

C5498860

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498860

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT 5 17 90	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		6/22/90	KCR
615	Rollmark Caliber		6/22/90	G.S.
617	Drill and Tap Sight Holes		5/23/90	F.B.
618	Polish Barrel RB		5/24/90	W.B.
620	Apply Coatings (Barrel Action)		6-4-90	JA
	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		8/24/90	JE

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/24/90	SL
	G) Safety Off Force	3	3	3			7/24/90	SL
	H) Trigger Pull Test & Retainability						8/24/90	SL
	I) Firing Pin Indent	.0215	.0215	.0215			7/24/90	SL
	J) Assemble Stock						8/1/90	RW
	K) Assemble Swivel Studs						8/29/90	SL
	L) Attach Front and Rear Sight Assemblies						8/1/90	RW
	M) Iron Sight Alignment						8/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/90	RW
	O) Attach Scope to Rifle						8/1/90	RW
	P) Detach & Attach Scope 20 Times						8/1/90	RW
640	Gallery Target & Test						8-2-90	DH
	A) Time						8-2-90	DH
	B) Malfunctions						8-2-90	DH
	C) Pierced Primers						8-2-90	DH
	D) Optical Clarity of Scope						8-2-90	DH
645	Inspect for Live Ammo						8-2-90	DH
655	Final Inspection						8/24/90	SL
	A) Headspace						8/24/90	SL
	B) Trigger Pull	2.50	2.21	2.10	2.50	2.45	8/24/90	SL
	C) Function						8/24/90	SL
660	Pack						7/20/90	SL

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6498860

DATE 8/24/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.34	2.41	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.39	2.50	2.21	
PULL #3	2.21	2.44	2.23	2.10	
PULL #4	2.38	2.38	2.40	2.50	
PULL #5	2.19	2.26	2.00	2.45	
TOTAL	11.42	11.81	11.54	11.76	
AVG.	2.284	2.362	2.308	2.352	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.26		
PULL #2	3.18	3.23		
PULL #3	3.22	3.11		
PULL #4	3.03	3.22		
PULL #5	3.17	3.40		
TOTAL	16.00	16.22		
AVG.	3.2	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.27		4.33
PULL #2	4.08	4.27		4.21
PULL #3	4.49	4.09		4.29
PULL #4	4.29	4.07		4.14
PULL #5	4.19	4.17		4.25
TOTAL	21.41	20.87		21.22
AVG.	4.282	4.174		4.244

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498860
2 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.614869
1 TO	2	.559064
1 TO	3	.644525
1 TO	4	.853197
1 TO	5	.271118

+ $\frac{1}{\sqrt{4}}$ (----POB

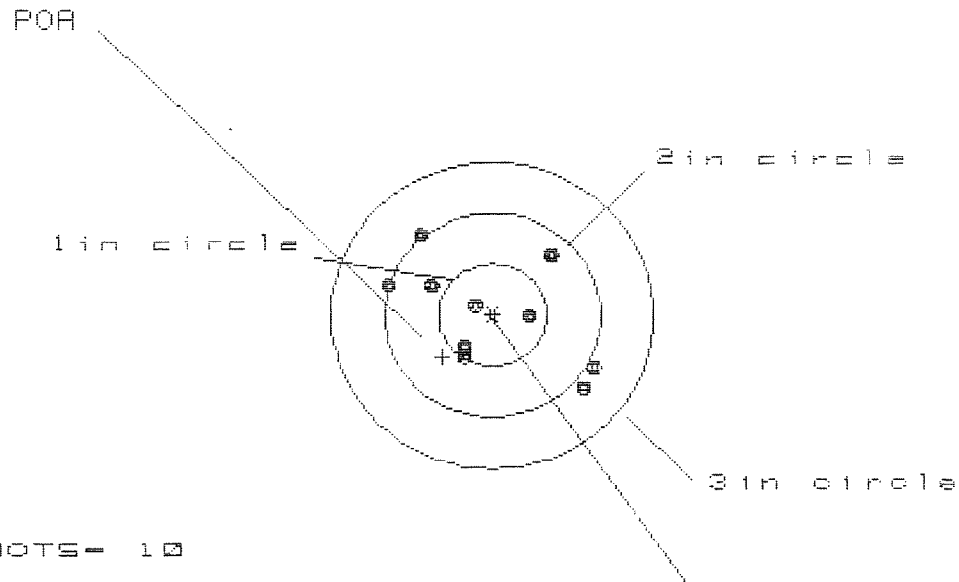
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4914
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0518
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .494123

THE AMR FOR THIS RIFLE IS: .7814

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6438860

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.905

VS= 1.532

GS= 2.089

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	.901	.798
MINIMUM X	:	-.930	-.822	-.710
MAXIMUM Y	:	.786	.729	.629
MINIMUM Y	:	-.746	-.803	-.585
CENTROID X	:	.460	.352	.239
CENTROID Y	:	.408	.465	.565
POA TO CENTROID in.	:	.615	.583	.614
MIN RADIUS	:	.188	.076	.086
MEAN RADIUS	:	.703	.639	.558
MAX RADIUS	:	1.100	1.207	.904
HORIZONTAL SPREAD	:	1.905	1.723	1.508
VERTICAL SPREAD	:	1.532	1.532	1.214
EXTREME SPREAD	:	2.089	2.089	1.534
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C649B860

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.642

VS= 2.137

GS= 2.238

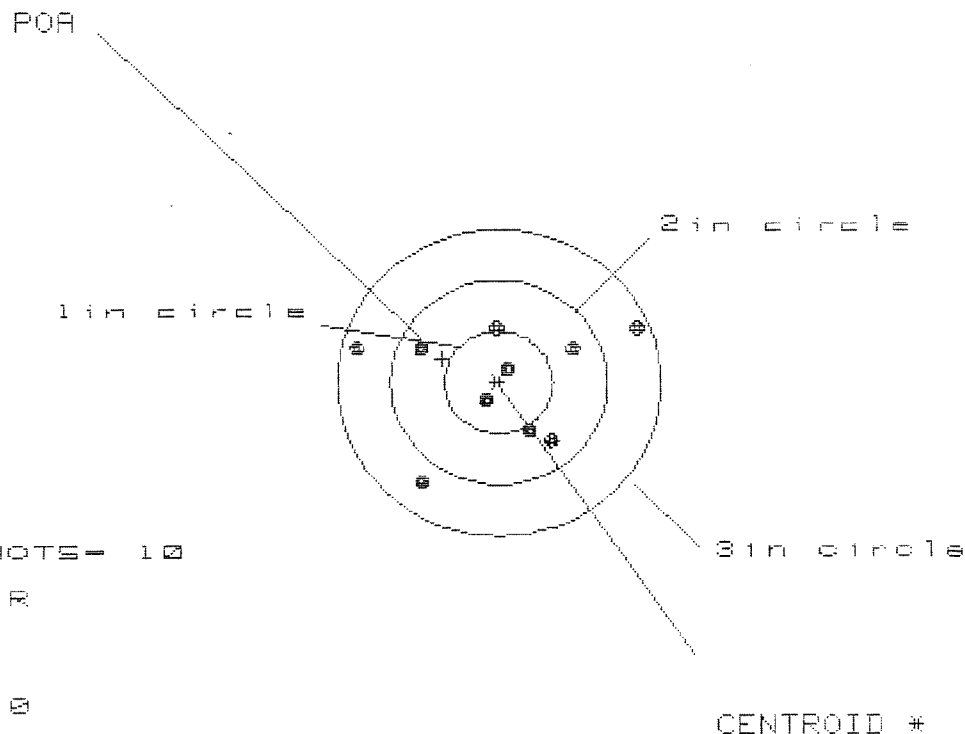
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.037	1.031	.828
MINIMUM X	:	-.605	-.611	-.482
MAXIMUM Y	:	.902	.765	.666
MINIMUM Y	:	-1.235	-1.019	-1.118
CENTROID X	:	.412	.418	.289
CENTROID Y	:	-.149	-.012	.087
POA TO CENTROID in.	:	.439	.418	.302
MIN RADIUS	:	.301	.417	.324
MEAN RADIUS	:	.838	.776	.686
MAX RADIUS	:	1.236	1.301	1.211
HORIZONTAL SPREAD	:	1.642	1.642	1.310
VERTICAL SPREAD	:	2.137	1.784	1.784
EXTREME SPREAD	:	2.238	2.238	1.946
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.628

VS= 1.516

GS= 2.633

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.299	.847	.699
MINIMUM X	:	-1.329	-1.184	-.742
MAXIMUM Y	:	.560	.614	.662
MINIMUM Y	:	-.956	-.902	-.854
CENTROID X	:	.517	.372	.521
CENTROID Y	:	-.234	-.288	-.336
POA TO CENTROID in.	:	.567	.471	.620
MIN RADIUS	:	.156	.104	.089
MEAN RADIUS	:	.773	.710	.618
MAX RADIUS	:	1.388	1.245	1.131
HORIZONTAL SPREAD	:	2.628	2.031	1.440
VERTICAL SPREAD	:	1.516	1.516	1.516
EXTREME SPREAD	:	2.633	2.039	1.908
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.915

VS= 1.812

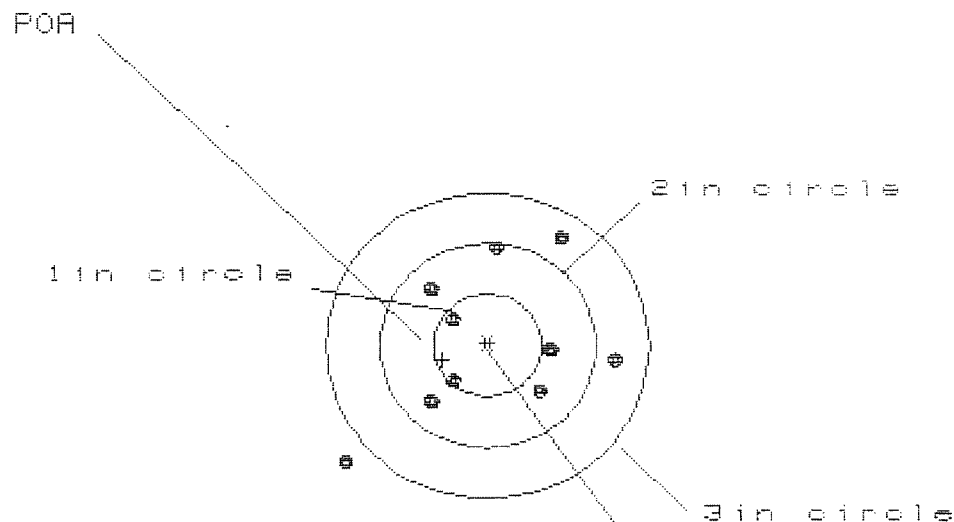
GS= 2.280

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.640	.371	.220
MINIMUM X	:	-1.275	-1.203	-.545
MAXIMUM Y	:	.623	.490	.480
MINIMUM Y	:	-1.190	-.935	-.945
CENTROID X	:	.649	.577	.728
CENTROID Y	:	-.424	-.291	-.281
POA TO CENTROID in.	:	.775	.647	.780
MIN RADIUS	:	.367	.302	.205
MEAN RADIUS	:	.719	.616	.513
MAX RADIUS	:	1.351	1.206	.955
HORIZONTAL SPREAD	:	1.915	1.574	.765
VERTICAL SPREAD	:	1.812	1.425	1.425
EXTREME SPREAD	:	2.280	1.716	1.437
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.468

VS= 2.197

GS= 2.961

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.167	1.022	1.090
MINIMUM X	:	-1.301	-.673	-.605
MAXIMUM Y	:	1.032	.902	.948
MINIMUM Y	:	-1.165	-.716	-.603
CENTROID X	:	.419	.564	.496
CENTROID Y	:	.140	.270	.157
POA TO CENTROID in.	:	.442	.625	.520
MIN RADIUS	:	.369	.449	.425
MEAN RADIUS	:	.874	.773	.721
MAX RADIUS	:	1.747	1.064	1.105
HORIZONTAL SPREAD	:	2.468	1.695	1.695
VERTICAL SPREAD	:	2.197	1.618	1.551
EXTREME SPREAD	:	2.961	2.022	1.818
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



MODEL 700™ H24

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



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

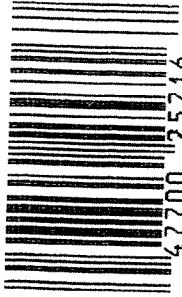
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SERIAL NO.
C6498860

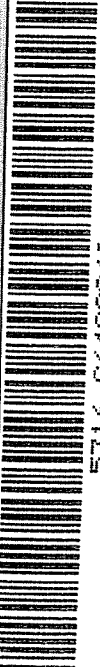
ORDER NO.
5716

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