

C6523354

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

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

SERIAL NO.
C6523354

ORDER NO.
5716

01


5716 C6523354

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

UPC


0 47700 25716 7

H 3.3
M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523354

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	LL
617	Drill and Tap Sight Holes		10/18/90	LB
618	Polish Barrel RB		10/18/90	LB
620	Apply Coatings (Barrel Action)		11-5-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 1/2			11/12/90	WB
	G) Safety Off Force	2	2	2			11/12/90	WB
	H) Trigger Pull Test & Retainability						11-12-90	RL
	I) Firing Pin Indent	.0205	.020	.0205			11/12/90	WB
	J) Assemble Stock						11/14/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/14/90	RW
	M) Iron Sight Alignment						11/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	RW
	O) Attach Scope to Rifle						11/14/90	RW
	P) Detach & Attach Scope 20 Times						11/14/90	RW
640	Gallery Target & Test						11-15-90	DH
	A) Time						11-15-90	DH
	B) Malfunctions						11-15-90	DH
	C) Pierced Primers						11-15-90	DH
	D) Optical Clarity of Scope						11-15-90	DH
645	Inspect for Live Ammo						11-15-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	2.47	2.41	2.40	2.36	2.30	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/18/90	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523354

DATE 11-12-90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.50	2.26	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.43	2.47	2.46	
PULL #3	2.48	2.46	2.45	2.40	
PULL #4	2.44	2.32	2.43	2.36	
PULL #5	2.44	2.41	2.44	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.27		
PULL #2	3.19	3.16		
PULL #3	3.25	3.27		
PULL #4	3.18	3.26		
PULL #5	3.26	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	4.21	4.31		4.33
PULL #2	4.16	4.30		4.34
PULL #3	4.14	4.35		4.32
PULL #4	4.35	4.28		4.33
PULL #5	4.31	4.31		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523354
15 Nov 1990

CENTROIDAL DISTANCES

Ø TO	1	.210262
1 TO	2	.203666
1 TO	3	.342475
1 TO	4	.24797
1 TO	5	.550311

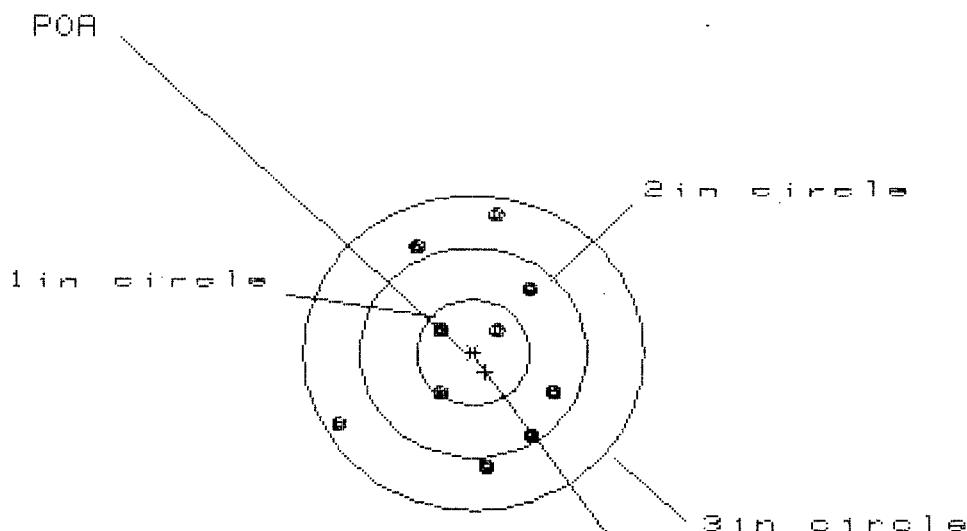
$\frac{1}{4} \times 3$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1152
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .135849
THE AMR FOR THIS RIFLE IS: .8574

15 May 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.895

VS = 2.393

GS = 2.468

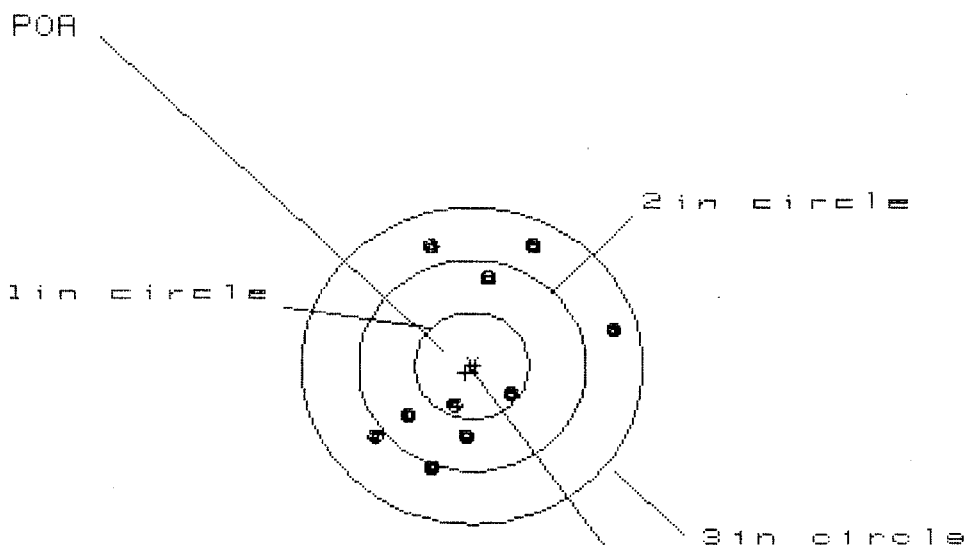
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.672	.536	.547
MINIMUM X	:	-1.223	-.629	-.618
MAXIMUM Y	:	1.296	1.217	1.052
MINIMUM Y	:	-1.097	-1.176	-1.024
CENTROID X	:	-.107	.029	.018
CENTROID Y	:	.181	.260	.107
POA TO CENTROID in.	:	.210	.261	.109
MIN RADIUS	:	.321	.191	.331
MEAN RADIUS	:	.856	.779	.721
MAX RADIUS	:	1.412	1.220	1.220
HORIZONTAL SPREAD	:	1.895	1.165	1.165
VERTICAL SPREAD	:	2.393	2.393	2.075
EXTREME SPREAD	:	2.468	2.395	2.163
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.086

VS= 2.151

GS= 2.349

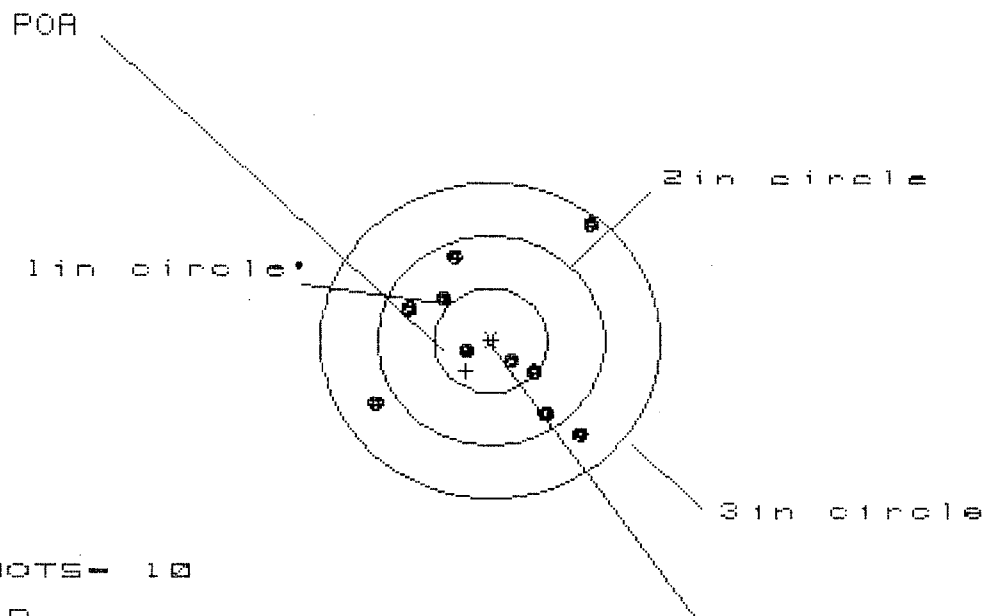
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.229	1.293	.600
MINIMUM X	:	-.857	-.793	-.631
MAXIMUM Y	:	1.143	1.238	1.293
MINIMUM Y	:	-1.008	-.881	-.826
CENTROID X	:	.059	-.005	-.167
CENTROID Y	:	.063	-.064	-.119
POA TO CENTROID in.	:	.086	.064	.205
MIN RADIUS	:	.409	.270	.232
MEAN RADIUS	:	.901	.822	.727
MAX RADIUS	:	1.280	1.366	1.300
HORIZONTAL SPREAD	:	2.086	2.086	1.231
VERTICAL SPREAD	:	2.151	2.119	2.119
EXTREME SPREAD	:	2.349	2.294	2.119
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS- 1.881

VS= 2.039

GS= 2.575

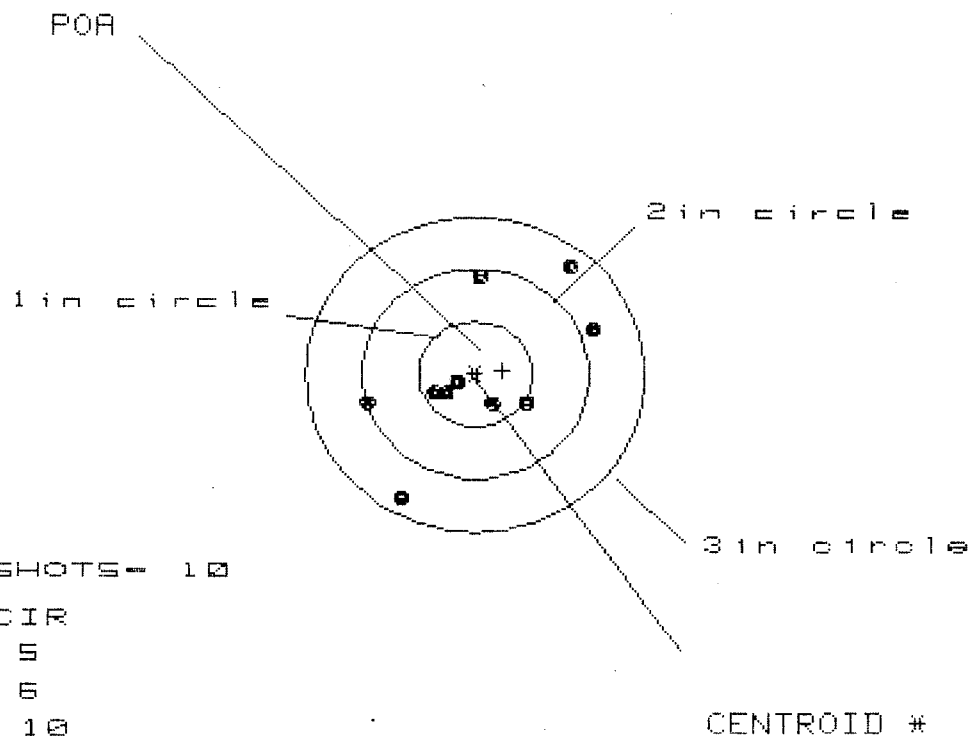
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.911	.899	.683
MINIMUM X	:	-.970	-.869	-.756
MAXIMUM Y	:	1.138	.968	.871
MINIMUM Y	:	-.901	-.775	-.630
CENTROID X	:	.218	.117	.004
CENTROID Y	:	.289	.163	.260
POR TO CENTROID in.	:	.362	.200	.260
MIN RADIUS	:	.212	.135	.053
MEAN RADIUS	:	.787	.695	.621
MAX RADIUS	:	1.458	1.187	.960
HORIZONTAL SPREAD	:	1.881	1.768	1.440
VERTICAL SPREAD	:	2.039	1.743	1.501
EXTREME SPREAD	:	2.575	2.073	1.698
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 5

2 in - 6

3 in = 10

HS= 1.995

VS= 2.229

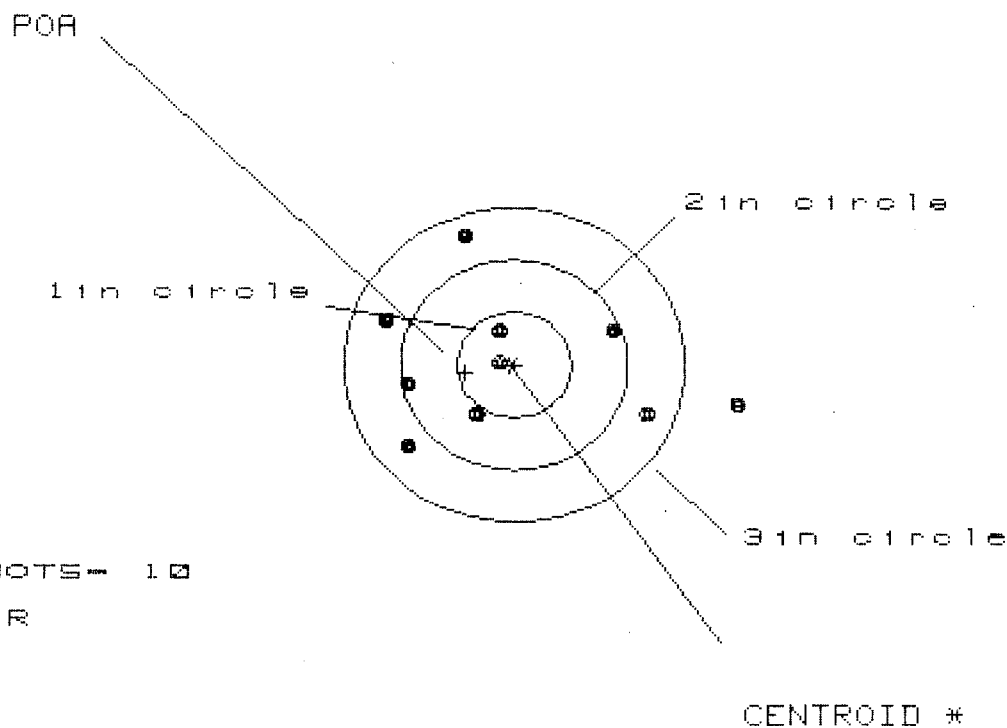
GS= 2.679

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	.938	1.034
MINIMUM X	-.985	-1.057	-.961
MAXIMUM Y	1.029	.896	.954
MINIMUM Y	-1.200	-.416	-.304
CENTROID X	-.242	-.170	-.266
CENTROID Y	-.027	.107	-.005
POA TO CENTROID in.	.244	.201	.266
MIN RADIUS	.174	.313	.167
MEAN RADIUS	.754	.715	.608
MAX RADIUS	1.364	1.178	1.121
HORIZONTAL SPREAD	1.995	1.995	1.995
VERTICAL SPREAD	2.229	1.312	1.258
EXTREME SPREAD	2.679	2.212	2.107
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.133

VS= 1.993

GS= 3.229

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.991	1.367	1.347
MINIMUM X	:	-1.142	-.921	-.941
MAXIMUM Y	:	1.235	1.192	.505
MINIMUM Y	:	-.758	-.801	-.652
CENTROID X	:	.432	.211	.231
CENTROID Y	:	.070	.113	-.036
POA TO CENTROID in.	:	.437	.239	.234
MIN RADIUS	:	.174	.054	.156
MEAN RADIUS	:	.989	.828	.785
MAX RADIUS	:	2.028	1.461	1.396
HORIZONTAL SPREAD	:	3.133	2.288	2.288
VERTICAL SPREAD	:	1.993	1.993	1.157
EXTREME SPREAD	:	3.229	2.448	2.448
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	

NUMBER IN THREE INCH CIRCLE =

9