

C6611655

MODEL 700TM M24

Model **SMS**TM

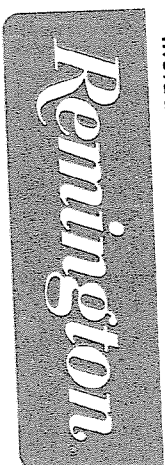
Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.



Remington[®]


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

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

MODEL 700TM H24

SERIAL NO.
C6611655

ORDER NO.
5716

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

20


5716 C6611655

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611655

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/25/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/11/91	KS
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	YB
617	Drill and Tap Sight Holes	1 24	91	LB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		1-15-91	JA
	Apply Coating (Bolt)		2	JA
625	Final Assembly		3/8/91	KA
	A) Clean inside of Bolt Assembly		3/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KA
	C) Inspect Ejector Hole for Chamfer		3/8/91	KA
	D) Oil Firing Pin Ass'y		3/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		3-22-91	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3-22-91	KS
	G) Safety Off Force	2 1/4	2 1/2	2 1/4			3-22-91	KS
	H) Trigger Pull Test & Retainability						3-22-91	RW
	I) Firing Pin Indent	0.0255	.021	.021			3-22-91	KS.
	J) Assemble Stock						3/25/91	KS
	K) Assemble Swivel Studs						4-8-91	DH
	L) Attach Front and Rear Sight Assemblies						3/25/91	KS
	M) Iron Sight Alignment						3/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						3/25/91	KS
	O) Attach Scope to Rifle						3/25/91	KS
	P) Detach & Attach Scope 20 Times						3/25/91	KS
640	Gallery Target & Test						4/4/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/4/91	KS
655	Final Inspection							
	A) Headspace						4-8-91	DH
	B) Trigger Pull	2.26	2.40	2.39	2.45	2.43	4/5/91	KS
	C) Function						4-8-91	DH
660	Pack						6-17-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611655

DATE 3/22/91

TESTER Rw

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.59	2.54	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.49	2.41	2.40	
PULL #3	2.27	2.48	2.52	2.39	
PULL #4	2.29	2.49	2.51	2.45	
PULL #5	2.19	2.49	2.61	2.43	
TOTAL	11.45	12.54	12.57		
AVG.	2.29	2.51	2.51		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.17		
PULL #2	3.05	3.32		
PULL #3	3.06	3.21		
PULL #4	3.11	3.30		
PULL #5	3.19	3.42		
TOTAL	15.61	16.42		
AVG.	3.12	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.03		4.10
PULL #2	4.21	4.23		4.04
PULL #3	4.12	4.28		4.22
PULL #4	4.22	4.42		4.39
PULL #5	4.26	4.11		4.44
TOTAL	20.85	21.07		21.19
AVG.	4.17	4.22		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611655
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.2449
1 TO	2	.263471
1 TO	3	.461532
1 TO	4	.239376
1 TO	5	.463228

POI <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0194
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0460825
THE RM FOR THIS RIFLE IS: .7026

4 Apr 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8611655

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 9

HS= 2.370

VS= 2.406

GS= 2.879

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.420

.627

.687

-.950

-.792

-.732

1.086

.939

.738

-1.320

-1.108

-.991

.126

-.032

-.092

-.210

-.063

-.180

.244

.071

.202

.334

.305

.208

.824

.668

.607

1.939

1.140

1.013

2.370

1.419

1.419

2.406

2.047

1.729

2.879

2.179

1.816

3

6

9

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611655

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.639

VS= 1.772

CS= 2.230

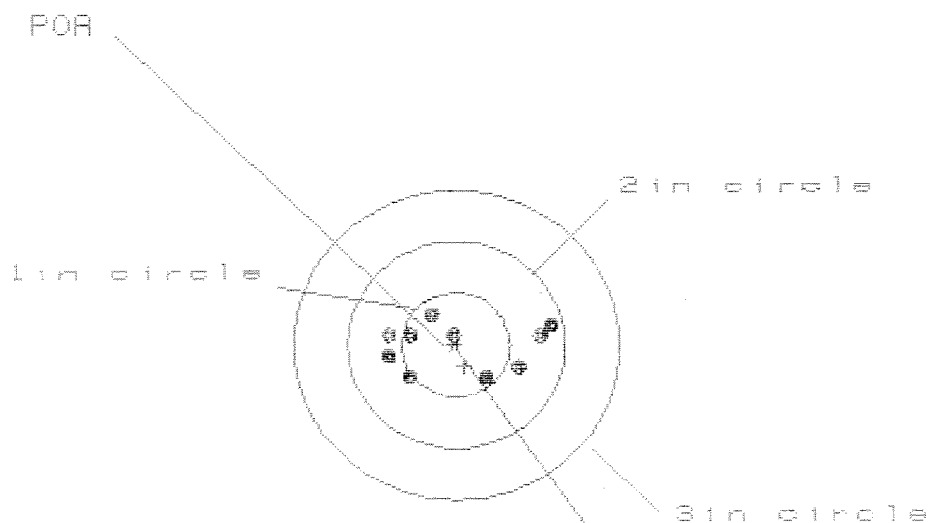
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.902	1.001	.955
MINIMUM X	:	-.737	-.638	-.684
MAXIMUM Y	:	.753	.422	.305
MINIMUM Y	:	-1.019	-.935	-.579
CENTROID X	:	.090	-.009	.037
CENTROID Y	:	.051	-.033	.084
POA TO CENTROID in.	:	.103	.034	.092
MIN RADIUS	:	.155	.042	.163
MEAN RADIUS	:	.693	.629	.578
MAX RADIUS	:	1.166	1.065	.987
HORIZONTAL SPREAD	:	1.639	1.639	1.639
VERTICAL SPREAD	:	1.772	1.357	.884
EXTREME SPREAD	:	2.230	1.885	1.835
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 10

3in = 10

HE= 1.529

VS= .659

GS= 1.565

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.883	.859	.733
MINIMUM X	:	-.646	-.548	-.441
MAXIMUM Y	:	.341	.364	.376
MINIMUM Y	:	-.319	-.295	-.283
CENTROID X	:	-.078	-.176	-.283
CENTROID Y	:	.204	.181	.169
POA TO CENTROID in.	:	.219	.252	.330
MIN RADIUS	:	.103	.129	.207
MEAN RADIUS	:	.548	.494	.432
MAX RADIUS	:	.907	.864	.746
HORIZONTAL SPREAD	:	1.529	1.407	1.174
VERTICAL SPREAD	:	.659	.659	.659
EXTREME SPREAD	:	1.565	1.421	1.196
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Apr 1991

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CENTERFIRE PATTERNS

4

POA

2in circle

1in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.460

VS= 1.542

GS= 1.702

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.738	.781	.696
MINIMUM X	-.723	-.679	-.682
MAXIMUM Y	.729	.639	.687
MINIMUM Y	-.813	-.600	-.552
CENTROID X	-.075	-.118	-.033
CENTROID Y	-.080	.010	-.038
POA TO CENTROID in.	.109	.118	.050
MIN RADIUS	.407	.389	.466
MEAN RADIUS	.684	.655	.636
MAX RADIUS	.902	.801	.794
HORIZONTAL SPREAD	1.460	1.460	1.378
VERTICAL SPREAD	1.542	1.239	1.239
EXTREME SPREAD	1.702	1.560	1.466
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 10		
NUMBER IN THREE INCH CIRCLE	= 10		

4 Apr 1991

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CENTERFIRE PATTERNS # 5

POA

2 in circle

1 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

CENTROID #

HS= 1.716

VS= 1.872

GS= 2.281

PATTERN #	1	3	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.948	1.032	1.113
MINIMUM X	-.768	-.684	-.603
MAXIMUM Y	.861	.749	.774
MINIMUM Y	-1.011	-.877	-.784
CENTROID X	.034	-.050	-.131
CENTROID Y	.244	.356	.263
POA TO CENTROID in.	.246	.360	.293
MIN RADIUS	.163	.023	.137
MEAN RADIUS	.764	.679	.632
MAX RADIUS	1.266	1.115	1.160
HORIZONTAL SPREAD	1.716	1.716	1.716
VERTICAL SPREAD	1.872	1.626	1.558
EXTREME SPREAD	2.281	1.928	1.928
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	