

C6498745

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498745

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/23/90	LS
617	Drill and Tap Sight Holes		5/23/90	FAB
618	Polish Barrel AB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/25/90	gcl
	G) Safety Off Force	3	3	3			7/25/90	gcl
	H) Trigger Pull Test & Retainability						8/22/90	gcl
	I) Firing Pin Indent	.023	.023	.023			7/25/90	gcl
	J) Assemble Stock						7/25/90	RW
	K) Assemble Swivel Studs						8/29/90	gcl
	L) Attach Front and Rear Sight Assemblies						7/25/90	RW
	M) Iron Sight Alignment						7/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/25/90	RW
	O) Attach Scope to Rifle						7/27/90	gcl
	P) Detach & Attach Scope 20 Times						7/27/90	gcl
640	Gallery Target & Test						7-31-90	AC
	A) Time						7-31-90	AC
	B) Malfunctions						7-31-90	AC
	C) Pierced Primers						7-31-90	AC
	D) Optical Clarity of Scope						7-31-90	AC
645	Inspect for Live Ammo						7-31-90	AC
655	Final Inspection						8/29/90	gcl
	A) Headspace						8/29/90	gcl
	B) Trigger Pull	2.26	2.28	2.18	2.28	2.35	8/22/90	gcl
	C) Function						8/29/90	gcl
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO 26498745

DATE 8/22/90

TESTER JCL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.11	2.30	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.11	2.24	2.28	
PULL #3	2.43	2.18	2.33	2.18	
PULL #4	2.27	2.17	2.35	2.28	
PULL #5	2.24	2.20	2.37	2.35	
TOTAL	11.77	10.77	11.69	11.35	
AVG.	2.354	2.154	2.318	2.27	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.36		
PULL #2	3.45	3.43		
PULL #3	3.36	3.45		
PULL #4	3.43	3.43		
PULL #5	3.36	3.37		
TOTAL	17.03	17.04		
AVG.	3.406	3.408		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.47		4.46
PULL #2	4.14	4.44		4.46
PULL #3	4.14	4.46		4.26
PULL #4	4.48	4.48		4.27
PULL #5	4.44	4.50		4.29
TOTAL	21.38	22.35		21.74
AVG.	4.276	4.47		4.348

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498745
31 Jul 1990

CENTROIDAL DISTANCES

0 TO	1	.408104
1 TO	2	.447161
1 TO	3	.724458
1 TO	4	.207331
1 TO	5	.494162

$\frac{2.14}{3.5}$ <----POA

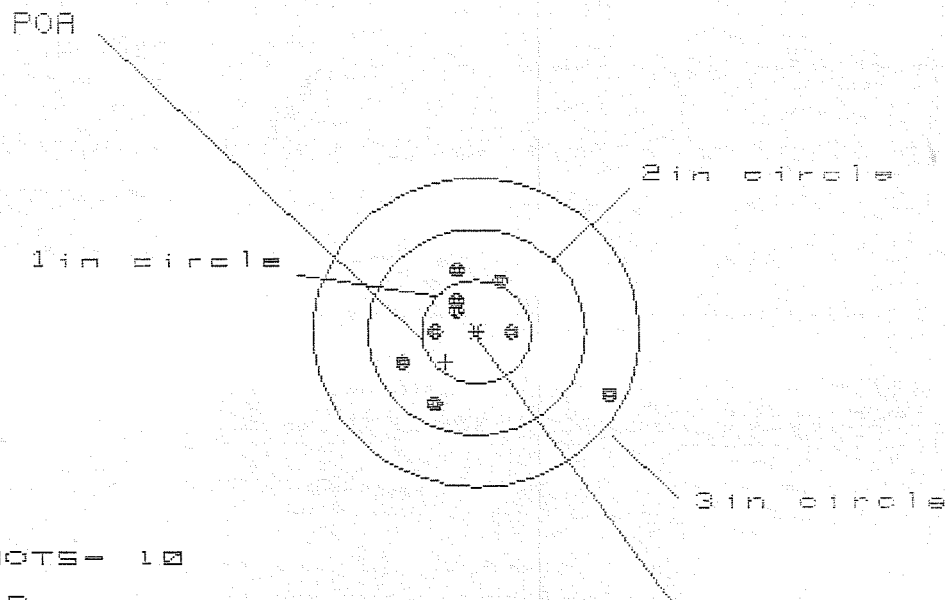
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1324
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157879

THE AMR FOR THIS RIFLE IS: .7556

31 JUL 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS43B745

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.883

VS= 1.295

GS= 1.803

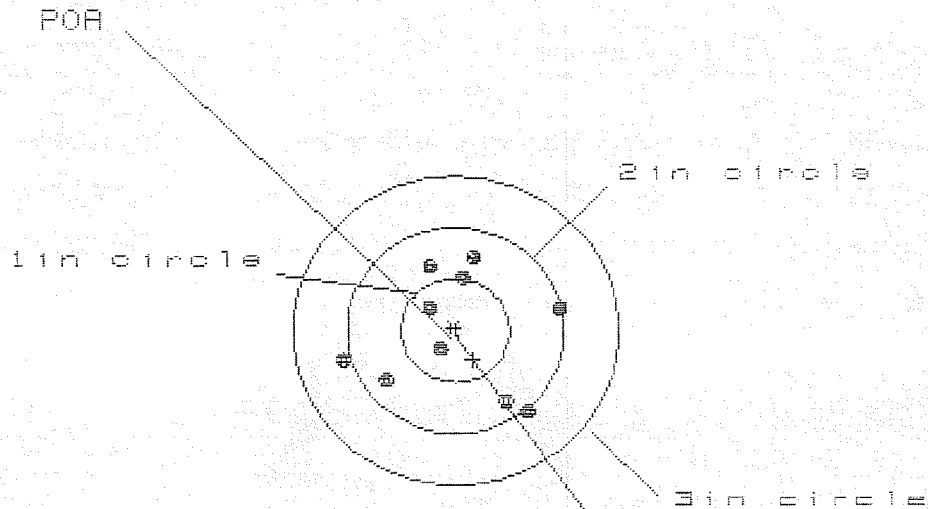
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	.483	.447
MINIMUM X	:	-.686	-.553	-.589
MAXIMUM Y	:	.557	.489	.388
MINIMUM Y	:	-.738	-.806	-.511
CENTROID X	:	.282	.149	.185
CENTROID Y	:	.295	.363	.464
POA TO CENTROID in.	:	.408	.393	.500
MIN RADIUS	:	.284	.170	.090
MEAN RADIUS	:	.590	.478	.404
MAX RADIUS	:	1.347	.855	.780
HORIZONTAL SPREAD	:	1.883	1.036	1.036
VERTICAL SPREAD	:	1.295	1.295	.899
EXTREME SPREAD	:	1.903	1.427	1.263
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.069

VS= 1.457

GS= 2.131

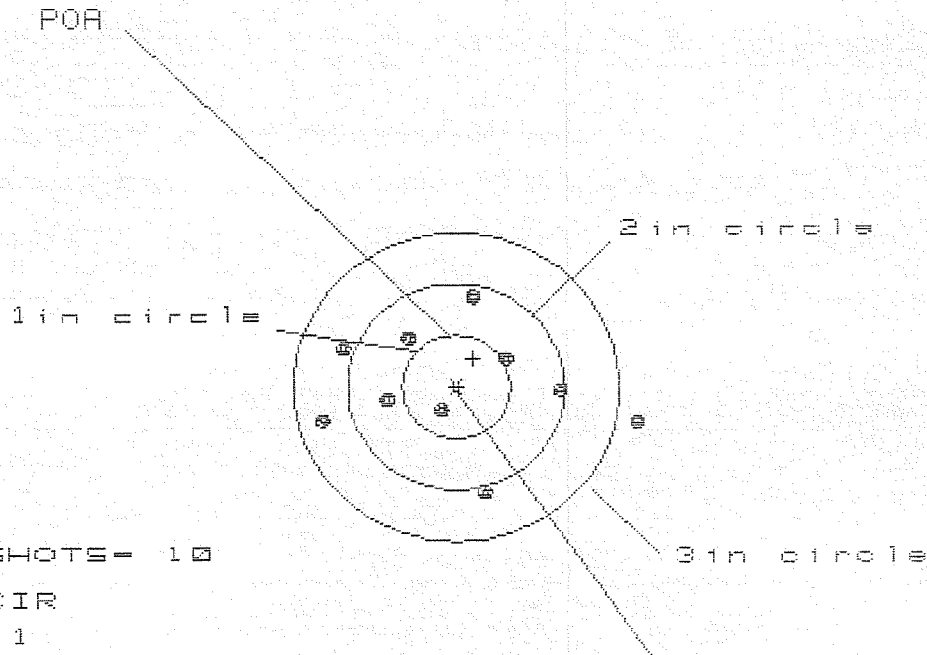
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.892	.682
MINIMUM X	:	-1.059	-.797	-.686
MAXIMUM Y	:	.715	.684	.708
MINIMUM Y	:	-.742	-.773	-.749
CENTROID X	:	-.165	-.047	-.158
CENTROID Y	:	.283	.314	.290
POA TO CENTROID in.	:	.327	.318	.331
MIN RADIUS	:	.242	.345	.252
MEAN RADIUS	:	.736	.701	.654
MAX RADIUS	:	1.097	.961	1.014
HORIZONTAL SPREAD	:	2.069	1.689	1.368
VERTICAL SPREAD	:	1.457	1.457	1.457
EXTREME SPREAD	:	2.131	1.830	1.685
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.837

VS= 1.900

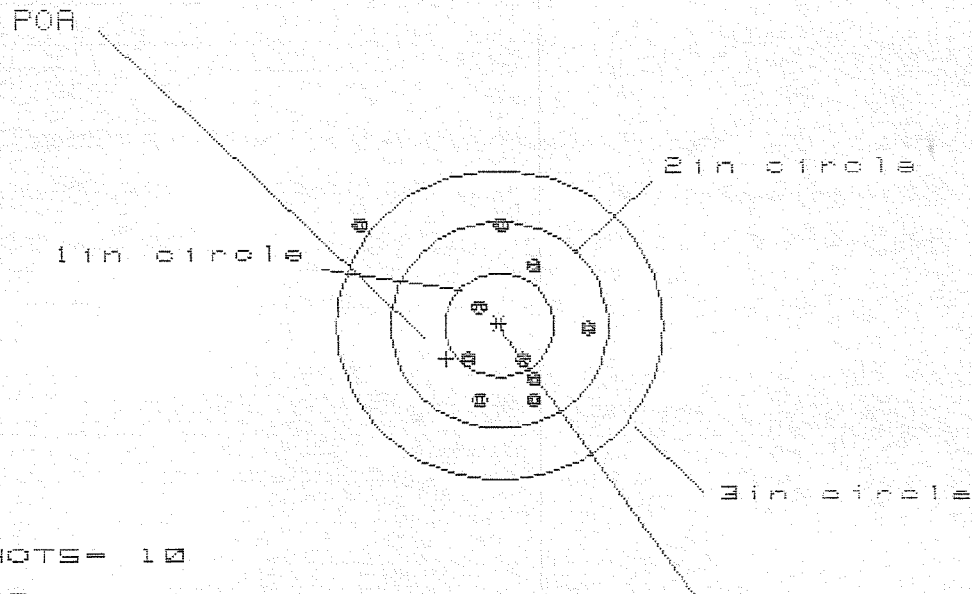
GS= 2.838

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.615
MINIMUM X	:	-1.222
MAXIMUM Y	:	.915
MINIMUM Y	:	-.985
CENTROID X	:	-.160
CENTROID Y	:	-.279
POA TO CENTROID in.	:	.321
MIN RADIUS	:	.291
MEAN RADIUS	:	.899
MAX RADIUS	:	1.656
HORIZONTAL SPREAD	:	2.837
VERTICAL SPREAD	:	1.900
EXTREME SPREAD	:	2.838
NUMBER IN ONE INCH CIRCLE =	:	1
NUMBER IN TWO INCH CIRCLE =	:	6
NUMBER IN THREE INCH CIRCLE =	:	9

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 9

HS= 2.071

VS= 1.711

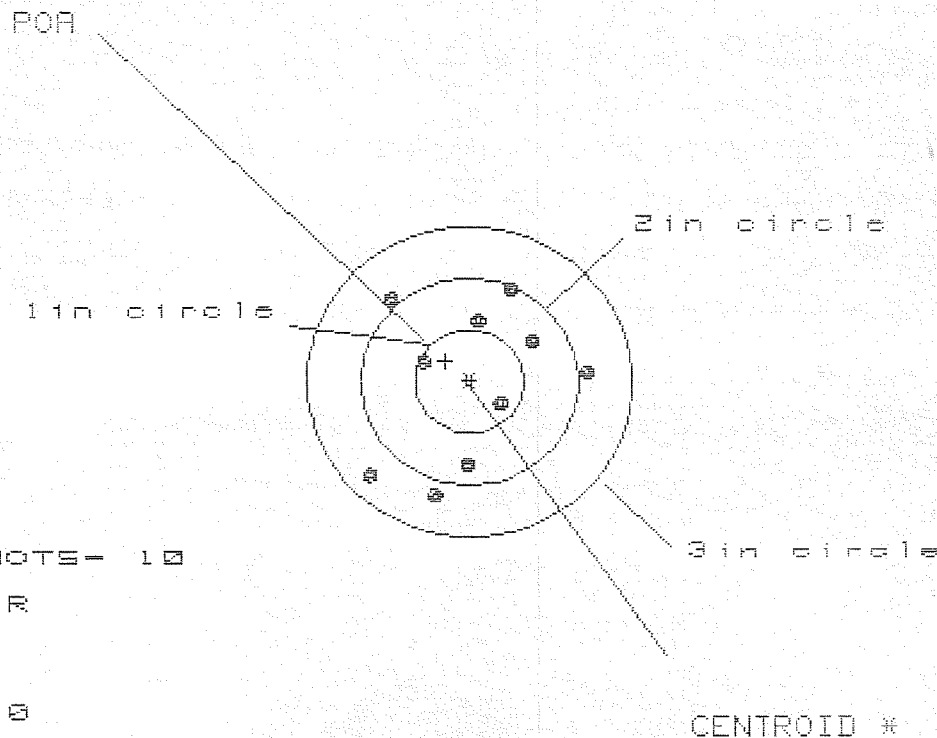
GS= 2.378

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.767	.622	.604
MINIMUM X	:	-1.304	-.388	-.406
MAXIMUM Y	:	.991	1.037	.808
MINIMUM Y	:	-.720	-.609	-.480
CENTROID X	:	.487	.632	.650
CENTROID Y	:	.326	.215	.086
POA TO CENTROID in.	:	.586	.668	.655
MIN RADIUS	:	.240	.192	.073
MEAN RADIUS	:	.717	.581	.489
MAX RADIUS	:	1.638	1.046	.831
HORIZONTAL SPREAD	:	2.071	1.010	1.010
VERTICAL SPREAD	:	1.711	1.646	1.288
EXTREME SPREAD	:	2.378	1.681	1.384
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.956

VS= 1.932

GS= 2.218

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.042	.941	.887
MINIMUM X	-.914	-.792	-.846
MAXIMUM Y	.865	.760	.614
MINIMUM Y	-1.067	-1.172	-1.007
CENTROID X	.218	.319	.373
CENTROID Y	-.195	-.090	.056
POA TO CENTROID in.	.292	.332	.377
MIN RADIUS	.326	.322	.355
MEAN RADIUS	.836	.763	.681
MAX RADIUS	1.310	1.248	1.019
HORIZONTAL SPREAD	1.956	1.733	1.733
VERTICAL SPREAD	1.932	1.932	1.621
EXTREME SPREAD	2.218	2.053	1.867
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

Remington[®]

MODEL 700TM H24

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

DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6498745

ORDER NO.
5716

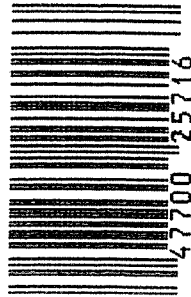
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