

C6636256

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.

MODEL 700™ H24

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

UPPONT

SERIAL NO.
C6636256

ORDER NO.
5716

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

06

UPC 0 47700 25716 2

5716 C6636256

GUN SERIAL # C6636256

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCR
	Magnaflux Bolt	5 6 91		KCR
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	JA
	Apply Coating (Bolt)		5/30/91	JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/12/91	JA

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-12-91	DH
	G) Safety Off Force	3	3	3			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	FL
	I) Firing Pin Indent	.022	.021	.022			6-12-91	DH
	J) Assemble Stock						6-12-91	RW
	K) Assemble Swivel Studs						6-14-91	FL
	L) Attach Front and Rear Sight Assemblies						6-12-91	RW
	M) Iron Sight Alignment						6-12-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-12-91	RW
	O) Attach Scope to Rifle						6-12-91	RW
	P) Detach & Attach Scope 20 Times						6-12-91	RW
640	Gallery Target & Test						6-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-13-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	FL
	B) Trigger Pull	2.15	2.25	2.28	2.22	2.22	6-14-91	FL
	C) Function						6-14-91	FL
660	Pack						6-19-91	NF

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

SERIAL NO. C66 36 256DATE 6-12-91TESTER JCL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.30	2.44	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.30	2.38	2.25	
PULL #3	2.26	2.30	2.30	2.28	
PULL #4	2.29	2.32	2.31	2.22	
PULL #5	2.28	2.35	2.39	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.23		
PULL #2	3.25	3.21		
PULL #3	3.28	3.19		
PULL #4	3.30	3.32		
PULL #5	3.28	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.58		4.49
PULL #2	4.36	4.34		4.35
PULL #3	4.43	4.41		4.48
PULL #4	4.46	4.49		4.29
PULL #5	4.16	4.11		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636256
13 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.179201
1 TO	2	.812518
1 TO	3	.49261
1 TO	4	.730335
1 TO	5	.255877

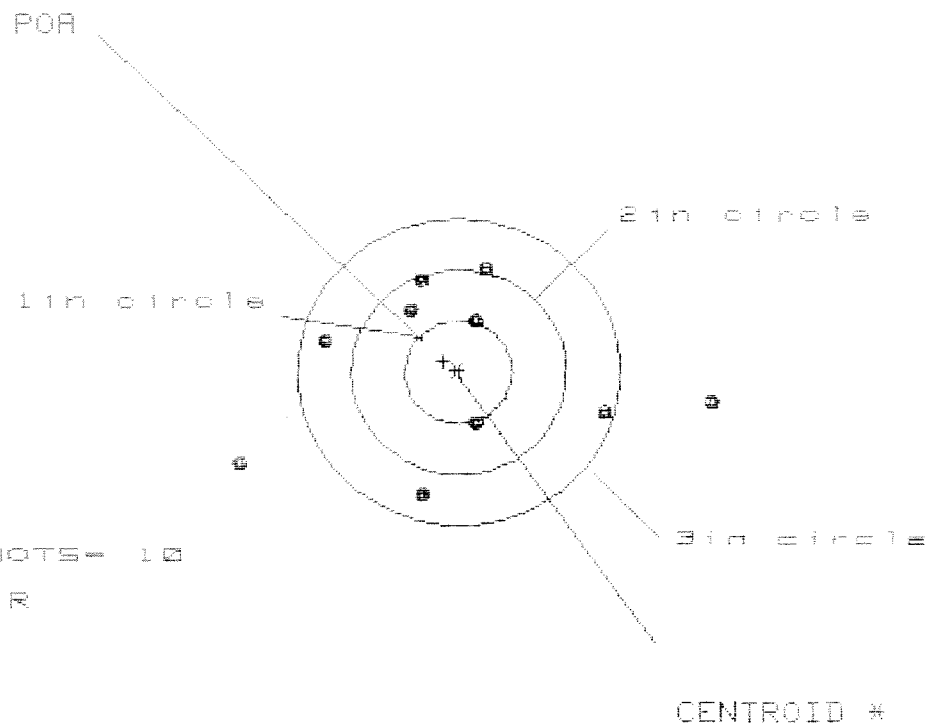
$\begin{matrix} 4 & 5 \\ 2 & 1 \\ & 3 \end{matrix}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0782
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0768
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .109606
THE AMR FOR THIS RIFLE IS: 1.297

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8696256

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 4.257

VS = 2.220

CS = 4.397

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

2.339

1.631

1.412

MINIMUM X

:

-2.018

-1.758

-1.167

MAXIMUM Y

:

1.055

1.017

.895

MINIMUM Y

:

-1.165

-1.203

-1.325

CENTROID X

:

.143

-.117

.102

CENTROID Y

:

-.108

-.070

.052

POA TO CENTROID in.:

:

.179

.137

.115

MIN RADIUS

:

.492

.625

.432

MEAN RADIUS

:

1.231

1.089

.935

MAX RADIUS

:

2.364

2.009

1.528

HORIZONTAL SPREAD

:

4.357

3.389

2.579

VERTICAL SPREAD

:

2.220

2.220

2.220

EXTREME SPREAD

:

4.397

3.427

2.671

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

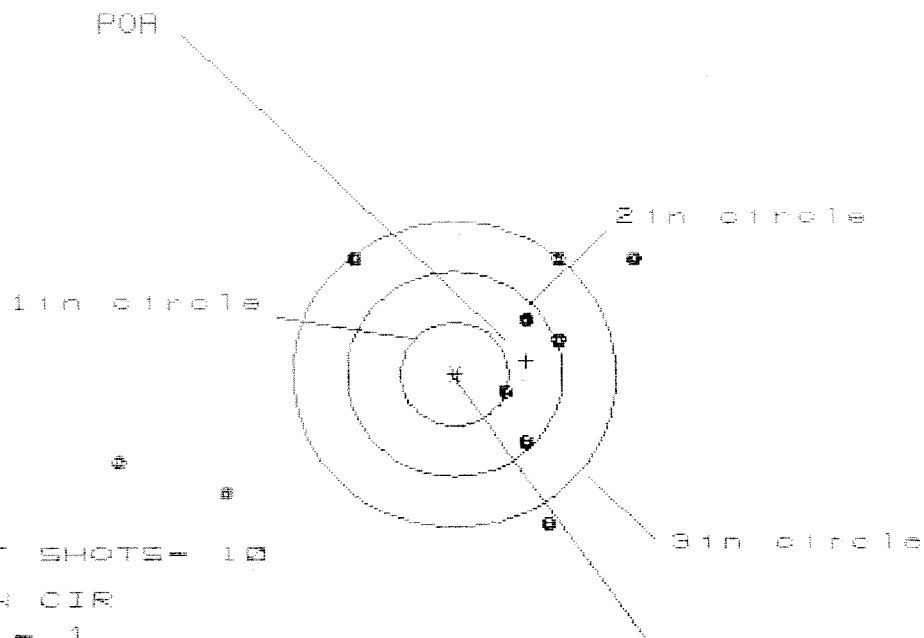
NUMBER IN THREE INCH CIRCLE =

8

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638256

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 4.886

VS = 2.624

GS = 5.260

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.708	1.354	1.040
MINIMUM X	:	-3.178	-2.516	-1.604
MAXIMUM Y	:	1.130	1.039	.886
MINIMUM Y	:	-1.494	-1.585	-1.738
CENTROID X	:	-.669	-.315	-.001
CENTROID Y	:	-.137	-.046	.107
POA TO CENTROID in.	:	.683	.319	.107
MIN RADIUS	:	.479	.253	.274
MEAN RADIUS	:	1.571	1.253	.975
MAX RADIUS	:	3.282	2.799	1.815
HORIZONTAL SPREAD	:	4.886	3.870	2.644
VERTICAL SPREAD	:	2.624	2.624	2.624
EXTREME SPREAD	:	5.260	4.485	3.139
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

13 Jun 1931

FILE:/PATTERNING/CENTERFIRE_PATT/06636236

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 5

HS = 2.731

VS = 3.861

GS = 4.817

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.456

1.468

1.444

MINIMUM X

:

-1.275

-1.263

-1.287

MAXIMUM Y

:

1.234

.942

.680

MINIMUM Y

:

-2.627

-2.100

-1.313

CENTROID X

:

.436

.424

.448

CENTROID Y

:

-.594

-.212

.050

POA TO CENTROID in.

:

.667

.474

.451

MIN RADIUS

:

.261

.115

.321

MEAN RADIUS

:

1.400

1.204

1.073

MAX RADIUS

:

2.629

2.109

1.449

HORIZONTAL SPREAD

:

2.731

2.731

2.731

VERTICAL SPREAD

:

3.861

3.842

1.993

EXTREME SPREAD

:

4.817

3.358

2.787

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

2

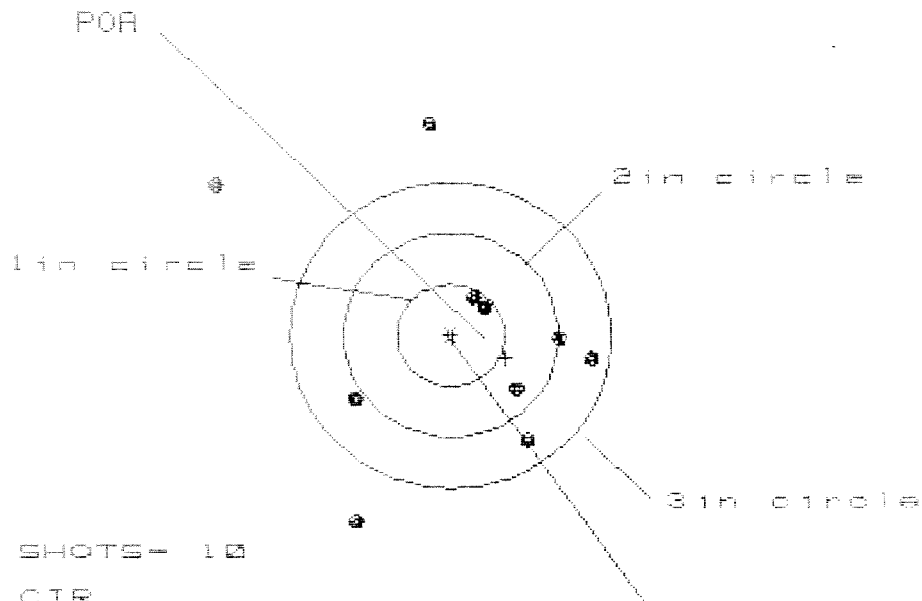
NUMBER IN THREE INCH CIRCLE =

5

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636256

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.454

VS= 3.962

GS= 4.037

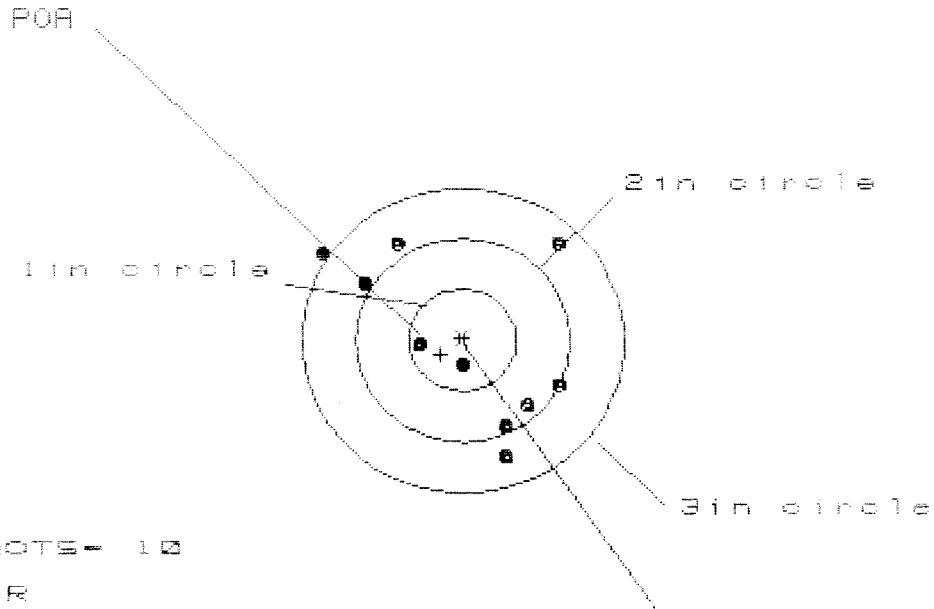
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.308	1.070	1.022
MINIMUM X	-2.146	-1.160	-1.208
MAXIMUM Y	2.120	2.286	.834
MINIMUM Y	-1.843	-1.676	-1.390
CENTROID X	-.507	-.269	-.221
CENTROID Y	.225	.059	-.227
POR TO CENTROID in.	.555	.275	.316
MIN RADIUS	.416	.424	.354
MEAN RADIUS	1.310	1.097	.937
MAX RADIUS	2.618	2.318	1.842
HORIZONTAL SPREAD	3.454	2.230	2.230
VERTICAL SPREAD	3.962	3.962	2.224
EXTREME SPREAD	4.037	4.037	2.752
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36256

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.197

VS = 2.179

GS = 2.687

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.755	.843
MINIMUM X	-1.298	-1.005	-.917
MAXIMUM Y	1.008	1.106	1.214
MINIMUM Y	-1.171	-1.073	-.935
CENTROID X	.206	.350	.263
CENTROID Y	.140	.042	-.096
POA TO CENTROID in.	.249	.353	.279
MIN RADIUS	.276	.226	.065
MEAN RADIUS	.974	.887	.795
MAX RADIUS	1.567	1.309	1.360
HORIZONTAL SPREAD	2.197	1.760	1.760
VERTICAL SPREAD	2.179	2.179	2.149
EXTREME SPREAD	2.687	2.369	2.369
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636256
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.374995
1 TO	2	.184621
1 TO	3	.275182
1 TO	4	.145413
1 TO	5	.185065

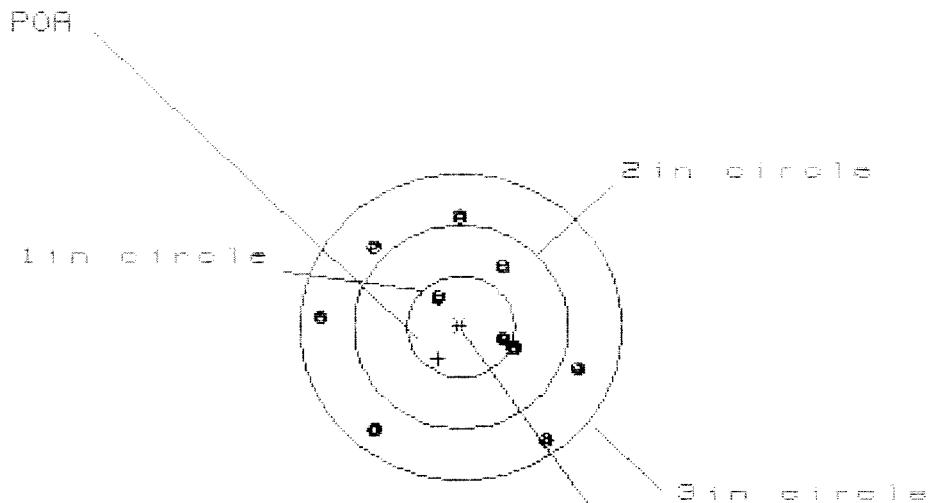
POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .198
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .267724
THE AMR FOR THIS RIFLE IS: .889

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638256.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.407

VS= 2.175

GS= 2.497

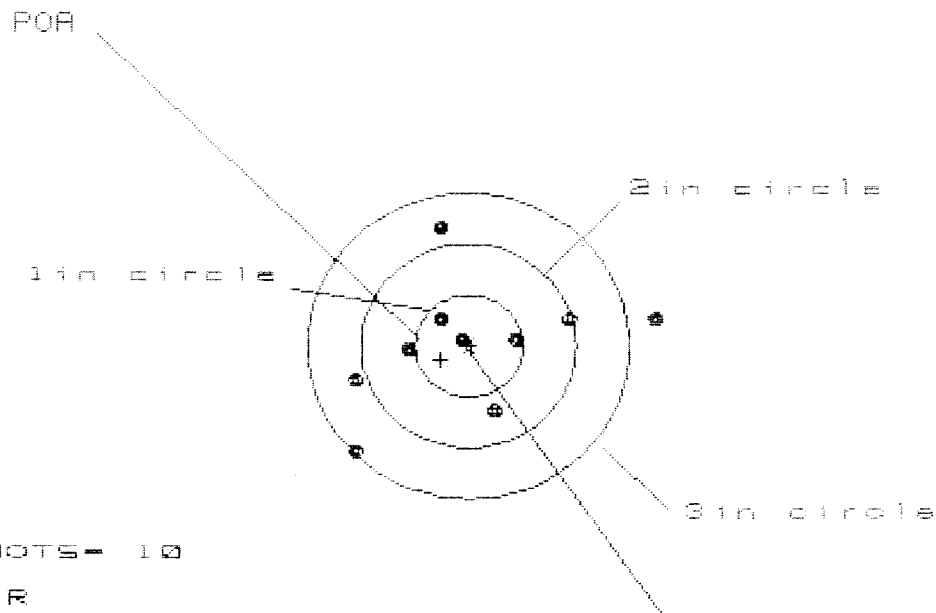
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.114	1.200	1.111
MINIMUM X	-1.293	-1.207	-1.296
MAXIMUM Y	1.048	.923	.777
MINIMUM Y	-1.127	-1.167	-.664
CENTROID X	.211	.125	.214
CENTROID Y	.310	.435	.581
POA TO CENTROID in.	.375	.453	.619
MIN RADIUS	.402	.251	.261
MEAN RADIUS	.944	.883	.797
MAX RADIUS	1.369	1.368	1.387
HORIZONTAL SPREAD	2.407	2.407	2.407
VERTICAL SPREAD	2.175	2.090	1.441
EXTREME SPREAD	2.497	2.458	2.458
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08696236.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.827

VS = 2.202

GS = 3.138

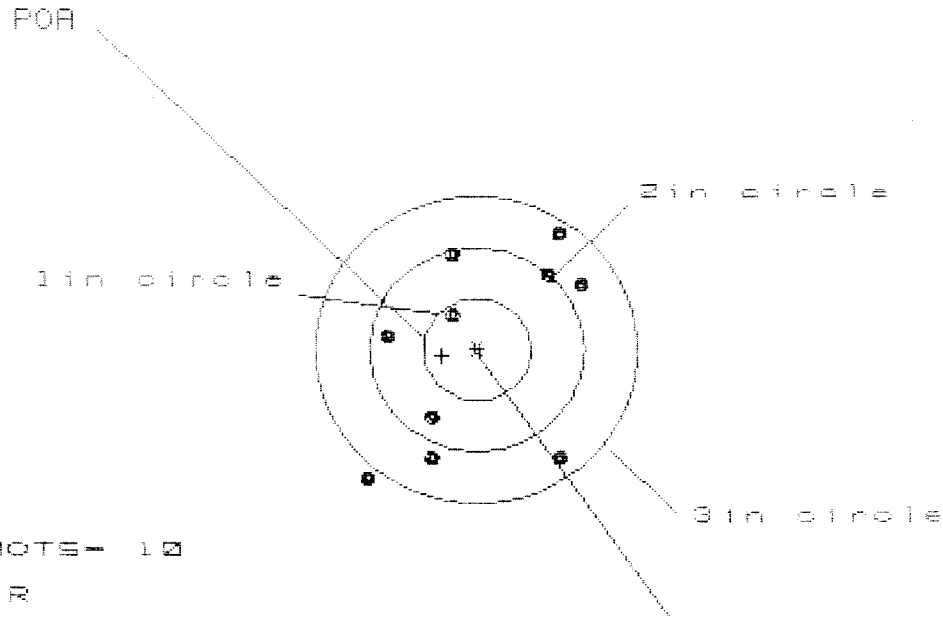
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.722	1.147	1.032
MINIMUM X	:	-1.105	-.913	-.970
MAXIMUM Y	:	1.142	1.175	1.047
MINIMUM Y	:	-1.060	-1.027	-.683
CENTROID X	:	.260	.068	.183
CENTROID Y	:	.132	.099	.227
POA TO CENTROID in.	:	.292	.120	.291
MIN RADIUS	:	.100	.157	.026
MEAN RADIUS	:	.875	.767	.667
MAX RADIUS	:	1.748	1.374	1.078
HORIZONTAL SPREAD	:	2.827	2.060	2.002
VERTICAL SPREAD	:	2.202	2.202	1.730
EXTREME SPREAD	:	3.138	2.459	2.107
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8536256.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.971

VS= 2.345

GS= 2.968

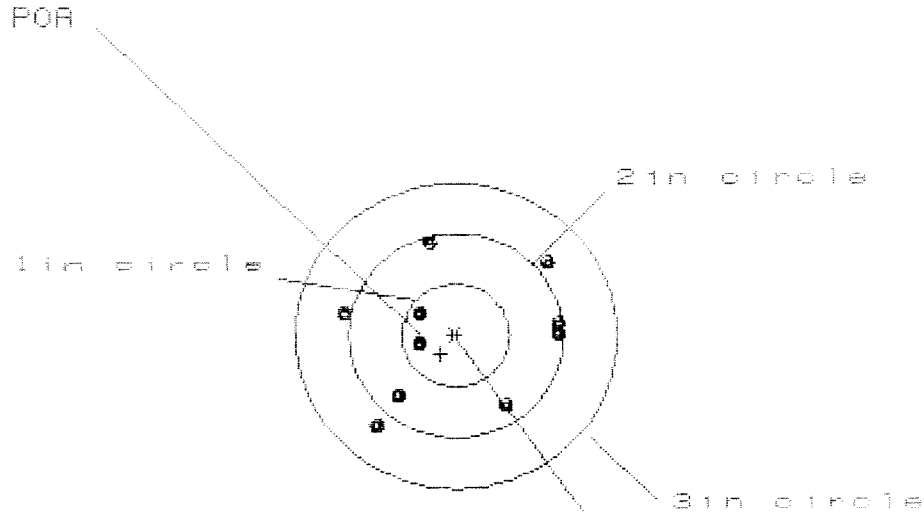
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.939	.824	.908
MINIMUM X	-1.032	-.981	-.897
MAXIMUM Y	1.131	.997	.920
MINIMUM Y	-1.214	-1.222	-1.098
CENTROID X	.326	.441	.357
CENTROID Y	.060	.194	.070
FOR TO CENTROID in.	.332	.482	.364
MIN RADIUS	.419	.399	.427
MEAN RADIUS	1.055	.981	.949
MAX RADIUS	1.593	1.382	1.317
HORIZONTAL SPREAD	1.971	1.805	1.805
VERTICAL SPREAD	2.345	2.219	2.018
EXTREME SPREAD	2.968	2.487	2.243
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

17 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636256.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.028

VS = 1.782

GS = 2.220

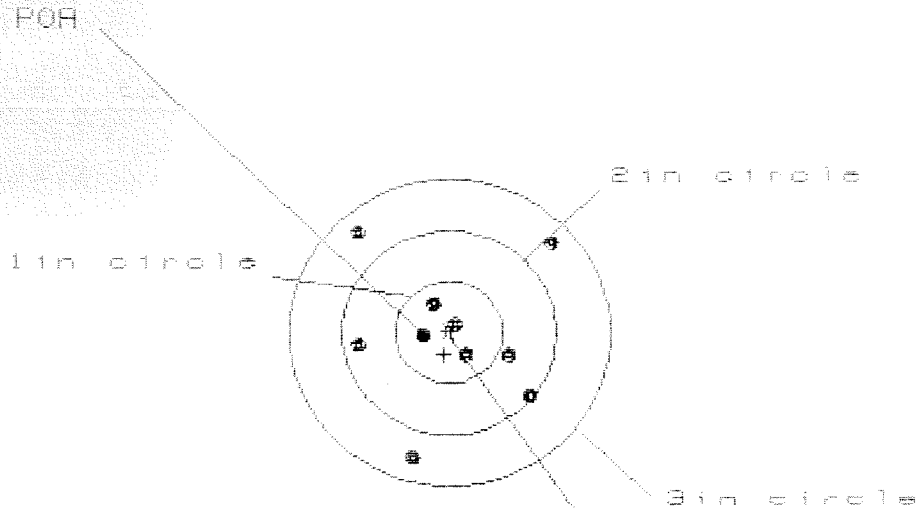
CENTROID #

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.997	.917	1.014
MINIMUM X	-1.031	-1.111	-1.014
MAXIMUM Y	.885	.785	.856
MINIMUM Y	-.897	-.820	-.749
CENTROID X	.142	.222	.125
CENTROID Y	.182	.282	.211
POA TO CENTROID in.	.231	.359	.245
MIN RADIUS	.323	.424	.310
MEAN RADIUS	.857	.825	.789
MAX RADIUS	1.149	1.117	1.031
HORIZONTAL SPREAD	2.028	2.028	2.028
VERTICAL SPREAD	1.782	1.605	1.605
EXTREME SPREAD	2.220	2.036	2.036
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08686258.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.754

VS= 2.120

GS= 2.456

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	.818	.731
MINIMUM X	-.830	-.727	-.814
MAXIMUM Y	.940	1.042	.547
MINIMUM Y	-1.180	-1.078	-.947
CENTROID X	.051	-.052	.035
CENTROID Y	.217	.115	-.016
POA TO CENTROID in.	.223	.126	.039
MIN RADIUS	.138	.194	.221
MEAN RADIUS	.714	.652	.583
MAX RADIUS	1.308	1.255	1.002
HORIZONTAL SPREAD	1.754	1.545	1.545
VERTICAL SPREAD	2.120	2.120	1.494
EXTREME SPREAD	2.456	2.169	1.610
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		