

05348719

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



GUN SERIAL # C6348719

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A.C.
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	10 1689		JB
618	Polish Barrel RB	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/89	JS

BARBER - M24 0062264		READINGS			DATE	INIT
op. #	OP. NAME					
625 cont.	F) Safety On Force	5	5	5	10/30/89	RL
	G) Safety Off Force	3	3	3	10/30/89	RL
	H) Trigger Pull Test & Retainability				30 Oct 89	RL
	I) Firing Pin Indent	10225	10225	1023	10/30/89	RL
	J) Assemble Stock				10/31/89	RL
	K) Assemble Swivel Studs				10/30/89	RL
	L) Attach Front and Rear Sight Assemblies				10/31/89	RL
	M) Iron Sight Alignment				10/31/89	RL
	N) Detach Front & Rear Sights & place in numbered container				10/31/89	RL
	O) Attach Scope to Rifle				10/31/89	RL
	P) Detach & Attach Scope 20 Times				10/31/89	RL
640	Gallery Target & Test				11-1-89	DH
	A) Time				11-1-89	DH
	B) Malfunctions				11-1-89	DH
	C) Pierced Primers				11-1-89	DH
	D) Optical Clarity of Scope				11-1-89	DH
645	Inspect for Live Ammo				11-1-89	DH
655	Final Inspection				6 Nov 89	RL
	A) Headspace				6 Nov 89	RL
	B) Trigger Pull	281	261	223	6 Nov 89	RL
	C) Function				6 Nov 89	RL
660	Pack				15 Dec 89	RL

RC

BARBER - M24 0062265

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348719

DATE 13 MAR 90

TESTER QSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	249	250		222	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	250	246		238	
PULL #3	247	240		242	
PULL #4	240	242		256	
PULL #5	242	238		243	
TOTAL	1246	1216			
AVG.	249.2	243.2			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	334	331		
PULL #2	324	329		
PULL #3	332	337		
PULL #4	332	328		
PULL #5	327	338		
TOTAL	1649	1663		
AVG.	329.8	332.6		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	405	407		
PULL #2	403	410		
PULL #3	402	401		
PULL #4	403	406		
PULL #5	405	406		
TOTAL	2018	2030		
AVG.	403.6	406		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348719
1 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.181805
1 TO	2	.261232
1 TO	3	.235372
1 TO	4	.593418
1 TO	5	.735275

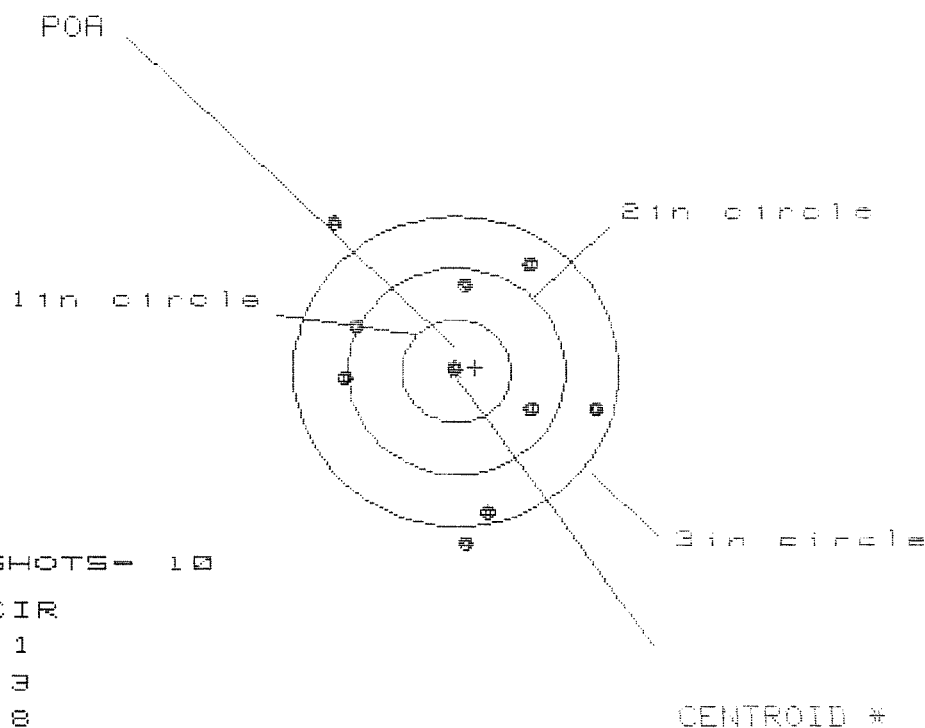
5.2 ft (----) POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.5248
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .031
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .525715
THE AMR FOR THIS RIFLE IS: .9604

1 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06340719

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.340

VS= 3.053

GS= 3.269

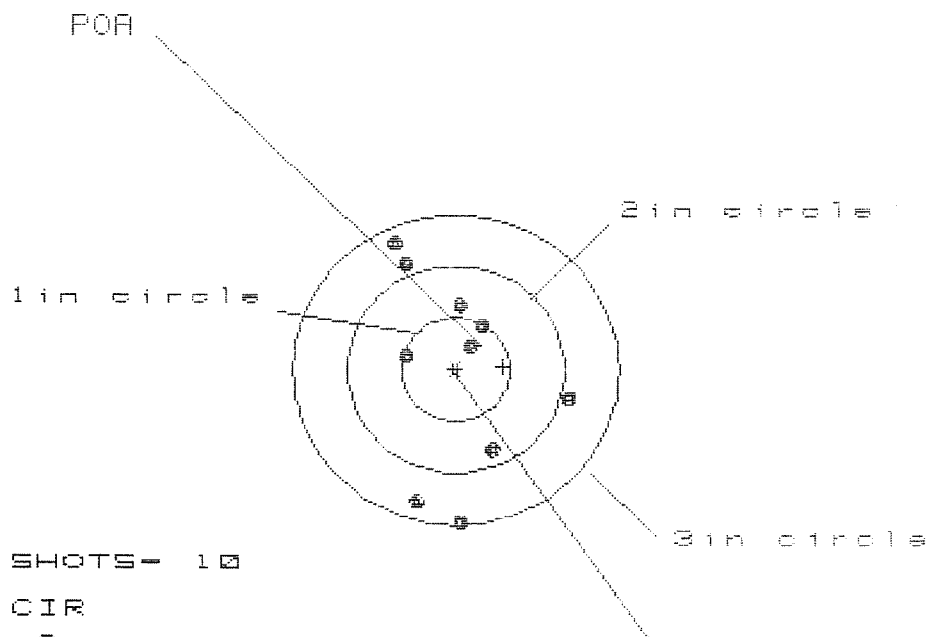
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.126	1.121
MINIMUM X	-1.092	-1.127	-1.132
MAXIMUM Y	1.437	1.170	.988
MINIMUM Y	-1.616	-1.456	-1.421
CENTROID X	-.178	-.056	-.051
CENTROID Y	-.037	-.197	-.015
POA TO CENTROID in.	.181	.204	.053
MIN RADIUS	.069	.268	.180
MEAN RADIUS	1.105	1.035	.956
MAX RADIUS	1.805	1.457	1.431
HORIZONTAL SPREAD	2.340	2.253	2.253
VERTICAL SPREAD	3.053	2.626	2.408
EXTREME SPREAD	3.269	2.690	2.435
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIE

117 - 2

215 - 5

$$317 = 15$$

HS- 1 - 597

V3= 2.665

GS= 2.712

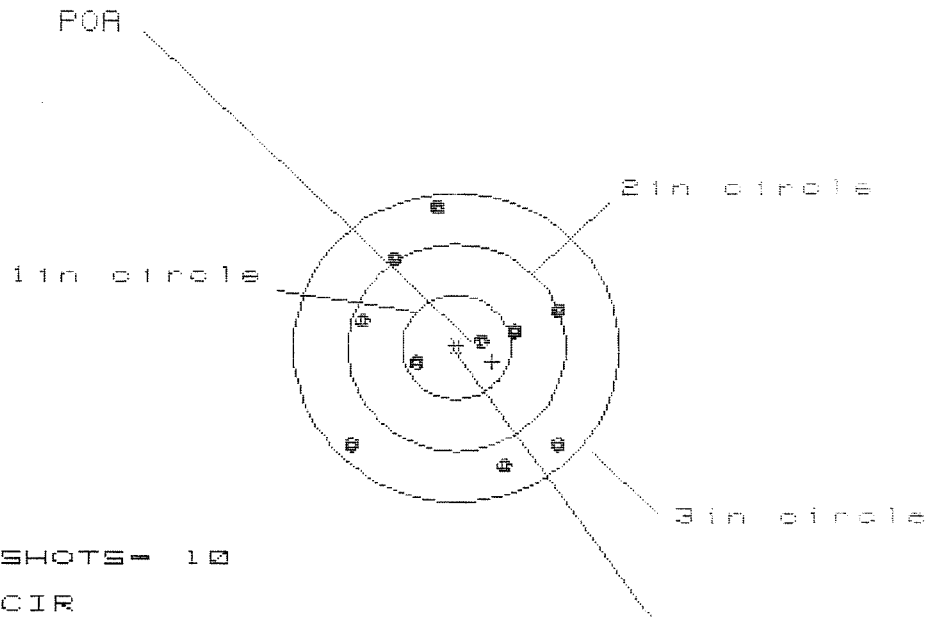
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.084	1.083	1.019
MINIMUM X	:	-.513	-.514	-.558
MAXIMUM Y	:	1.238	1.079	.974
MINIMUM Y	:	-1.427	-1.400	-1.265
CENTROID X	:	-.439	-.438	-.374
CENTROID Y	:	-.026	.133	-.002
POA TO CENTROID in.	:	.440	.458	.374
MIN RADIUS	:	.243	.124	.198
MEAN RADIUS	:	.896	.796	.756
MAX RADIUS	:	1.427	1.439	1.326
HORIZONTAL SPREAD	:	1.597	1.597	1.577
VERTICAL SPREAD	:	2.665	2.479	2.239
EXTREME SPREAD	:	2.712	2.486	2.245
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Nov 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 1.892

VS= 2.449

GS= 2.521

CENTROID *

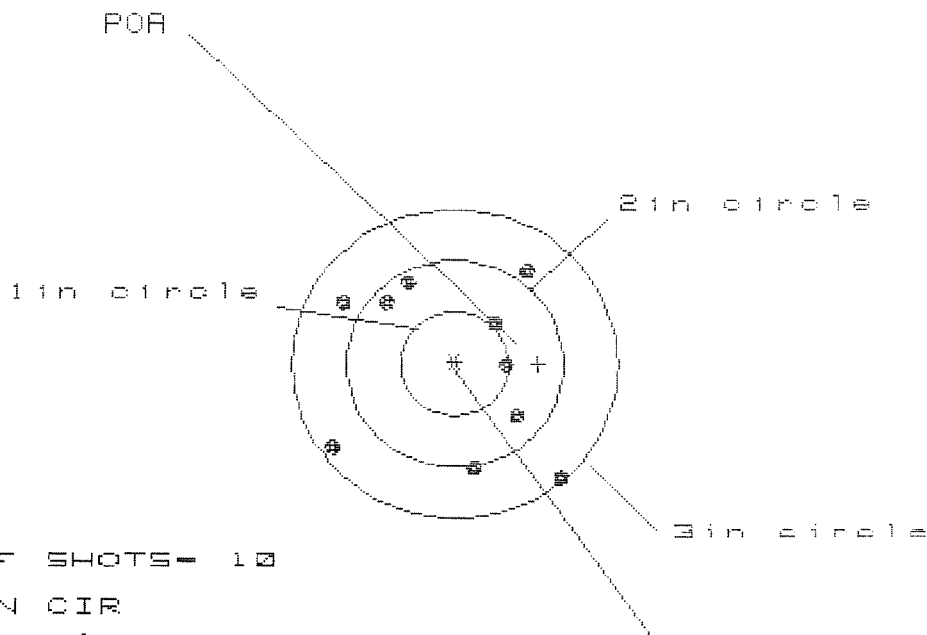
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.924	.907	.784
MINIMUM X	:	-.968	-.985	-.988
MAXIMUM Y	:	1.356	1.037	.936
MINIMUM Y	:	-1.093	-.942	-1.043
CENTROID X	:	-.332	-.315	-.192
CENTROID Y	:	.141	-.010	.091
POA TO CENTROID in.	:	.361	.315	.212
MIN RADIUS	:	.213	.303	.157
MEAN RADIUS	:	.926	.880	.804
MAX RADIUS	:	1.366	1.273	1.195
HORIZONTAL SPREAD	:	1.892	1.892	1.772
VERTICAL SPREAD	:	2.449	1.979	1.979
EXTREME SPREAD	:	2.521	2.356	2.356
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			10	

1 May 1989

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 10

HS- 2.050

VS- 1.995

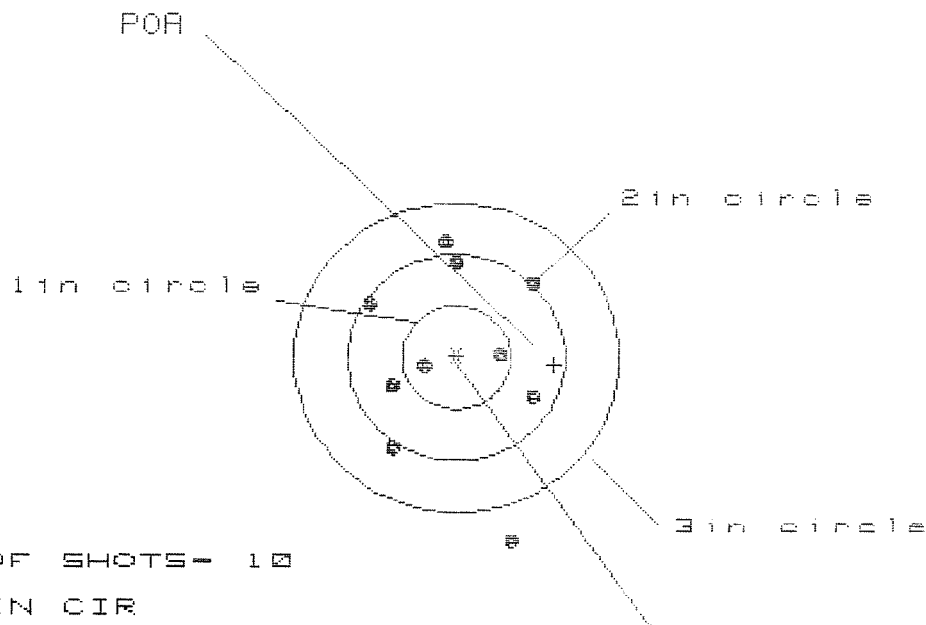
GS- 2.614

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.813	.690
MINIMUM X	:	-1.090	-.984	-1.056
MAXIMUM Y	:	.930	.812	.696
MINIMUM Y	:	-1.065	-1.094	-1.210
CENTROID X	:	-.770	-.876	-.753
CENTROID Y	:	.004	.122	.238
POA TO CENTROID in.	:	.770	.885	.790
MIN RADIUS	:	.469	.534	.368
MEAN RADIUS	:	.977	.917	.832
MAX RADIUS	:	1.434	1.351	1.222
HORIZONTAL SPREAD	:	2.050	1.797	1.746
VERTICAL SPREAD	:	1.995	1.906	1.906
EXTREME SPREAD	:	2.614	2.499	2.012
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Nov 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.514

VS= 2.848

GS= 2.905

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.745	.797	.790
MINIMUM X	:	-.769	-.717	-.724
MAXIMUM Y	:	1.122	.930	.820
MINIMUM Y	:	-1.726	-1.079	-.962
CENTROID X	:	-.905	-.957	-.950
CENTROID Y	:	.073	.265	.148
POA TO CENTROID in.	:	.908	.993	.962
MIN RADIUS	:	.272	.364	.277
MEAN RADIUS	:	.898	.787	.757
MAX RADIUS	:	1.788	1.218	1.120
HORIZONTAL SPREAD	:	1.514	1.514	1.514
VERTICAL SPREAD	:	2.848	2.009	1.782
EXTREME SPREAD	:	2.905	2.102	2.102
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington.



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

MODEL 700™ H24

SERIAL NO.
C6348719

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 C6348719

UPC



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