

C5611476

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ H24

SERIAL NO.
 C6611476

ORDER NO.
5716

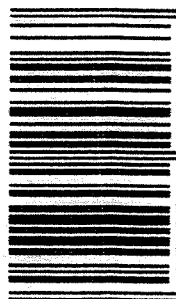
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611476

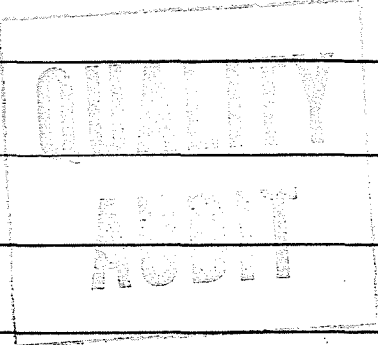
UPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611476**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	SL
617	Drill and Tap Sight Holes		APR 3 1991	KB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	KS
	C) Inspect Ejector Hole for Chamfer		4/30/91	KS
	D) Oil Firing Pin Ass'y		4/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/3/91	OK
	G) Safety Off Force	4	4	4			5/3/91	OK
	H) Trigger Pull Test & Retainability						5/3/91	OK
	I) Firing Pin Indent	.023	.023	.023			5/3/91	OK
	J) Assemble Stock						5/6/91	K-S
	K) Assemble Swivel Studs						5-10-91	A
	L) Attach Front and Rear Sight Assemblies						5/6/91	K-S
	M) Iron Sight Alignment						5/6/91	K-S
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	K-S
	O) Attach Scope to Rifle						5/6/91	K-S
	P) Detach & Attach Scope 20 Times						5/6/91	K-S
640	Gallery Target & Test						5-7-91	AC
	A) Time						5-7-91	AC
	B) Malfunctions						5-7-91	AC
	C) Pierced Primers						5-7-91	AC
	D) Optical Clarity of Scope						5-7-91	AC
645	Inspect for Live Ammo						5-7-91	AC
655	Final Inspection							
	A) Headspace						5-10-91	A
	B) Trigger Pull	2.27	2.35	2.31	2.29	2.30	5/9/91	OK
	C) Function						5-10-91	A
660	Pack						6-17-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611476
DATE 5-3-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.13	2.22	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.18	2.20	2.35	
PULL #3	2.30	2.36	2.25	2.31	
PULL #4	2.35	2.32	2.36	2.29	
PULL #5	2.30	2.34	2.30	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.27	3.26			
PULL #2	3.29	3.28			
PULL #3	3.28	3.29			
PULL #4	3.25	3.27			
PULL #5	3.29	3.28			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX-SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.40		4.40
PULL #2	4.16	4.43		4.40
PULL #3	4.40	4.41		4.37
PULL #4	4.42	4.37		4.25
PULL #5	4.44	4.35		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611476
7 May 1991

CENTROIDAL DISTANCES

0 TO	1	.273607
1 TO	2	.413943
1 TO	3	.201921
1 TO	4	.223009
1 TO	5	.240208

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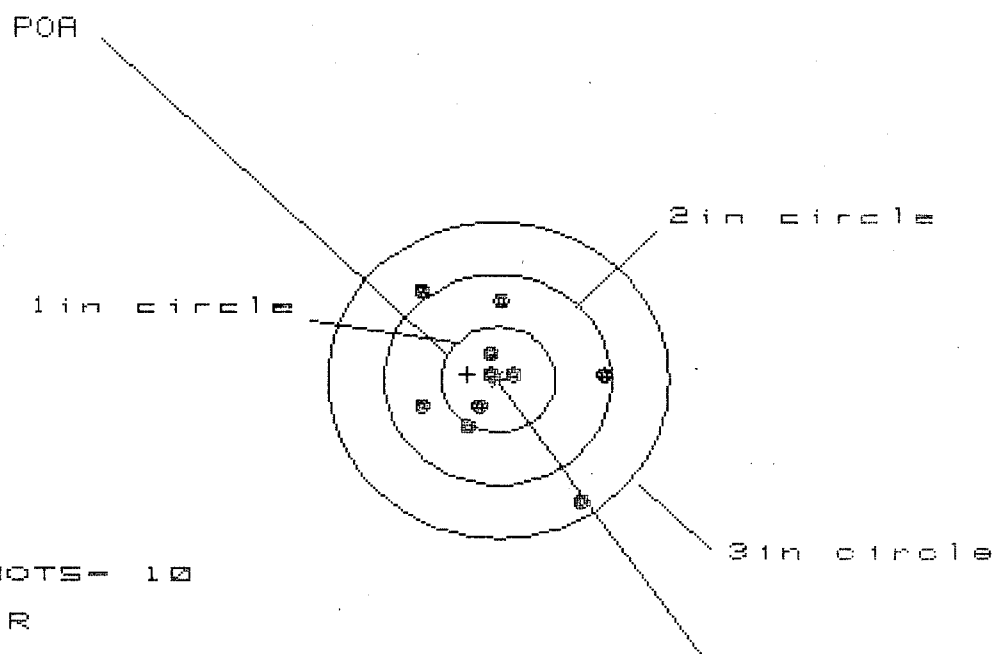
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1440
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.001
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1411
THE AMR FOR THIS RIFLE IS: .956

7 May 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6611476

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.585

VS= 1.983

GS= 2.455

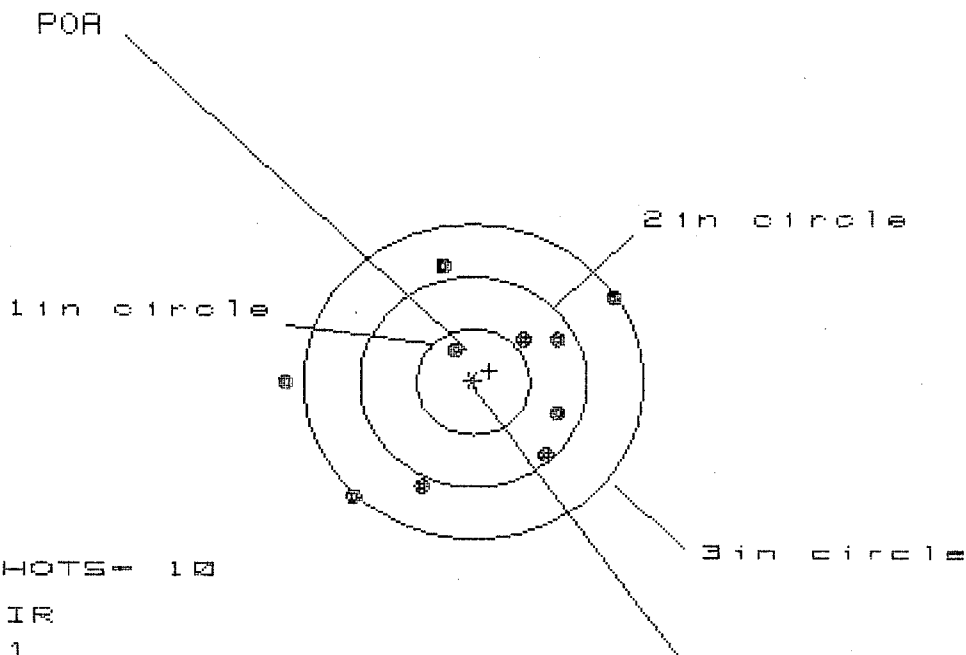
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.896	.980	.505
MINIMUM X	-.689	-.605	-.617
MAXIMUM Y	.852	.726	.686
MINIMUM Y	-1.131	-.551	-.500
CENTROID X	.269	.185	.191
CENTROID Y	-.050	.076	.005
POA TO CENTROID in.	.274	.200	.211
MIN RADIUS	.091	.083	.091
MEAN RADIUS	.605	.513	.447
MAX RADIUS	1.362	.981	.908
HORIZONTAL SPREAD	1.585	1.585	1.522
VERTICAL SPREAD	1.983	1.277	1.146
EXTREME SPREAD	2.455	1.761	1.564
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

7 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.903

VS= 2.272

GS= 3.017

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.204	1.015	.856
MINIMUM X	-1.699	-1.271	-.854
MAXIMUM Y	1.130	1.129	.936
MINIMUM Y	-1.142	-1.143	-1.129
CENTROID X	-.141	.048	.207
CENTROID Y	-.107	-.106	.037
POA TO CENTROID in.	.177	.117	.210
MIN RADIUS	.366	.435	.238
MEAN RADIUS	1.040	.930	.784
MAX RADIUS	1.699	1.709	1.416
HORIZONTAL SPREAD	2.903	2.286	1.710
VERTICAL SPREAD	2.272	2.272	2.116
EXTREME SPREAD	3.017	3.009	2.483
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

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 4.385

VS = 2.026

GS = 4.503

PATTERN #

:

10

9

8

SHOTS (BEST OF)

MAXIMUM X :

2.792

1.012

.852

MINIMUM X :

-1.592

-1.282

-.675

MAXIMUM Y :

1.076

1.000

1.032

MINIMUM Y :

-.950

-1.026

-.994

CENTROID X :

.075

-.235

-.074

CENTROID Y :

-.106

-.030

-.062

POA TO CENTROID in.:

.130

.237

.097

MIN RADIUS :

.317

.204

.221

MEAN RADIUS :

1.041

.785

.713

MAX RADIUS :

2.876

1.308

1.082

HORIZONTAL SPREAD :

4.385

2.294

1.527

VERTICAL SPREAD :

2.026

2.026

2.026

EXTREME SPREAD :

4.503

2.299

2.154

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

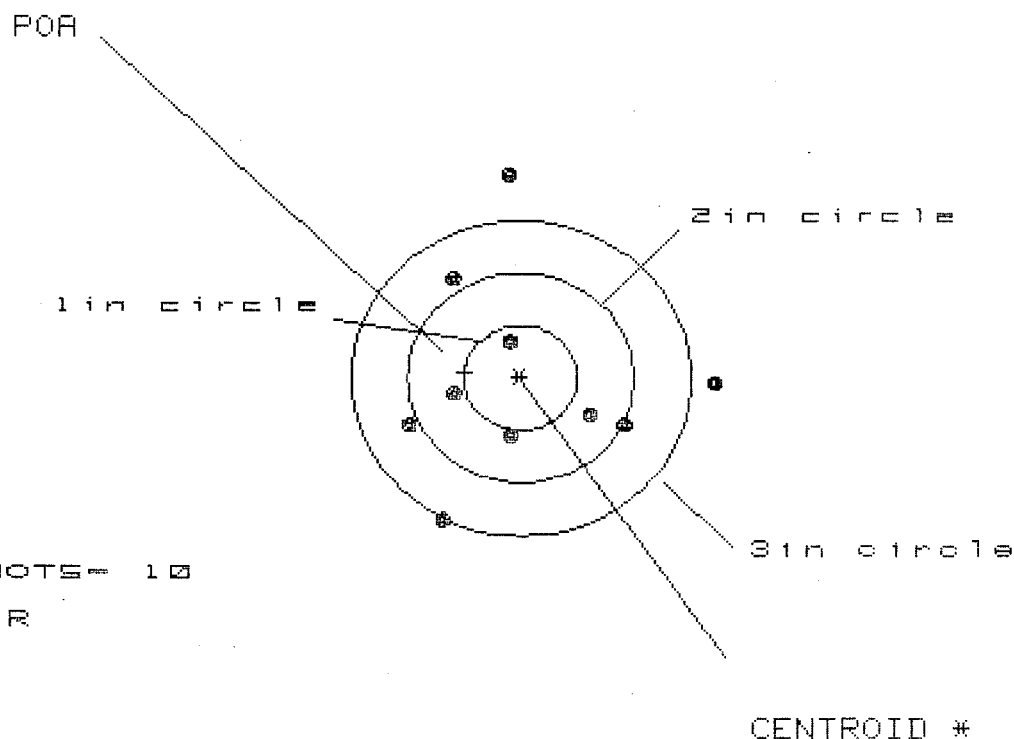
NUMBER IN THREE INCH CIRCLE =

8

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.763

VS = 3.293

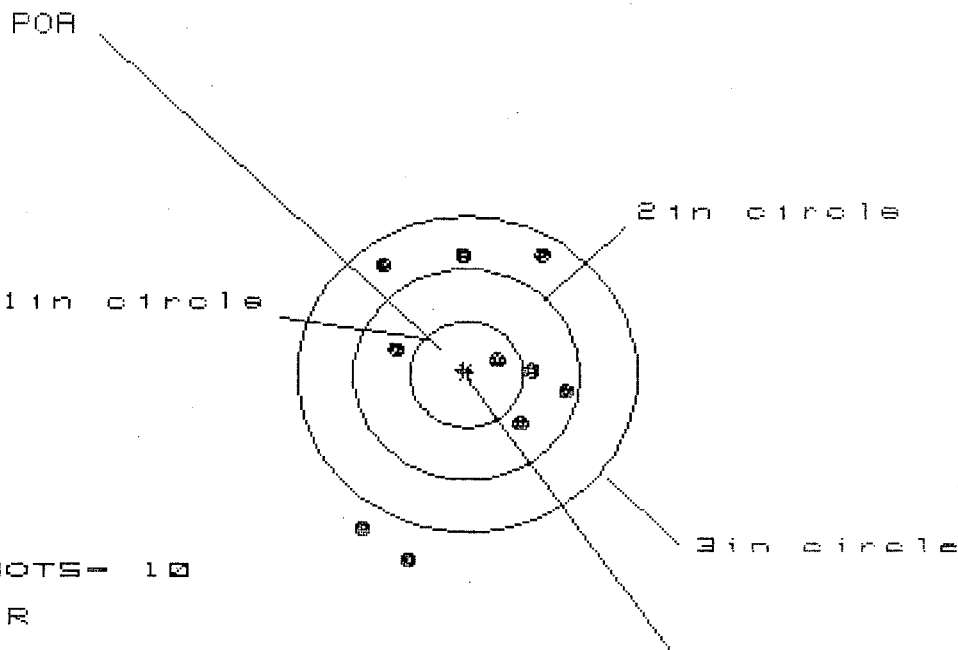
GS = 3.353

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.728	1.718	1.107
MINIMUM X	:	-1.035	-1.045	-.830
MAXIMUM Y	:	1.937	1.158	1.180
MINIMUM Y	:	-1.356	-1.140	-1.118
CENTROID X	:	.492	.502	.287
CENTROID Y	:	-.052	-.268	-.290
POA TO CENTROID in.	:	.495	.569	.408
MIN RADIUS	:	.382	.373	.333
MEAN RADIUS	:	1.072	.954	.831
MAX RADIUS	:	1.939	1.728	1.257
HORIZONTAL SPREAD	:	2.763	2.763	1.937
VERTICAL SPREAD	:	3.293	2.298	2.298
EXTREME SPREAD	:	3.353	2.789	2.299
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.767

VS= 2.832

GS= 3.065

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.885	.826	.708
MINIMUM X	-.882	-.941	-.938
MAXIMUM Y	1.119	.929	.727
MINIMUM Y	-1.713	-1.617	-.815
CENTROID X	.029	.088	.206
CENTROID Y	-.040	.150	.352
POA TO CENTROID in.	.050	.174	.408
MIN RADIUS	.313	.213	.251
MEAN RADIUS	1.022	.902	.762
MAX RADIUS	1.794	1.871	1.164
HORIZONTAL SPREAD	1.767	1.767	1.646
VERTICAL SPREAD	2.832	2.546	1.542
EXTREME SPREAD	3.065	2.966	2.063
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		