

C6594571

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

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

MODEL 700TM H24

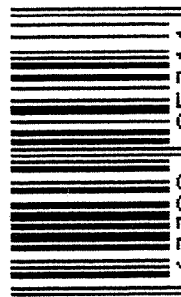
SERIAL NO. C6594571

ORDER NO. 5716

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

20

UPC



0 47700 25716 7



5716 C6594571

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594571

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	"
615	Rollmark Caliber	3 28	91	JS
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-10-91	AC
	G) Safety Off Force	3	3	3			5-10-91	AC
	H) Trigger Pull Test & Retainability						5-9-91	D/H
	I) Firing Pin Indent	.020	.021	.020			5-10-91	AC
	J) Assemble Stock						5/13/91	RW
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/13/91	RW
	M) Iron Sight Alignment						5/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/13/91	RW
	O) Attach Scope to Rifle						5/13/91	RW
	P) Detach & Attach Scope 20 Times						5/13/91	RW
640	Gallery Target & Test						5-14-91	AC
	A) Time						5-14-91	AC
	B) Malfunctions						5-14-91	AC
	C) Pierced Primers						5-14-91	AC
	D) Optical Clarity of Scope						5-14-91	AC
645	Inspect for Live Ammo						5-14-91	AC
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.43	2.59	2.34	2.31	2.33	5/21/91	gdl
	C) Function						5-21-91	D/H
660	Pack						5-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594571
DATE 5-9-91
TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.23	2.42	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.28	2.46	2.59	
PULL #3	2.02	2.13	2.51	2.34	
PULL #4	2.30	2.18	2.33	2.31	
PULL #5	2.26	2.23	2.51	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.50	3.40		
PULL #3	3.44	3.32		
PULL #4	3.08	3.30		
PULL #5	3.43	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.15		4.59
PULL #2	4.16	4.18		4.48
PULL #3	4.22	4.18		4.36
PULL #4	4.23	4.05		4.29
PULL #5	4.25	4.25		4.44
TOTAL				
AVG.				

2-2-5
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594571
14 May 1991

CENTROIDAL DISTANCES

0 TO 1	.163893
1 TO 2	.135532
1 TO 3	.273885
1 TO 4	.174977
1 TO 5	.209344

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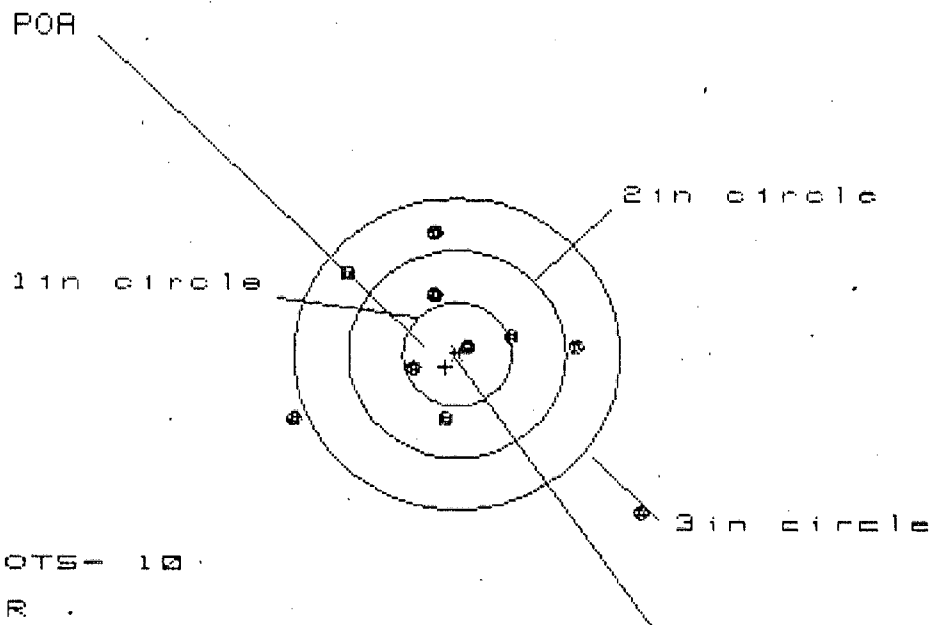
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0236
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142567

THE AMR FOR THIS RIFLE IS: .8342

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594571

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR .

1in = 2

2in = 5

3in = 8

HS= 3.229

VS= 2.662

GS= 3.592

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.741	1.291	1.129
MINIMUM X	:	-1.488	-1.294	-.999
MAXIMUM Y	:	1.172	1.007	.911
MINIMUM Y	:	-1.490	-.837	-.933
CENTROID X	:	.106	-.088	.074
CENTROID Y	:	.125	.290	.386
POA TO CENTROID in.:	:	.163	.303	.393
MIN RADIUS	:	.182	.332	.218
MEAN RADIUS	:	.989	.828	.722
MAX RADIUS	:	2.292	1.506	1.140
HORIZONTAL SPREAD	:	3.229	2.585	2.128
VERTICAL SPREAD	:	2.662	1.844	1.844
EXTREME SPREAD	:	3.592	2.680	2.238
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

14 May 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.860

VS= 2.173

GS= 2.226

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.781

.747

.608

MINIMUM X

-1.079

-1.113

-1.245

MAXIMUM Y

.913

.773

.830

MINIMUM Y

-1.260

-1.716

-.659

CENTROID X

-.029

.005

.144

CENTROID Y

.137

.277

.220

POA TO CENTROID in.

.140

.277

.263

MIN RADIUS

.352

.351

.326

MEAN RADIUS

.841

.775

.696

MAX RADIUS

1.297

1.205

1.248

HORIZONTAL SPREAD

1.860

1.860

1.853

VERTICAL SPREAD

2.173

1.489

1.489

EXTREME SPREAD

2.226

2.191

1.935

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534571

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 8

HS= 2.605

VS= 2.390

GS= 2.718

CENTROID *

PATTERN #

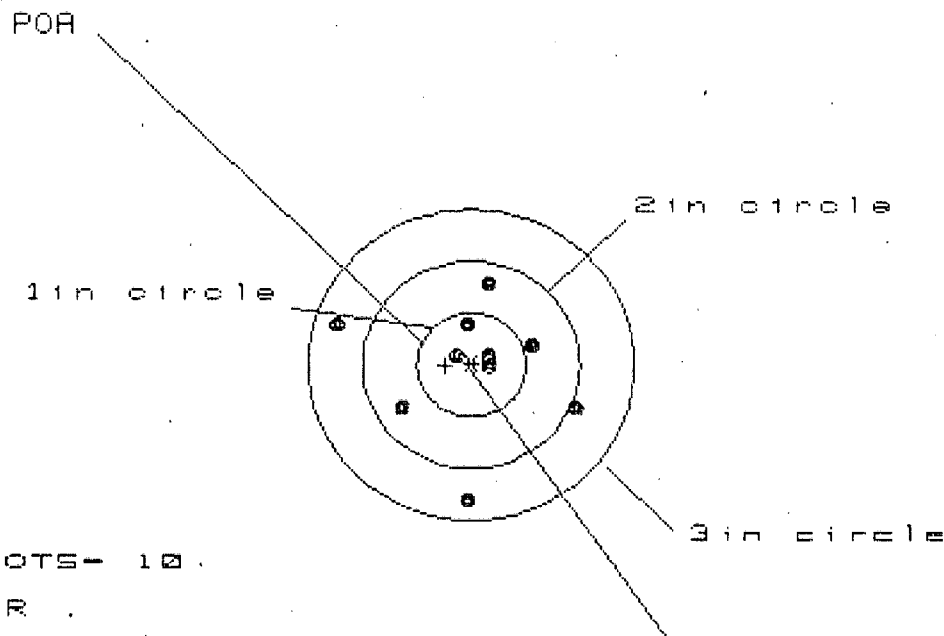
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	.954	.771	.826
MINIMUM X	-1.651	-1.014	-.959
MAXIMUM Y	1.411	1.402	.774
MINIMUM Y	-.979	-.988	-.813
CENTROID X	-.167	.016	-.039
CENTROID Y	.147	.156	-.019
POA TO CENTROID in.	.223	.157	.043
MIN RADIUS	.518	.378	.358
MEAN RADIUS	.911	.808	.701
MAX RADIUS	1.653	1.469	.962
HORIZONTAL SPREAD	2.605	1.785	1.785
VERTICAL SPREAD	2.390	2.390	1.587
EXTREME SPREAD	2.718	2.472	1.786
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594571

CENTERFIRE PATTERNS # 4



OF SHOTS- 10 .

IN CIR .

1in = 4

2in = 7

3in = 10

HS= 2.181

VS= 2.130

GS= 2.334

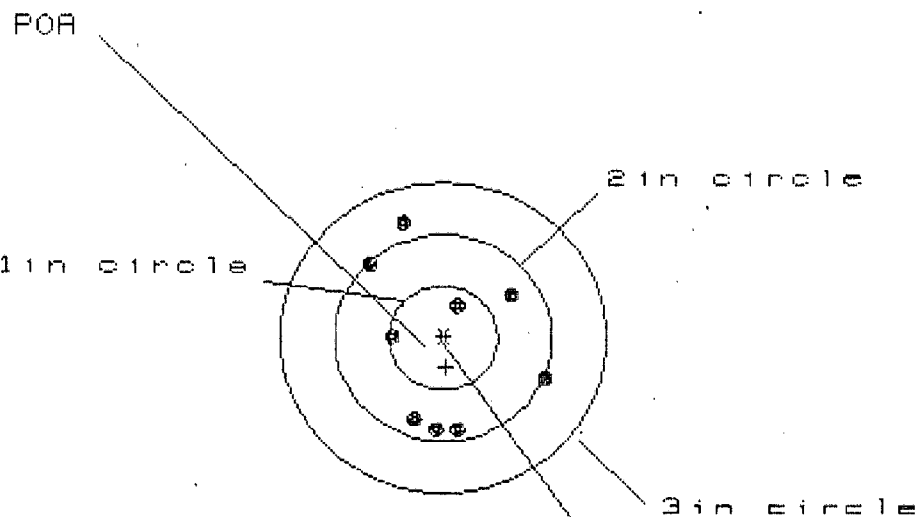
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.991	.990	.841
MINIMUM X	-1.190	-1.191	-.810
MAXIMUM Y	.839	.696	.730
MINIMUM Y	-1.291	-.555	-.521
CENTROID X	.237	.238	.387
CENTROID Y	.009	.152	.118
POA TO CENTROID in.	.237	.282	.404
MIN RADIUS	.170	.153	.059
MEAN RADIUS	.679	.591	.489
MAX RADIUS	1.291	1.222	.989
HORIZONTAL SPREAD	2.181	2.181	1.651
VERTICAL SPREAD	2.130	1.251	1.251
EXTREME SPREAD	2.334	2.334	1.652
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

14 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.617

VS= 2.004

GS= 2.071

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.909
MINIMUM X	-.708
MAXIMUM Y	1.150
MINIMUM Y	-.854
CENTROID X	-.029
CENTROID Y	.285
POA TO CENTROID in.	.286
MIN RADIUS	.286
MEAN RADIUS	.751
MAX RADIUS	1.213
HORIZONTAL SPREAD	1.617
VERTICAL SPREAD	2.004
EXTREME SPREAD	2.071
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10