

C6522285

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522285

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/9/90	Kd
600	Proof		7/9/90	Kd
607	Check Headspace		7/9/90	Kd
610	Dis-assemble Gun		7/9/90	Kd
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	ZL
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/17/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/90	KS
	C) Inspect Ejector Hole for Chamfer		8/17/90	KS
	D) Oil Firing Pin Ass'y		8/17/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-14-90	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			8/22/90	WLB
	G) Safety Off Force	2	2	2			8/20/90	WLB
	H) Trigger Pull Test & Retainability						9-14-90	96
	I) Firing Pin Indent	.023	.023	.023			8/22/90	WLB
	J) Assemble Stock						8/20/90	KS
	K) Assemble Swivel Studs						9/15/90	928
	L) Attach Front and Rear Sight Assemblies						8/20/90	KS
	M) Iron Sight Alignment						8/20/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	KS
	O) Attach Scope to Rifle						8/20/90	KS
	P) Detach & Attach Scope 20 Times						8/20/90	KS
640	Gallery Target & Test						8/21/90	NF
	A) Time						8/21/90	NF
	B) Malfunctions						8/21/90	NF
	C) Pierced Primers						8/21/90	NF
	D) Optical Clarity of Scope						8/21/90	NF
645	Inspect for Live Ammo						8/21/90	NF
655	Final Inspection							
	A) Headspace						9/15/90	928
	B) Trigger Pull	2.47	2.50	2.34	2.47	2.43	9-14-90	96
	C) Function						9/15/90	928
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. C6522285

DATE 9-14-90

TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.37	2.34	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.33	2.38	2.50	
PULL #3	2.37	2.36	2.43	2.34	
PULL #4	2.38	2.40	2.42	2.47	
PULL #5	2.38	2.34	2.29	2.43	
TOTAL	12.06	11.80	11.86	12.21	
AVG.	2.412	2.36	2.372	2.442	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.35		
PULL #2	3.13	3.26		
PULL #3	3.38	3.30		
PULL #4	3.36	3.33		
PULL #5	3.30	3.33		
TOTAL	16.33	16.57		
AVG.	3.266	3.314		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.29		4.28
PULL #2	4.13	4.05		4.34
PULL #3	4.14	4.34		4.36
PULL #4	4.42	4.15		4.21
PULL #5	4.31	4.12		4.34
TOTAL	21.13	21.05		21.53
AVG.	4.226	4.21		4.306

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522285
22 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.394203
1 TO	2	.655355
1 TO	3	.132593
1 TO	4	1.02085
1 TO	5	.393022

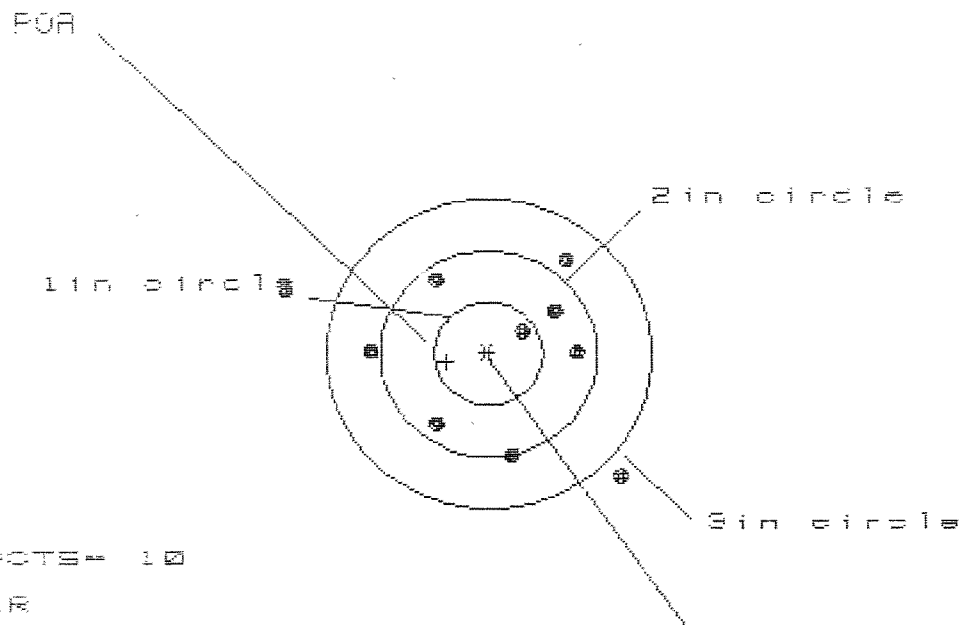
4
2
44 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0756
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2724
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .282696
THE AMR FOR THIS RIFLE IS: .8732

21 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C85222B5

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

MEAN = 2.002

STD = 2.539

GB = 6.539

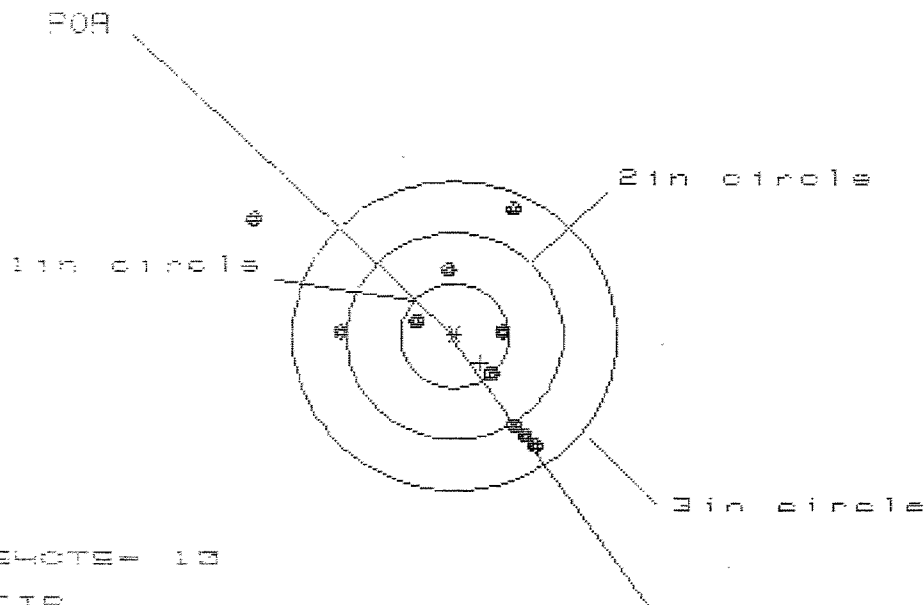
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.202	.996	.749
MINIMUM X	-1.060	-1.255	-1.131
MAXIMUM Y	.893	.961	.825
MINIMUM Y	-1.160	-1.092	-1.029
CENTROID X	.386	.592	.468
CENTROID Y	.080	.012	.148
POA TO CENTROID (in)	.394	.592	.491
1IN RADIUS	.347	.293	.240
MEAN RADIUS	1.044	.915	.832
MAX RADIUS	1.958	1.478	1.131
HORIZONTAL SPREAD	3.062	2.251	1.880
VERTICAL SPREAD	2.053	2.053	1.854
EXTREME SPREAD	3.539	2.558	1.975
SHOTS IN ONE INCH CIRCLE =	1		
SHOTS IN TWO INCH CIRCLE =	6		
SHOTS IN THREE INCH CIRCLE =	8		

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C85222B5

CENTERFIRE PATTERNS # 2



* OF SHOTS= 13

* IN CIR

1in = 2

2in = 8

3in = 9

ME = 2.824

MS = 2.828

POE = 2.476

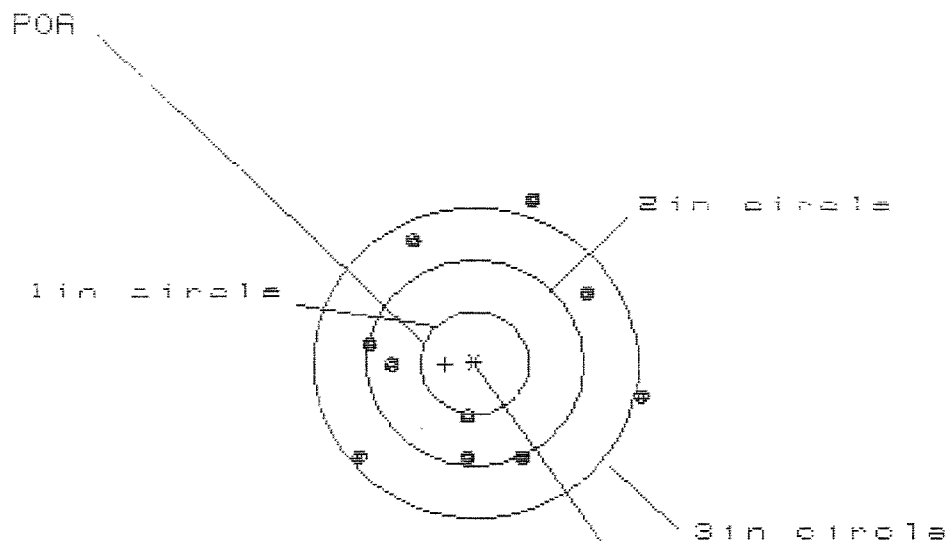
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.793	.589	.629
MINIMUM X	:	-1.831	-1.244	-1.204
MAXIMUM Y	:	1.248	1.379	.912
MINIMUM Y	:	-1.091	-.960	-.788
CENTROID X	:	-.245	-.041	-.081
CENTROID Y	:	.257	.126	-.046
POA TO CENTROID in.	:	.355	.133	.093
MIN RADIUS	:	.413	.284	.191
MEAN RADIUS	:	1.008	.840	.754
MAX RADIUS	:	2.178	1.415	1.246
HORIZONTAL SPREAD	:	2.624	1.833	1.833
VERTICAL SPREAD	:	2.339	2.339	1.700
EXTREME SPREAD	:	3.476	2.355	2.142
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

21 Aug 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C652E2B5

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

100 = 2.562

100 = 2.545

100 = 2.562

CENTROID *

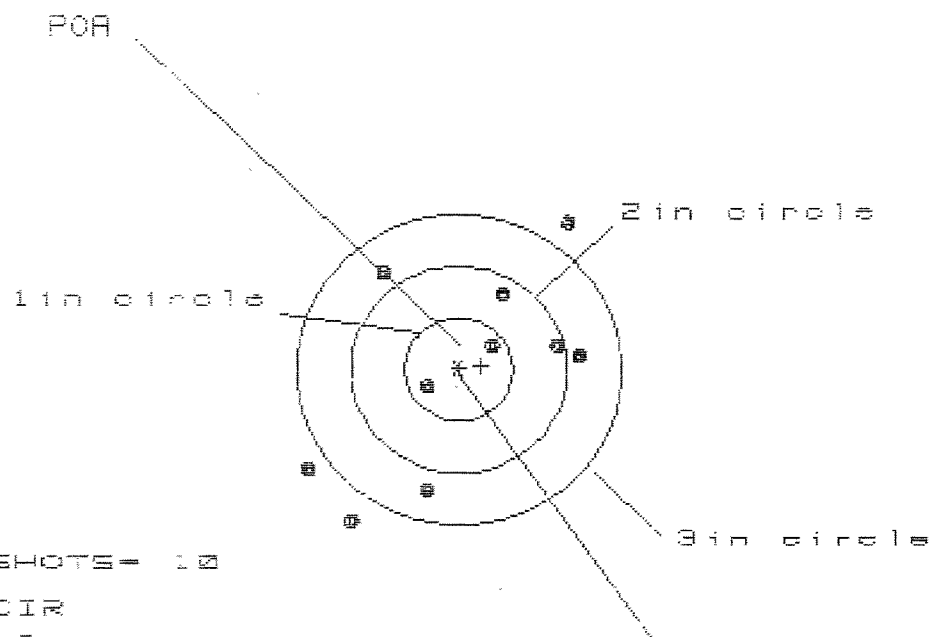
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.530	1.590	1.240
MINIMUM X	:	-1.032	-.972	-.773
MAXIMUM Y	:	1.590	1.381	1.369
MINIMUM Y	:	-.955	-.779	-.791
CENTROID X	:	.271	.211	.012
CENTROID Y	:	.014	-.162	-.150
POR TO CENTROID IN.	:	.272	.266	.151
MIN RADIUS	:	.476	.293	.355
MEAN RADIUS	:	1.126	1.022	.923
MAX RADIUS	:	1.679	1.593	1.477
HORIZONTAL SPREAD	:	2.562	2.562	2.013
VERTICAL SPREAD	:	2.545	2.160	2.160
EXTREME SPREAD	:	2.992	2.651	2.568
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

21 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522285

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

Y0 = 2.495

Y0 = 2.689

Y0 = 3.518

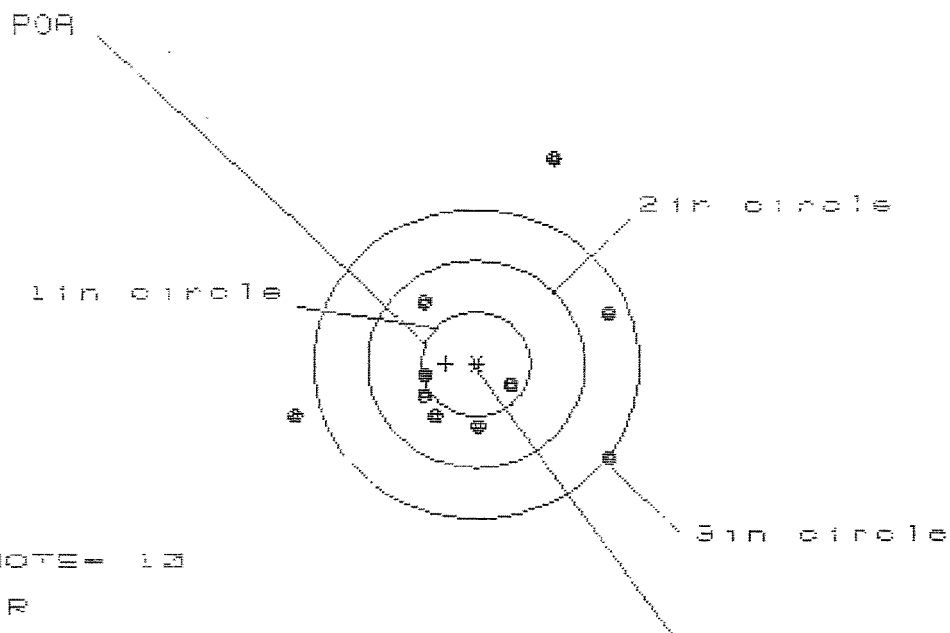
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	1.197	1.031
MINIMUM X	-1.413	-1.298	-1.404
MAXIMUM Y	1.425	1.101	.938
MINIMUM Y	-1.464	-1.306	-1.181
CENTROID X	-.287	-.322	-.216
CENTROID Y	-.035	-.193	-.038
POA TO CENTROID in.	.210	.376	.218
MIN RADIUS	.335	.193	.329
MEAN RADIUS	1.117	1.052	.957
MAX RADIUS	1.763	1.560	1.683
HORIZONTAL SPREAD	2.495	2.495	2.495
VERTICAL SPREAD	2.889	2.407	2.119
EXTREME SPREAD	3.518	2.707	2.707
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

21 Aug 1980

FILE:/PATTERNING/CENTERFIRE_PATT/C85822B5

CENTERFIRE PATTERNS # 5



OF SHOTS= 13

IN CIR

1in = 2

2in = 5

3in = 7

UE= 2.844

VE= 2.975

GE= 3.475

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.277	1.081
MINIMUM X	:	-1.647	-1.567	-1.599
MAXIMUM Y	:	2.039	.820	.784
MINIMUM Y	:	-.936	-.709	-.745
CENTROID X	:	.278	.198	.394
CENTROID Y	:	.001	-.226	-.190
POA TO CENTROID in.	:	.278	.300	.438
MIN RADIUS	:	.398	.361	.245
MEAN RADIUS	:	1.010	.829	.750
MAX RADIUS	:	2.161	1.593	1.313
HORIZONTAL SPREAD	:	2.844	2.844	1.680
VERTICAL SPREAD	:	2.975	1.529	1.529
EXTREME SPREAD	:	3.475	2.996	2.272
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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

Remington®

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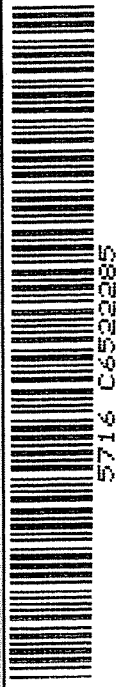
MODEL 700™ H24

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SERIAL NO.
C6522285

ORDER NO.
5716

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