

C6523367

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
 VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm
 REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO. C6523367

ORDER NO. 5716

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

Ø1



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523367

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9/25/90	KCR
	Magnaflux Bolt		9/25/90	KCR
615	Rollmark Caliber		9/25/90	63
617	Drill and Tap Sight Holes		9/26/90	EB
618	Polish Barrel RW		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-8/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	5	4 3/4	5			11/7/90	W.B
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			11/7/90	W.B
	H) Trigger Pull Test & Retainability						11-7-90	JS
	I) Firing Pin Indent	.0215	.0215	.0215			11/7/90	W.B
	J) Assemble Stock						11/7/90	RW
	K) Assemble Swivel Studs						11-20-90	JS
	L) Attach Front and Rear Sight Assemblies						11/7/90	RW
	M) Iron Sight Alignment						11/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/7/90	RW
	O) Attach Scope to Rifle						11/7/90	RW
	P) Detach & Attach Scope 20 Times						11/7/90	RW
640	Gallery Target & Test						11-8-90	K.T
	A) Time						11-8-90	K.T
	B) Malfunctions						11-8-90	KS
	C) Pierced Primers						11-8-90	KS
	D) Optical Clarity of Scope						11-8-90	KS
645	Inspect for Live Ammo						11-8-90	KS
655	Final Inspection						11-20-90	JS
	A) Headspace						11-20-90	JS
	B) Trigger Pull	244	244	246	247	255	11-20-90	JS
	C) Function						11-20-90	JS
660	Pack						12-17-90	PH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523367

DATE 11-7-90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.38	2.35	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.28	2.33	2.44	
PULL #3	2.21	2.33	2.35	2.46	
PULL #4	2.18	2.38	2.31	2.47	
PULL #5	2.40	2.37	2.28	2.55	
TOTAL	11.26	11.74	11.62		
AVG.	2.252	2.348	2.324		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.29		
PULL #2	3.40	3.29		
PULL #3	3.21	3.23		
PULL #4	3.25	3.26		
PULL #5	3.24	3.13		
TOTAL	16.47	16.20		
AVG.	3.294	3.24		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.36		4.30
PULL #2	4.30	4.19		4.30
PULL #3	4.36	4.35		4.34
PULL #4	4.35	4.30		4.32
PULL #5	4.13	4.29		4.31
TOTAL	21.49	21.49		21.57
AVG.	4.298	4.298		4.314

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523367
9 Nov 1990

CENTROIDAL DISTANCES

Ø TO	1	.212339
1 TO	2	.175855
1 TO	3	.132612
1 TO	4	.394645
1 TO	5	.159703

⊙ <----POA

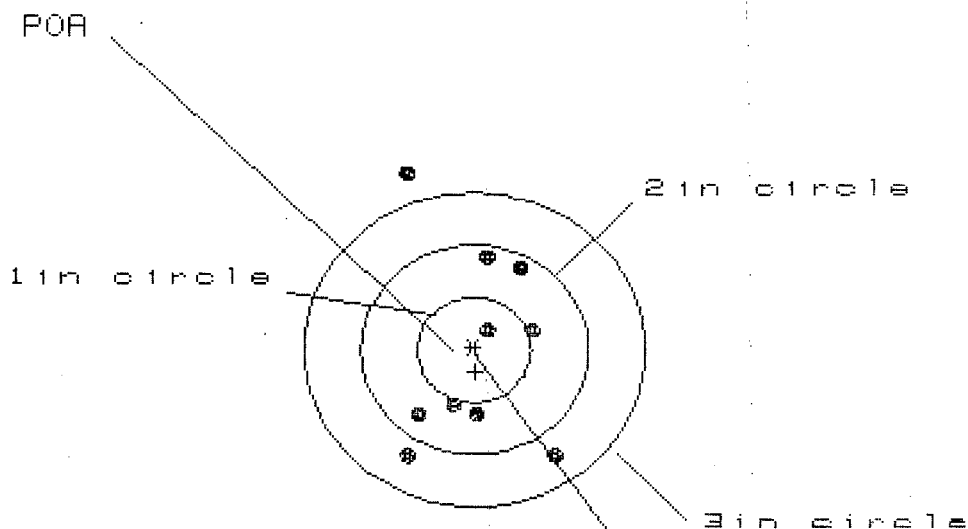
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0528
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0668494
THE AMR FOR THIS RIFLE IS: .9856

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6523367

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.336

VS= 2.688

GS= 3.002

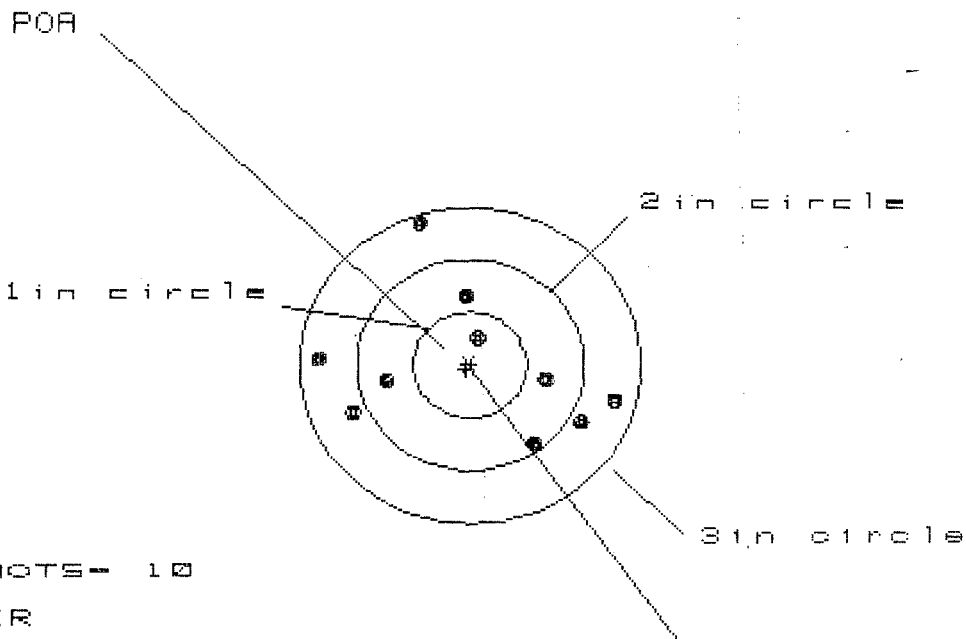
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.721	.652	.483
MINIMUM X	-.615	-.623	-.541
MAXIMUM Y	1.681	1.067	.964
MINIMUM Y	-1.007	-.820	-.880
CENTROID X	-.012	.057	-.025
CENTROID Y	.212	.025	.128
POA TO CENTROID in.	.212	.062	.130
MIN RADIUS	.205	.378	.289
MEAN RADIUS	.860	.737	.694
MAX RADIUS	1.790	1.068	1.033
HORIZONTAL SPREAD	1.336	1.275	1.024
VERTICAL SPREAD	2.688	1.887	1.844
EXTREME SPREAD	3.002	2.031	2.031
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

9 May 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 10

HS= 2.666

VS= 2.176

GS= 2.694

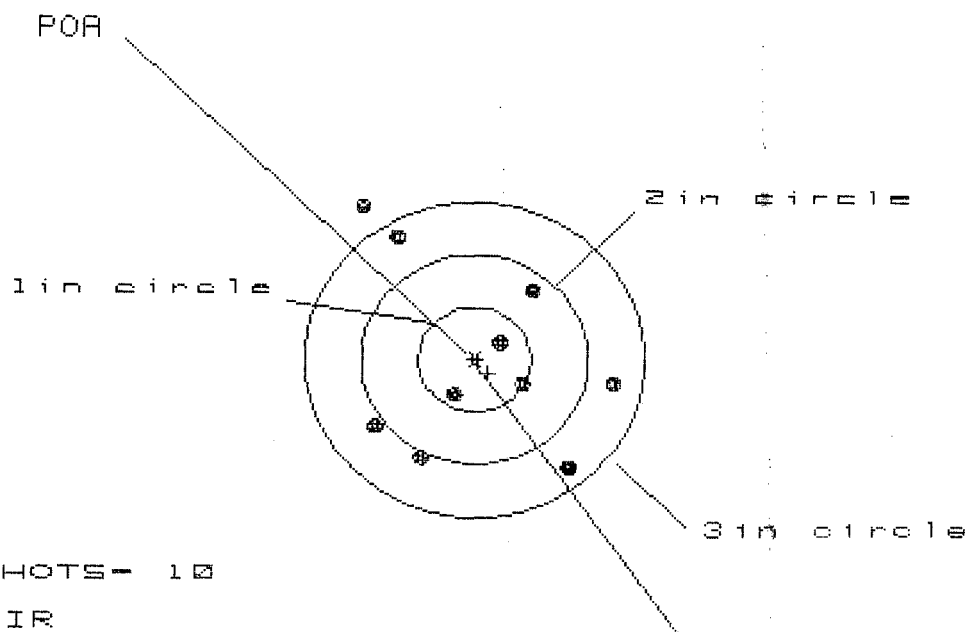
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.240	1.051
MINIMUM X	:	-1.378	-1.426	-1.255
MAXIMUM Y	:	1.394	.826	.854
MINIMUM Y	:	-.782	-.627	-.599
CENTROID X	:	.033	.081	.260
CENTROID Y	:	.042	-.113	-.141
POA TO CENTROID in.	:	.053	.139	.295
MIN RADIUS	:	.281	.430	.470
MEAN RADIUS	:	.978	.924	.834
MAX RADIUS	:	1.460	1.443	1.289
HORIZONTAL SPREAD	:	2.666	2.666	2.316
VERTICAL SPREAD	:	2.176	1.453	1.453
EXTREME SPREAD	:	2.694	2.694	2.321
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 2.142

VS= 2.510

GS= 3.068

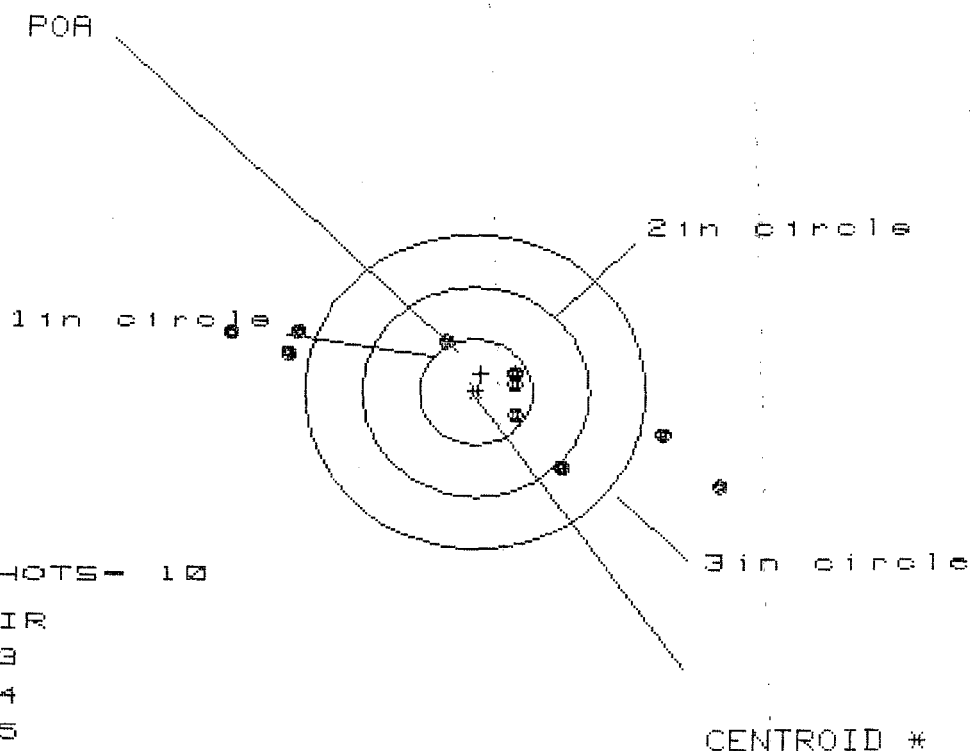
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.082	.986
MINIMUM X	:	-.954	-1.014	-1.110
MAXIMUM Y	:	1.473	1.326	.953
MINIMUM Y	:	-1.037	-.873	-.707
CENTROID X	:	-.117	-.011	.085
CENTROID Y	:	.131	-.033	-.199
POA TO CENTROID in.	:	.176	.035	.216
MIN RADIUS	:	.290	.312	.237
MEAN RADIUS	:	.977	.861	.765
MAX RADIUS	:	1.755	1.533	1.149
HORIZONTAL SPREAD	:	2.142	2.096	2.096
VERTICAL SPREAD	:	2.510	2.199	1.660
EXTREME SPREAD	:	3.068	2.647	2.131
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 5

HS= 4.284

VS= 1.516

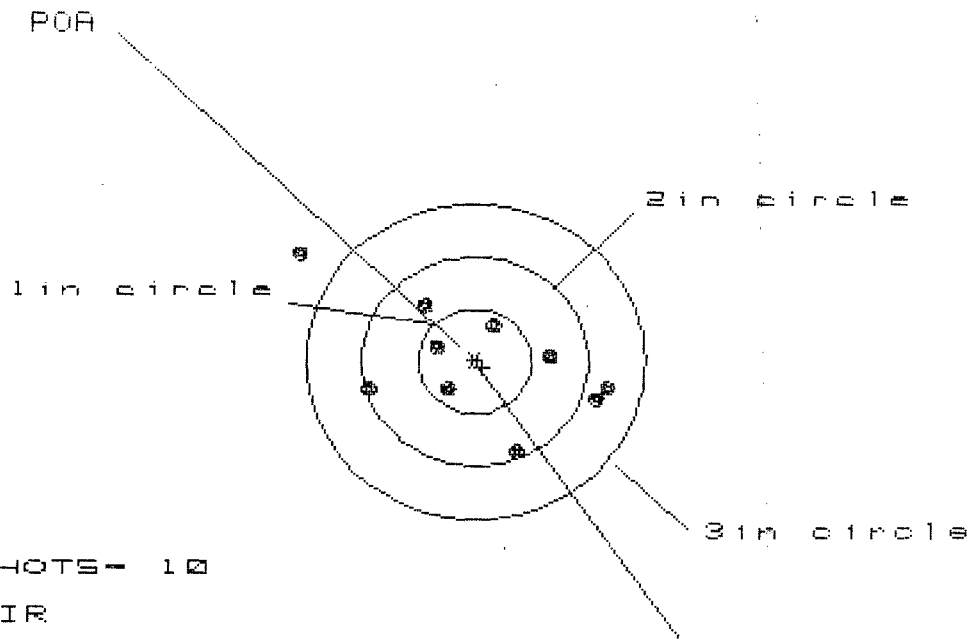
GS= 4.553

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.150	1.852	1.614
MINIMUM X	:	-2.144	-1.906	-1.642
MAXIMUM Y	:	.625	.526	.592
MINIMUM Y	:	-.891	-.823	-.757
CENTROID X	:	-.048	-.286	-.048
CENTROID Y	:	-.181	-.082	-.148
POA TO CENTROID in.	:	.187	.298	.156
MIN RADIUS	:	.372	.367	.362
MEAN RADIUS	:	1.244	1.152	.983
MAX RADIUS	:	2.327	1.976	1.700
HORIZONTAL SPREAD	:	4.294	3.758	3.256
VERTICAL SPREAD	:	1.516	1.349	1.349
EXTREME SPREAD	:	4.553	3.894	3.367
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in - 9

HS= 2.768

VS= 1.838

GS= 3.052

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.195	1.020	1.038
MINIMUM X	:	-1.573	-1.077	-.950
MAXIMUM Y	:	1.008	.629	.608
MINIMUM Y	:	-.830	-.718	-.739
CENTROID X	:	-.061	.114	-.013
CENTROID Y	:	.060	-.052	-.031
POA TO CENTROID in.	:	.086	.125	.034
MIN RADIUS	:	.392	.465	.374
MEAN RADIUS	:	.869	.756	.705
MAX RADIUS	:	1.868	1.089	1.088
HORIZONTAL SPREAD	:	2.768	2.097	1.987
VERTICAL SPREAD	:	1.838	1.347	1.347
EXTREME SPREAD	:	3.052	2.097	1.991
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	