

C6225594

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 # C6225594

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber		4/14/89	KCR
617	Drill and Tap Sight Holes	4 14	89	FB
618	Polish Barrel RB	4 14	89	FB
620	Apply Coatings (Barrel Action)		4/19/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/8/89	RW
	C) Inspect Ejector Hole for Chamfer		5/8/89	RW
	D) Oil Firing Pin Ass'y		5/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/11/89	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	5/12/89	JU		
	G) Safety Off Force	2	3	3	5/12/89	JU		
	H) Trigger Pull Test & Retainability				5/11/89	WB		
	I) Firing Pin Indent	.022	.021.5	.020.5	5/12/89	JU		
	J) Assemble Stock				5/12/89	RW		
	K) Assemble Swivel Studs				16 May 89	JS		
	L) Attach Front and Rear Sight Assemblies				5/12/89	RW		
	M) Iron Sight Alignment				5/12/89	RW		
	N) Detach Front & Rear Sights & place in numbered container				5/12/89	RW		
	O) Attach Scope to Rifle				5/12/89	JU		
	P) Detach & Attach Scope 20 Times				5/15/89	JU		
640	Gallery Target & Test	60 R	100 L	5/15/89	DH			
	A) Time			5/15/89	DH			
	B) Malfunctions			5/15/89	DH			
	C) Pierced Primers			5/15/89	DH			
	D) Optical Clarity of Scope			5/15/89	DH			
645	Inspect for Live Ammo			5/15/89	DH			
655	Final Inspection							
	A) Headspace				16 May 89	JS		
	B) Trigger Pull	2.70	2.72	2.65	2.66	2.72	16 May 89	JS
	C) Function						16 May 89	JS
660	Pack						26 June 89	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225594

DATE 3-28-90

TESTER J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.43		2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.42		2.40	
PULL #3	2.39	2.46		2.44	
PULL #4	2.46	2.38		2.45	
PULL #5	2.42	2.40		2.40	
TOTAL	12.30	12.09		11.93	
AVG.	2.46	2.418		2.386	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.37		
PULL #2	3.58	3.44		
PULL #3	3.32	3.40		
PULL #4	3.48	3.44		
PULL #5	3.40	3.46		
TOTAL	17.31	17.11		
AVG.	3.462	3.422		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.26		
PULL #2	4.26	4.25		
PULL #3	4.28	4.30		
PULL #4	4.25	4.23		
PULL #5	4.28	4.24		
TOTAL	21.36	21.28		
AVG.	4.272	4.256		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225594
16 May 1989

CENTROIDAL DISTANCES

0 TO	1	.4634
1 TO	2	.209914
1 TO	3	1.11397
1 TO	4	.891278
1 TO	5	.506495

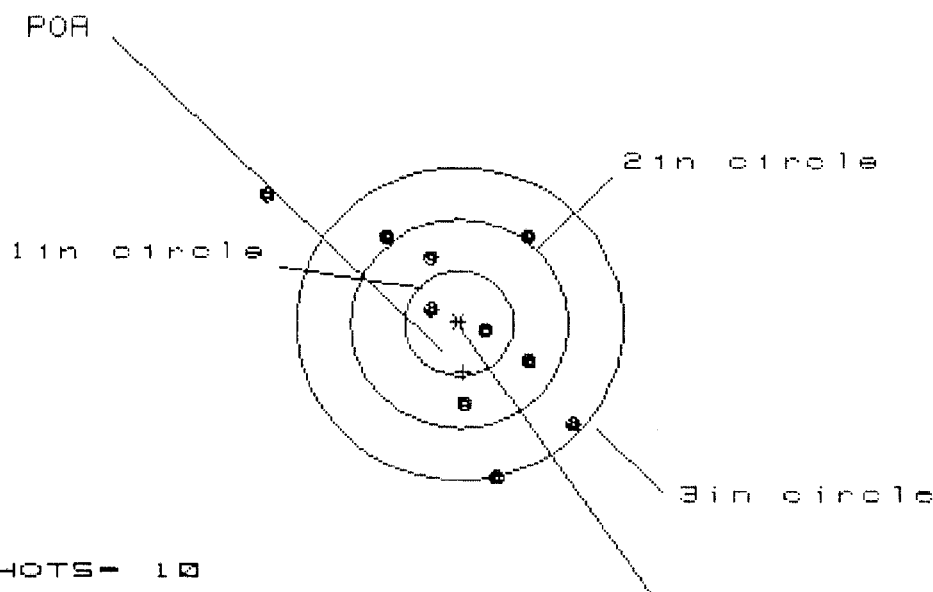
$\frac{4}{3} \frac{2}{5} < \text{----FOR}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .307451
THE AMR FOR THIS RIFLE IS: .9166

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225594

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.747

VS= 2.695

GS= 3.558

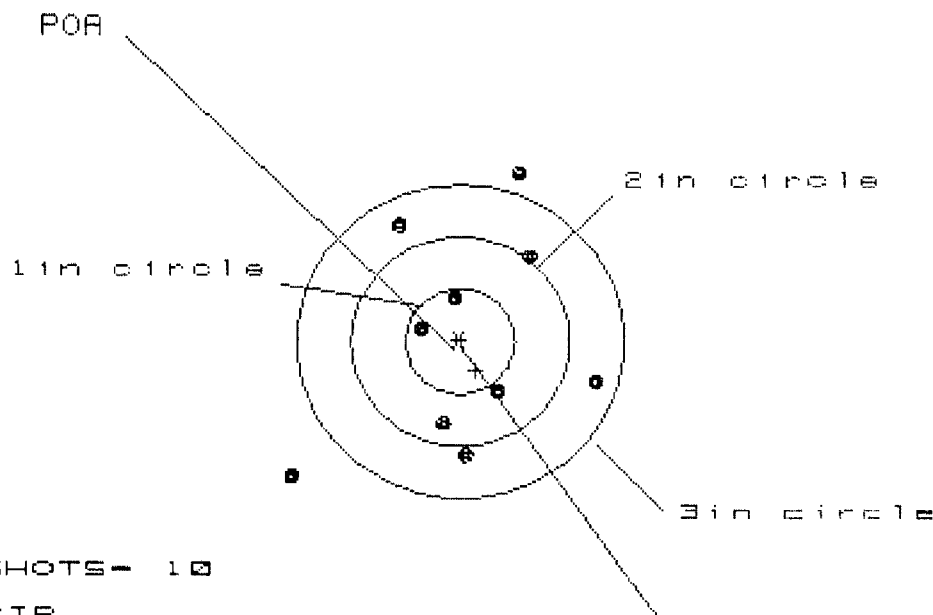
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.822	.836
MINIMUM X	:	-1.732	-.829	-.815
MAXIMUM Y	:	1.271	.939	.779
MINIMUM Y	:	-1.424	-1.283	-1.009
CENTROID X	:	-.036	.157	.143
CENTROID Y	:	.462	.321	.481
POA TO CENTROID in.	:	.463	.357	.502
MIN RADIUS	:	.281	.085	.143
MEAN RADIUS	:	.987	.829	.767
MAX RADIUS	:	2.148	1.287	1.310
HORIZONTAL SPREAD	:	2.747	1.651	1.651
VERTICAL SPREAD	:	2.695	2.222	1.788
EXTREME SPREAD	:	3.558	2.428	2.428
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225594

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.830

VS = 2.946

GS = 3.627

CENTROID #

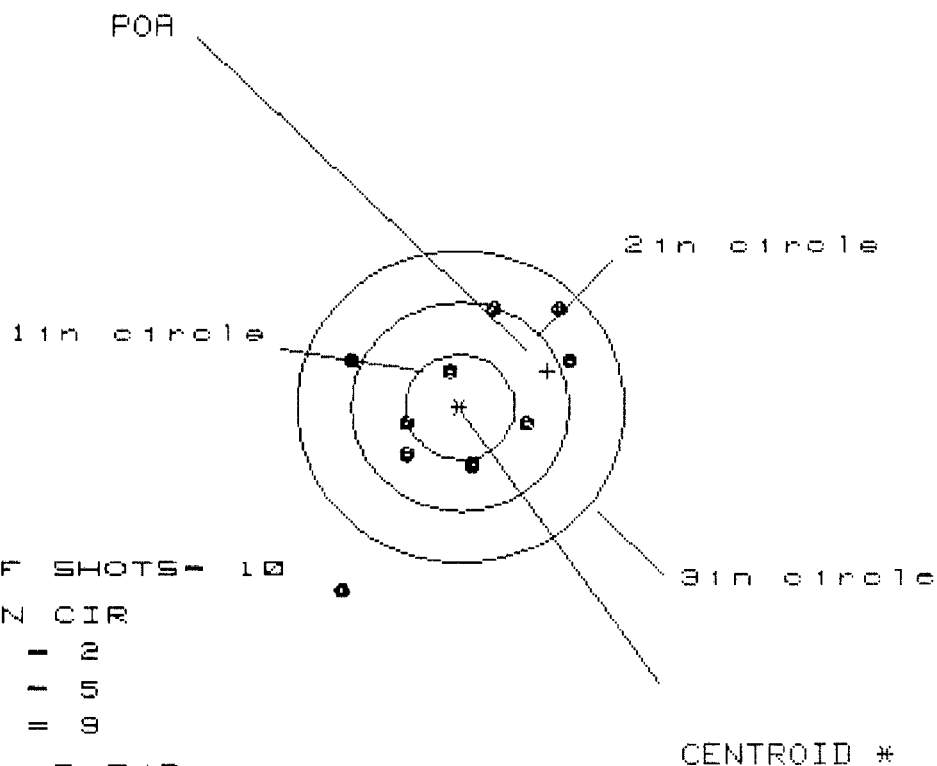
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.237	1.060	1.103
MINIMUM X	:	-1.593	-.754	-.711
MAXIMUM Y	:	1.637	1.492	1.152
MINIMUM Y	:	-1.308	-1.256	-1.069
CENTROID X	:	-.144	.033	-.010
CENTROID Y	:	.282	.427	.240
POA TO CENTROID in.	:	.316	.428	.241
MIN RADIUS	:	.376	.332	.433
MEAN RADIUS	:	1.070	.956	.864
MAX RADIUS	:	2.062	1.532	1.354
HORIZONTAL SPREAD	:	2.830	1.814	1.814
VERTICAL SPREAD	:	2.946	2.748	2.221
EXTREME SPREAD	:	3.627	2.795	2.371
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225594

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.043

VS= 2.697

GS= 3.283

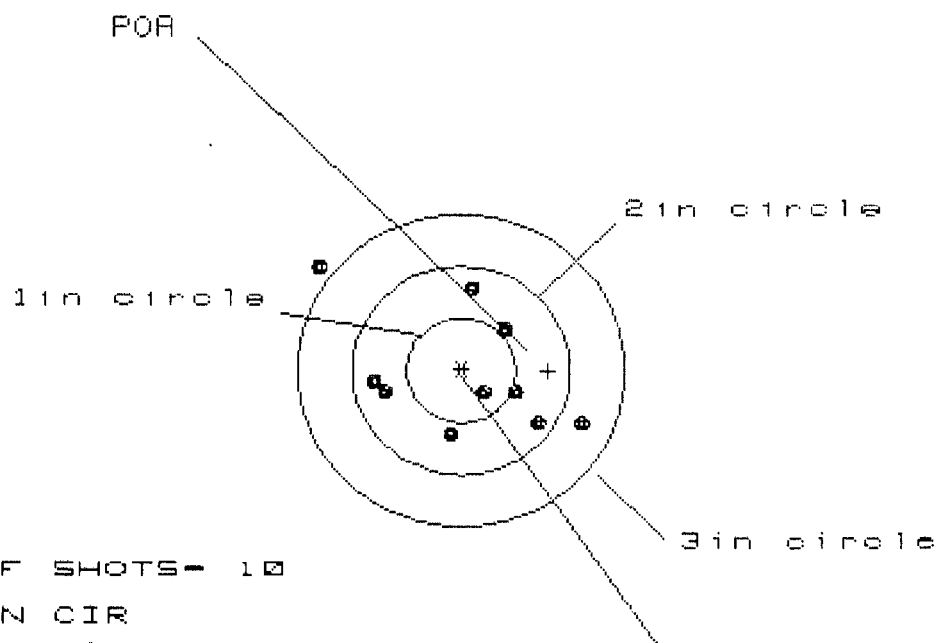
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.996	.880	.979
MINIMUM X	:	-1.047	-1.088	-.989
MAXIMUM Y	:	.967	.775	.864
MINIMUM Y	:	-1.730	-.798	-.709
CENTROID X	:	-.806	-.690	-.789
CENTROID Y	:	-.343	-.151	-.240
POA TO CENTROID in.	:	.876	.706	.825
MIN RADIUS	:	.379	.247	.281
MEAN RADIUS	:	.935	.799	.753
MAX RADIUS	:	2.022	1.107	1.054
HORIZONTAL SPREAD	:	2.043	1.968	1.968
VERTICAL SPREAD	:	2.697	1.573	1.573
EXTREME SPREAD	:	3.283	1.986	1.970
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225594

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 2.362

VS= 1.598

GS= 2.786

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.922	.631
MINIMUM X	:	-1.296	-.915	-.800
MAXIMUM Y	:	1.009	.945	.900
MINIMUM Y	:	-.589	-.477	-.522
CENTROID X	:	-.800	-.656	-.771
CENTROID Y	:	.003	-.109	-.064
POA TO CENTROID in.	:	.800	.665	.774
MIN RADIUS	:	.319	.138	.254
MEAN RADIUS	:	.800	.663	.637
MAX RADIUS	:	1.643	.988	.902
HORIZONTAL SPREAD	:	2.362	1.837	1.431
VERTICAL SPREAD	:	1.598	1.422	1.422
EXTREME SPREAD	:	2.786	1.881	1.488
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225584

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 3.084

VS= 1.625

GS= 3.241

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.218	1.011	.440
MINIMUM X	:	-1.866	-.489	-.363
MAXIMUM Y	:	.819	.781	.858
MINIMUM Y	:	-.806	-.844	-.767
CENTROID X	:	.343	.550	.424
CENTROID Y	:	.126	.164	.087
POA TO CENTROID in.	:	.365	.574	.433
MIN RADIUS	:	.199	.157	.111
MEAN RADIUS	:	.791	.658	.570
MAX RADIUS	:	1.897	1.184	.868
HORIZONTAL SPREAD	:	3.084	1.500	.803
VERTICAL SPREAD	:	1.625	1.625	1.625
EXTREME SPREAD	:	3.241	1.755	1.652
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	




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

MODEL 700™ H24

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

SERIAL NO.
C6225594

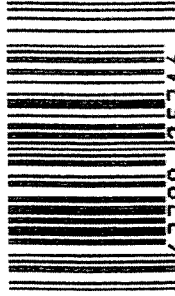
ORDER NO.
5716

Ø1



5716 C6225594

UPC



0 47700 25716 7