

C6611567

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ 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.
C6611567

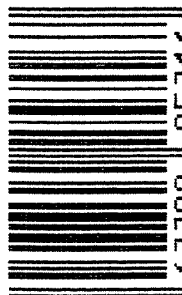
ORDER NO.
5716

20



5716 C6611567

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611567

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		Rw
600	Proof	3 25 91		Rw
607	Check Headspace	3 25 91		Rw
610	Dis-assemble Gun	3 25 91		Rw
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		Y
615	Rollmark Caliber	3 28 91		GL
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)			JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	7			5-7-91	DH
	G) Safety Off Force	4	4	4			5-7-91	DH
	H) Trigger Pull Test & Retainability						5/7/91	SH
	I) Firing Pin Indent	.022	.020	.020			5-7-91	DH
	J) Assemble Stock						5/8/91	RW
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/8/91	RW
	M) Iron Sight Alignment						5/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/8/91	RW
	O) Attach Scope to Rifle						5/8/91	RW
	P) Detach & Attach Scope 20 Times						5/8/91	RW
640	Gallery Target & Test						5-13-91	DH
	A) Time						5-13-91	DH
	B) Malfunctions						5-13-91	DH
	C) Pierced Primers						5-13-91	DH
	D) Optical Clarity of Scope						5-13-91	DH
645	Inspect for Live Ammo						5-13-91	DH
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.58	2.58	2.49	2.58	2.66	5/20/91	SH
	C) Function						5-21-91	DH
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611567

DATE 5/7/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.33	2.40	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.27	2.38	2.58	
PULL #3	2.25	2.31	2.36	2.49	
PULL #4	2.23	2.39	2.40	2.58	
PULL #5	2.31	2.43	2.41	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.50		
PULL #2	3.39	3.53		
PULL #3	3.42	3.46		
PULL #4	3.49	3.59		
PULL #5	3.39	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.26		4.42
PULL #2	4.29	4.20		4.47
PULL #3	4.17	4.18		4.46
PULL #4	4.19	4.43		4.46
PULL #5	4.32	4.45		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611567
13 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.146513
1 TO	2	.472869
1 TO	3	.197003
1 TO	4	.496883
1 TO	5	.448341

$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156155

THE AMR FOR THIS RIFLE IS: .8796

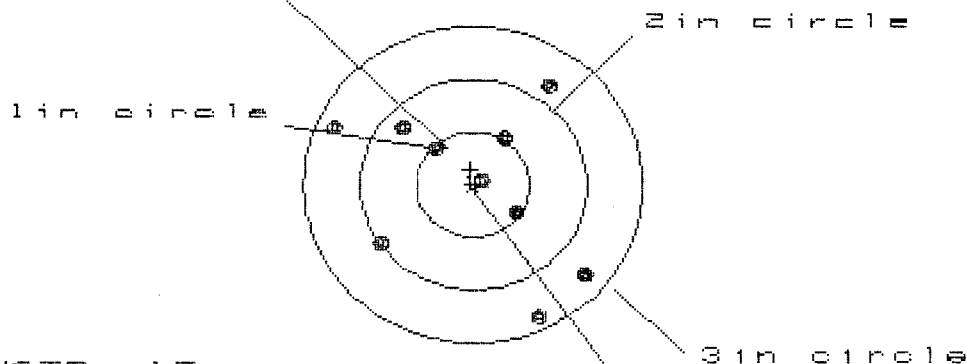
13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611567

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.226

VS= 2.186

GS= 2.623

CENTROID #

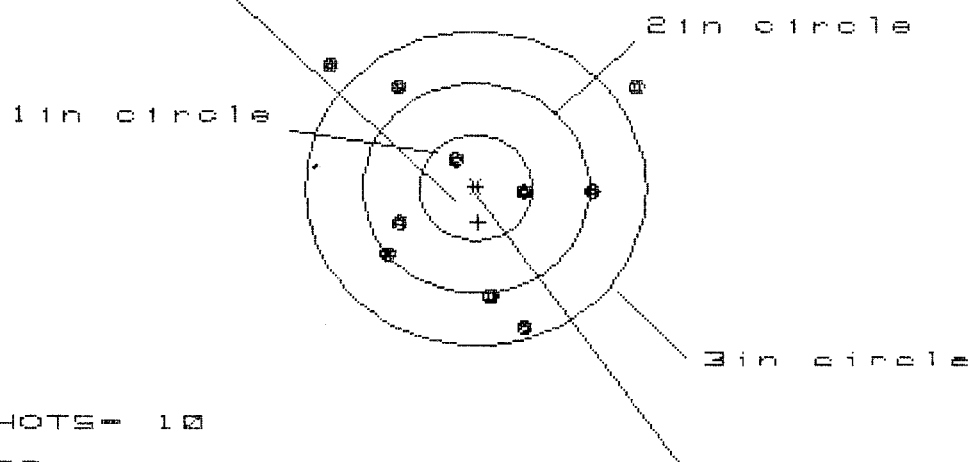
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	.822	.876
MINIMUM X	:	-1.264	-.934	-.880
MAXIMUM Y	:	.974	1.034	.890
MINIMUM Y	:	-1.212	-1.152	-.938
CENTROID X	:	.021	.162	.108
CENTROID Y	:	-.145	-.205	-.061
POA TO CENTROID in.	:	.147	.261	.124
MIN RADIUS	:	.105	.161	.022
MEAN RADIUS	:	.858	.800	.711
MAX RADIUS	:	1.372	1.231	1.284
HORIZONTAL SPREAD	:	2.226	1.756	1.756
VERTICAL SPREAD	:	2.186	2.186	1.828
EXTREME SPREAD	:	2.623	2.189	2.155
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.685

VS = 2.447

GS = 2.960

CENTROID *

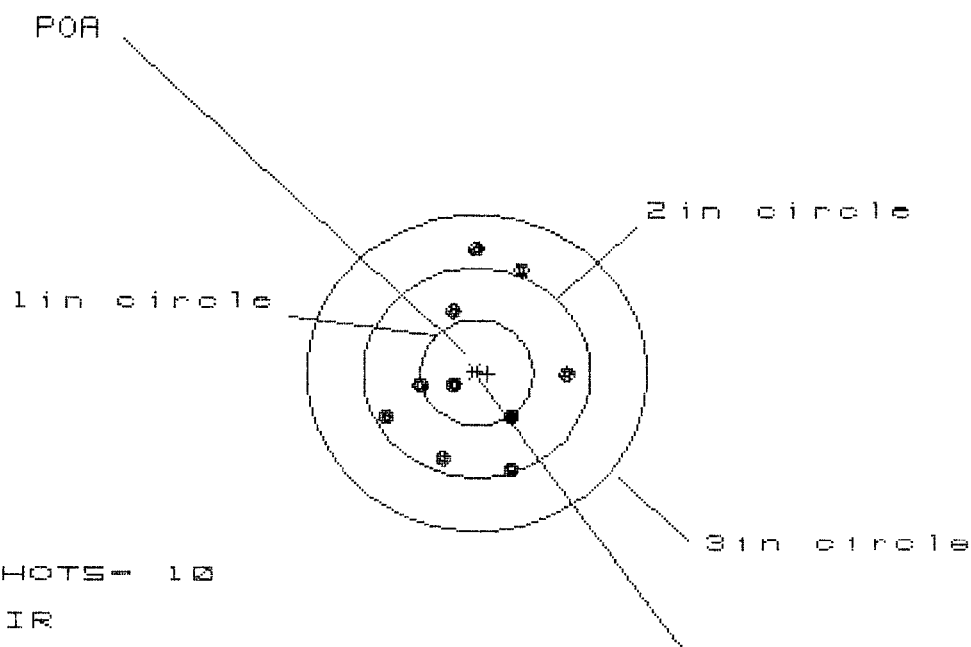
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.444	1.138	1.003
MINIMUM X	:	-1.241	-1.081	-.712
MAXIMUM Y	:	1.144	1.251	1.250
MINIMUM Y	:	-1.303	-1.196	-1.039
CENTROID X	:	-.021	-.181	-.046
CENTROID Y	:	.326	.219	.062
POA TO CENTROID in.	:	.326	.284	.077
MIN RADIUS	:	.337	.390	.546
MEAN RADIUS	:	1.049	.958	.860
MAX RADIUS	:	1.736	1.654	1.389
HORIZONTAL SPREAD	:	2.685	2.219	1.715
VERTICAL SPREAD	:	2.447	2.447	2.289
EXTREME SPREAD	:	2.960	2.960	2.520
NUMBER IN ONE INCH CIRCLE	=		2	
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 = 8

3 in = 10

CENTROID *

HS= 1.593

VS= 2.099

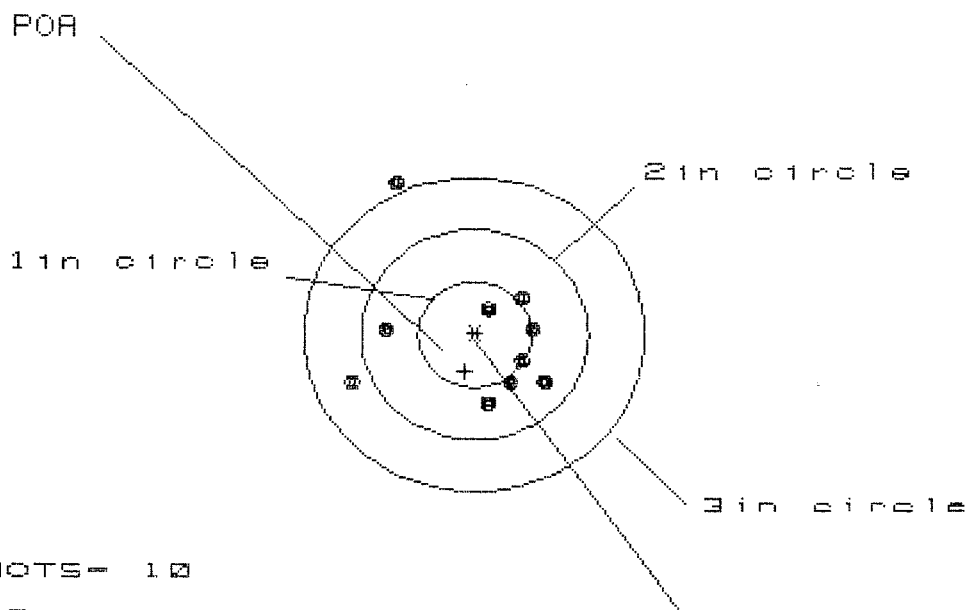
GS= 2.111

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.840	.846	.900
MINIMUM X	:	-.753	-.747	-.693
MAXIMUM Y	:	1.199	1.082	.878
MINIMUM Y	:	-.900	-.767	-.632
CENTROID X	:	-.098	-.104	-.158
CENTROID Y	:	.012	-.121	-.256
POA TO CENTROID in.	:	.099	.159	.301
MIN RADIUS	:	.266	.223	.213
MEAN RADIUS	:	.757	.685	.601
MAX RADIUS	:	1.200	1.165	.927
HORIZONTAL SPREAD	:	1.593	1.593	1.593
VERTICAL SPREAD	:	2.099	1.849	1.510
EXTREME SPREAD	:	2.111	1.873	1.625
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.688

VS= 2.179

GS= 2.324

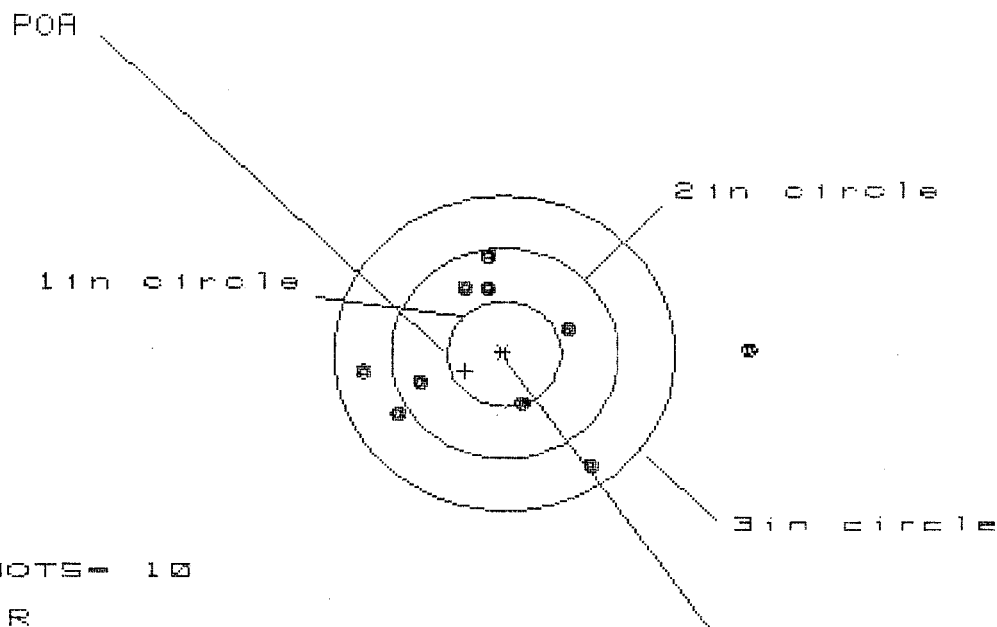
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.599	.524	.378
MINIMUM X	:	-1.089	-1.164	-.970
MAXIMUM Y	:	1.496	.541	.511
MINIMUM Y	:	-.683	-.517	-.547
CENTROID X	:	.083	.158	.304
CENTROID Y	:	.348	.182	.212
POA TO CENTROID in.	:	.358	.241	.370
MIN RADIUS	:	.270	.384	.259
MEAN RADIUS	:	.737	.603	.485
MAX RADIUS	:	1.640	1.188	.989
HORIZONTAL SPREAD	:	1.688	1.688	1.348
VERTICAL SPREAD	:	2.179	1.058	1.058
EXTREME SPREAD	:	2.324	1.688	1.425
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS = 3.317

VS = 1.978

GS = 3.328

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.118	.981	.905
MINIMUM X	-1.199	-.963	-.841
MAXIMUM Y	.959	.968	.841
MINIMUM Y	-1.019	-1.010	-.656
CENTROID X	.342	.106	-.016
CENTROID Y	.168	.159	.286
POA TO CENTROID in.	.381	.192	.286
MIN RADIUS	.544	.593	.494
MEAN RADIUS	.997	.845	.750
MAX RADIUS	2.120	1.408	.908
HORIZONTAL SPREAD	3.317	1.944	1.746
VERTICAL SPREAD	1.978	1.978	1.497
EXTREME SPREAD	3.328	2.179	1.787
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	