

C6535340

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

MOD.		GA. CAL.	GUN #
			6340
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	8/17	Ejector sticks & shower Brass	KS
	2nd		
	8/17/91	REAMED EJECTOR HOLE CLEANED SHROUD F' FACE OF BOLT POLISHED EJECTOR CHANGED EXTRACTOR	KS "23"
	3rd		
	8/18/91	Re - Reamed Re - Cleaned NEW EJECTOR & EXTRACTOR	KS
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Ed. test OK AC 9-91	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

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

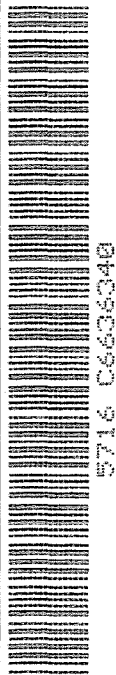
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6636340

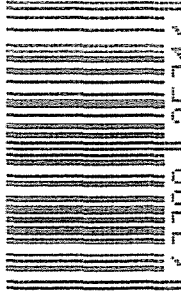
ORDER NO.
5716

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



5716 C6636340

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636340**

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-2-91	DH
	G) Safety Off Force	3	3 1/2	3 1/2			8-2-91	DH
	H) Trigger Pull Test & Retainability						8-2-91	JP
	I) Firing Pin Indent	.022	.022	.022			8-2-91	JP
	J) Assemble Stock						8/7/91	KS
	K) Assemble Swivel Studs						8-8-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	KS
	M) Iron Sight Alignment						8/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	KS
	O) Attach Scope to Rifle						8/7/91	KS
	P) Detach & Attach Scope 20 Times						8/7/91	KS
640	Gallery Target & Test						8-7-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-7-91	AF
655	Final Inspection							
	A) Headspace						8-8-91	DH
	B) Trigger Pull	2.68	2.70	2.72	2.60	2.54	8-8-91	JP
	C) Function						8-8-91	DH
660	Pack						9-8-91	AF

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

SERIAL NO. C-6636340DATE 8-2-91TESTER JL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.24	2.36	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.33	2.40	2.70	
PULL #3	2.19	2.38	2.37	2.72	
PULL #4	2.39	2.32	2.44	2.60	
PULL #5	2.36	2.31	2.38	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.28		
PULL #2	3.42	3.42		
PULL #3	3.43	3.33		
PULL #4	3.49	3.42		
PULL #5	3.38	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.50		4.51
PULL #2	4.42	4.44		4.49
PULL #3	4.44	4.56		4.49
PULL #4	4.58	4.59		4.49
PULL #5	4.50	4.59		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # D6636340
7 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0451885
1 TO	2	.188733
1 TO	3	.222036
1 TO	4	.166589
1 TO	5	.201683

←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0794
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0796
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112572
THE BMR FOR THIS RIFLE IS: 1.149

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G8636340

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 1.740

VS= 2.788

ES= 2.943

PATTERN #

:

10

9

8

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.952

.953

.749

MINIMUM X

:

.788

.787

.667

MAXIMUM Y

:

1.142

.959

.950

MINIMUM Y

:

-1.646

-1.390

-1.271

CENTROID X

:

.041

.040

-.079

CENTROID Y

:

-.019

.163

.044

POA TO CENTROID in:

:

.045

.168

.031

MIN RADIUS

:

.283

.418

.255

MEAN RADIUS

:

1.021

.932

.864

MAX RADIUS

:

1.647

1.598

1.485

HORIZONTAL SPREAD

:

1.740

1.740

1.416

VERTICAL SPREAD

:

2.788

2.349

2.221

EXTREME SPREAD

:

2.943

2.923

2.532

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0863B340

CENTERFIRE PATTERNS

2

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS = 3.005

VS = 2.908

GS = 3.705

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.072	1.079	1.036
MINIMUM X	:	-1.193	-1.985	-1.027
MAXIMUM Y	:	1.301	.905	.735
MINIMUM Y	:	-1.507	-1.362	-.937
CENTROID X	:	-.001	-.209	-.167
CENTROID Y	:	-.203	-.348	-.178
POB TO CENTROID in.	:	.203	.406	.244
MIN RADIUS	:	.680	.469	.595
MEAN RADIUS	:	1.120	.937	.868
MAX RADIUS	:	2.280	1.407	1.270
HORIZONTAL SPREAD	:	3.065	2.063	2.063
VERTICAL SPREAD	:	2.808	2.267	1.672
EXTREME SPREAD	:	3.705	2.672	2.247
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3B340

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.531

VS= 4.025

GS= 4.373

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.104

.834

.830

MINIMUM X

-2.427

-1.553

-1.507

MAXIMUM Y

2.225

2.312

1.513

MINIMUM Y

-1.800

-1.713

-1.424

CENTROID X

-.153

.117

.071

CENTROID Y

-.127

-.214

-.503

POA TO CENTROID in.

.199

.244

.508

MIN RADIUS

.332

.448

.453

MEAN RADIUS

1.416

1.267

1.099

MAX RADIUS

2.551

2.341

1.715

HORIZONTAL SPREAD

3.531

2.387

2.387

VERTICAL SPREAD

4.025

4.025

2.937

EXTREME SPREAD

4.373

4.052

3.274

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636340

CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.079

VS= 3.031

GS= 3.033

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.830	.863	.796
MINIMUM X	:	-1.249	-1.216	-1.109
MAXIMUM Y	:	1.744	1.538	1.070
MINIMUM Y	:	-1.287	-1.033	-.981
CENTROID X	:	-.125	-.158	-.266
CENTROID Y	:	-.005	-.199	-.391
POB TO CENTROID in.	:	.125	.254	.473
MIN RADIUS	:	.204	.223	.420
MEAN RADIUS	:	1.111	1.014	.914
MAX RADIUS	:	1.768	1.763	1.235
HORIZONTAL SPREAD	:	2.079	2.079	1.904
VERTICAL SPREAD	:	3.031	2.631	1.971
EXTREME SPREAD	:	3.033	2.939	2.278
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

7 Aug 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06536340

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.908

VS = 1.845

GS = 4.838

CENTROID +

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

1.806

1.573

1.169

-2.102

-1.106

-.809

1.003

1.038

.982

-.942

-.797

-.863

-.159

.074

-.123

-.045

-.090

-.024

.166

.117

.125

.405

.383

.427

1.078

.924

.851

2.140

1.661

1.312

3.908

2.679

2.878

1.845

1.845

1.845

4.838

2.810

2.103

2

5

8