

C6636321

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

Remington[®]

MODEL 700TM M24

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

DUPONT

SERIAL NO. C6636321

ORDER NO. 5716

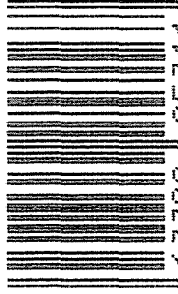
MADE IN LION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

20



5716 C6636321

UPC



0 47700 25746 7

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Test OK AC Aug 15, 1991	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____		GA. CAL. _____	GUN # <u>6321</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
N	8/14	Shaver Brass + Ejector stuck	KS
	2nd		
	8/14	REAMED EJECTOR POLISHED FACE OF BOLT	KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636321

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KL
600	Proof		6/25/91	KL
607	Check Headspace		6/25/91	KL
610	Dis-assemble Gun		6/25/91	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	LS
617	Drill and Tap Sight Holes	JUL 1 1991	1 1991	LS
618	Polish Barrel	JUL 2 1991	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	KA
	C) Inspect Ejector Hole for Chamfer		8/5/91	KA
	D) Oil Firing Pin Ass'y		8/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-6-91	DH
	G) Safety Off Force	3	2 1/2	2 1/2			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	gdl
	I) Firing Pin Indent	.021	.020	.020			8-6-91	DH
	J) Assemble Stock						8/9/91	KL
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/9/91	KL
	M) Iron Sight Alignment						8/9/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	KL
	O) Attach Scope to Rifle						8/9/91	KL
	P) Detach & Attach Scope 20 Times						8/9/91	KL
640	Gallery Target & Test						8-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-14-91	NF
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.57	2.46	2.55	2.61	2.51	8-15-91	gdl
	C) Function						8-17-91	DH
660	Pack						9-19-91	NF

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

SERIAL NO. C6636321DATE 8-6-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.39	2.40	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.34	2.44	2.45	
PULL #3	2.40	2.53	2.52	2.55	
PULL #4	2.46	2.33	2.50	2.61	
PULL #5	2.47	2.44	2.53	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.60		
PULL #2	3.18	3.51		
PULL #3	3.27	3.51		
PULL #4	3.37	3.32		
PULL #5	3.26	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.53		4.45
PULL #2	4.49	4.48		4.60
PULL #3	4.47	4.46		4.60
PULL #4	4.49	4.35		4.59
PULL #5	4.43	4.26		4.56
TOTAL				
AVG.				

ENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6636321
 20 Aug 1991

ENTROIDAL DISTANCES

0 TO	1	.0496488
1 TO	2	.13306
1 TO	3	.0126491
1 TO	4	.0393177
1 TO	5	.0240832

←----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0706
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.023
 THE RESULTING AVERAGE POR RADIUS FOR THIS RIFLE IS: .074252

THE TOP FOR THIS RIFLE IS: .9104

13 Aug 1951

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in = 10

HS- 1.855

VS- 2.582

GS- 2.649.

CENTROID *

PATTERN #

SHOT (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE

NUMBER IN TWO

NUMBER IN THREE

:

:

:

:

:

:

:

:

:

:

:

:

:

:

:

:

:

10

.965

-.890

1.099

-1.483

-.049

.008

.050

.291

.958

1.483

1.855

2.582

2.649

=

=

=

9

.965

-.890

.934

-1.278

-.049

.173

.180

.322

.878

1.451

1.855

2.212

2.285

=

=

=

8

.879

-.976

.774

-1.135

.037

.333

.335

.363

.781

1.173

1.855

1.909

1.948

=

=

=

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636321

CENTERFIRE PATTERNS # 2

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= 2.099

VS= 2.718

GS= 2.920

CENTROID *

PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.971	.960	.706
MINIMUM X	-1.129	-1.139	-1.019
MAXIMUM Y	1.725	.801	.701
MINIMUM Y	-.994	-.802	-.673
CENTROID X	-.053	-.042	-.162
CENTROID Y	-.125	-.316	-.216
POA TO CENTROID in.	.135	.319	.270
MIN RADIUS	.333	.249	.245
MEAN RADIUS	.810	.679	.603
MAX RADIUS	1.727	1.393	1.237
HORIZONTAL SPREAD	2.099	2.099	1.725
VERTICAL SPREAD	2.718	1.603	1.374
EXTREME SPREAD	2.920	2.641	1.921
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636321

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 10

HS= 2.409

VS= 1.900

GS= 2.411

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =



10

9

8

1.233

.629

.499

-1.176

-1.039

-.910

.990

.989

.977

-.910

-.911

-.923

-.061

-.198

-.068

.004

.004

.016

.061

.198

.069

.268

.341

.259

.810

.773

.710

1.233

1.145

1.081

2.409

1.668

1.409

1.900

1.900

1.900

2.411

2.118

2.118

4

5

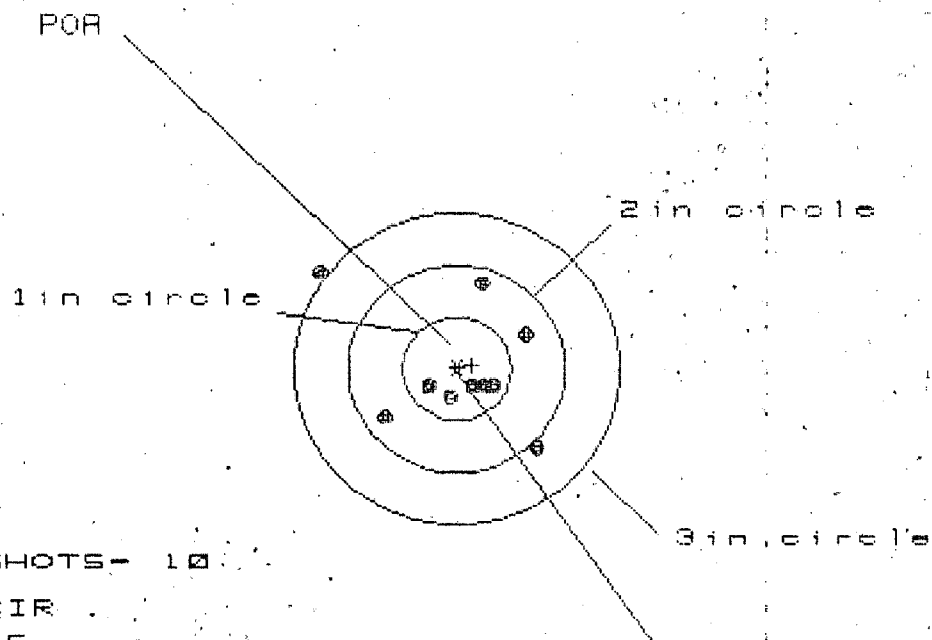
10

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.027

VS= 1.671

GS= 2.627

CENTROID #

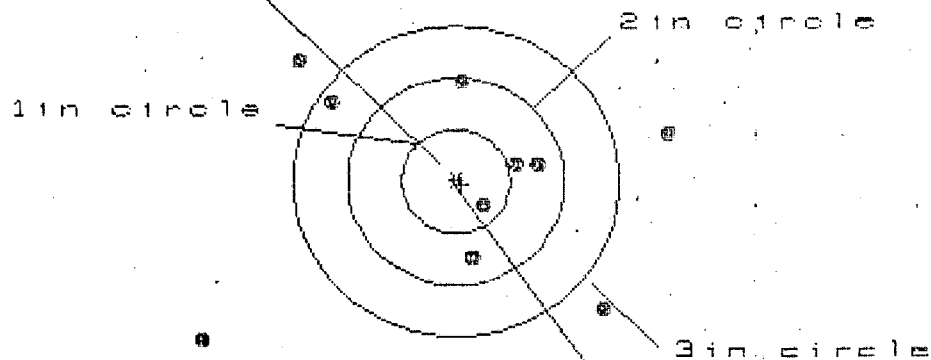
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.755	.613	.565
MINIMUM X	-1.272	-.794	-.717
MAXIMUM Y	.943	.945	.867
MINIMUM Y	-.728	-.623	-.437
CENTROID X	-.139	.003	-.074
CENTROID Y	-.034	-.139	-.061
POA TO CENTROID in.	.143	.139	.096
MIN RADIUS	.224	.083	.170
MEAN RADIUS	.646	.492	.463
MAX RADIUS	1.584	.948	.881
HORIZONTAL SPREAD	2.027	1.407	1.282
VERTICAL SPREAD	1.671	1.568	1.304
EXTREME SPREAD	2.627	1.656	1.569
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 4.261

VS= 2.724

GS= 4.738

PATTERN

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.964	1.642	1.293
MINIMUM X	-2.357	-1.756	-1.551
MAXIMUM Y	1.162	.989	1.031
MINIMUM Y	-1.562	-1.378	-1.336
CENTROID X	-.051	.211	.006
CENTROID Y	.032	.205	.163
POA TO CENTROID in.	.060	.294	.163
MIN RADIUS	.362	.286	.436
MEAN RADIUS	1.328	1.099	1.050
MAX RADIUS	2.828	2.015	1.862
HORIZONTAL SPREAD	4.261	3.398	2.844
VERTICAL SPREAD	2.724	2.367	2.367
EXTREME SPREAD	4.738	3.700	3.700
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		