

06225578

MODEL 700™ M24

Model **SMS**™

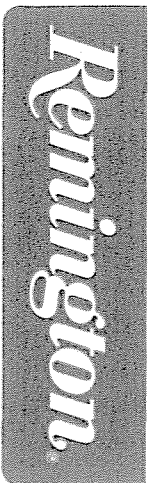
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®



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

MODEL 700™ H24

SERIAL NO.

06225578

ORDER NO.

5716

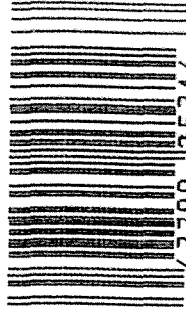
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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5716 06225578

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225578

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9	88	RW
600	Proof	12 9	88	RW
607	Check Headspace	12 9	88	RW
610	Dis-assemble Gun	12 9	88	RW
612	Magnaflux Barrel Action		12 22 88	PFC.
	Magnaflux Bolt		1-3-89	PFC.
615	Rollmark Caliber		12/22/88	WBC
617	Drill and Tap Sight Holes	11 3389		FB
618	Polish Barrel	12 2	88	WJT
620	Apply Coatings (Barrel Action)		1-16-89	ISA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/2/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/2/89	RW
	C) Inspect Ejector Hole for Chamfer		2/2/89	RW
	D) Oil Firing Pin Ass'y		2/2/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/89	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/2/89	JS
	G) Safety Off Force	3	3	3			3/2/89	JS
	H) Trigger Pull Test & Retainability						2/2/89	JS
	I) Firing Pin Indent	.021	.021	.021			3/2/89	JS
	J) Assemble Stock						2/9/89	RW
	K) Assemble Swivel Studs						6 Mar 89	JS
	L) Attach Front and Rear Sight Assemblies						2/9/89	RW
	M) Iron Sight Alignment						2/9/89	RW
	N) Detach Front & Rear Sights & place in numbered container						2/9/89	RW
	O) Attach Scope to Rifle						10/2/89	JS
	P) Detach & Attach Scope 20 Times						10/2/89	JS
640	Gallery Target & Test	66 R	85 L				2/14/89	K
	A) Time						11	K
	B) Malfunctions						11	
	C) Pierced Primers					NONE	11	K
	D) Optical Clarity of Scope					OK	2/14/89	K
645	Inspect for Live Ammo					NONE	2/14/89	K
655	Final Inspection							
	A) Headspace						6 Mar 89	JS
	B) Trigger Pull	2.58	2.59	2.52	2.53	2.51	6 Mar 89	JS
	C) Function						6 Mar 89	JS
660	Pack						3/22	W.B.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 622578

DATE 4-6-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.44	2.52		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.31	2.50		
PULL #3	2.33	2.39	2.51		
PULL #4	2.25	2.27	2.50		
PULL #5	2.23	2.31	2.50		
TOTAL	11.44	11.72	12.53		
AVG.	2.28	2.34	2.51		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.29		
PULL #2	3.28	3.19		
PULL #3	3.19	3.12		
PULL #4	3.15	3.18		
PULL #5	3.19	3.09		
TOTAL	16.09	15.87		
AVG.	3.21	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.28		
PULL #2	4.28	4.28		
PULL #3	4.30	4.34		
PULL #4	4.33	4.09		
PULL #5	4.30	4.00		
TOTAL	21.39	20.99		
AVG.	4.27	4.19		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225578
17 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.59895
1 TO	2	.0570789
1 TO	3	.40321
1 TO	4	.280845
1 TO	5	.688796

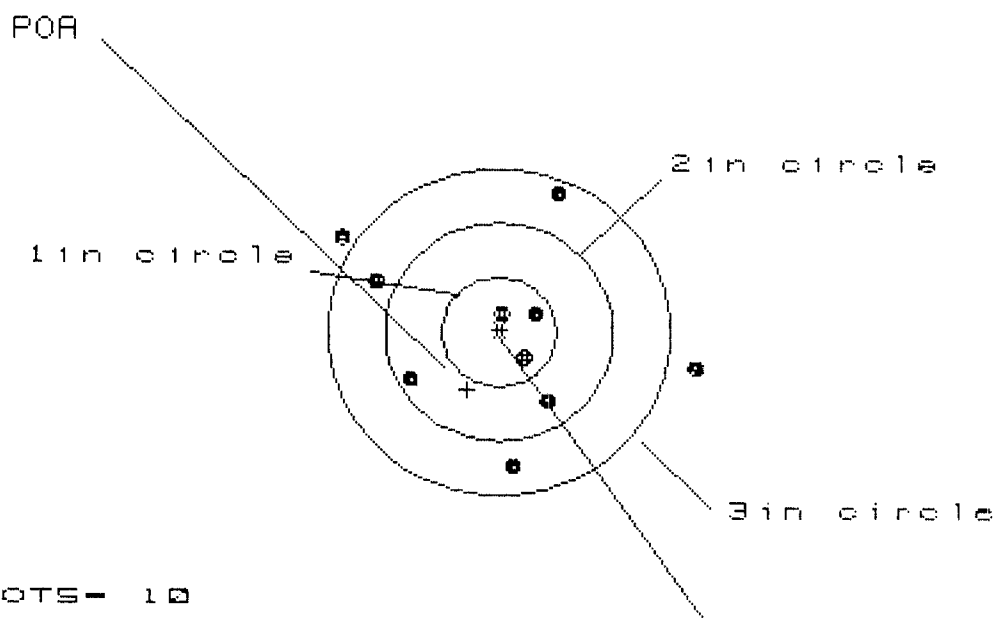
$\frac{3}{4}$
+5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2832
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2738
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .393915
THE AMR FOR THIS RIFLE IS: .903

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FILE:/PATTERNING/CENTERFIRE_PATT/C6225578

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.098

VS = 2.446

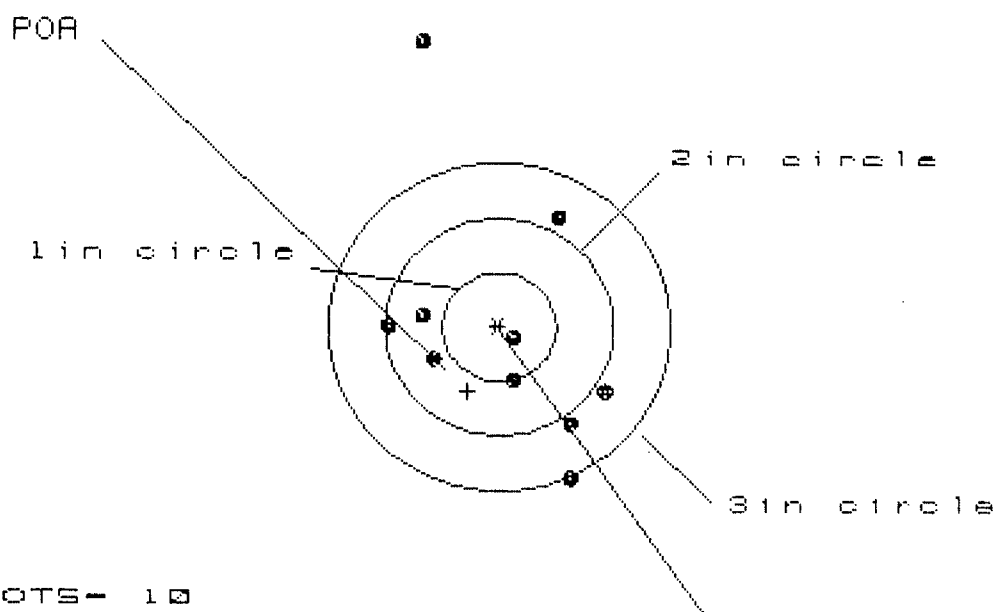
GS = 3.344

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.729	.669	.522
MINIMUM X	-1.369	-1.177	-1.019
MAXIMUM Y	1.223	1.180	1.285
MINIMUM Y	-1.223	-1.266	-1.161
CENTROID X	.279	.087	.234
CENTROID Y	.530	.573	.468
POA TO CENTROID in.	.599	.579	.523
MIN RADIUS	.147	.216	.213
MEAN RADIUS	.952	.879	.770
MAX RADIUS	1.771	1.444	1.387
HORIZONTAL SPREAD	3.098	1.846	1.541
VERTICAL SPREAD	2.446	2.446	2.446
EXTREME SPREAD	3.344	2.592	2.468
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.879

VS= 3.990

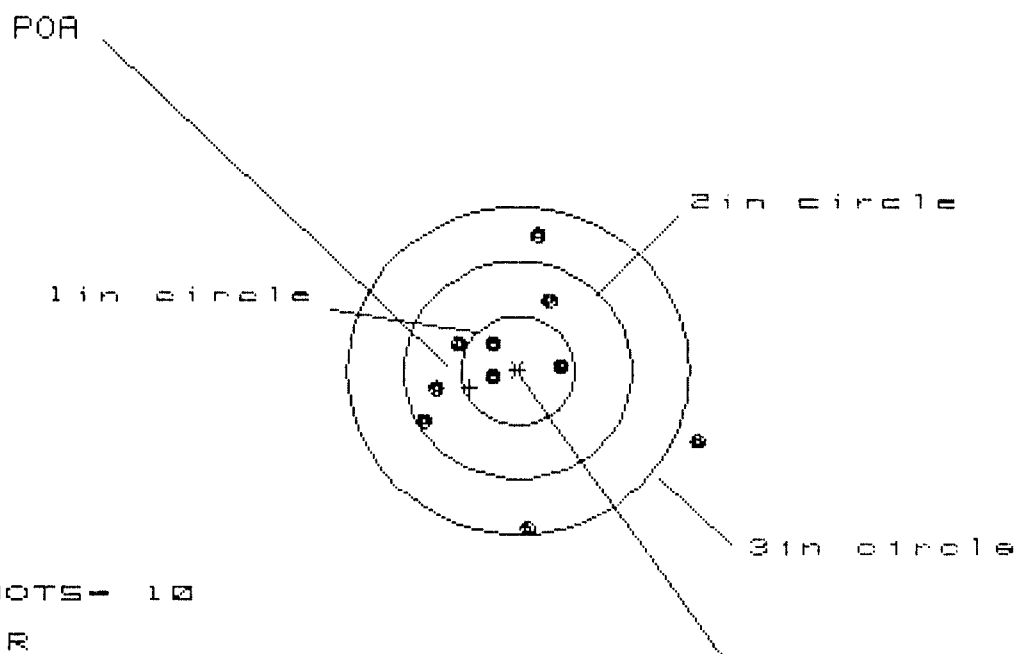
GS= 4.196

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.866	.935
MINIMUM X	:	-.939	-1.013	-.944
MAXIMUM Y	:	2.582	1.302	1.162
MINIMUM Y	:	-1.408	-1.122	-.696
CENTROID X	:	.276	.350	.281
CENTROID Y	:	.587	.301	.441
POA TO CENTROID in.	:	.649	.461	.523
MIN RADIUS	:	.145	.184	.104
MEAN RADIUS	:	1.043	.808	.748
MAX RADIUS	:	2.667	1.373	1.266
HORIZONTAL SPREAD	:	1.879	1.879	1.879
VERTICAL SPREAD	:	3.990	2.424	1.858
EXTREME SPREAD	:	4.196	2.427	1.980
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.454

VS = 2.705

GS = 2.706

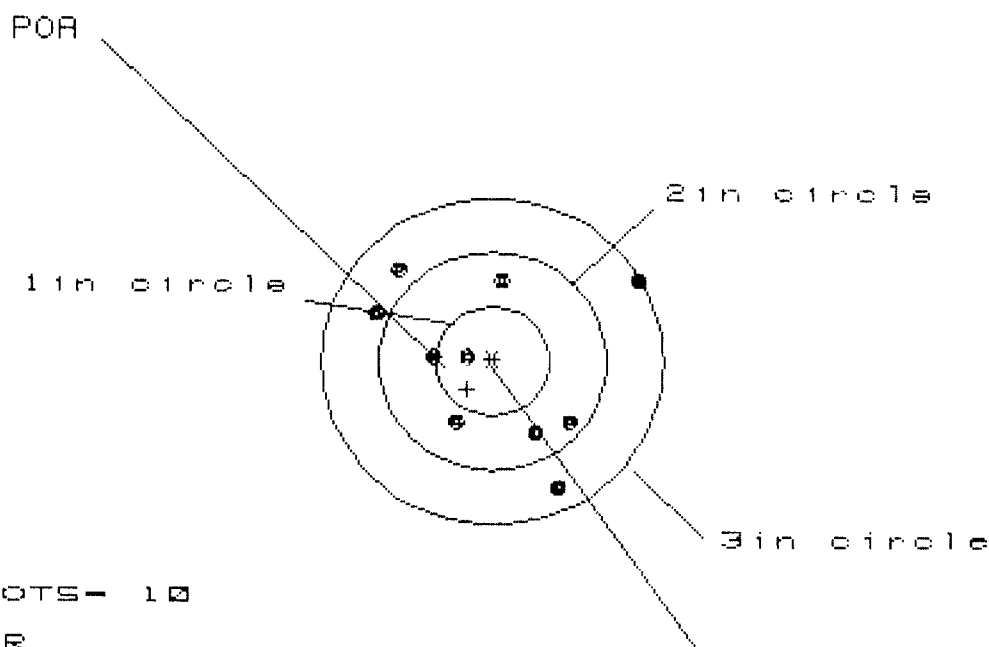
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.602	.514	.547
MINIMUM X	:	-.852	-.674	-.641
MAXIMUM Y	:	1.294	1.224	1.038
MINIMUM Y	:	-1.411	-1.481	-.668
CENTROID X	:	.422	.244	.211
CENTROID Y	:	.153	.223	.409
POA TO CENTROID in.	:	.449	.331	.460
MIN RADIUS	:	.195	.142	.041
MEAN RADIUS	:	.831	.689	.569
MAX RADIUS	:	1.721	1.505	1.107
HORIZONTAL SPREAD	:	2.454	1.188	1.188
VERTICAL SPREAD	:	2.705	2.705	1.706
EXTREME SPREAD	:	2.706	2.706	1.990
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 10

HS- 2.252

VS- 1.972

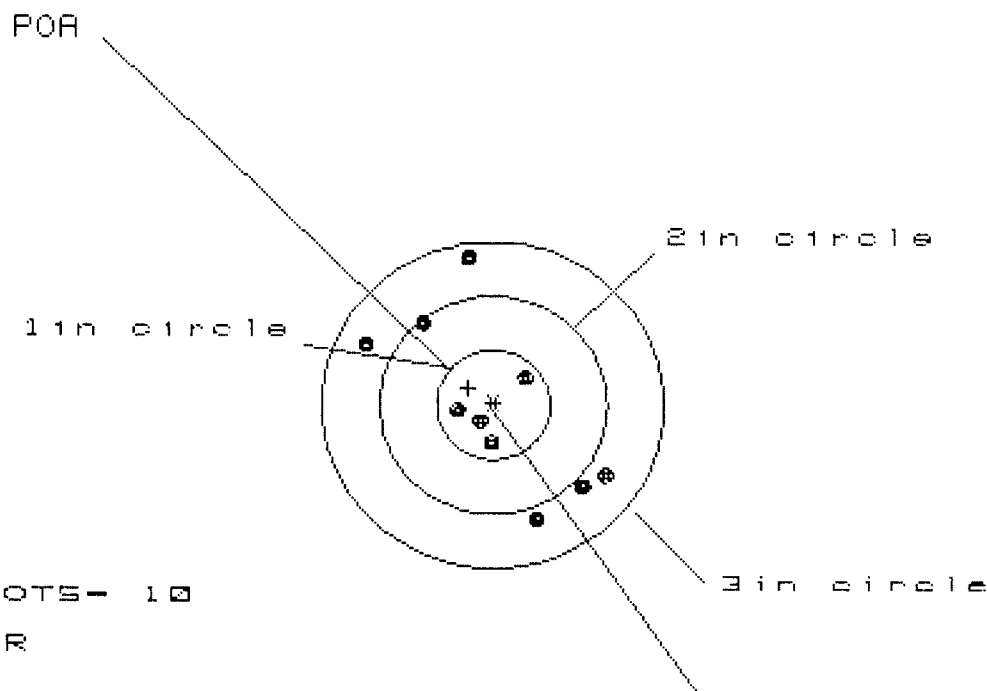
GS- 2.393

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	.792	.881
MINIMUM X	:	-1.004	-.865	-.776
MAXIMUM Y	:	.801	.885	.749
MINIMUM Y	:	-1.171	-1.087	-.659
CENTROID X	:	.222	.083	-.006
CENTROID Y	:	.255	.171	.307
POA TO CENTROID in.	:	.338	.190	.307
MIN RADIUS	:	.238	.161	.008
MEAN RADIUS	:	.876	.783	.685
MAX RADIUS	:	1.456	1.300	1.079
HORIZONTAL SPREAD	:	2.252	1.657	1.657
VERTICAL SPREAD	:	1.972	1.972	1.408
EXTREME SPREAD	:	2.393	2.393	1.984
NUMBER IN ONE INCH CIRCLE	=	1		
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 = 4

2in = 5

3in = 10

HS= 2.016

VS= 2.428

GS= 2.500

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.935	.917	.779
MINIMUM X	:	-1.081	-1.099	-.813
MAXIMUM Y	:	1.364	.902	.995
MINIMUM Y	:	-1.064	-.912	-.819
CENTROID X	:	.217	.235	.373
CENTROID Y	:	-.156	-.308	-.401
POA TO CENTROID in.	:	.267	.387	.547
MIN RADIUS	:	.205	.179	.229
MEAN RADIUS	:	.813	.733	.669
MAX RADIUS	:	1.374	1.327	1.284
HORIZONTAL SPREAD	:	2.016	2.016	1.592
VERTICAL SPREAD	:	2.428	1.814	1.814
EXTREME SPREAD	:	2.500	2.358	2.113
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

MOD. _____ GA. _____ GUN # C6225578
 CAL. _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Extractor sticks back	Blacksmith DICK
	2nd		
	2/ 15/ 89	New EXTRACTOR	
	3rd	100 Rd. OK.	
	4th		
		FUNCTION	

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rds OK AC	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		