

C6349093

MODEL 700™ M24

Model SMS™

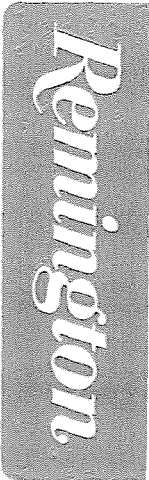
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington[®]

MODEL 700TM H24

MADE IN ILION, 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.
C6349093

ORDER NO.
5716

Ø1

5716 C6349093

UPC

0 47700 25716 7

GUN SERIAL # C6349095

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12-20 89	RW
600	Proof		12-20 89	L
607	Check Headspace		12-20 89	L
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action		1-5-90	KER
	Magnaflux Bolt		1-5-90	
615	Rollmark Caliber		1/5/90	JS
7	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel AB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		22 Jan 90	JS

BARBER - M24 0107630

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-22-90	JS
	G) Safety Off Force	3	3	3			1-22-90	JS
	H) Trigger Pull Test & Retainability						2/2/90	JS
	I) Firing Pin Indent	.0225	.022	.022			1-22-90	JS
	J) Assemble Stock						1/29/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						1/29/90	RW
	M) Iron Sight Alignment						1/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/29/90	RW
	O) Attach Scope to Rifle						1/28/90	WB
	P) Detach & Attach Scope 20 Times						2/28/90	WB
640	Gallery Target & Test						2-28-90	AC
	A) Time						2-28-90	AC
	B) Malfunctions						2-28-90	AC
	C) Pierced Primers						2-28-90	AC
	D) Optical Clarity of Scope						2-28-90	AC
645	Inspect for Live Ammo						2-28-90	AC
655	Final Inspection						1/6/90	JS
	A) Headspace						1/6/90	JS
	B) Trigger Pull	232	242	241	220	247	1/6/90	JS
	C) Function						1/6/90	JS
660	Pack						1/9/90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349093DATE 22 Jan 90TESTER AS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.44	2.56	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.41	2.42	2.42	
PULL #3	2.45	2.43	2.40	2.41	
PULL #4	2.24	2.44	2.31	2.20	
PULL #5	2.49	2.36	2.38	2.47	
TOTAL	12.17	12.08	12.07	11.82	
AVG.	2.434	2.416	2.414	2.364	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.99	2.93		
PULL #2	2.98	3.09		
PULL #3	2.91	3.09		
PULL #4	2.96	2.97		
PULL #5	3.00	3.05		
TOTAL	14.84	14.93		
AVG.	2.968	2.986		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.24		3.83
PULL #2	4.05	3.79		3.78
PULL #3	4.06	4.06		3.76
PULL #4	4.12	4.07		3.76
PULL #5	4.13	4.04		3.76
TOTAL	20.46	20.20		18.89
AVG.	4.092	4.04		3.778

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349093
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.394635
1 TO	2	.423359
1 TO	3	.38629
1 TO	4	.432404
1 TO	5	.499685

4.25 <----POA

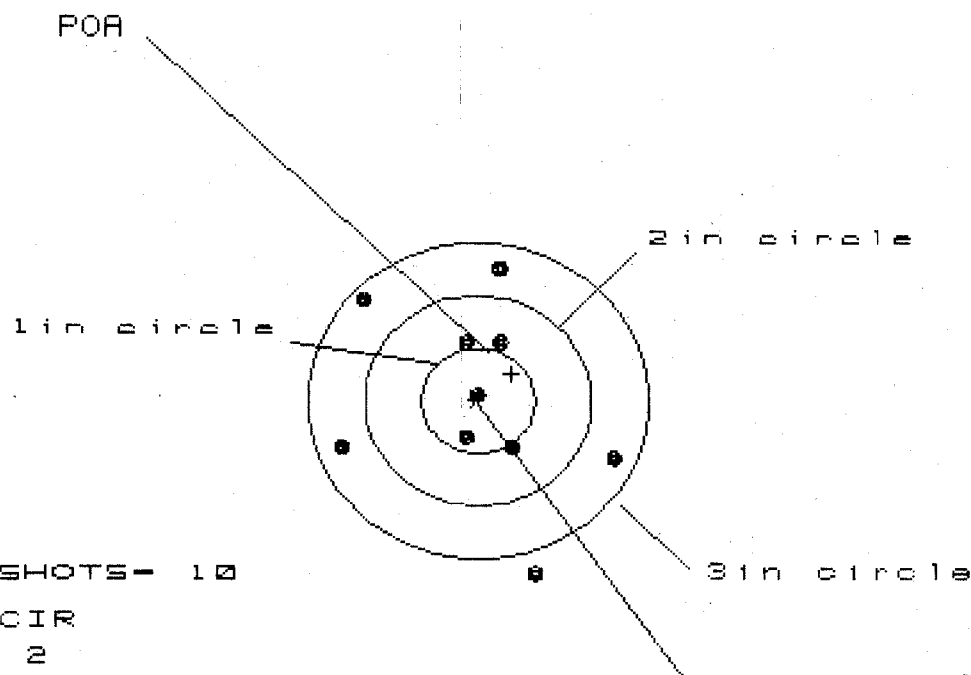
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.196
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0148
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .196558

THE AMR FOR THIS RIFLE IS: .9378

26 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6349093

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 9

HS- 2.433

VS- 2.886

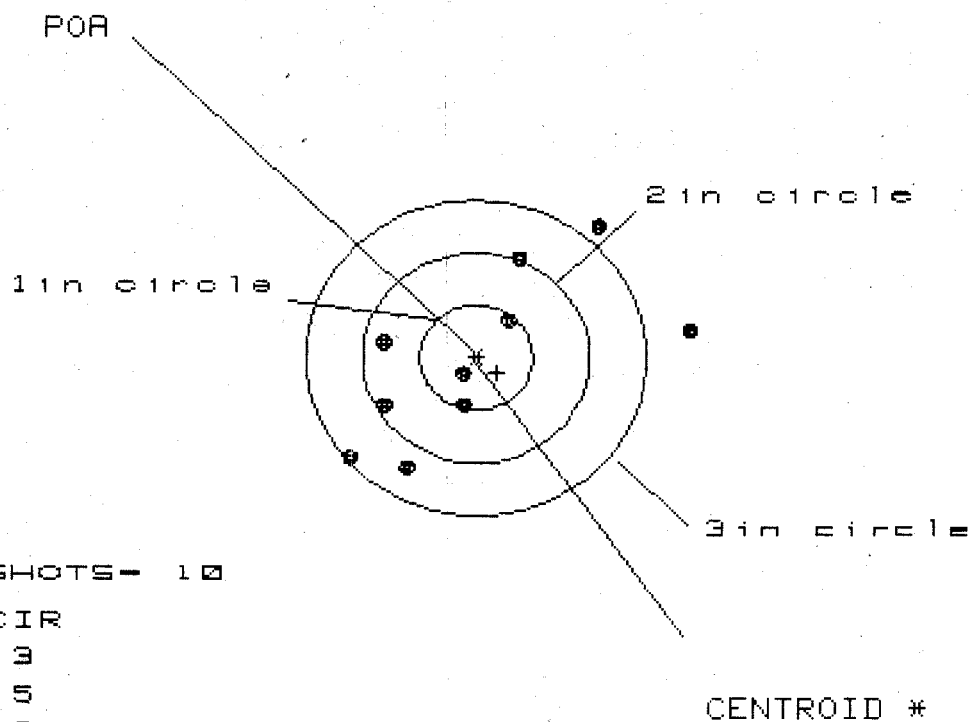
GS- 2.955

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.258	1.144
MINIMUM X	:	-1.234	-1.175	-1.289
MAXIMUM Y	:	1.266	1.086	1.178
MINIMUM Y	:	-1.620	-.721	-.629
CENTROID X	:	-.296	-.356	-.242
CENTROID Y	:	-.261	-.081	-.173
POA TO CENTROID in.	:	.395	.365	.298
MIN RADIUS	:	.070	.132	.112
MEAN RADIUS	:	.915	.817	.761
MAX RADIUS	:	1.706	1.450	1.376
HORIZONTAL SPREAD	:	2.433	2.433	2.433
VERTICAL SPREAD	:	2.886	1.807	1.807
EXTREME SPREAD	:	2.955	2.617	2.437
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.040

VS= 2.307

GS= 3.236

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.914
MINIMUM X	-1.126
MAXIMUM Y	1.288
MINIMUM Y	-1.019
CENTROID X	-0.183
CENTROID Y	.147
POA TO CENTROID in.	.235
MIN RADIUS	.205
MEAN RADIUS	1.011
MAX RADIUS	1.926
HORIZONTAL SPREAD	3.040
VERTICAL SPREAD	2.307
EXTREME SPREAD	3.236
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

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 9

3 in = 9

HS= 2.475

VS= 1.790

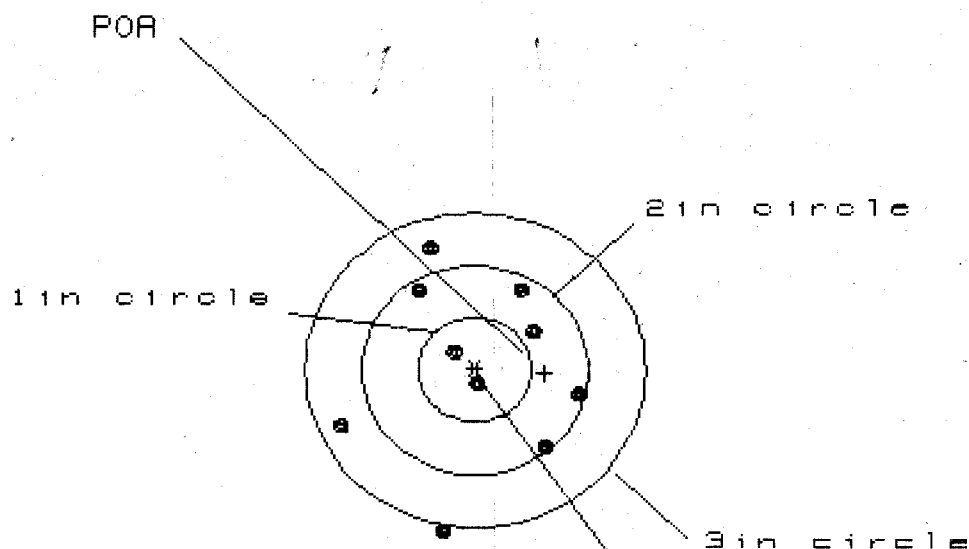
GS= 2.546

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.776	.805
MINIMUM X	:	-1.529	-.858	-.829
MAXIMUM Y	:	.915	.882	.857
MINIMUM Y	:	-.875	-.908	-.798
CENTROID X	:	-.014	.156	.127
CENTROID Y	:	.003	.036	-.074
POA TO CENTROID in.	:	.014	.160	.147
MIN RADIUS	:	.456	.446	.470
MEAN RADIUS	:	.871	.772	.748
MAX RADIUS	:	1.558	1.053	.961
HORIZONTAL SPREAD	:	2.475	1.634	1.634
VERTICAL SPREAD	:	1.790	1.790	1.655
EXTREME SPREAD	:	2.546	1.947	1.759
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS #. 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.140

VS= 2.630

GS= 2.631

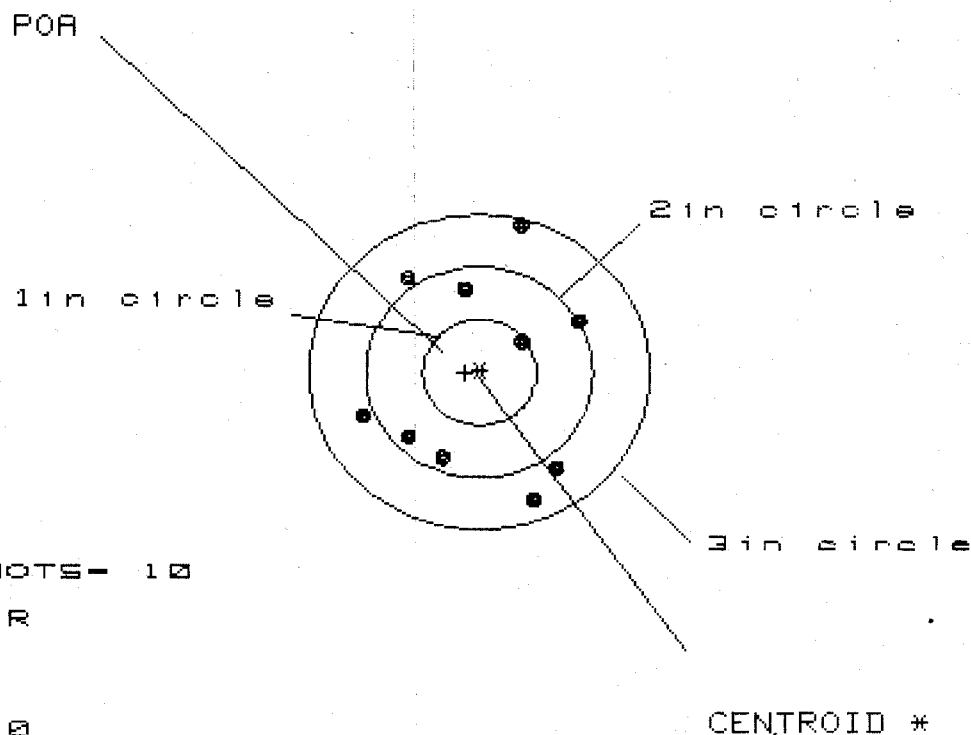
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	.925	.773
MINIMUM X	:	-1.178	-1.215	-.642
MAXIMUM Y	:	1.146	.981	.888
MINIMUM Y	:	-1.484	-.858	-.951
CENTROID X	:	-.614	-.577	-.425
CENTROID Y	:	.032	.197	.290
POA TO CENTROID in.	:	.615	.610	.515
MIN RADIUS	:	.150	.179	.328
MEAN RADIUS	:	.871	.778	.688
MAX RADIUS	:	1.522	1.423	1.072
HORIZONTAL SPREAD	:	2.140	2.140	1.415
VERTICAL SPREAD	:	2.630	1.839	1.839
EXTREME SPREAD	:	2.631	2.160	2.093
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in - 10

HS- 1.906

VS= 2.674

GS= 2.679

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.946	1.014
MINIMUM X	:	-.999	-.960	-.892
MAXIMUM Y	:	1.438	1.066	.931
MINIMUM Y	:	-1.236	-1.076	-.850
CENTROID X	:	.127	.088	.021
CENTROID Y	:	.005	-.155	-.020
POA TO CENTROID in.	:	.127	.178	.029
MIN RADIUS	:	.485	.629	.582
MEAN RADIUS	:	1.021	.962	.921
MAX RADIUS	:	1.479	1.215	1.145
HORIZONTAL SPREAD	:	1.906	1.906	1.906
VERTICAL SPREAD	:	2.674	2.142	1.781
EXTREME SPREAD	:	2.679	2.421	2.196
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		