

C6594632

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594632

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/21/90	K.S.
600	Proof		12/21/90	K.S.
607	Check Headspace		12/21/90	K.S.
610	Dis-assemble Gun		12/21/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	U.S.
617	Drill and Tap Sight Holes			K.S.
618	Polish Barrel			K.S.
620	Apply Coatings (Barrel Action)		1/22/91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/29/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/91	K.S.
	C) Inspect Ejector Hole for Chamfer		1/29/91	K.S.
	D) Oil Firing Pin Ass'y		1/29/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1/31/91	98

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3.5	3.5	3.5			1/31/91	JL
	G) Safety Off Force	2.5	2.5	2.5			1/31/91	JL
	H) Trigger Pull Test & Retainability						1/31/91	JL
	I) Firing Pin Indent	.020	.020	.020			1/31/91	JL
	J) Assemble Stock						1-31-91	KS
	K) Assemble Swivel Studs						2-6-91	DH
	L) Attach Front and Rear Sight Assemblies						1-31-91	KS
	M) Iron Sight Alignment						1-31-91	KS
	N) Detach Front & Rear Sights & place in numbered container						1-31-91	KS
	O) Attach Scope to Rifle						1-31-91	KS
	P) Detach & Attach Scope 20 Times						1-31-91	KS
640	Gallery Target & Test						1/31/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						1/31/91	KS
655	Final Inspection							
	A) Headspace						2-6-91	DH
	B) Trigger Pull	2.31	2.25	2.24	2.36	2.44	2-4-91	KS
	C) Function						2-6-91	DH
660	Pack						3-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594632
DATE 1/31/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.16	2.30	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.28	2.26	2.25	
PULL #3	2.16	2.26	2.33	2.29	
PULL #4	2.52	2.14	2.35	2.36	
PULL #5	2.20	2.33	2.34	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.14		
PULL #2	3.14	3.34		
PULL #3	3.22	3.31		
PULL #4	3.22	3.38		
PULL #5	3.21	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.14		4.28
PULL #2	4.11	4.24		4.30
PULL #3	4.16	4.24		4.31
PULL #4	4.20	4.27		4.30
PULL #5	4.17	4.23		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594632
31 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.253671
1 TO	2	.345442
1 TO	3	.275951
1 TO	4	.215035
1 TO	5	.271553

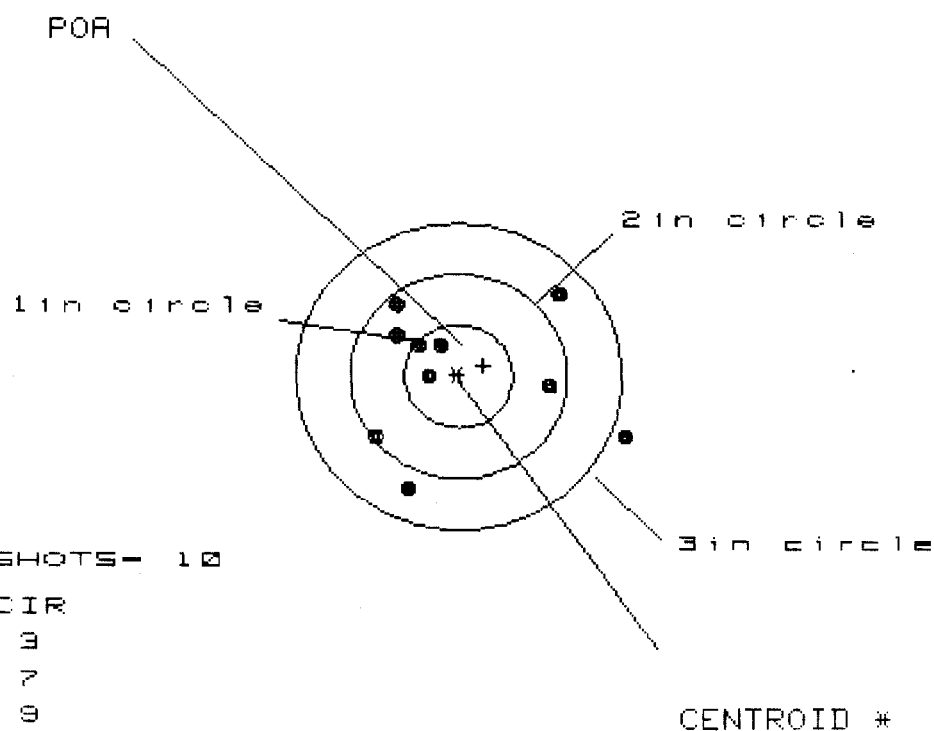
43 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0534
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114779
THE AMR FOR THIS RIFLE IS: .974

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594632

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in - 9

HS- 2.268

VS- 1.895

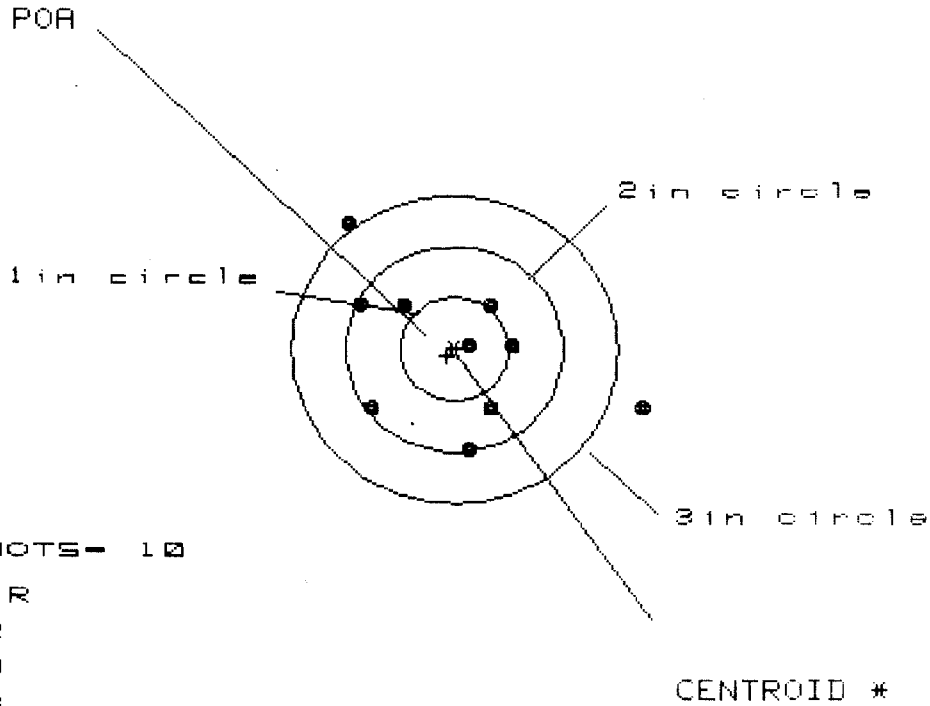
GS- 2.443

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.505	1.114	1.101
MINIMUM X	-.763	-.596	-.457
MAXIMUM Y	.777	.710	.699
MINIMUM Y	-1.118	-1.185	-1.096
CENTROID X	-.230	-.397	-.536
CENTROID Y	-.107	-.040	-.129
POA TO CENTROID in.	.254	.399	.552
MIN RADIUS	.306	.173	.019
MEAN RADIUS	.854	.708	.608
MAX RADIUS	1.622	1.321	1.105
HORIZONTAL SPREAD	2.268	1.710	1.558
VERTICAL SPREAD	1.895	1.895	1.795
EXTREME SPREAD	2.443	2.352	1.800
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 8

3 in - 8

HS - 2.731

VS - 2.229

GS - 3.303

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.779	.685	.590
MINIMUM X	:	-.952	-.754	-.801
MAXIMUM Y	:	1.273	1.208	.548
MINIMUM Y	:	-.956	-1.021	-.870
CENTROID X	:	.069	-.129	-.034
CENTROID Y	:	.066	.131	-.020
POA TO CENTROID in.	:	.096	.184	.040
MIN RADIUS	:	.105	.311	.220
MEAN RADIUS	:	.885	.786	.686
MAX RADIUS	:	1.873	1.424	.949
HORIZONTAL SPREAD	:	2.731	1.439	1.391
VERTICAL SPREAD	:	2.229	2.229	1.418
EXTREME SPREAD	:	3.303	2.477	1.723
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	

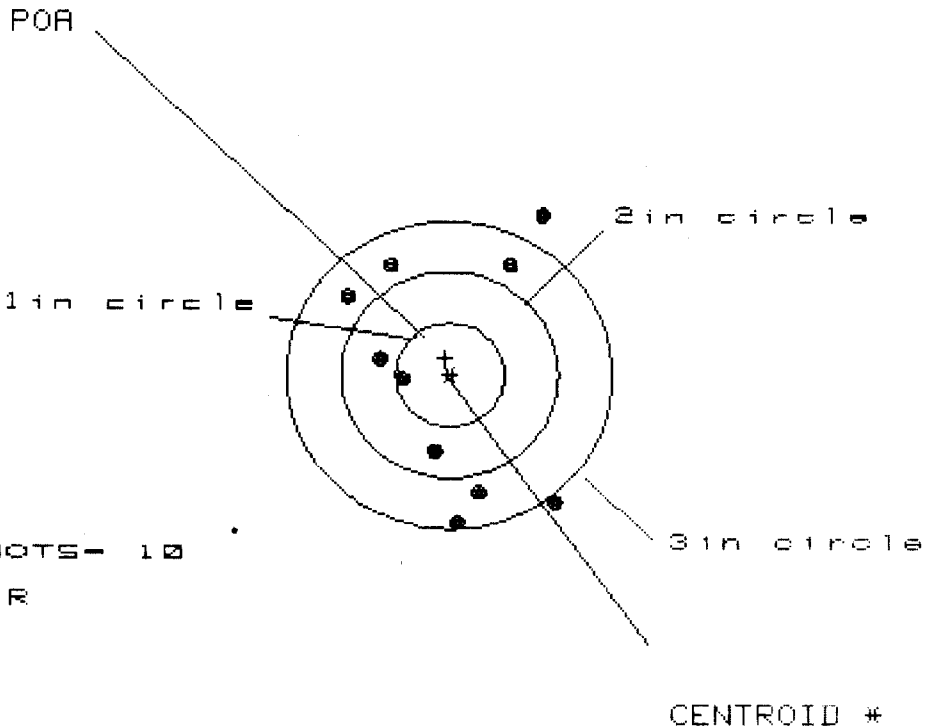
NUMBER IN THREE INCH CIRCLE =

8

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 1.886

VS= 2.995

GS= 3.098

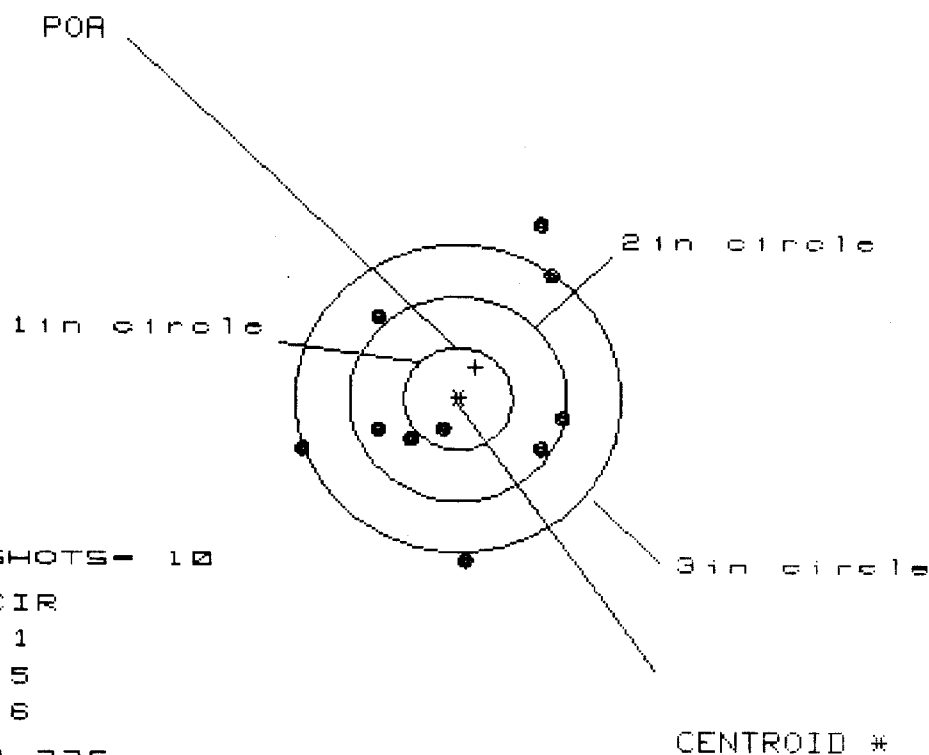
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.954	1.048	.818
MINIMUM X	-.932	-.838	-.707
MAXIMUM Y	1.523	1.244	1.112
MINIMUM Y	-1.472	-1.303	-1.435
CENTROID X	.040	-.054	-.185
CENTROID Y	-.164	-.333	-.201
POA TO CENTROID in.	.168	.337	.273
MIN RADIUS	.408	.341	.182
MEAN RADIUS	1.144	1.048	.959
MAX RADIUS	1.739	1.485	1.460
HORIZONTAL SPREAD	1.886	1.886	1.525
VERTICAL SPREAD	2.995	2.547	2.547
EXTREME SPREAD	3.098	2.755	2.618
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



HS= 2.336
VS= 3.251
GS= 3.323

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.920	1.004	1.023
MINIMUM X	-1.415	-1.332	-1.313
MAXIMUM Y	1.708	1.398	1.228
MINIMUM Y	-1.543	-1.353	-.490
CENTROID X	-.162	-.245	-.264
CENTROID Y	-.311	-.501	-.331
POR TO CENTROID in.	.350	.557	.424
MIN RADIUS	.321	.126	.254
MEAN RADIUS	1.099	.961	.929
MAX RADIUS	1.866	1.707	1.583
HORIZONTAL SPREAD	2.336	2.336	2.336
VERTICAL SPREAD	3.251	2.751	1.718
EXTREME SPREAD	3.323	2.880	2.880
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 1.525

VS = 3.105

GS = 3.308

CENTROID *

PATTERN #	:	9		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.843	.768	.816
MINIMUM X	:	-.682	-.735	-.688
MAXIMUM Y	:	1.844	.818	.686
MINIMUM Y	:	-1.261	-1.056	-.552
CENTROID X	:	.016	.091	.044
CENTROID Y	:	.008	-.197	-.065
POA TO CENTROID in.	:	.018	.217	.078
MIN RADIUS	:	.553	.380	.513
MEAN RADIUS	:	.888	.751	.695
MAX RADIUS	:	1.966	1.123	.966
HORIZONTAL SPREAD	:	1.525	1.503	1.503
VERTICAL SPREAD	:	3.105	1.874	1.238
EXTREME SPREAD	:	3.308	1.875	1.608
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

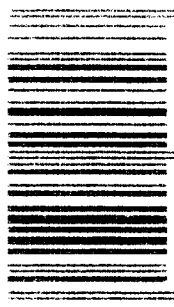



VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700 TM H24		SERIAL NO. C6594602
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



C6594602



5716 42700 25216