

C6349080

MODEL 700<sup>TM</sup> M24

Model **SMS** <sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**<sup>®</sup>

**MODEL 700<sup>TM</sup> H24**

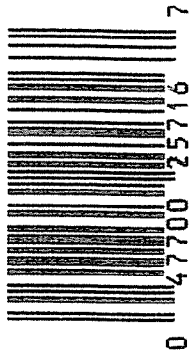
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

**DUPONT**  
REG. U.S. PAT. & T.M. OFF.

|                               |    |
|-------------------------------|----|
| SERIAL NO.<br><b>C6349080</b> | 01 |
| ORDER NO.<br><b>5716</b>      |    |

UPC



GUN SERIAL # C6349080

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| OP. #        | OP. NAME                                                       | READINGS | DATE                          | INIT |
|--------------|----------------------------------------------------------------|----------|-------------------------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 12-20    | 89                            | RW   |
| 600          | Proof                                                          | 12-20    | 89                            | K    |
| 607          | Check Headspace                                                | 12-20    | 89                            | K    |
| 610          | Dis-assemble Gun                                               | 12-20    | 89                            | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | 1-5-90   |                               | KCR  |
|              | Magnaflux Bolt                                                 | 1-5-90   |                               |      |
| 615          | Rollmark Caliber                                               |          | 1/5/90                        | JS   |
| 617          | Drill and Tap Sight Holes                                      |          | 1/8/90                        | FB   |
| 618          | Polish Barrel RB                                               |          | 1/9/90                        | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 1-15-90                       | JA   |
|              | Apply Coating (Bolt)                                           |          |                               |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | <del>1/24/90</del><br>1/24/90 | WB   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 1/24/90                       | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 1/24/90                       | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 1/24/90                       | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 2/2/90                        | JS   |

**BARBER - M24 0107375**

| BARBER - M24 0107375 |                                                             |          |       |       |           |                           |
|----------------------|-------------------------------------------------------------|----------|-------|-------|-----------|---------------------------|
| op. #                | OP. NAME                                                    | READINGS |       |       | DATE      | INIT                      |
| 625<br>cont.         | F) Safety On Force                                          | 6        | 6     | 6     | 1-26-90   | SM                        |
|                      | G) Safety Off Force                                         | 3        | 3     | 3     | 1-26-90   | SM                        |
|                      | H) Trigger Pull Test & Retainability                        |          |       |       | 2/27/90   | JS                        |
|                      | I) Firing Pin Indent                                        | .023     | .0235 | .0235 | 1-26-90   | SM                        |
|                      | J) Assemble Stock                                           |          |       |       | 2/27/90   | RW                        |
|                      | K) Assemble Swivel Studs                                    |          |       |       | 3/15/90   | WB                        |
|                      | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 2/27/90   | RW                        |
|                      | M) Iron Sight Alignment                                     |          |       |       | 2/27/90   | RW                        |
|                      | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 2/27/90   | RW                        |
|                      | O) Attach Scope to Rifle                                    |          |       |       | 2/27/90   | WB                        |
|                      | P) Detach & Attach Scope 20 Times                           |          |       |       | 2/27/90   | WB                        |
| 640                  | Gallery Target & Test                                       |          |       |       | 2-28-90   | JS<br>(TEMPORARY)<br>HELP |
|                      | A) Time                                                     |          |       |       |           | "                         |
|                      | B) Malfunctions                                             |          |       |       |           | "                         |
|                      | C) Pierced Primers                                          |          |       |       |           | "                         |
|                      | D) Optical Clarity of Scope                                 |          |       |       |           | "                         |
| 645                  | Inspect for Live Ammo                                       |          |       |       |           | "                         |
| 655                  | Final Inspection                                            |          |       |       | 15/Mar/90 | JS                        |
|                      | A) Headspace                                                |          |       |       | 15/Mar/90 | JS                        |
|                      | B) Trigger Pull                                             | 258      | 239   | 237   | 241-251   | 15/Mar/90                 |
|                      | C) Function                                                 |          |       |       | 15/Mar/90 | JS                        |
| 660                  | Pack                                                        |          |       |       | 19/Mar/90 | JS                        |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#  
3.00# + .75#  
4.00# + 1.00#

SERIAL NO. C6349080  
DATE 26 Jan 90  
TESTER WJS

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.48             | 2.43                     | 2.39                           | 2.58  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.37                     | 2.35                           | 2.39  |                                                                        |
| PULL #3 | 2.53             | 2.44                     | 2.36                           | 2.37  |                                                                        |
| PULL #4 | 2.49             | 2.37                     | 2.32                           | 2.44  |                                                                        |
| PULL #5 | 2.54             | 2.37                     | 2.34                           | 2.51  |                                                                        |
| TOTAL   | 1252             | 1198                     | 1176                           | 1229  |                                                                        |
| AVG.    | 2.504            | 2.396                    | 2.352                          | 2.458 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 2.93             | 3.04                     |  |          |
| PULL #2 | 2.99             | 3.07                     |  |          |
| PULL #3 | 3.06             | 3.07                     |  |          |
| PULL #4 | 2.95             | 3.03                     |  |          |
| PULL #5 | 3.01             | 3.06                     |  |          |
| TOTAL   | 1494             | 1527                     |  |          |
| AVG.    | 2.988            | 3.054                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.00             | 3.77                     |                                | 3.80                                 |
| PULL #2 | 3.96             | 3.90                     |                                | 4.14                                 |
| PULL #3 | 4.09             | 3.84                     |                                | 3.98                                 |
| PULL #4 | 3.98             | 3.88                     |                                | 4.03                                 |
| PULL #5 | 4.02             | 3.93                     |                                | 3.95                                 |
| TOTAL   | 2005             | 1939                     |                                | 1490                                 |
| AVG.    | 4.01             | 3.874                    |                                | 3.98                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6349080  
28 Feb 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .414146 |
| 1 TO | 2 | .510549 |
| 1 TO | 3 | .634206 |
| 1 TO | 4 | .512533 |
| 1 TO | 5 | .440822 |

1 (----POA

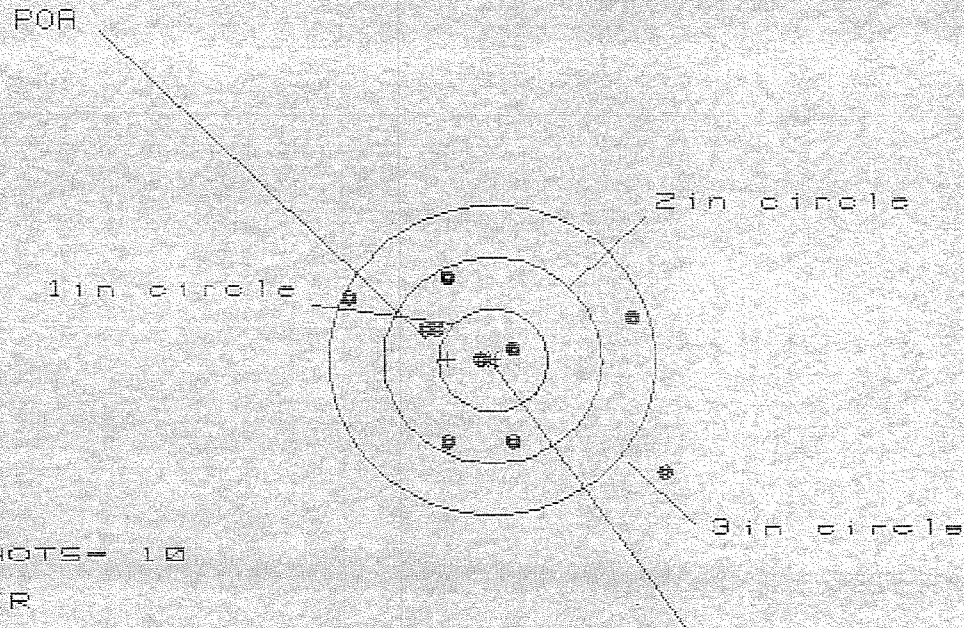
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1084  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2036  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .230659  
THE AMR FOR THIS RIFLE IS: .9526



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FILE:/PATTERNING/CENTERFIRE\_PATT/06349060

## CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 3.880

VS = 1.865

GS = 3.353

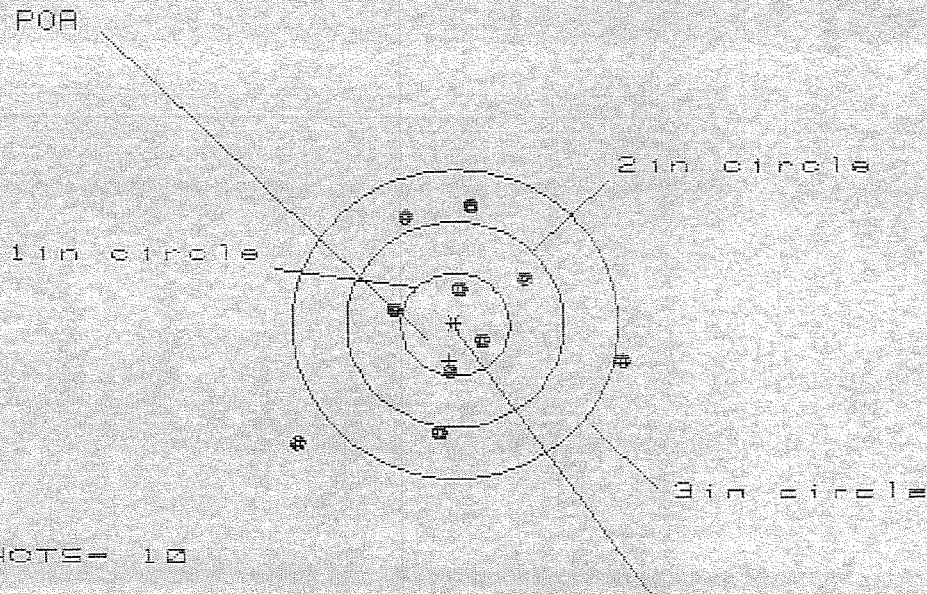
| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.578  | 1.509  | 1.368  |
| MINIMUM X                     | -1.302 | -1.126 | -1.534 |
| MAXIMUM Y                     | .791   | .672   | .738   |
| MINIMUM Y                     | -1.074 | -1.868 | -1.802 |
| CENTROID X                    | .414   | .238   | .379   |
| CENTROID Y                    | -.011  | .108   | .042   |
| POA TO CENTROID in.           | .414   | .262   | .381   |
| MIN RADIUS                    | .155   | .120   | .131   |
| MEAN RADIUS                   | .894   | .747   | .690   |
| MAX RADIUS                    | 1.909  | 1.545  | 1.425  |
| HORIZONTAL SPREAD             | 2.880  | 2.635  | 1.952  |
| VERTICAL SPREAD               | 1.865  | 1.540  | 1.540  |
| EXTREME SPREAD                | 3.353  | 2.642  | 2.103  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |



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FILE:/PATTERNING/CENTERFIRE\_PATT/C63490B0

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.044

VS = 2.306

GS = 3.142

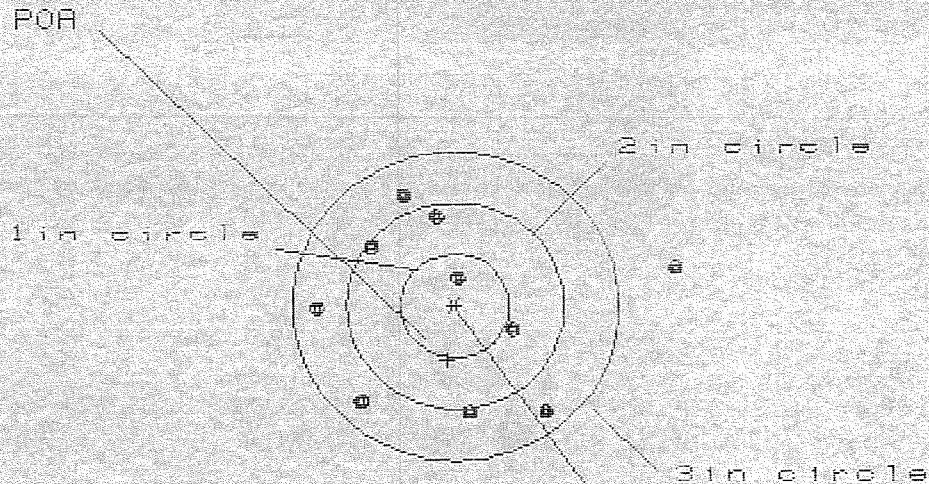
| PATTERN #                   | 1      | 2      | 3      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.577  | 1.414  | .630   |
| MINIMUM X                   | -1.467 | -.712  | -.535  |
| MAXIMUM Y                   | 1.153  | 1.025  | .963   |
| MINIMUM Y                   | -1.153 | -1.154 | -1.216 |
| CENTROID X                  | .056   | .219   | .042   |
| CENTROID Y                  | .353   | .481   | .543   |
| POA TO CENTROID in.         | .357   | .528   | .545   |
| MIN RADIUS                  | .319   | .230   | .169   |
| MEAN RADIUS                 | .928   | .809   | .709   |
| MAX RADIUS                  | 1.866  | 1.500  | 1.224  |
| HORIZONTAL SPREAD           | 3.044  | 2.126  | 1.165  |
| VERTICAL SPREAD             | 2.306  | 2.179  | 2.179  |
| EXTREME SPREAD              | 3.142  | 2.487  | 2.194  |
| NUMBER IN ONE INCH CIRCLE   | = 3    |        |        |
| NUMBER IN TWO INCH CIRCLE   | = 5    |        |        |
| NUMBER IN THREE INCH CIRCLE | = 8    |        |        |



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## CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 3.259

VS= 2.056

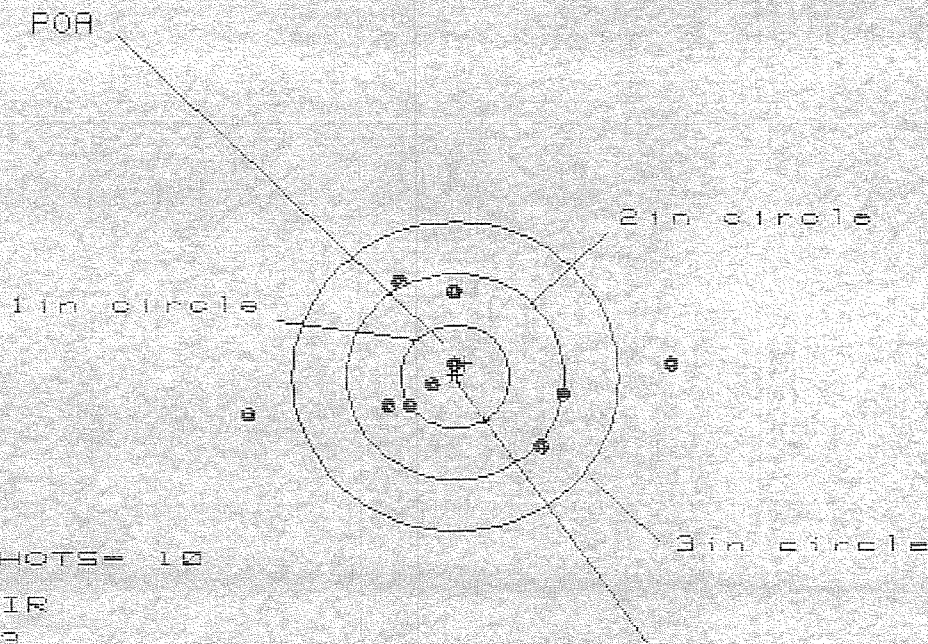
GS= 3.287

| PATTERN #                     | 3      |        |        |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 9      |
| MAXIMUM X                     | 2.001  | 1.022  | .914   |
| MINIMUM X                     | -1.258 | -1.035 | -.908  |
| MAXIMUM Y                     | 1.047  | 1.090  | .972   |
| MINIMUM Y                     | -1.009 | -.966  | -1.084 |
| CENTROID X                    | .075   | -.148  | -.275  |
| CENTROID Y                    | .525   | .482   | .600   |
| POA TO CENTROID IN.           | .531   | .504   | .661   |
| MIN RADIUS                    | .308   | .421   | .429   |
| MEAN RADIUS                   | 1.075  | .958   | .882   |
| MAX RADIUS                    | 2.039  | 1.394  | 1.195  |
| HORIZONTAL SPREAD             | 3.259  | 2.057  | 1.822  |
| VERTICAL SPREAD               | 2.056  | 2.056  | 2.056  |
| EXTREME SPREAD                | 3.287  | 2.410  | 2.153  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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## CENTERFIRE PATTERNS # 4



HS= 3.927

VS= 1.575

GS= 3.954

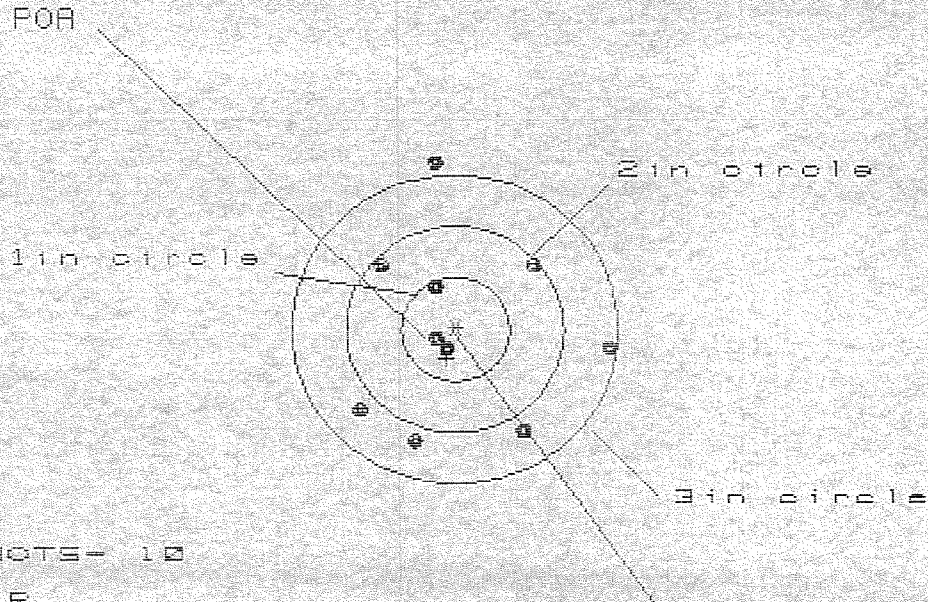
| PATTERN #                     | 4      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST QF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.989  | 1.156  | .942  |
| MINIMUM X                     | -1.938 | -1.717 | -.630 |
| MAXIMUM Y                     | .878   | .888   | .842  |
| MINIMUM Y                     | -.697  | -.687  | -.733 |
| CENTROID X                    | -.085  | -.306  | -.091 |
| CENTROID Y                    | -.128  | -.138  | -.092 |
| POA TO CENTROID in.           | .154   | .336   | .130  |
| MIN RADIUS                    | .099   | .064   | .067  |
| MEAN RADIUS                   | .931   | .788   | .665  |
| MAX RADIUS                    | 1.991  | 1.755  | 1.079 |
| HORIZONTAL SPREAD             | 3.927  | 2.873  | 1.572 |
| VERTICAL SPREAD               | 1.575  | 1.575  | 1.575 |
| EXTREME SPREAD                | 3.954  | 2.883  | 2.038 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |       |



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## CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.289

VS= 2.744

GS= 2.747

PATTERN #

5

| SHOTS (BEST OF)               | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| MAXIMUM X                     | 1.372  | 1.348 | .919  |
| MINIMUM X                     | -.917  | -.941 | -.773 |
| MAXIMUM Y                     | 1.640  | .842  | .842  |
| MINIMUM Y                     | -1.104 | -.922 | -.922 |
| CENTROID X                    | .082   | .106  | -.062 |
| CENTROID Y                    | .279   | .097  | .097  |
| POA TO CENTROID in.           | .291   | .144  | .115  |
| MIN RADIUS                    | .196   | .070  | .093  |
| MEAN RADIUS                   | .935   | .840  | .747  |
| MAX RADIUS                    | 1.654  | 1.348 | 1.145 |
| HORIZONTAL SPREAD             | 2.289  | 2.289 | 1.592 |
| VERTICAL SPREAD               | 2.744  | 1.764 | 1.764 |
| EXTREME SPREAD                | 2.747  | 2.368 | 2.122 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 5     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |