTROID in.	:	.568	.402	.211
MIN RADIUS	:	.384	.270	.186
MEAN RADIUS	:	.855	.741	.601
MAX RADIUS	:	1.522	1.560	1.224
HORIZONTAL SPREAD	:	2.365	2.183	1.034
VERTICAL SPREAD	:	2.005	2.005	2.005
EXTREME SPREAD	:	2.667	2.261	2.050
NUMBER IN ONE INCH CIRCLE	=	3	2	1
NUMBER IN TWO INCH CIRCLE	=	6	4	2
NUMBER IN THREE INCH CIRCLE	=	9	7	4

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FILE:/PATTERNING/CENTERFIRE_PATT/085221B3

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= .769

VS= 2.036

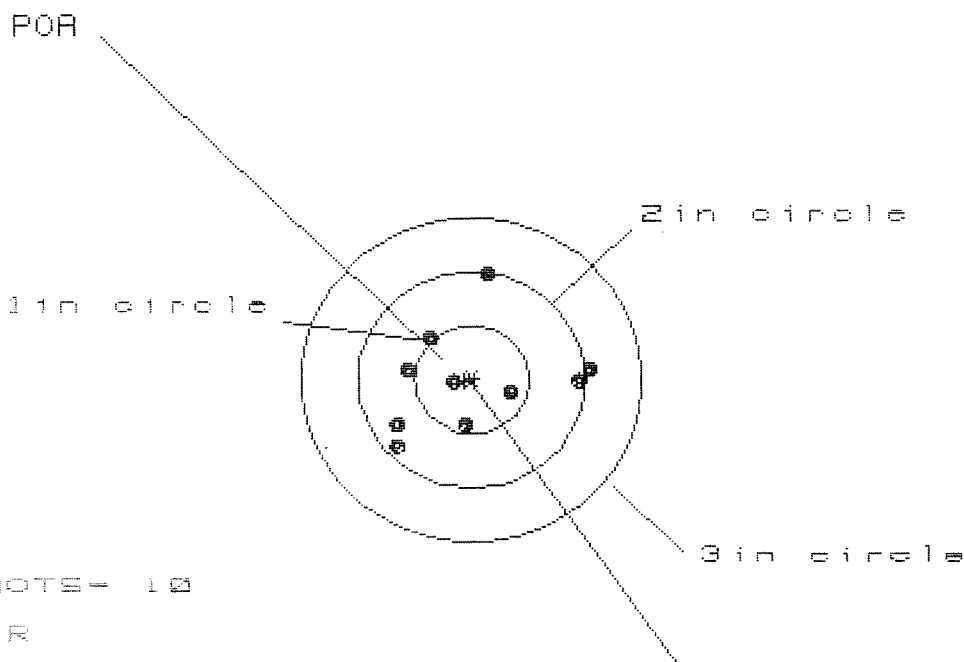
GS= 2.048

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.354	.364	.404
MINIMUM X	-.415	-.405	-.365
MAXIMUM Y	1.253	.872	.791
MINIMUM Y	-.783	-.643	-.701
CENTROID X	-.133	-.143	-.183
CENTROID Y	.065	-.075	.006
POA TO CENTROID in.	.148	.161	.183
MIN RADIUS	.129	.048	.059
MEAN RADIUS	.592	.483	.460
MAX RADIUS	1.256	.985	.817
HORIZONTAL SPREAD	.769	.769	.769
VERTICAL SPREAD	2.036	1.515	1.492
EXTREME SPREAD	2.048	1.615	1.505
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.746

VS= 1.571

GS= 1.895

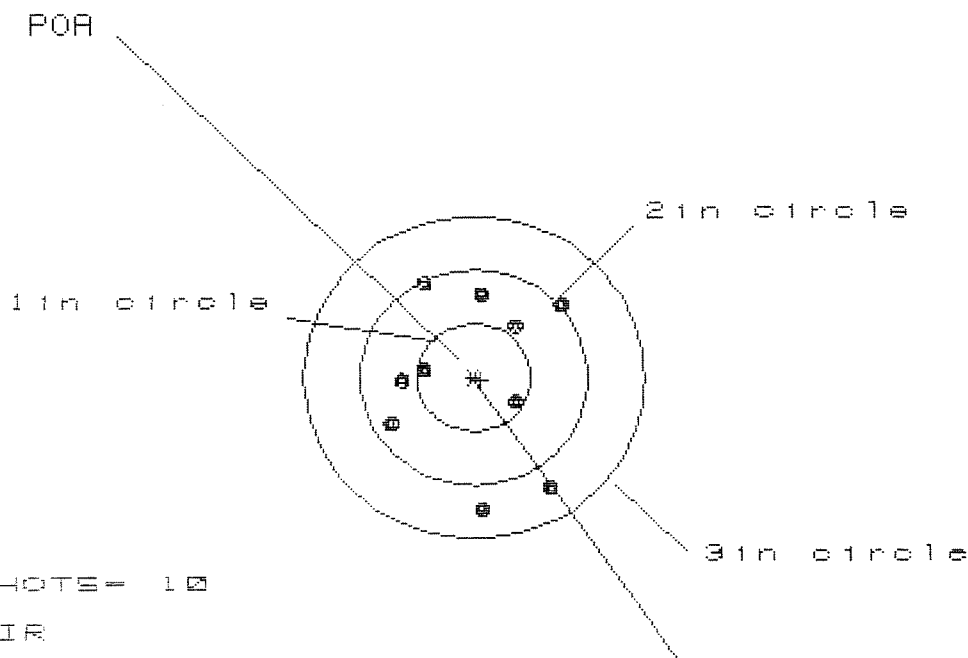
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.060	1.061	1.094
MINIMUM X	-.686	-.569	-.536
MAXIMUM Y	.960	.974	.556
MINIMUM Y	-.611	-.597	-.475
CENTROID X	.061	-.056	-.089
CENTROID Y	.012	-.002	-.124
POR TO CENTROID in.	.062	.056	.153
MIN RADIUS	.206	.091	.090
MEAN RADIUS	.668	.599	.531
MAX RADIUS	1.067	1.062	1.100
HORIZONTAL SPREAD	1.746	1.630	1.630
VERTICAL SPREAD	1.571	1.571	1.031
EXTREME SPREAD	1.895	1.778	1.731
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



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.441

VS = 2.093

GS = 2.259

CENTROID #

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.732	.805	.827
MINIMUM X	:	-.710	-.636	-.614
MAXIMUM Y	:	.904	.786	.623
MINIMUM Y	:	-1.189	-1.307	-.659
CENTROID X	:	-.063	-.136	-.158
CENTROID Y	:	.025	.143	.306
POA TO CENTROID in.	:	.067	.197	.344
MIN RADIUS	:	.396	.333	.391
MEAN RADIUS	:	.814	.747	.660
MAX RADIUS	:	1.253	1.318	.920
HORIZONTAL SPREAD	:	1.441	1.441	1.441
VERTICAL SPREAD	:	2.093	2.093	1.282
EXTREME SPREAD	:	2.259	2.164	1.789
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

Remington



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

MODEL 700™ H24

SERIAL NO.

C6522183

ORDER NO.

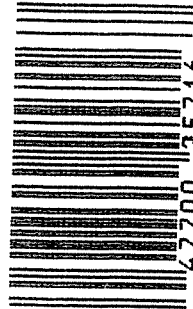
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MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



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UPC



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