

C6225381

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



C6225381

New BBL Action

SEE

C6702845

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6225381

ORDER NO.
5716

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

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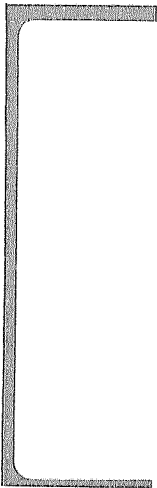


5716 C6225381

UPC



0 47700 25716 7



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225381

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 21	89	RW
600	Proof	4 21	89	RW
607	Check Headspace	4 21	89	RW
610	Dis-assemble Gun	4 21	89	RW
612	Magnaflux Barrel Action		4/26	KER
	Magnaflux Bolt		4/27	KER
615	Rollmark Caliber		4/27	G.S.
617	Drill and Tap Sight Holes	4 27	89	JB
618	Polish Barrel RB	4 27	89	BT
620	Apply Coatings (Barrel Action)		5-28-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/89	RW
	C) Inspect Ejector Hole for Chamfer		5/10/89	RW
	D) Oil Firing Pin Ass'y		5/10/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/17/89	G.S.

op. #	BARBER - M24 0014061 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/17/89	J.P.
	G) Safety Off Force	3	3	3			5/17/89	J.P.
	H) Trigger Pull Test & Retainability						5/17/89	G.S.
	I) Firing Pin Indent	.021	.021	.020			5/17/89	J.P.
	J) Assemble Stock						5/17/89	Ru
	K) Assemble Swivel Studs						18 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/17/89	Ru
	M) Iron Sight Alignment						5/17/89	Ru
	N) Detach Front & Rear Sights & place in numbered container						5/17/89	Ru
	O) Attach Scope to Rifle						5/17/89	J.P.
	P) Detach & Attach Scope 20 Times						5/18/89	J.P.
640	Gallery Target & Test	73 R	79 L				5/18/89	DH
	A) Time						5/18/89	DH
	B) Malfunctions						5/18/89	DH
	C) Pierced Primers						5/18/89	DH
	D) Optical Clarity of Scope						5/18/89	DH
645	Inspect for Live Ammo						5/18/89	DH
655	Final Inspection							
	A) Headspace						18 May 89	JS
	B) Trigger Pull	248	273	239	259	235	18 May 89	JS
	C) Function						18 May 89	JS
660	Pack						20 June 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 62253H

DATE 4/4/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.44	2.25	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.24	2.36	
PULL #3	2.25	2.23	2.27	
PULL #4	2.21	2.22	2.38	
PULL #5	2.18	2.15	2.30	
TOTAL	11.35	11.09	11.60	
AVG.	2.23	2.21	2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.14	3.09	
PULL #2	3.13	3.05	
PULL #3	3.14	3.03	
PULL #4	3.12	3.06	
PULL #5	3.10	3.02	
TOTAL	15.63	15.25	
AVG.	3.12	3.05	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.14		
PULL #2	4.18	4.11		
PULL #3	4.19	4.14		
PULL #4	4.21	4.15		
PULL #5	4.17	4.11		
TOTAL	20.96	20.65		
AVG.	4.19	4.13		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225381
18 May 1989

CENTROIDAL DISTANCES

Ø TO	1	.691886
1 TO	2	.88305
1 TO	3	.30104
1 TO	4	.821192
1 TO	5	1.23974

5 4+ 2 <----POA
1³

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168596
THE AMR FOR THIS RIFLE IS: .9648

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225361

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.794

VS= 2.347

GS= 2.545

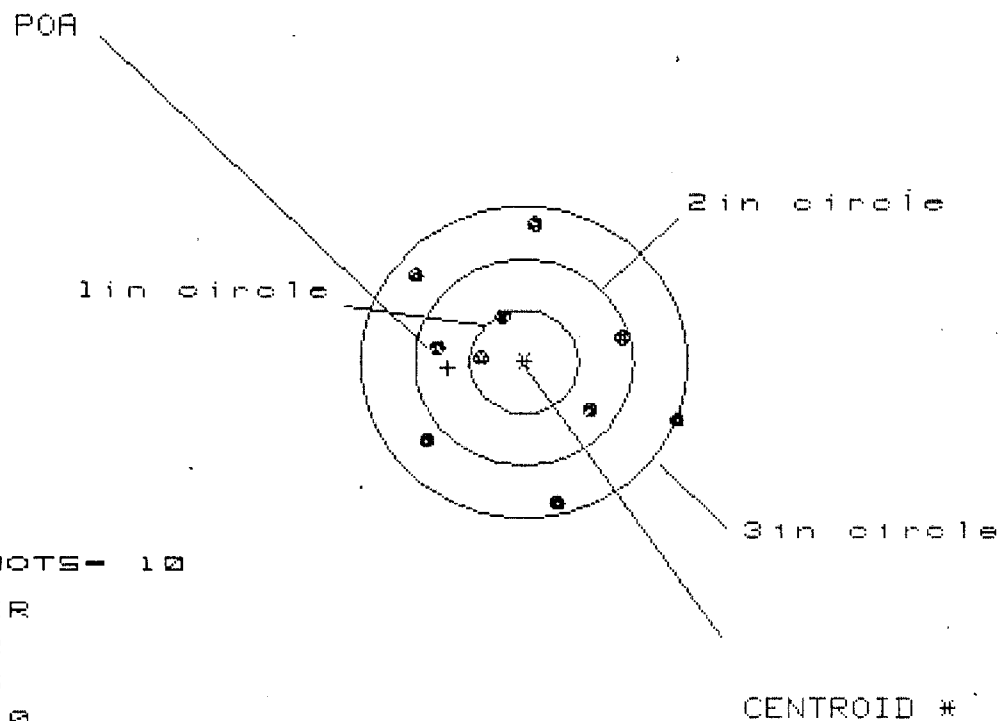
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.708	.588	.490
MINIMUM X	:	-1.086	-.778	-.398
MAXIMUM Y	:	1.083	.943	1.044
MINIMUM Y	:	-1.264	-.792	-.674
CENTROID X	:	.191	.311	.409
CENTROID Y	:	-.665	-.525	-.643
POA TO CENTROID in.	:	.692	.610	.762
MIN RADIUS	:	.206	.180	.105
MEAN RADIUS	:	.771	.649	.558
MAX RADIUS	:	1.666	1.223	1.081
HORIZONTAL SPREAD	:	1.794	1.366	.888
VERTICAL SPREAD	:	2.347	1.735	1.718
EXTREME SPREAD	:	2.545	2.050	1.755
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225381

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.429

VS = 2.632

GS = 2.801

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.387	1.039	.928
MINIMUM X	:	-1.042	-.888	-.870
MAXIMUM Y	:	1.319	1.261	1.363
MINIMUM Y	:	-1.313	-1.371	-1.269
CENTROID X	:	.698	.544	.655
CENTROID Y	:	.058	.117	.015
POA TO CENTROID in.	:	.701	.557	.656
MIN RADIUS	:	.386	.239	.346
MEAN RADIUS	:	.998	.914	.890
MAX RADIUS	:	1.482	1.447	1.366
HORIZONTAL SPREAD	:	2.429	1.927	1.798
VERTICAL SPREAD	:	2.632	2.632	2.632
EXTREME SPREAD	:	2.801	2.644	2.644
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/062253B1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS = 2.114

VS = 3.109

GS = 3.111

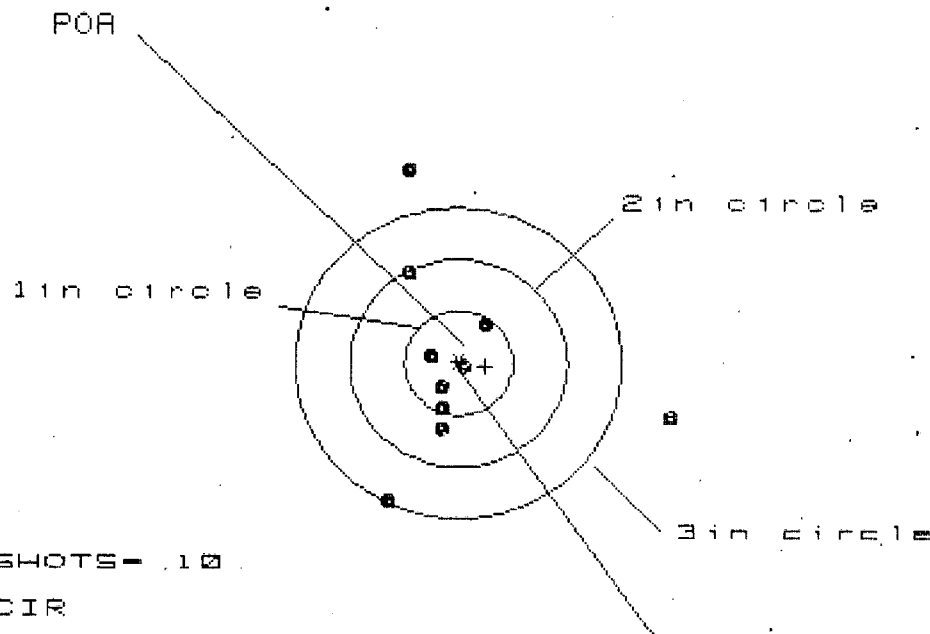
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.232
MINIMUM X	-.882
MAXIMUM Y	1.562
MINIMUM Y	-1.547
CENTROID X	.391
CENTROID Y	-.440
POA TO CENTROID in.	.588
MIN RADIUS	.633
MEAN RADIUS	1.237
MAX RADIUS	1.572
HORIZONTAL SPREAD	2.114
VERTICAL SPREAD	3.109
EXTREME SPREAD	3.111
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	6

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in - 5

2in - 6

3in - 8

HS - 2.568

VS - 3.131

GS - 3.342

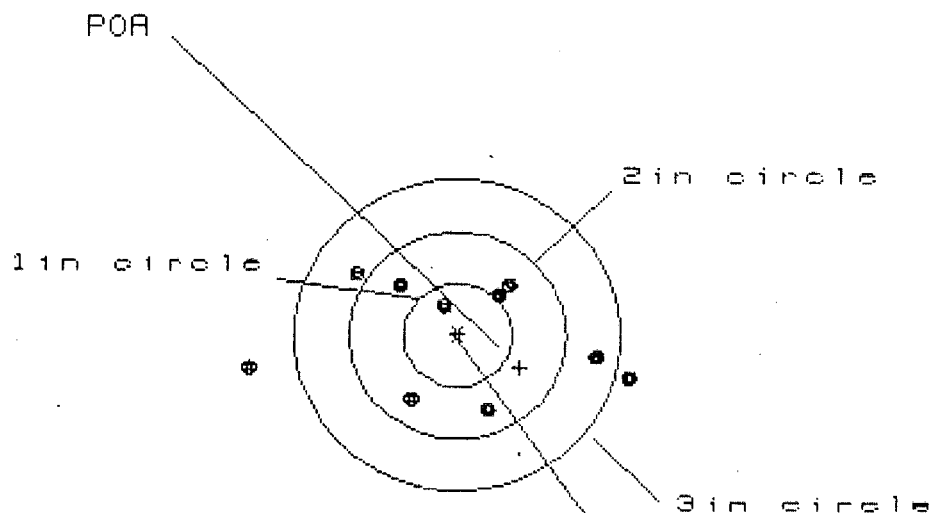
CENTROID +

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.966	.429	.404
MINIMUM X	-.602	-.384	-.409
MAXIMUM Y	1.945	1.789	1.050
MINIMUM Y	-1.286	-1.342	-1.118
CENTROID X	-.248	-.466	-.441
CENTROID Y	.029	.085	-.139
POA TO CENTROID in.	.249	.474	.462
MIN RADIUS	.045	.085	.115
MEAN RADIUS	.853	.719	.544
MAX RADIUS	2.027	1.801	1.190
HORIZONTAL SPREAD	2.568	.813	.813
VERTICAL SPREAD	3.131	3.131	2.168
EXTREME SPREAD	3.342	3.136	2.172
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

HS - 3.446

VS - 1.291

GS - 3.448

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.539
MINIMUM X	-1.907
MAXIMUM Y	.552
MINIMUM Y	-.739
CENTROID X	-.576
CENTROID Y	.309
POA TO CENTROID in.	.654
MIN RADIUS	.350
MEAN RADIUS	.965
MAX RADIUS	1.925
HORIZONTAL SPREAD	3.446
VERTICAL SPREAD	1.291
EXTREME SPREAD	3.448
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8