

C6649295

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

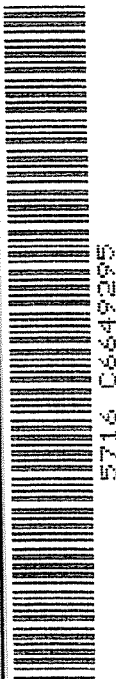
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

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

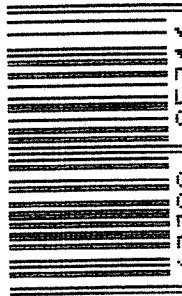
SERIAL NO. C6649295

ORDER NO. 5716

20



UPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649295

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	dw
607	Check Headspace	6 27	9 1	dw
610	Dis-assemble Gun	6 27	9 1	dw
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL	1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-26-91	JJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7-26-91	DH
	G) Safety Off Force	3	3	3			7-26-91	DH
	H) Trigger Pull Test & Retainability						7-26-91	JH
	I) Firing Pin Indent	.020	.020	.020			7-26-91	DH
	J) Assemble Stock						7/30/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/30/91	RW
	M) Iron Sight Alignment						7/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	RW
	O) Attach Scope to Rifle						7/30/91	RW
	P) Detach & Attach Scope 20 Times						7/30/91	RW
640	Gallery Target & Test						7-30-91	AC
	A) Time						7-30-91	AC
	B) Malfunctions						7-30-91	AC
	C) Pierced Primers						7-30-91	AC
	D) Optical Clarity of Scope						7-30-91	AC
645	Inspect for Live Ammo						7-30-91	AC
655	Final Inspection							
	A) Headspace						8-5-91	K
	B) Trigger Pull	2.35	2.48	2.20	2.23	2.25	8-5-91	JH
	C) Function						8-5-91	AC
660	Pack						9-18-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6649295

DATE 7-26-91

TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.17	2.50	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.53	2.44	2.48	
PULL #3	2.59	2.52	2.38	2.20	
PULL #4	2.49	2.52	2.50	2.23	
PULL #5	2.56	2.30	2.49	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.42		
PULL #2	3.59	3.37		
PULL #3	3.39	3.40		
PULL #4	3.29	3.35		
PULL #5	3.67	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.39		4.43
PULL #2	4.38	4.35		4.41
PULL #3	4.20	4.29		4.28
PULL #4	4.29	4.39		4.14
PULL #5	4.22	4.39		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649295
31 JUL 1991

CENTROIDAL DISTANCES

0 TO	1	.241963
1 TO	2	.631953
1 TO	3	.53388
1 TO	4	.126143
1 TO	5	.611734

4.5 <----POA

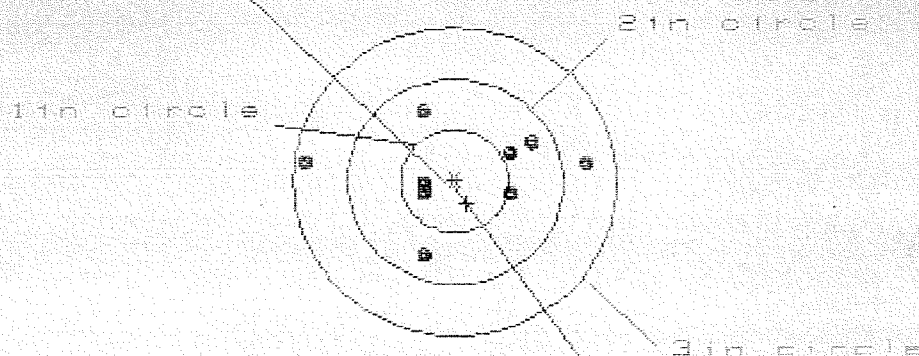
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0532
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212178
THE AMR FOR THIS RIFLE IS: .9088

31 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649295

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 2.624

VS = 1.453

CS = 2.624

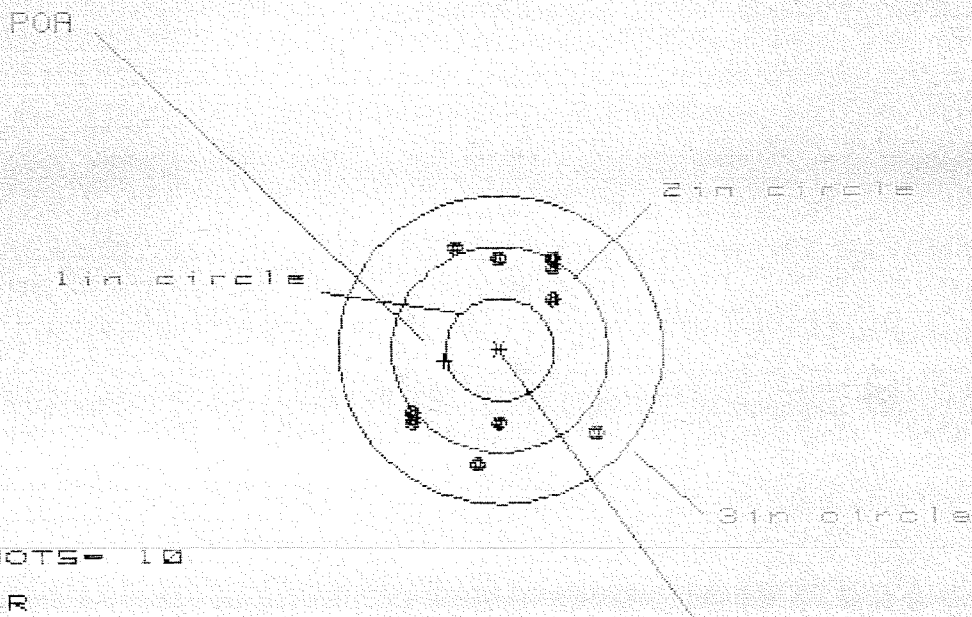
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.260	1.100	.651
MINIMUM X	-1.364	-.490	-.351
MAXIMUM Y	.720	.736	.758
MINIMUM Y	-.733	-.717	-.695
CENTROID X	-.111	.041	-.090
CENTROID Y	.215	.199	.177
POA TO CENTROID in.	.242	.203	.202
MIN RADIUS	.275	.392	.290
MEAN RADIUS	.747	.673	.604
MAX RADIUS	1.372	1.122	.827
HORIZONTAL SPREAD	2.624	1.598	1.002
VERTICAL SPREAD	1.453	1.453	1.453
EXTREME SPREAD	2.624	1.923	1.474
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

31 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 1.769

VS= 2.114

GS= 2.224

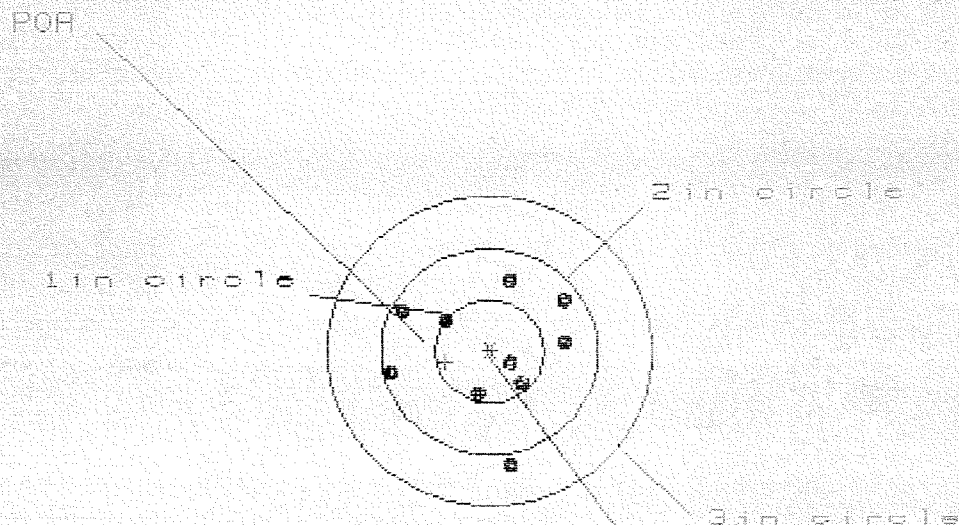
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.921	.601	.589
MINIMUM X	:	-.847	-.745	-.757
MAXIMUM Y	:	.961	.873	.718
MINIMUM Y	:	-1.153	-1.241	-.996
CENTROID X	:	.512	.410	.422
CENTROID Y	:	.109	.197	.352
POA TO CENTROID in.	:	.524	.455	.549
MIN RADIUS	:	.670	.685	.593
MEAN RADIUS	:	.975	.938	.870
MAX RADIUS	:	1.217	1.245	1.229
HORIZONTAL SPREAD	:	1.769	1.346	1.346
VERTICAL SPREAD	:	2.114	2.114	1.714
EXTREME SPREAD	:	2.224	2.150	2.074
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649295

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.581

VS= 1.889

GS= 1.889

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.710	.731	.629
MINIMUM X	:	-.871	-.850	-.952
MAXIMUM Y	:	.744	.617	.654
MINIMUM Y	:	-1.145	-.482	-.445
CENTROID X	:	.411	.390	.492
CENTROID Y	:	.103	.230	.193
POA TO CENTROID in.	:	.424	.453	.529
MIN RADIUS	:	.239	.315	.214
MEAN RADIUS	:	.679	.627	.579
MAX RADIUS	:	1.160	.921	1.004
HORIZONTAL SPREAD	:	1.581	1.581	1.581
VERTICAL SPREAD	:	1.889	1.099	1.099
EXTREME SPREAD	:	1.889	1.741	1.741
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849295

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.577

VS= 3.090

GS= 3.293

PATTERN #

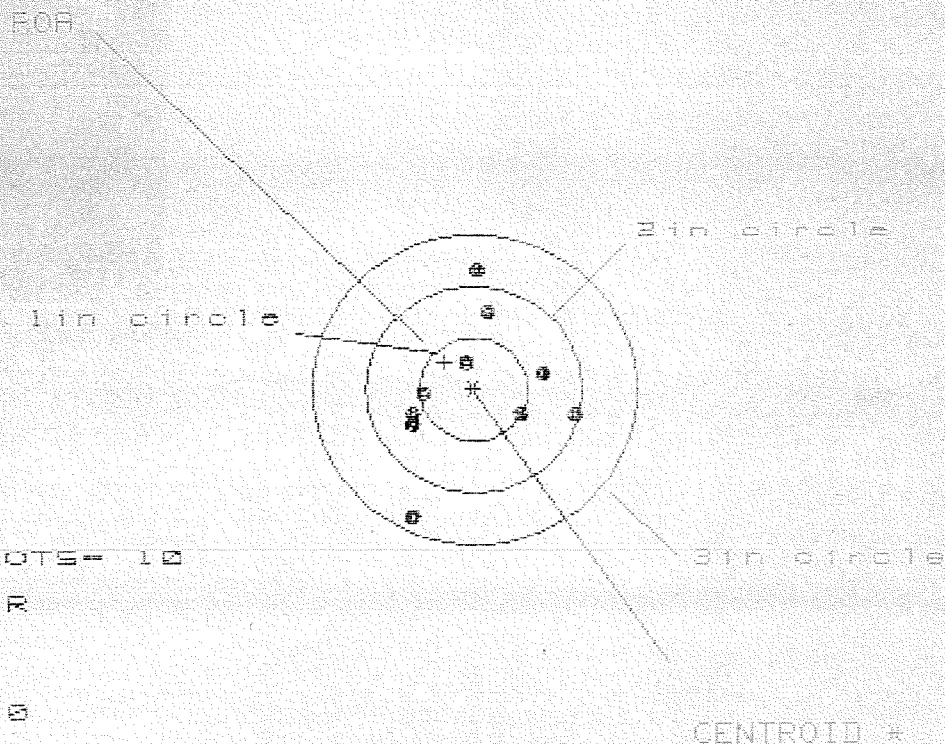
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SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.881	.794	.828
MINIMUM X	:	-.796	-.883	-.819
MAXIMUM Y	:	1.429	1.244	.646
MINIMUM Y	:	-1.661	-.818	-.662
CENTROID X	:	-.057	.030	-.004
CENTROID Y	:	.101	.286	.130
POA TO CENTROID in.	:	.116	.287	.130
MIN RADIUS	:	.263	.210	.319
MEAN RADIUS	:	.900	.778	.708
MAX RADIUS	:	1.935	1.274	1.066
HORIZONTAL SPREAD	:	1.677	1.677	1.677
VERTICAL SPREAD	:	3.090	2.062	1.308
EXTREME SPREAD	:	3.293	2.176	2.005
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jul 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8849295

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.551

VS= 2.403

GS= 2.475

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.970	.906	.900
MINIMUM X	-.581	-.645	-.651
MAXIMUM Y	1.139	.998	.768
MINIMUM Y	-1.264	-.441	-.316
CENTROID X	.272	.336	.342
CENTROID Y	-.262	-.121	-.246
FOA TO CENTROID IN.	.377	.357	.421
MIN RADIUS	.247	.157	.258
MEAN RADIUS	.743	.659	.613
MAX RADIUS	1.388	.999	.924
HORIZONTAL SPREAD	1.551	1.551	1.551
VERTICAL SPREAD	2.403	1.439	1.084
EXTREME SPREAD	2.475	1.636	1.554
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		