

C6348768

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

GUN SERIAL # *C6348768*

0626

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	AC
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		10/13/89	G.S.
7	Drill and Tap Sight Holes	10	1689	LB
618	Polish Barrel <i>RB</i>	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		11/1/89	WLB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/1/89	RL
	G) Safety Off Force	3	3	3			11/1/89	RL
	H) Trigger Pull Test & Retainability						11/1/89	WB
	I) Firing Pin Indent	1022	1021	10215			11/1/89	RL
	J) Assemble Stock						11/2/89	RL
	K) Assemble Swivel Studs						11/2/89	RL
	L) Attach Front and Rear Sight Assemblies						11/2/89	RL
	M) Iron Sight Alignment						11/2/89	RL
	N) Detach Front & Rear Sights & place in numbered container						11/2/89	RL
	O) Attach Scope to Rifle						11/2/89	RL
	P) Detach & Attach Scope 20 Times						11/2/89	RL
640	Gallery Target & Test						11-3-89	DH
	A) Time						11-3-89	DH
	B) Malfunctions						11-3-89	DH
	C) Pierced Primers						11-3-89	DH
	D) Optical Clarity of Scope						11-3-89	DH
645	Inspect for Live Ammo						11-3-89	DH
655	Final Inspection						11/2/89	RL
	A) Headspace						11/2/89	RL
	B) Trigger Pull	237	254	244	245	240	11/2/89	RL
	C) Function						11/2/89	RL
660	Pack						11/2/89	RL

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

SERIAL NO. C6348768DATE 4-6-80TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	^{2.2} 2.47	2.37		2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.31		2.31	
PULL #3	2.49	2.31		2.30	
PULL #4	2.53	2.36		2.34	
PULL #5	2.54	2.33		2.40	
TOTAL	12.43	11.68		11.71	
AVG.	2.486	2.336		2.342	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	^{3.2} 3.51	3.50		
PULL #2	3.47	3.51		
PULL #3	3.55	3.49		
PULL #4	3.45	3.56		
PULL #5	3.55	3.53		
TOTAL	17.53	17.59		
AVG.	3.506	3.518		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.27		
PULL #2	4.20	4.24		
PULL #3	4.24	4.24		
PULL #4	4.28	4.17		
PULL #5	4.24	4.32		
TOTAL	21.28	21.24		
AVG.	4.256	4.248		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348768
3 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.151924
1 TO	2	.283544
1 TO	3	.132925
1 TO	4	.221461
1 TO	5	.282406

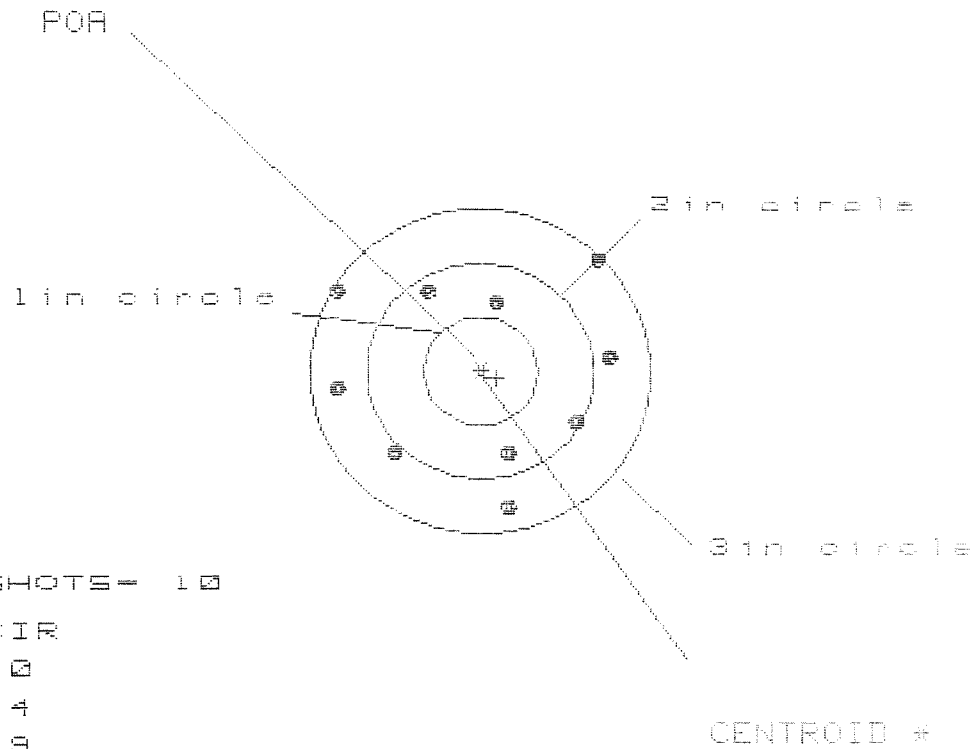
52
(----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.105
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0936
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .143672
THE AMR FOR THIS RIFLE IS: .996

3 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B780

CENTERFIRE PATTERNS # 1

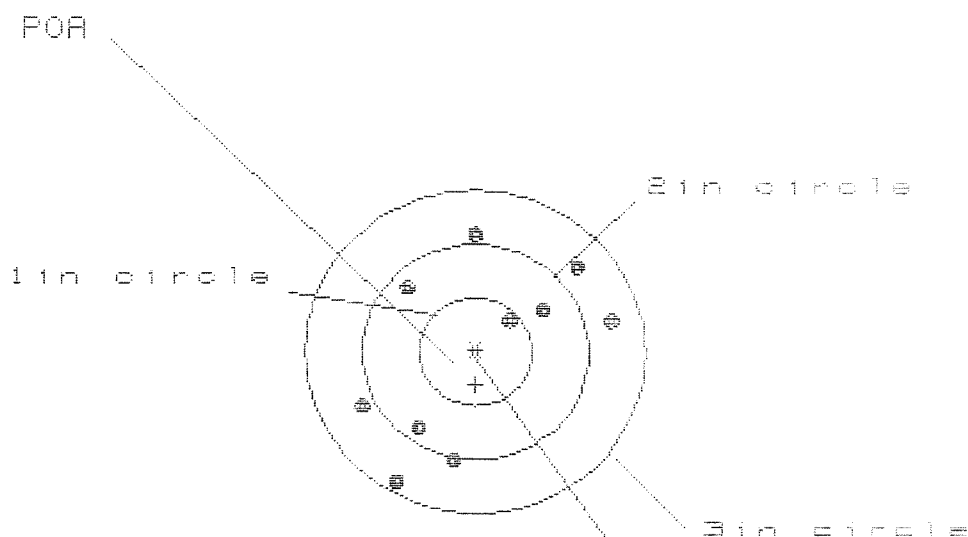


PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.134	.990	1.106
MINIMUM X	:	-1.299	-1.362	-1.246
MAXIMUM Y	:	1.034	1.121	.992
MINIMUM Y	:	-1.247	-1.160	-1.020
CENTROID X	:	-.140	.004	-.112
CENTROID Y	:	.059	-.028	-.168
POA TO CENTROID in.	:	.152	.028	.202
MIN RADIUS	:	.623	.639	.548
MEAN RADIUS	:	1.089	1.025	.959
MAX RADIUS	:	1.517	1.458	1.248
HORIZONTAL SPREAD	:	2.433	2.352	2.352
VERTICAL SPREAD	:	2.281	2.281	2.012
EXTREME SPREAD	:	2.581	2.581	2.365
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Nov 1988

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.111

VS= 2.267

GS= 2.570

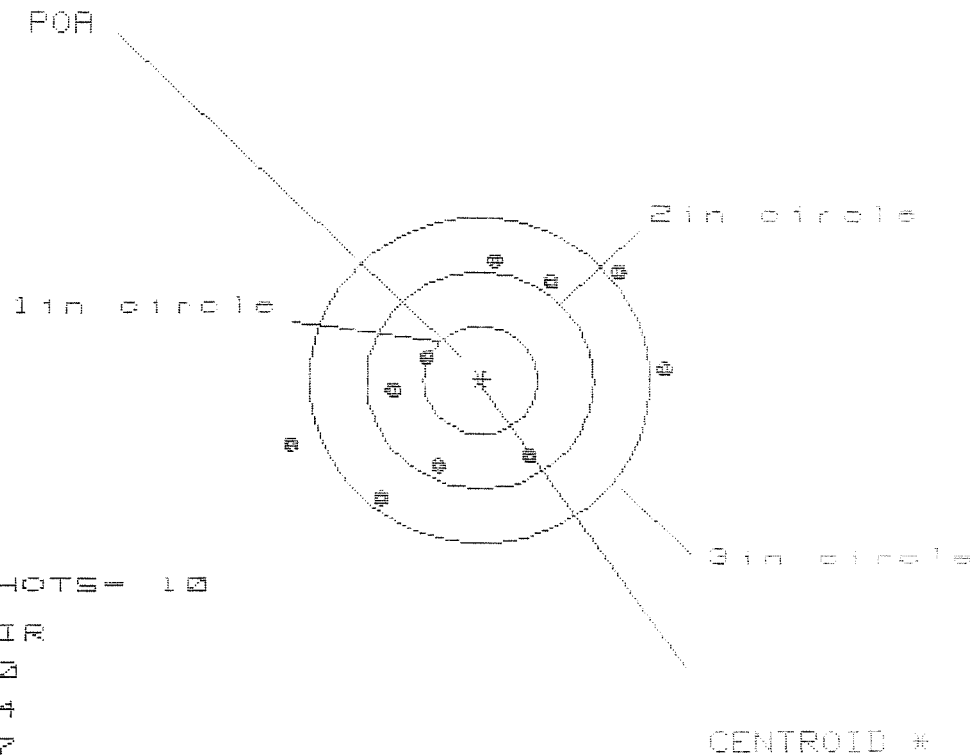
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.157	1.076	1.176
MINIMUM X	:	-.954	-1.035	-.935
MAXIMUM Y	:	1.085	.953	1.039
MINIMUM Y	:	-1.182	-1.117	-1.031
CENTROID X	:	.001	.082	-.018
CENTROID Y	:	.305	.437	.351
POA TO CENTROID in.	:	.305	.444	.352
MIN RADIUS	:	.440	.299	.429
MEAN RADIUS	:	.992	.921	.913
MAX RADIUS	:	1.392	1.228	1.197
HORIZONTAL SPREAD	:	2.111	2.111	2.111
VERTICAL SPREAD	:	2.267	2.070	2.070
EXTREME SPREAD	:	2.570	2.275	2.257
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Nov 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 3.3000

VS= 2.227

GS= 3.367

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.600	1.411	1.544
MINIMUM X	:	-1.700	-1.030	-1.897
MAXIMUM Y	:	1.113	1.046	1.165
MINIMUM Y	:	-1.114	-1.181	-1.062
CENTROID X	:	-.027	.162	.029
CENTROID Y	:	-.011	.056	-.063
POA TO CENTROID in.	:	.029	.171	.069
MIN RADIUS	:	.518	.684	.589
MEAN RADIUS	:	1.164	1.099	1.031
MAX RADIUS	:	1.804	1.567	1.548
HORIZONTAL SPREAD	:	3.300	2.441	2.441
VERTICAL SPREAD	:	2.227	2.227	2.227
EXTREME SPREAD	:	3.367	2.986	2.710
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/06348768

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.109

VS= 2.029

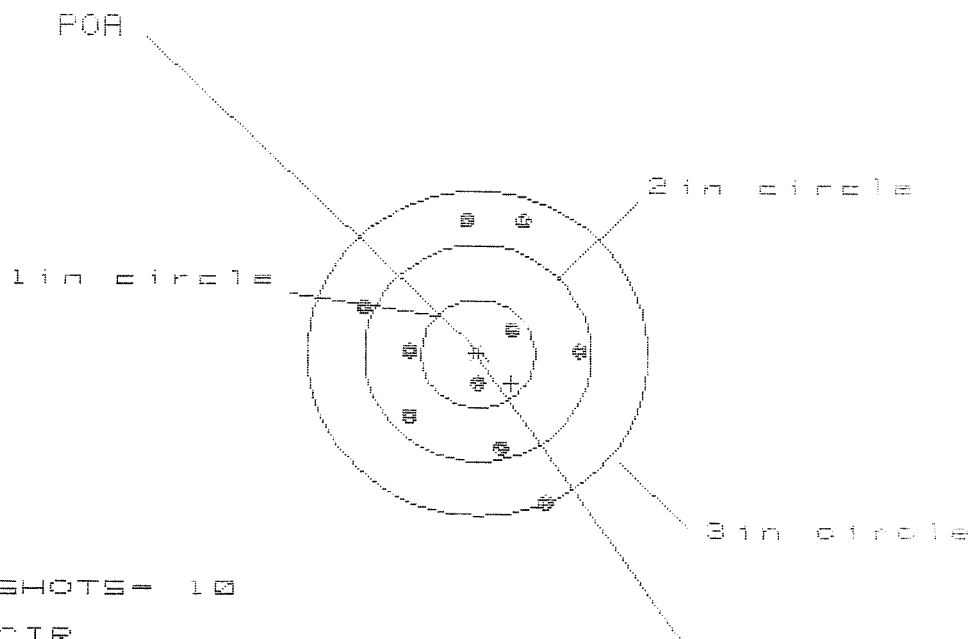
GS= 2.756

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.953	.771	.678
MINIMUM X	:	-1.156	-1.050	-1.151
MAXIMUM Y	:	.968	.850	.786
MINIMUM Y	:	-1.062	-.682	-.576
CENTROID X	:	-.083	-.189	-.088
CENTROID Y	:	-.155	-.038	-.144
POA TO CENTROID in.	:	.176	.193	.169
MIN RADIUS	:	.348	.424	.355
MEAN RADIUS	:	.842	.783	.709
MAX RADIUS	:	1.427	1.171	1.170
HORIZONTAL SPREAD	:	2.109	1.821	1.821
VERTICAL SPREAD	:	2.029	1.532	1.362
EXTREME SPREAD	:	2.756	2.012	1.822
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/06348768

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.885

VS= 2.602

GS= 2.715

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.911	.981	1.035
MINIMUM X	:	-.974	-.984	-.850
MAXIMUM Y	:	1.202	1.046	1.176
MINIMUM Y	:	-1.400	-1.022	-.892
CENTROID X	:	-.296	-.366	-.420
CENTROID Y	:	.270	.426	.296
POA TO CENTROID in.	:	.401	.561	.514
MIN RADIUS	:	.285	.335	.348
MEAN RADIUS	:	.893	.823	.766
MAX RADIUS	:	1.535	1.125	1.176
HORIZONTAL SPREAD	:	1.885	1.885	1.885
VERTICAL SPREAD	:	2.602	2.068	2.068
EXTREME SPREAD	:	2.715	2.090	2.090
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™ M24**SERIAL NO.**

C6348768

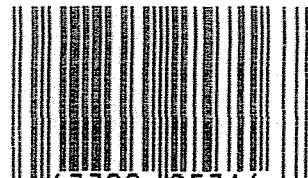
ORDER NO.**5716**

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

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5716 C6348768

UPC

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