

C6522313

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

SERIAL NO.
C6522313

ORDER NO.
5716

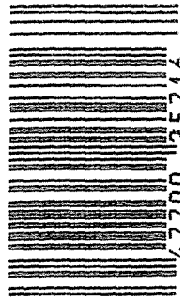
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6522313

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C65222313
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.410761
1 TO	2	.788495
1 TO	3	.372055
1 TO	4	1.29233
1 TO	5	.409313

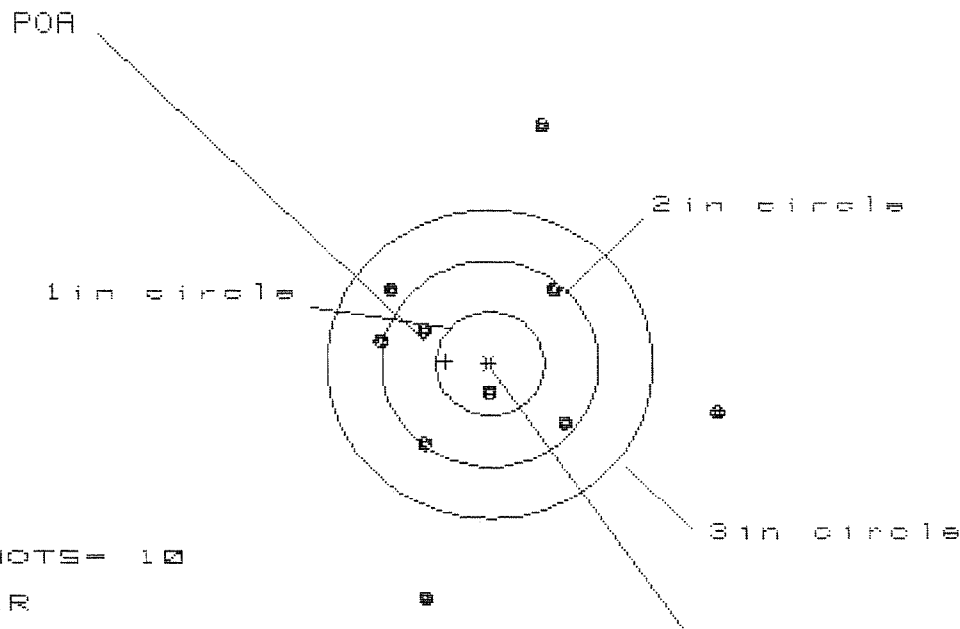
+ 231 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1588
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0558
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168318
THE AMR FOR THIS RIFLE IS: 1.045

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522313

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 3.111

VS= 4.588

GS= 4.718

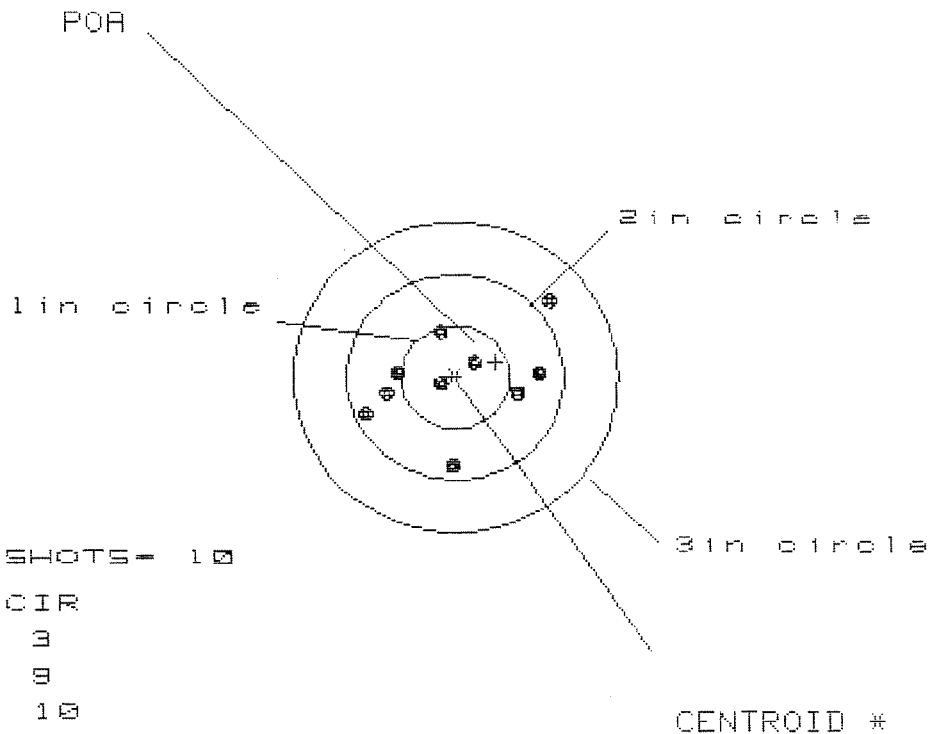
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.053	1.984	2.040
MINIMUM X	-1.058	-1.127	-1.071
MAXIMUM Y	2.303	2.050	.766
MINIMUM Y	-2.277	-.981	-.725
CENTROID X	.410	.479	.423
CENTROID Y	-.025	.228	-.028
POA TO CENTROID in.	.410	.530	.424
MIN RADIUS	.264	.523	.262
MEAN RADIUS	1.284	1.178	1.016
MAX RADIUS	2.360	2.102	2.086
HORIZONTAL SPREAD	3.111	3.111	3.111
VERTICAL SPREAD	4.588	3.031	1.491
EXTREME SPREAD	4.718	3.222	3.175
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	4		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.744

VS= 1.624

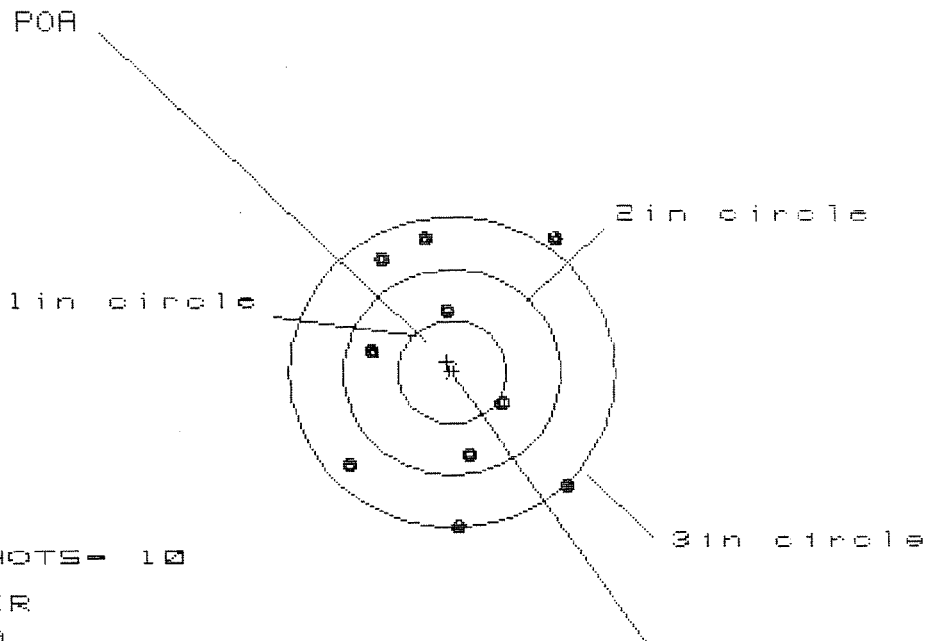
GS= 2.078

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.885	.873	.778
MINIMUM X	:	-.859	-.760	-.641
MAXIMUM Y	:	.763	.564	.528
MINIMUM Y	:	-.861	-.776	-.812
CENTROID X	:	-.369	-.468	-.373
CENTROID Y	:	-.147	-.232	-.196
POR TO CENTROID in.	:	.397	.522	.421
MIN RADIUS	:	.149	.090	.151
MEAN RADIUS	:	.631	.564	.530
MAX RADIUS	:	1.169	.888	.813
HORIZONTAL SPREAD	:	1.744	1.633	1.419
VERTICAL SPREAD	:	1.624	1.340	1.340
EXTREME SPREAD	:	2.078	1.694	1.432
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 1.956

VS= 2.836

GS= 2.962

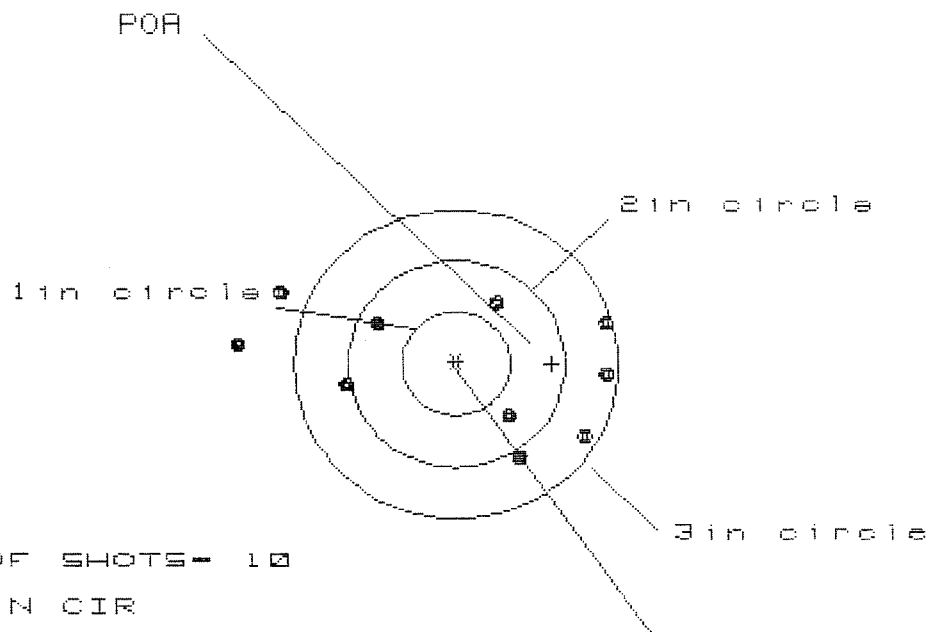
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.152	1.169
MINIMUM X	-.906	-.804	-.786
MAXIMUM Y	1.332	1.480	1.310
MINIMUM Y	-1.504	-1.356	-1.096
CENTROID X	.046	-.056	-.073
CENTROID Y	-.102	-.250	-.080
POA TO CENTROID in.	.112	.256	.109
MIN RADIUS	.555	.591	.531
MEAN RADIUS	1.121	1.056	1.004
MAX RADIUS	1.613	1.491	1.603
HORIZONTAL SPREAD	1.956	1.956	1.956
VERTICAL SPREAD	2.836	2.836	2.406
EXTREME SPREAD	2.962	2.855	2.788
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 3.452

VS= 1.656

GS= 3.457

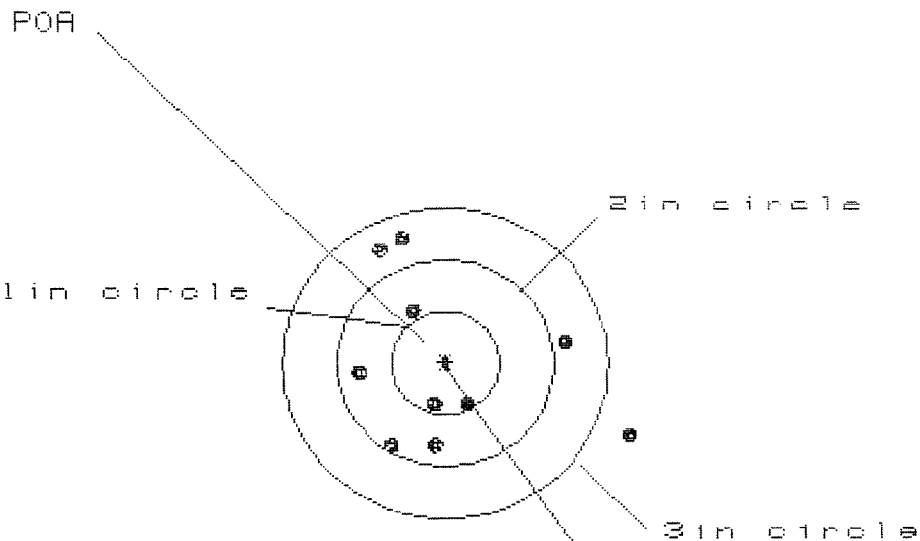
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.421	1.195	.966
MINIMUM X	:	-2.031	-1.834	-1.486
MAXIMUM Y	:	.738	.762	.752
MINIMUM Y	:	-.918	-.894	-.798
CENTROID X	:	-.882	-.656	-.427
CENTROID Y	:	.004	-.020	-.115
POA TO CENTROID in.	:	.882	.657	.442
MIN RADIUS	:	.647	.500	.357
MEAN RADIUS	:	1.246	1.121	.963
MAX RADIUS	:	2.043	1.986	1.487
HORIZONTAL SPREAD	:	3.452	3.029	2.452
VERTICAL SPREAD	:	1.656	1.656	1.551
EXTREME SPREAD	:	3.457	3.152	2.518
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.489

VS= 1.956

GS= 2.950

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.686	1.265	1.209
MINIMUM X	:	-.803	-.616	-.672
MAXIMUM Y	:	1.189	1.114	1.248
MINIMUM Y	:	-.767	-.842	-.708
CENTROID X	:	.001	-.186	-.130
CENTROID Y	:	-.009	.066	-.068
POA TO CENTROID in.	:	.009	.198	.146
MIN RADIUS	:	.414	.470	.341
MEAN RADIUS	:	.945	.832	.764
MAX RADIUS	:	1.816	1.271	1.282
HORIZONTAL SPREAD	:	2.489	1.881	1.881
VERTICAL SPREAD	:	1.956	1.956	1.956
EXTREME SPREAD	:	2.950	1.969	1.969
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6522313

DATE 8-22-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.34	2.32	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.54	2.36	2.55	
PULL #3	2.46	2.49	2.42	2.10	
PULL #4	2.47	2.49	2.43	2.14	
PULL #5	2.42	2.40	2.36	2.10	
TOTAL	12.24	12.26	11.89	11.40	
AVG.	2.44	2.45	2.37	2.28	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.12		
PULL #2	3.14	3.28		
PULL #3	3.17	3.28		
PULL #4	3.17	3.24		
PULL #5	3.14	3.26		
TOTAL	15.74	16.18		
AVG.	3.14	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.02		4.04
PULL #2	4.16	4.17		4.20
PULL #3	4.04	4.18		4.28
PULL #4	4.03	4.08		4.24
PULL #5	4.02	4.14		4.29
TOTAL	20.39	20.59		21.05
AVG.	4.07	4.11		4.21

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522313

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	L.S.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/12/90	OH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/23/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/23/90	WB
	H) Trigger Pull Test & Retainability						8/23/90	OH
	I) Firing Pin Indent	.024	.0235	.0235			8/23/90	WB
	J) Assemble Stock						8/24/90	RW
	K) Assemble Swivel Studs						8/30/90	JS
	L) Attach Front and Rear Sight Assemblies						8/24/90	RW
	M) Iron Sight Alignment						8/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	RW
	O) Attach Scope to Rifle						8/24/90	RW
	P) Detach & Attach Scope 20 Times						8/24/90	RW
640	Gallery Target & Test						8/24/90	NF
	A) Time						8/24/90	NF
	B) Malfunctions						8/24/90	NF
	C) Pierced Primers						8/24/90	NF
	D) Optical Clarity of Scope						8/24/90	NF
645	Inspect for Live Ammo						8/24/90	NF
655	Final Inspection							
	A) Headspace						8/30/90	JS
	B) Trigger Pull	2.51	2.55	2.10	2.14	2.10	8/30/90	JS
	C) Function						8/30/90	JS
660	Pack						9/20/90	NF