

C6522283

MODEL 700TM N24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522283

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		9-31-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/90	WB
	G) Safety Off Force	3	3	3			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	.0235	.024	.024			9/10/90	WB
	J) Assemble Stock						9/10/90	KS
	K) Assemble Swivel Studs						9/15/90	JSB
	L) Attach Front and Rear Sight Assemblies						9/10/90	KS
	M) Iron Sight Alignment						9/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KS
	O) Attach Scope to Rifle						9/10/90	KS
	P) Detach & Attach Scope 20 Times						9/10/90	KS
640	Gallery Target & Test						9-12-90	DH
	A) Time						9-12-90	DH
	B) Malfunctions						9-12-90	DH
	C) Pierced Primers						9-12-90	DH
	D) Optical Clarity of Scope						9-12-90	DH
645	Inspect for Live Ammo						9-12-90	DH
655	Final Inspection							
	A) Headspace						9/15/90	JSB
	B) Trigger Pull	2.50	2.51	2.48	2.43	2.45	9-14-90	JSB
	C) Function						9/15/90	JSB
660	Pack						9/19/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522283

DATE 9/10/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.22	2.36	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.19	2.28	2.51	
PULL #3	2.25	2.17	2.37	2.48	
PULL #4	2.29	2.12	2.31	2.43	
PULL #5	2.25	2.14	2.27	2.45	
TOTAL	11.40	10.84	11.59	12.37	
AVG.	2.28	2.17	2.32	2.474	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.09		
PULL #2	3.11	3.00		
PULL #3	3.00	3.06		
PULL #4	3.01	3.03		
PULL #5	3.07	3.04		
TOTAL	15.29	15.22		
AVG.	3.06	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.19		4.01
PULL #2	4.33	4.16		3.98
PULL #3	4.12	4.12		4.05
PULL #4	4.00	4.17		4.02
PULL #5	3.90	4.07		4.06
TOTAL	20.64	20.71		20.12
AVG.	4.13	4.14		4.02

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6522283
 12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.27674
1 TO	2	.678012
1 TO	3	.39785
1 TO	4	.334718
1 TO	5	1.17516

$\frac{1}{43}$ <----POA
 $\frac{2}{5}$

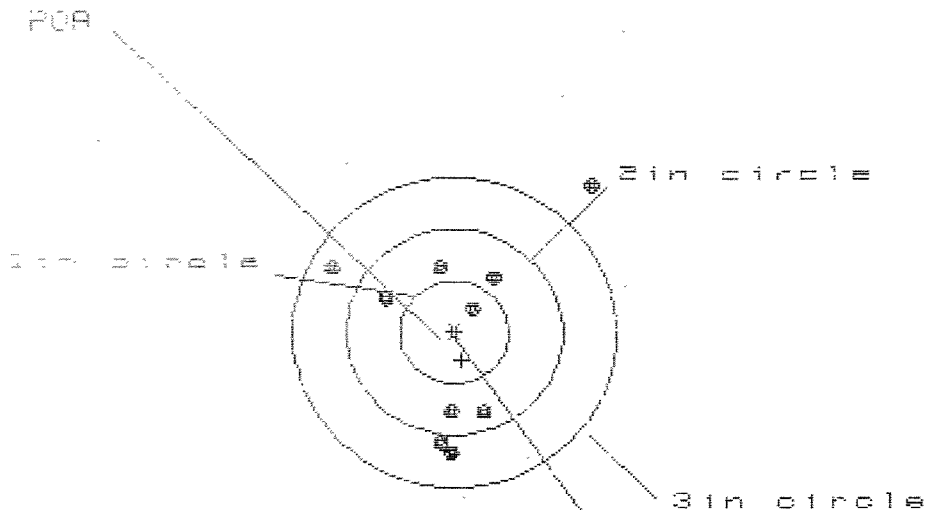
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .8678
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2888
 THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .219532
 THE AVERAGE Z-COORDINATE FOR THIS RIFLE IS: .8888

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65222B3

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CENTER

IN 1st

IN 2nd

IN 3rd

MEAN = 2.471

SD = 0.887

RC = 0.076

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.306	.548	.420
MINIMUM X	:	-1.165	-1.020	-.654
MAXIMUM Y	:	1.472	.786	.859
MINIMUM Y	:	-1.195	-1.022	-.924
CENTROID X	:	-.069	-.214	-.086
CENTROID Y	:	.268	.105	.007
FOR TO CENTROID in.	:	.277	.238	.086
FOR SPREAD	:	.310	.537	.459
FOR SPREAD	:	.941	.921	.742
FOR SPREAD	:	1.967	1.288	.924
HORIZONTAL SPREAD	:	2.471	1.568	1.074
VERTICAL SPREAD	:	2.657	1.908	1.783
CIRCULAR SPREAD	:	2.976	2.132	1.788
SHOTS IN ONE INCH CIRCLE	=		1	
SHOTS IN TWO INCH CIRCLE	=		6	
SHOTS IN THREE INCH CIRCLE	=		9	

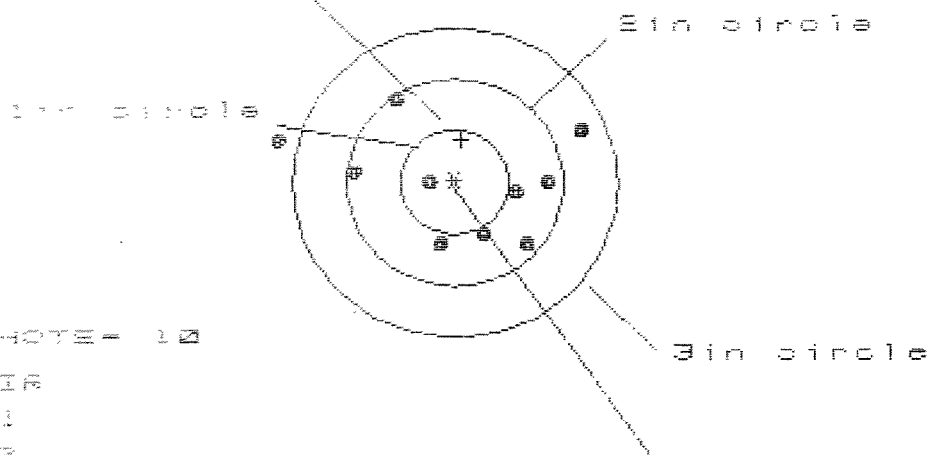
12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522263

CENTERFIRE PATTERNS

2

FOR



* OF SHOTS = 10

* IN CIR

1.0 = 1

2.0 = 7

3.0 = 9

CEX = 0.725

CEY = 1.475

CEZ = 2.788

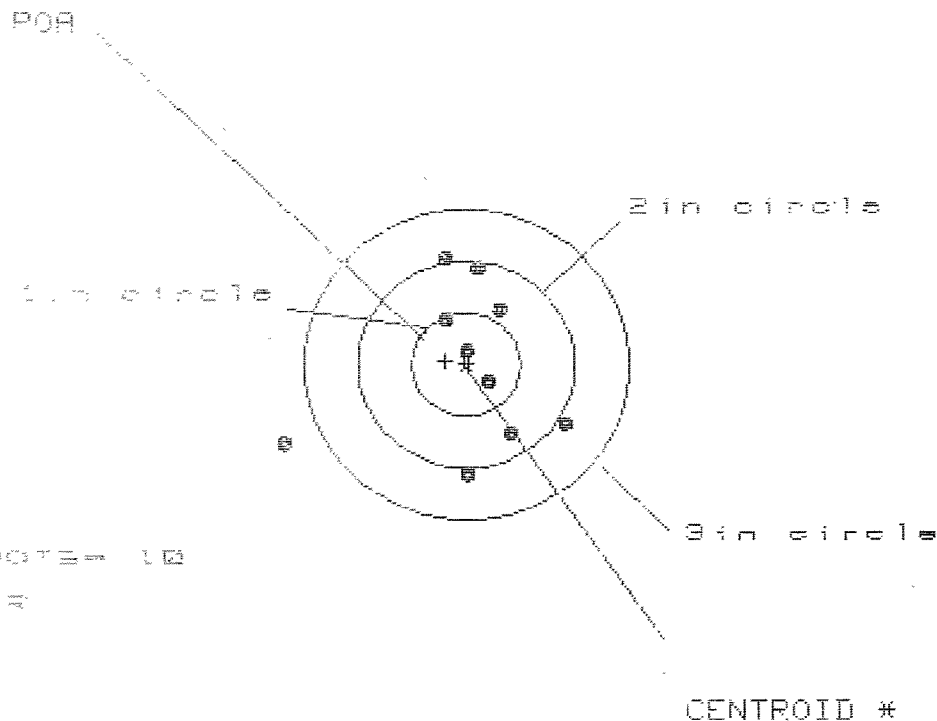
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.176	.997	.888
MINIMUM X	:	-1.611	-1.106	-.982
MAXIMUM Y	:	.858	.900	.966
MINIMUM Y	:	-.617	-.575	-.509
CENTROID X	:	-.065	.114	-.010
CENTROID Y	:	-.410	-.452	-.518
FOR TO CENTROID IN.	:	.415	.466	.518
HOR RADIUS	:	.288	.350	.375
VEA RADIUS	:	.866	.752	.696
OF RADIUS	:	1.656	1.162	1.142
HORIZONTAL SPREAD	:	2.787	2.103	1.790
VERTICAL SPREAD	:	1.475	1.475	1.475
OF SPREAD	:	2.788	2.142	1.936
WITH IN ONE INCH CIRCLE	=		1	
WITH IN TWO INCH CIRCLE	=		7	
WITH IN THREE INCH CIRCLE	=		9	

2 Sep 1988

FILE: PATTERNING/CENTERFIRE_PATT/C85222B3

CENTERFIRE PATTERNS # 3



* OF SPOTS = 10

OF CEN

1.0000

1.0000

1.0000

1.0000

1.0000

1.0000

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	.738	.355
MINIMUM X	:	-1.686	-.399	-.307
MAXIMUM Y	:	1.037	.957	.875
MINIMUM Y	:	-1.024	-1.104	-1.186
CENTROID X	:	.190	.378	.286
CENTROID Y	:	-.034	.046	.128
FOR TO CENTROID IN.	:	.194	.381	.313
MIN RADIUS	:	.165	.210	.116
MEAN RADIUS	:	.827	.688	.530
MAX RADIUS	:	1.835	1.122	1.191
HORIZONTAL SPREAD	:	2.612	1.137	.662
VERTICAL SPREAD	:	2.061	2.061	2.061
DIAGONAL SPREAD	:	2.618	2.071	2.071
SPOTS IN ONE INCH CIRCLE	=		3	
SPOTS IN TWO INCH CIRCLE	=		6	
SPOTS IN THREE INCH CIRCLE	=		9	

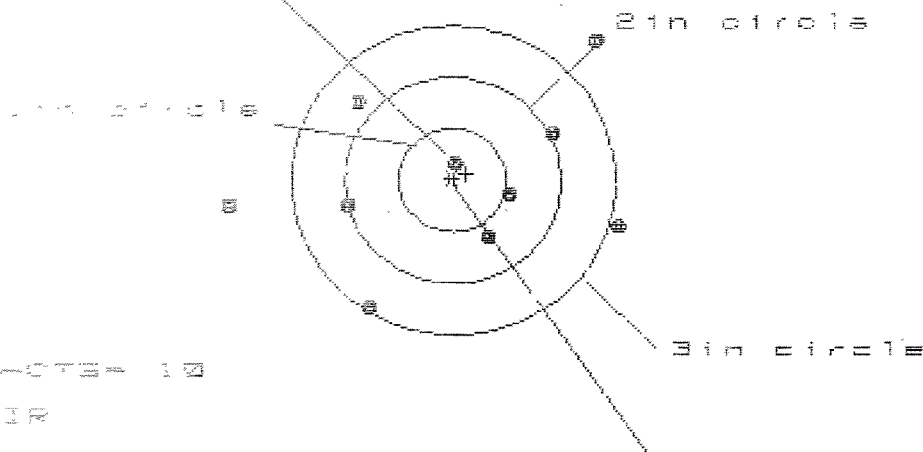
00 BPO 0000

FILE: PATTERNS/CENTERFIRE_PATT/C05222B3

CENTERFIRE PATTERNS

4

POA



NO OF SHOTS = 10

W. INCH

1.000

2.000

3.000

4.000

5.000

6.000

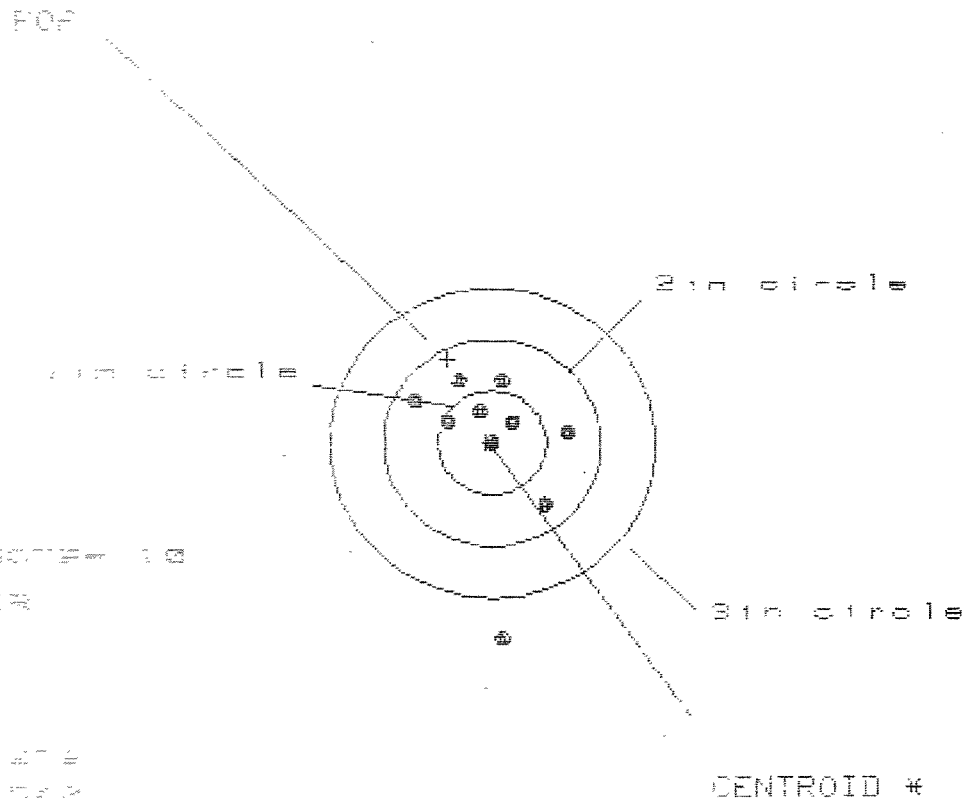
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.550	1.316	1.448
MINIMUM X	:	-2.105	-1.208	-1.076
MAXIMUM Y	:	1.331	1.300	.879
MINIMUM Y	:	-1.198	-1.229	-1.066
CENTROID X	:	-1.125	.109	-.023
CENTROID Y	:	-.062	-.031	-.194
POP TO CENTROID in.	:	.139	.113	.195
MR. RADIUS	:	.183	.234	.312
MRM RADIUS	:	1.146	1.007	.922
MR. RADIUS	:	2.123	1.673	1.475
HORIZONTAL SPREAD	:	3.655	2.524	2.524
VERTICAL SPREAD	:	2.529	2.529	1.945
CIRCULAR SPREAD	:	3.752	3.234	2.654
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

12 Jul 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C65222B3

CENTERFIRE PATTERNS # 5



NO OF SHOTS = 10

IN CIRC

1 in = 1

2 in = 2

3 in = 3

1 in = 1.276

2 in = 2.542

3 in = 3.813

PATTERN #		5		
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.644	.660	.570
MINIMUM X		-.732	-.716	-.469
MAXIMUM Y		.627	.415	.437
MINIMUM Y		-1.915	-.772	-.750
CENTROID X		.408	.392	.482
CENTROID Y		-.886	-.594	-.616
POF TO CENTROID in.		.902	.712	.792
MIN RADIUS		.062	.174	.137
MEAN RADIUS		.654	.474	.443
MR. RADIUS		1.920	.921	.855
HORIZONTAL SPREAD		1.376	1.376	1.039
VERTICAL SPREAD		2.542	1.187	1.187
EXTREME SPREAD		2.575	1.545	1.469
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	




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

MODEL 700™ H24

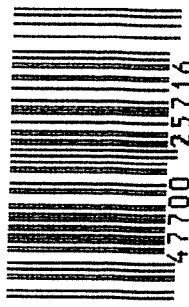
SERIAL NO.
C6522283

ORDER NO.
5716

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



5716 C6522283



0 47700 25716 7