

05649140

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



M2400065302

Remington®



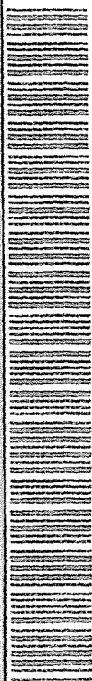
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
 firearm.

MODEL 700™ H24

SERIAL NO.
C6649140

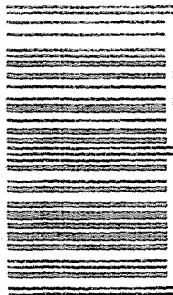
ORDER NO.
5716

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



5716 C6649140

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649140

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	KB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7/22/91	WB
	Apply Coating (Bolt)		7/22/91	WB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{1}{2}$	4 $\frac{1}{4}$			8-16-91	DH
	G) Safety Off Force	2 $\frac{1}{2}$	2	2 $\frac{1}{4}$			8-16-91	DH
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.023	.021	.022			8-16-91	DH
	J) Assemble Stock						8/17/91	RW
	K) Assemble Swivel Studs						8-21-91	A
	L) Attach Front and Rear Sight Assemblies						8/17/91	RW
	M) Iron Sight Alignment						8/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/17/91	RW
	O) Attach Scope to Rifle						8/17/91	RW
	P) Detach & Attach Scope 20 Times						8/17/91	RW
640	Gallery Target & Test						8-19-91	DH
	A) Time						8-19-91	DH
	B) Malfunctions						8-19-91	DH
	C) Pierced Primers						8-19-91	DH
	D) Optical Clarity of Scope						8-19-91	DH
645	Inspect for Live Ammo						8-19-91	DH
655	Final Inspection							
	A) Headspace						8-21-91	A
	B) Trigger Pull	2.47	2.56	2.61	2.65	2.68	8-21-91	DH
	C) Function						8-21-91	A
660	Pack						8-16-91	DH

AVERAGE PULL FORCE BETWEEN INITIAL & CYCLE TESTS

~~2.50# + .50#~~
$$3.00\# + .75\#$$
$$1.00\# + 1.00\#$$

SERIAL NO.

DATE _____

TESTER: *W. J. S.* *W. J. S.*

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & RE- TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.35	2.43	2.47	MIN. SETTING
PULL #2	2.47	2.39	2.38	2.56	NO AVG. OF 5
PULL #3	2.40	2.33	2.39	2.61	READINGS ACCEPT-
PULL #4	2.50	2.21	2.35	2.65	ABLENESS (THAN 2#
PULL #5	2.35	2.35	2.36	2.68	
TOTAL	12.12	11.63	11.91		
AVG.	2.42	2.33	2.38		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		PERIT OL COMMENTS
PULL #1	3.22	3.08		
PULL #2	3.11	3.01		
PULL #3	3.14	3.16		
PULL #4	3.12	3.15		
PULL #5	3.11	3.12		
TOTAL	15.70	15.52		
AVG.	3.14	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.00		4.11
PULL #2	4.14	4.02		4.04
PULL #3	4.16	4.00		4.04
PULL #4	4.21	4.08		4.00
PULL #5	4.15	4.06		4.00
TOTAL	20.79	20.16		20.19
AVG.	4.16	4.03		4.04

AL DISTANCE CALCULATIONS
RIFLE # 06649140
Aug 1991

CENTROIDAL DISTANCES

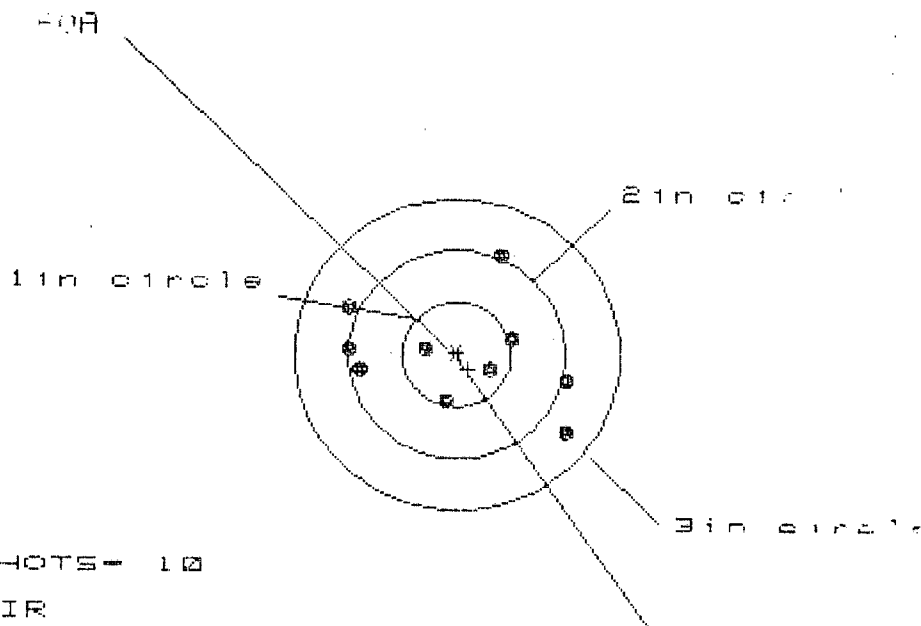
0 TO	1	.176011
1 TO	2	.530649
1 TO	3	.344768
1 TO	4	.225967
1 TO	5	.43042

$\frac{45}{3}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1
THE AMP FOR THIS RIFLE IS: .8692

FILE:/PATTERNING/CENTERFIRE_PATT/C6649140

CENTERFIRE PATTERNS



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.077

VS= 1.713

GS= 2.267

CENTROID

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.038	1.145	1.111
MINIMUM X	-1.040	-.932	-.977
MAXIMUM Y	.984	.903	.910
MINIMUM Y	-.729	-.543	-.500
CENTROID X	-.104	-.211	-.211
CENTROID Y	.142	.223	.211
POA TO CENTROID in.	.175	.307	.227
MIN RADIUS	.342	.220	.200
MEAN RADIUS	.807	.757	.700
MAX RADIUS	1.210	1.193	1.212
HORIZONTAL SPREAD	2.077	2.077	2.077
VERTICAL SPREAD	1.713	1.446	.950
EXTREME SPREAD	2.267	2.119	2.119
NUMBER IN ONE INCH CIRCLE =	3	5	10
NUMBER IN TWO INCH CIRCLE =	5	10	10
NUMBER IN THREE INCH CIRCLE =	10	10	10

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 1.679

VS= 2.584

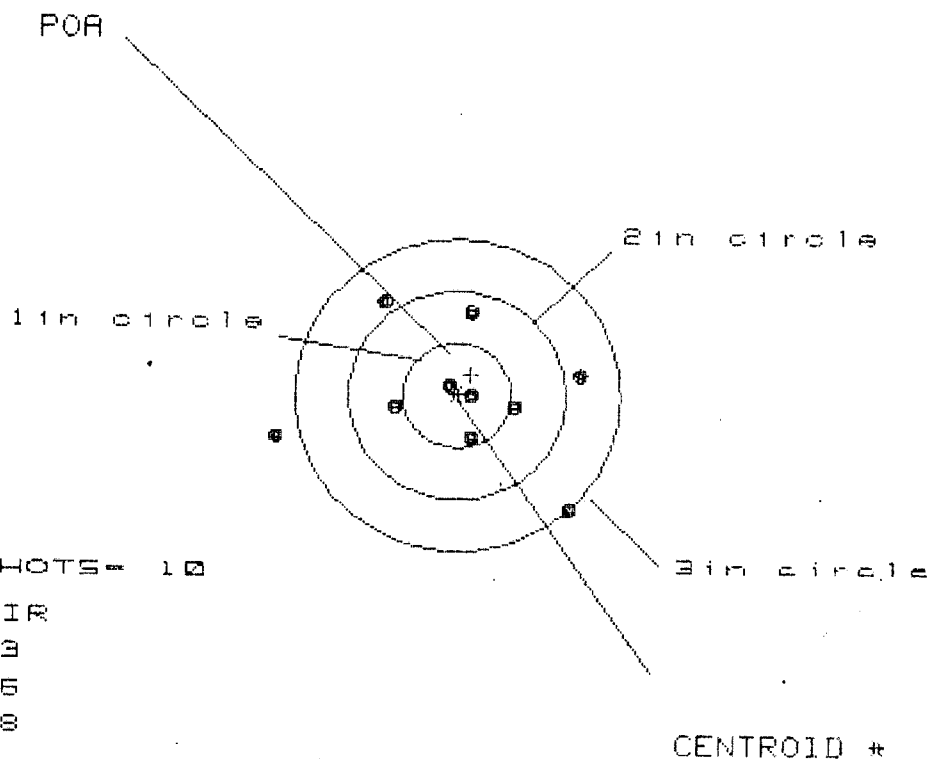
GS= 2.790

PATTERN #	127	128	129
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.903	.934	.841
MINIMUM X	-.776	-.745	-.768
MAXIMUM Y	1.534	1.217	1.107
MINIMUM Y	-1.050	-.880	-.797
CENTROID X	.398	.367	.460
CENTROID Y	.314	.144	.254
POA TO CENTROID in.	.507	.394	.526
MIN RADIUS	.673	.616	.692
MEAN RADIUS	.979	.894	.857
MAX RADIUS	1.559	1.301	1.237
HORIZONTAL SPREAD	1.679	1.679	1.609
VERTICAL SPREAD	2.584	2.097	1.904
EXTREME SPREAD	2.790	2.130	2.130
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 0.747

VS= 1.980

GS= 2.814

CENTROID +

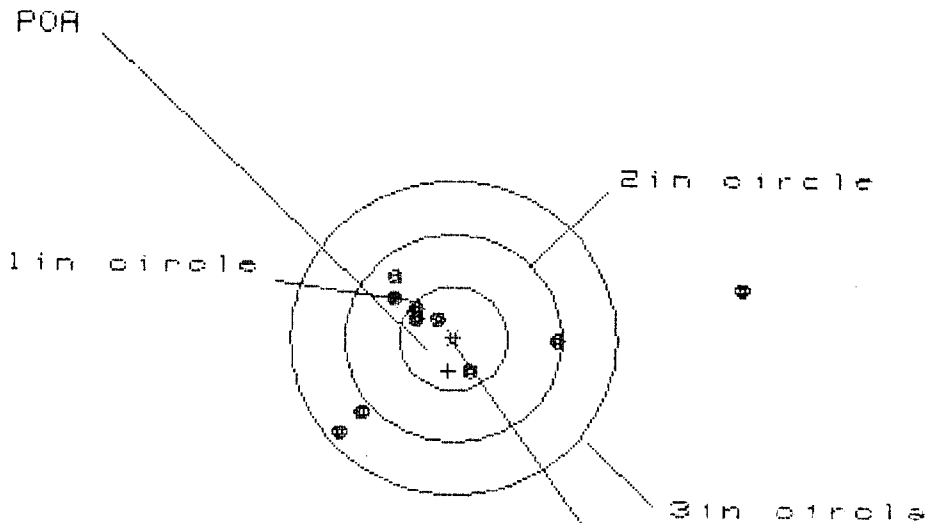
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.091	1.907	1.009
MINIMUM X	-1.656	-0.895	-0.793
MAXIMUM Y	0.855	0.813	0.668
MINIMUM Y	-1.125	-1.167	-0.580
CENTROID X	-0.127	0.057	-0.045
CENTROID Y	-0.202	-0.160	-0.015
POA TO CENTROID in.	0.238	0.170	0.048
MIN RADIUS	0.144	0.059	0.190
MEAN RADIUS	0.811	0.699	0.614
MAX RADIUS	1.697	1.427	1.036
HORIZONTAL SPREAD	2.747	1.802	1.802
VERTICAL SPREAD	1.980	1.980	1.248
EXTREME SPREAD	2.814	2.621	1.903
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.638

VS= 1.503

GS= 3.910

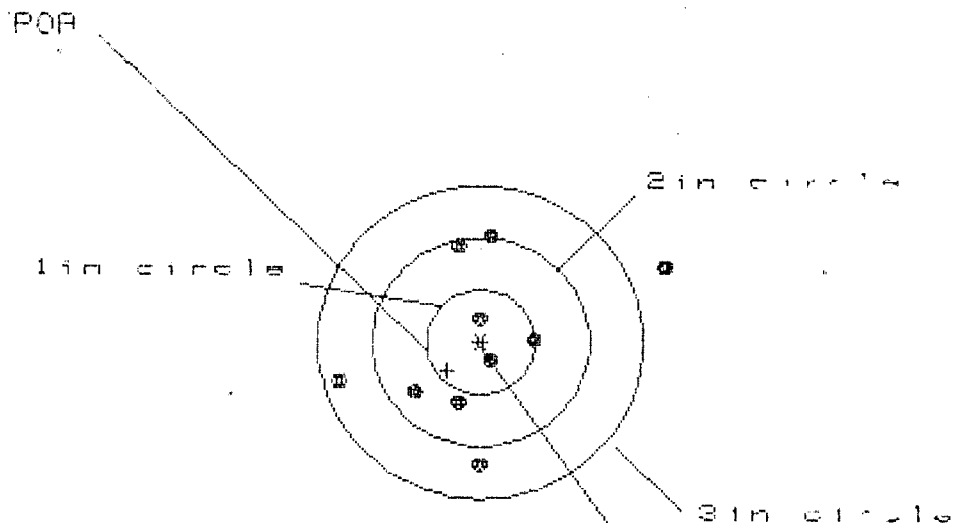
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.611	1.216	1.123
MINIMUM X	-1.028	-0.737	-0.680
MAXIMUM Y	.544	.596	.483
MINIMUM Y	-.959	-.907	-.795
CENTROID X	.046	-.245	-.152
CENTROID Y	.311	.259	.372
POR TO CENTROID in.	.315	.356	.402
MIN RADIUS	.246	.214	.107
MEAN RADIUS	.884	.632	.523
MAX RADIUS	2.653	1.217	1.125
HORIZONTAL SPREAD	3.638	1.953	1.803
VERTICAL SPREAD	1.503	1.503	1.278
EXTREME SPREAD	3.910	2.174	1.946
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

IS= 3.070

VS= 2.168

GS= 3.250

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.734	.731	.587
MINIMUM X	-1.344	-1.152	-.605
MAXIMUM Y	.979	1.055	1.019
MINIMUM Y	-1.189	-1.113	-1.149
CENTROID X	.306	.114	.250
CENTROID Y	.273	.197	.233
POA TO CENTROID in.	.410	.228	.347
MIN RADIUS	.196	.279	.192
MEAN RADIUS	.865	.750	.674
MAX RADIUS	1.863	1.186	1.151
HORIZONTAL SPREAD	3.078	1.883	1.192
VERTICAL SPREAD	2.168	2.168	2.168
EXTREME SPREAD	3.250	2.169	2.169
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		