

C6349185

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



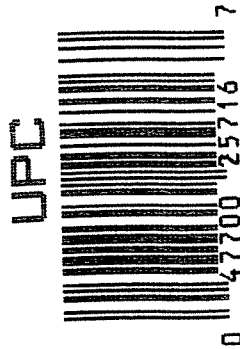
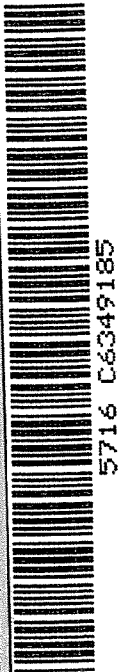
Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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. C6349185	Ø1
ORDER NO. 5716	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349185

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/27/90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/27/90	RL
	G) Safety Off Force	2	2	2			4/27/90	RL
	H) Trigger Pull Test & Retainability						4/27/90	RL
	I) Firing Pin Indent	.021	.020	.022			4/27/90	RL
	J) Assemble Stock						4/30/90	RL
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/30/90	RL
	M) Iron Sight Alignment						4/30/90	RL
	N) Detach Front & Rear Sights & place in numbered container						4/30/90	RL
	O) Attach Scope to Rifle						4/30/90	RL
	P) Detach & Attach Scope 20 Times						4/30/90	RL
640	Gallery Target & Test						4-30-90	AC
	A) Time						4-30-90	AC
	B) Malfunctions						4-30-90	AC
	C) Pierced Primers						4-30-90	AC
	D) Optical Clarity of Scope						4-30-90	AC
645	Inspect for Live Ammo						4-30-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace							
	B) Trigger Pull	2.43	2.48	2.43	2.44	2.54	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6/9/90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349185

DATE 4/27/90

TESTER JRU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.34	2.24	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.32	2.32	2.48	
PULL #3	2.35	2.28	2.31	2.43	
PULL #4	2.24	2.32	2.44	2.44	
PULL #5	2.34	2.42	2.28	2.54	
TOTAL	11.56	11.68	11.59		
AVG.	2.312	2.336	2.318		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.31		
PULL #2	3.30	3.14		
PULL #3	3.29	3.28		
PULL #4	3.24	3.28		
PULL #5	3.40	3.28		
TOTAL	16.41	16.29		
AVG.	3.282	3.258		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.55		4.41
PULL #2	4.14	4.43		4.28
PULL #3	4.50	4.57		4.22
PULL #4	4.39	4.48		4.23
PULL #5	4.27	4.38		4.23
TOTAL	21.64	22.41		21.37
AVG.	4.328	4.482		4.274

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349185
1 May 1990

CENTROIDAL DISTANCES

0 TO	1	.299962
1 TO	2	.390978
1 TO	3	.498678
1 TO	4	.285743
1 TO	5	.163884

$\frac{2}{10}$ <----POA

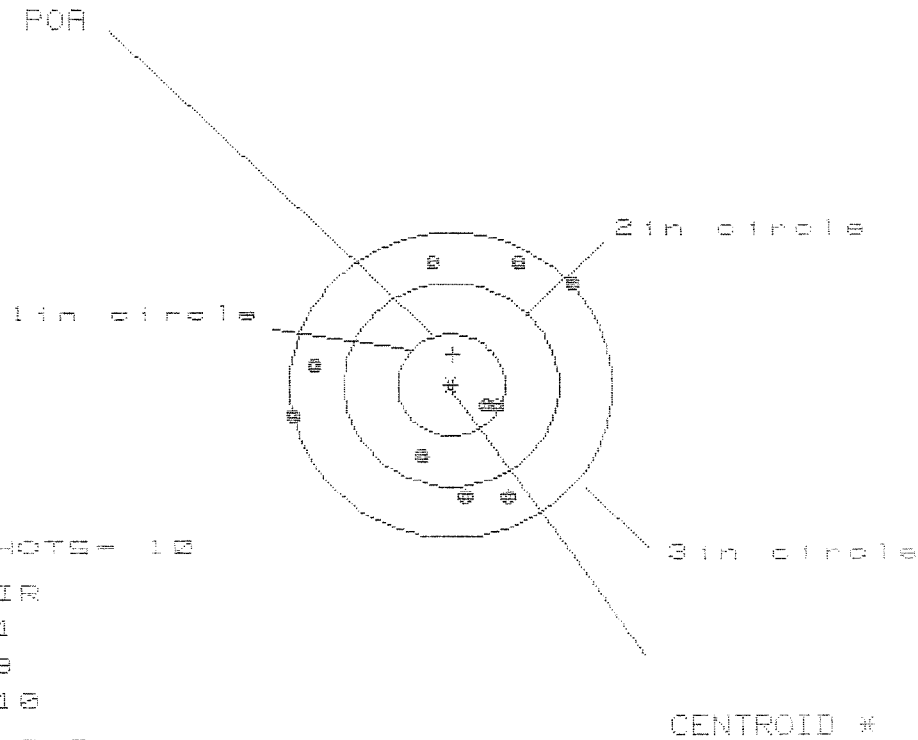
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1104
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0984
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147888
THE AMR FOR THIS RIFLE IS: .9586

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06949185

CENTERFIRE PATTERNS

1



* OF SHOTS = 10

IN CIR

1in = 1

2in = 0

3in = 10

MEAN = 0.842

VAR = 0.312

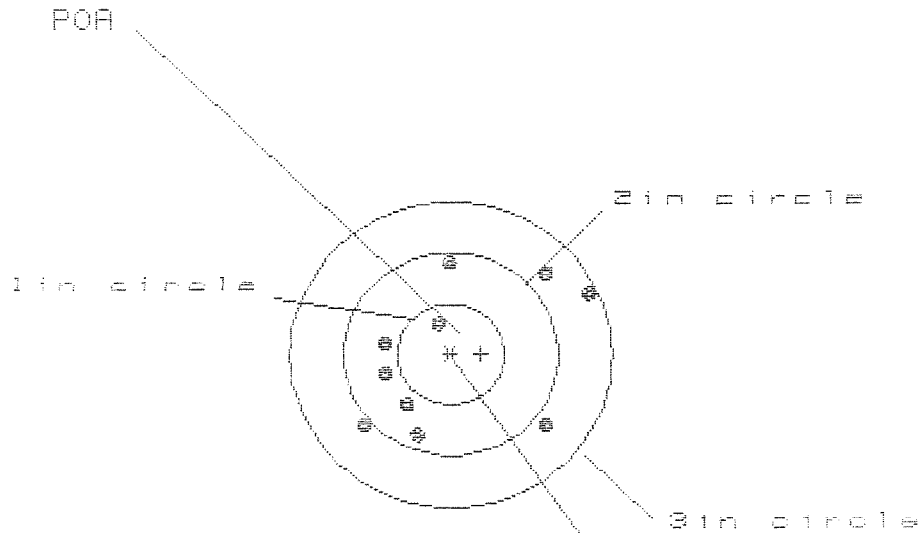
STD = 0.558

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	.921	.520
MINIMUM X	-1.400	-1.395	-1.200
MAXIMUM Y	1.207	1.171	1.295
MINIMUM Y	-1.105	-1.141	-1.017
CENTROID X	-.024	.138	.023
CENTROID Y	-.299	-.263	-.387
POB TO CENTROID in.	.300	.297	.388
MIN RADIUS	.363	.285	.276
MEAN RADIUS	1.060	1.002	.936
MAX RADIUS	1.495	1.405	1.414
HORIZONTAL SPREAD	2.543	2.316	1.900
VERTICAL SPREAD	2.312	2.312	2.312
EXTREME SPREAD	2.878	2.459	2.381
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	10	

1 May 1988

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.071

VS = 1.683

GS = 2.403

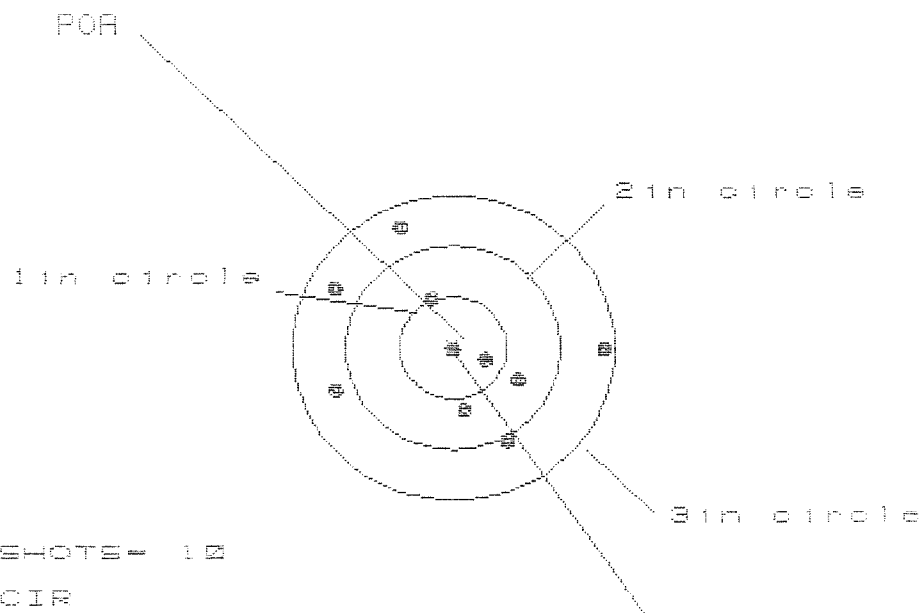
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.007	1.107
MINIMUM X	-.819	-.688	-.554
MAXIMUM Y	.929	.993	1.104
MINIMUM Y	-.754	-.690	-.579
CENTROID X	-.284	-.423	-.549
CENTROID Y	-.007	-.071	-.182
POR TO CENTROID in.	.284	.429	.578
MIN RADIUS	.319	.364	.340
MEAN RADIUS	.871	.779	.667
MAX RADIUS	1.376	1.345	1.226
HORIZONTAL SPREAD	2.071	1.687	1.661
VERTICAL SPREAD	1.683	1.683	1.683
EXTREME SPREAD	2.403	2.241	1.838
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.507

VS= 2.093

GS= 2.539

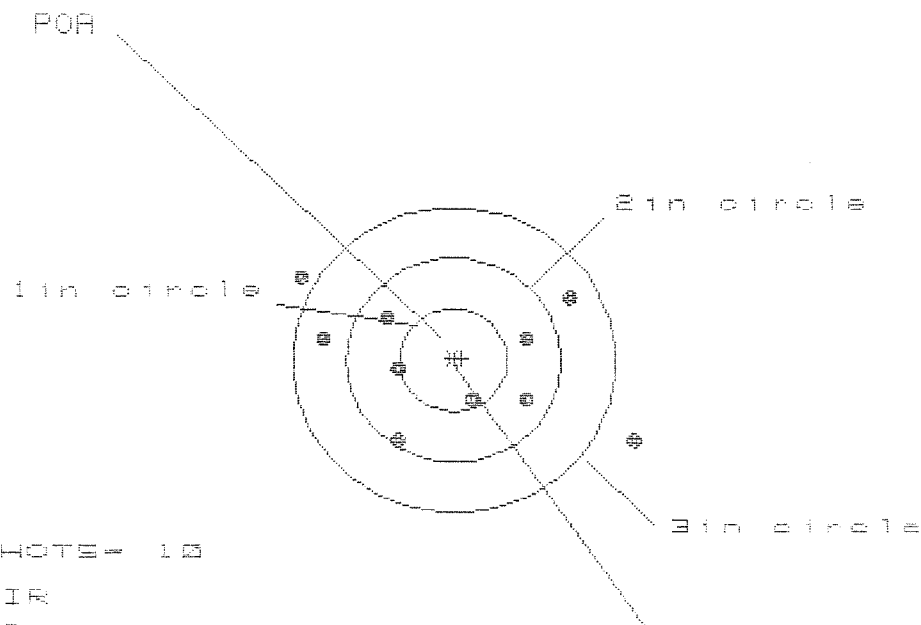
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	.720	.679
MINIMUM X	-1.135	-.982	-1.023
MAXIMUM Y	1.216	1.211	.736
MINIMUM Y	-.877	-.882	-.731
CENTROID X	-.382	-.455	-.414
CENTROID Y	.115	.120	-.031
POR TO CENTROID in.	.324	.470	.415
MIN RADIUS	.046	.198	.211
MEAN RADIUS	.882	.795	.719
MAX RADIUS	1.373	1.254	1.222
HORIZONTAL SPREAD	2.507	1.702	1.702
VERTICAL SPREAD	2.093	2.093	1.467
EXTREME SPREAD	2.539	2.319	2.174
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	10	

1 May 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 2

HS= 3.118

VS= 1.659

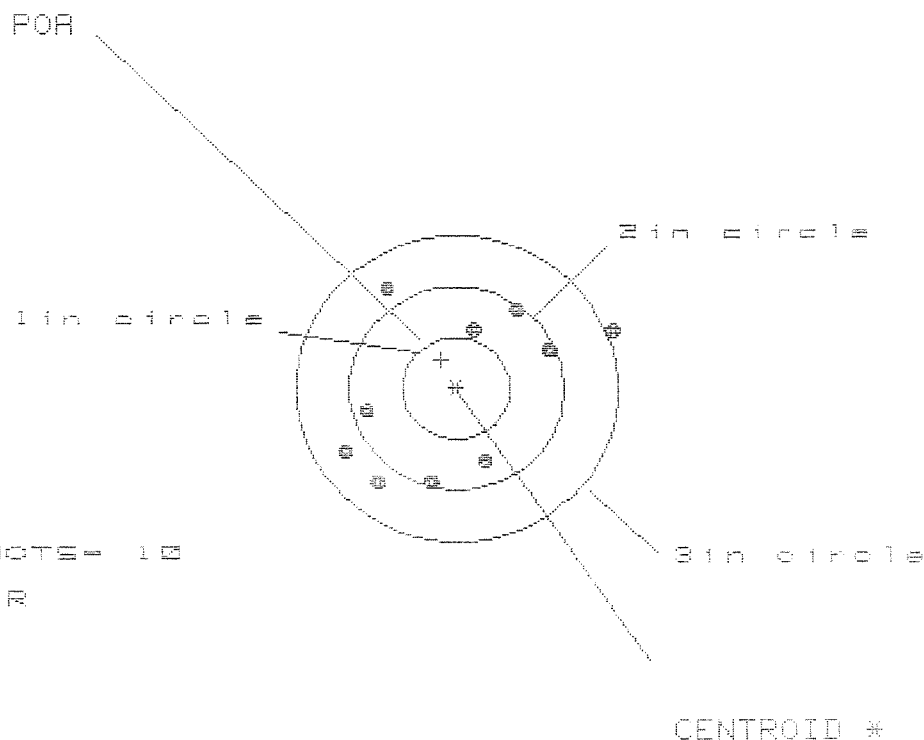
GS= 3.538

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.662	1.282	1.123
MINIMUM X	-1.456	-1.272	-1.192
MAXIMUM Y	.857	.768	.675
MINIMUM Y	-.882	-.891	-.795
CENTROID X	-.081	-.265	-.107
CENTROID Y	-.019	.070	-.026
POA TO CENTROID in.	.083	.275	.110
MIN RADIUS	.420	.336	.422
MEAN RADIUS	1.014	.910	.824
MAX RADIUS	1.844	1.485	1.311
HORIZONTAL SPREAD	3.118	2.554	2.316
VERTICAL SPREAD	1.659	1.559	1.470
EXTREME SPREAD	3.538	2.561	2.353
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 0

HM= 2.498

VS= 1.892

GS= 2.781

PATTERN #	5		
SHOTS (BEST OF)	10	9	0
MAXIMUM X	1.502	1.024	.920
MINIMUM X	-.996	-.829	-.727
MAXIMUM Y	1.004	1.067	.998
MINIMUM Y	-.888	-.825	-.894
CENTROID X	.139	-.028	.076
CENTROID Y	-.282	-.345	-.276
FOR TO CENTROID in.	.315	.346	.286
MIN RADIUS	.572	.639	.584
MEAN RADIUS	1.008	.926	.913
MAX RADIUS	1.604	1.170	1.130
HORIZONTAL SPREAD	2.498	1.853	1.647
VERTICAL SPREAD	1.892	1.892	1.892
EXTREME SPREAD	2.761	2.165	2.165
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	