

C6649082

MODEL 700TH M24

Model **SMS** TH

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead[®]

Remington
MODEL 700TM M24

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

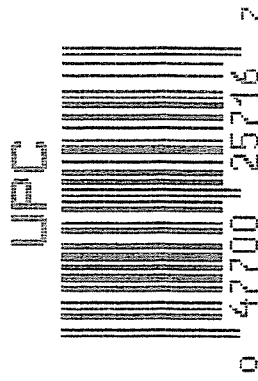
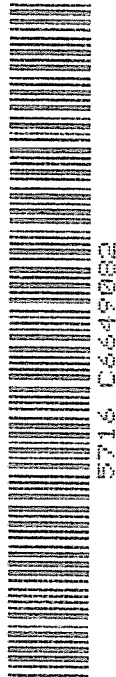
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6649082

ORDER NO.
5716

20



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649082

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KL
600	Proof		6/24/91	KL
607	Check Headspace		6/24/91	KL
610	Dis-assemble Gun		6/24/91	KL
612	Magnaflux Barrel Action	JUL 1 1991	1 1991	KR
	Magnaflux Bolt	JUL 1 1991	1 1991	KR
615	Rollmark Caliber	JUL 1 1991	1 1991	SS
617	Drill and Tap Sight Holes	JUL 1 1991	1 1991	LB
618	Polish Barrel	JUL 2 1991	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	TA
	Apply Coating (Bolt)			TA
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	KL
	C) Inspect Ejector Hole for Chamfer		8/5/91	KL
	D) Oil Firing Pin Ass'y		8/5/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-6-91	DH
	G) Safety Off Force	3	3	2 1/2			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	JV
	I) Firing Pin Indent	.020	.020	.020			8-6-91	DH
	J) Assemble Stock						8/8/91	KH
	K) Assemble Swivel Studs						8-8-91	DH
	L) Attach Front and Rear Sight Assemblies						8/6/91	KH
	M) Iron Sight Alignment						8/6/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/6/91	KH
	O) Attach Scope to Rifle						8/6/91	KH
	P) Detach & Attach Scope 20 Times						8/6/91	KH
640	Gallery Target & Test						8-7-91	DH
	A) Time						8-7-91	DH
	B) Malfunctions						8-7-91	DH
	C) Pierced Primers						8-7-91	DH
	D) Optical Clarity of Scope						8-7-91	DH
645	Inspect for Live Ammo						8-7-91	DH
655	Final Inspection						8-8-91	DH
	A) Headspace						8-8-91	DH
	B) Trigger Pull	2.54	2.45	2.55	2.50	2.57	8-7-91	JV
	C) Function						8-8-91	DH
660	Pack						9-19-91	NF

MOD.		GA. CAL.	GUN #
			26649082
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaver brass and ejector sticks	
	2nd	REAMED EJECT. HOLE POLISHED EJECTOR. NEW EXTRACTOR WIRE BRUSHED & CLEANED SHROUD &	23
	3rd	FACE OF BOLT Re-Reamed Re-Cleaned NEW EXTRACTOR	23
	4th	NEW EJECTOR	
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>shot OK</i>	
TEST		
TGT		
PROOF	<i>8-9-91</i>	<i>DH</i>
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

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

SERIAL NO. C-6649082DATE 8-6-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.44	2.44	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.37	2.40	2.45	
PULL #3	2.28	2.46	2.38	2.55	
PULL #4	2.23	2.37	2.30	2.50	
PULL #5	2.48	2.37	2.38	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.44		
PULL #2	3.43	3.54		
PULL #3	3.59	3.56		
PULL #4	3.59	3.52		
PULL #5	3.45	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.20		4.51
PULL #2	4.35	4.42		4.43
PULL #3	4.20	4.45		4.29
PULL #4	4.24	4.22		4.51
PULL #5	4.30	4.54		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649082
7 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.246175
1 TO 2	.319406
1 TO 3	.2768
1 TO 4	.138322
1 TO 5	.185235

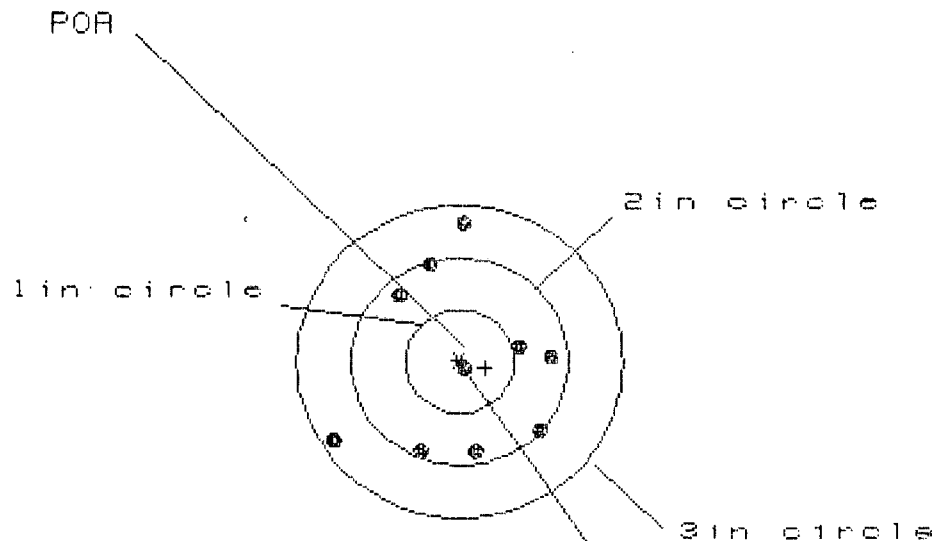
5
29 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1946
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197479
THE CM FOR THIS RIFLE IS: .8328

1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6649082

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 10

CENTROID #

HS = 1.999

VS = 2.283

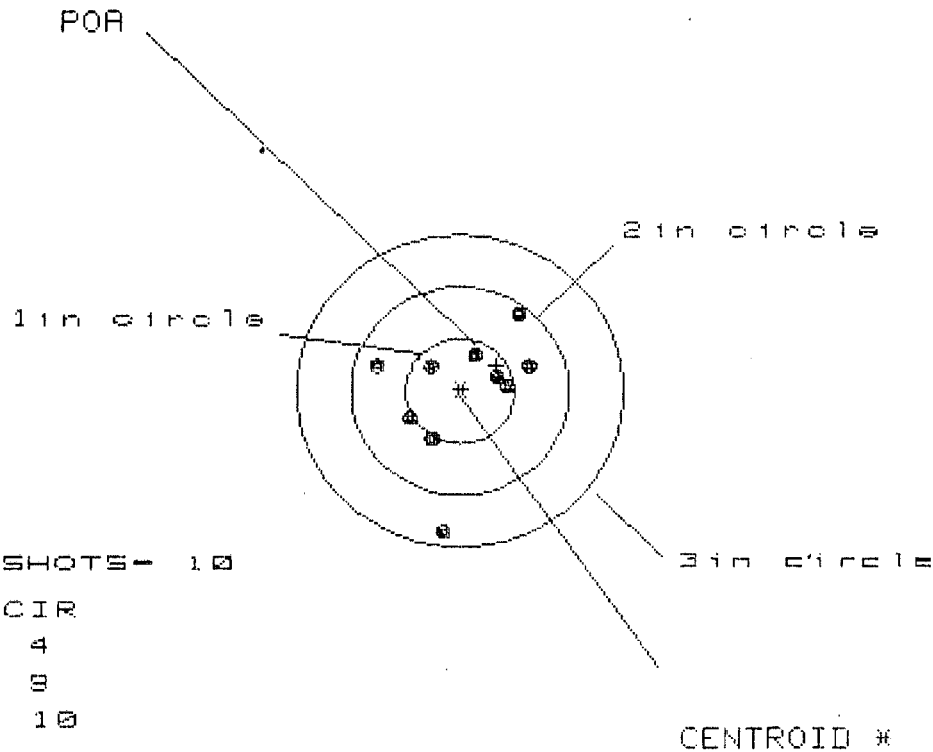
GS = 2.458

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.830	.700	.688
MINIMUM X	-1.169	-.665	-.677
MAXIMUM Y	1.379	1.295	1.066
MINIMUM Y	-.904	-.988	-.826
CENTROID X	-.239	-.109	-.097
CENTROID Y	.059	.143	-.019
POA TO CENTROID in.	.246	.180	.099
MIN RADIUS	.050	.160	.118
MEAN RADIUS	.893	.828	.750
MAX RADIUS	1.396	1.298	1.137
HORIZONTAL SPREAD	1.999	1.365	1.365
VERTICAL SPREAD	2.283	2.283	1.892
EXTREME SPREAD	2.458	2.323	1.921
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.366

VS= 2.133

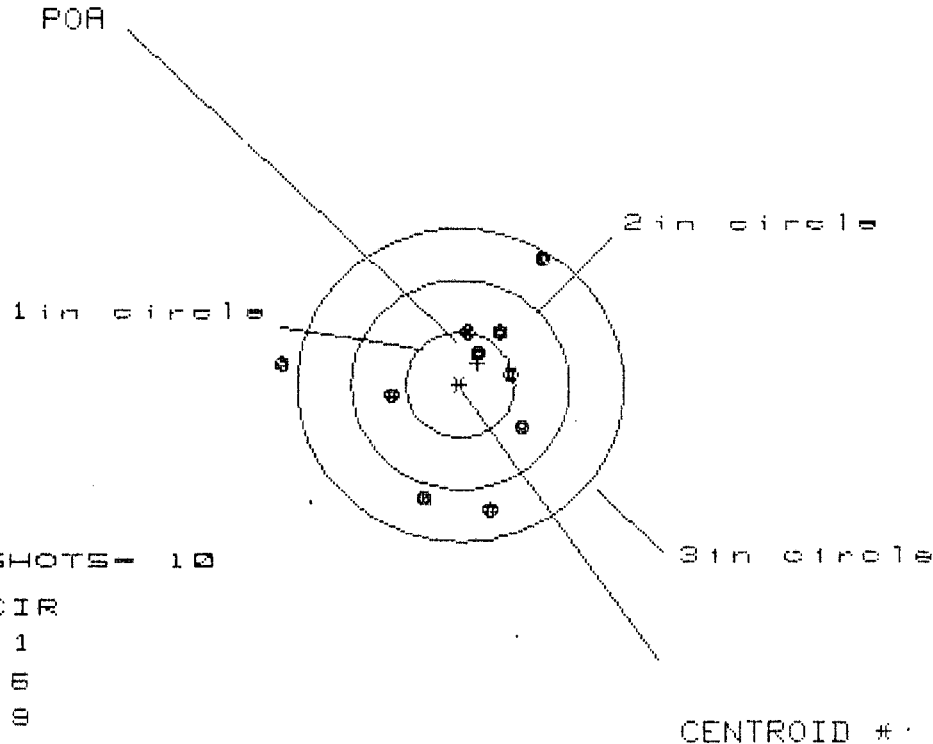
GS= 2.236

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.613	.595	.656
MINIMUM X	-.753	-.771	-.710
MAXIMUM Y	.787	.637	.264
MINIMUM Y	-1.346	-.583	-.503
CENTROID X	-.337	-.319	-.380
CENTROID Y	-.245	-.095	-.175
POA TO CENTROID in.	.417	.333	.418
MIN RADIUS	.349	.202	.300
MEAN RADIUS	.628	.523	.491
MAX RADIUS	1.356	.803	.723
HORIZONTAL SPREAD	1.366	1.366	1.366
VERTICAL SPREAD	2.133	1.220	.767
EXTREME SPREAD	2.236	1.458	1.367
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

7 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.466

VS= 2.381

GS= 2.654

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.797	.612	.433
MINIMUM X	-1.669	-.805	-.729
MAXIMUM Y	1.158	1.178	.720
MINIMUM Y	-1.223	-1.203	-1.056
CENTROID X	-.166	.019	-.057
CENTROID Y	-.208	-.228	-.375
POA TO CENTROID in.	.266	.229	.379
MIN RADIUS	.368	.333	.473
MEAN RADIUS	.882	.763	.715
MAX RADIUS	1.678	1.327	1.066
HORIZONTAL SPREAD	2.466	1.417	1.162
VERTICAL SPREAD	2.381	2.381	1.776
EXTREME SPREAD	2.654	2.550	1.788
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

IS = 2.053

VS = 2.601

GS = 2.738

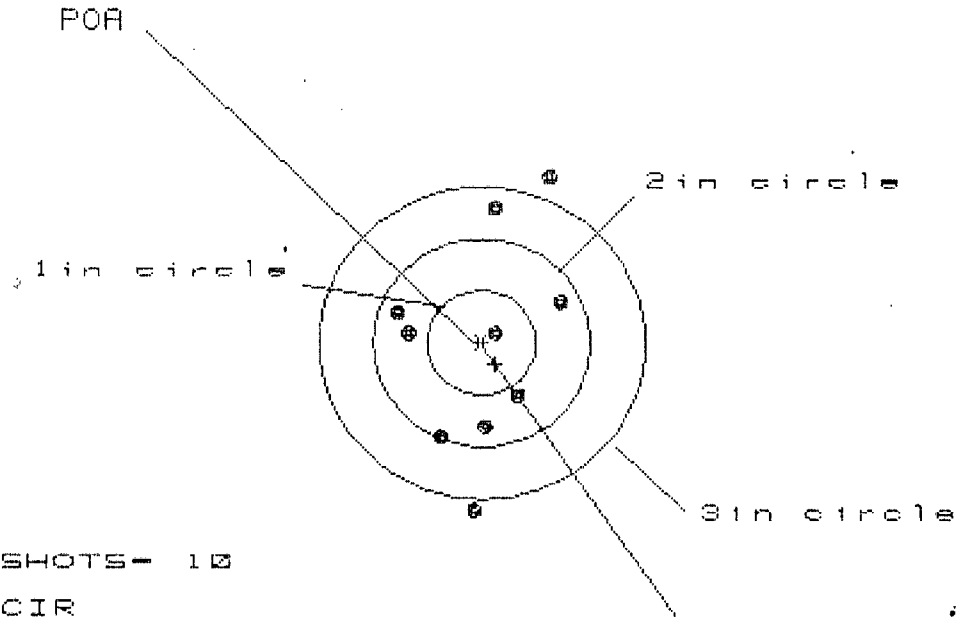
CENTROID #

PATTERN #	4	5	6
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.396	1.454	.620
MINIMUM X	-.667	-.609	-.427
MAXIMUM Y	1.522	1.085	1.031
MINIMUM Y	-1.079	-.910	-.964
CENTROID X	-.106	-.164	-.346
CENTROID Y	.021	-.148	-.094
POA TO CENTROID in.	.108	.221	.359
MIN RADIUS	.258	.242	.087
MEAN RADIUS	.809	.701	.557
MAX RADIUS	1.611	1.516	1.032
HORIZONTAL SPREAD	2.063	2.063	1.047
VERTICAL SPREAD	2.601	1.995	1.995
EXTREME SPREAD	2.738	2.251	1.996
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 1.476

VS= 3.280

GS= 3.369

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.678	.752	.748
MINIMUM X	-.798	-.724	-.728
MAXIMUM Y	1.641	1.519	1.337
MINIMUM Y	-1.639	-1.456	-.898
CENTROID X	-.125	-.199	-.195
CENTROID Y	.205	.022	.204
POA TO CENTROID in.	.240	.200	.283
MIN RADIUS	.135	.327	.188
MEAN RADIUS	.952	.849	.765
MAX RADIUS	1.771	1.529	1.348
HORIZONTAL SPREAD	1.476	1.476	1.476
VERTICAL SPREAD	3.280	2.975	2.235
EXTREME SPREAD	3.369	2.982	2.281
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	