

C6349177

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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. C6349177	ORDER NO. 5716
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0 47700 25716 7

UPC

5716 C6349177

GUN SERIAL # C6349177

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	E
607	Check Headspace	1 12	90	A
610	Dis-assemble Gun	1 12	90	RW
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber	1-17-90		GS
617	Drill and Tap Sight Holes	1-19-90		KB
618	Polish Barrel	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-28-90	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/1/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/1/90	RW
	C) Inspect Ejector Hole for Chamfer		2/1/90	RW
	D) Oil Firing Pin Ass'y		2/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		17 Feb 90	GS

op. #	UP. NAME BARBER, M24 0109518	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2-1-90	JJ
	G) Safety Off Force	3	3	3			2-1-90	JJ
	H) Trigger Pull Test & Retainability						1/26/90	JJ
	I) Firing Pin Indent	.021	.0215	.0215			2-1-90	JJ
	J) Assemble Stock						3/2/90	RW
	K) Assemble Swivel Studs						3/12/90	WB
	L) Attach Front and Rear Sight Assemblies						3/2/90	RW
	M) Iron Sight Alignment						3/2/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/2/90	RW
	O) Attach Scope to Rifle						3/5/90	WB
	P) Detach & Attach Scope 20 Times						3/5/90	WB
640	Gallery Target & Test						3-6-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						3-6-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace						3/13/90	WB
	B) Trigger Pull	2.28	2.45	2.43	2.39	2.31	3/13/90	WB
	C) Function						3/13/90	WB
660	Pack						20 Mar 90	JJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349177DATE 1/26/90TESTER 428

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.73	2.56	2.31	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.42	2.24	2.45	
PULL #3	2.44	2.38	2.34	2.43	
PULL #4	2.51	2.47	2.23	2.39	
PULL #5	2.56	2.52	2.30	2.31	
TOTAL	12.72	12.35	11.47		
AVG.	2.544	2.47	2.294		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.35		
PULL #2	3.42	3.23		
PULL #3	3.34	3.18		
PULL #4	3.26	3.00		
PULL #5	3.29	3.06		
TOTAL	16.87	15.88		
AVG.	3.374	3.176		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.12		3.97
PULL #2	4.06	4.00		3.96
PULL #3	4.22	4.08		3.90
PULL #4	4.14	4.22		3.96
PULL #5	4.14	4.08		3.97
TOTAL	20.75	20.50		19.76
AVG.	4.15	4.10		3.952

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349177
6 Mar 1990

CENTROIDAL DISTANCES

0	TO	1	.334073
1	TO	2	.179025
1	TO	3	.356202
1	TO	4	.724365
1	TO	5	.256182

4
2
#F <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1896
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189715
THE AMR FOR THIS RIFLE IS: .952

6 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349177

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 1.867

VS = 2.824

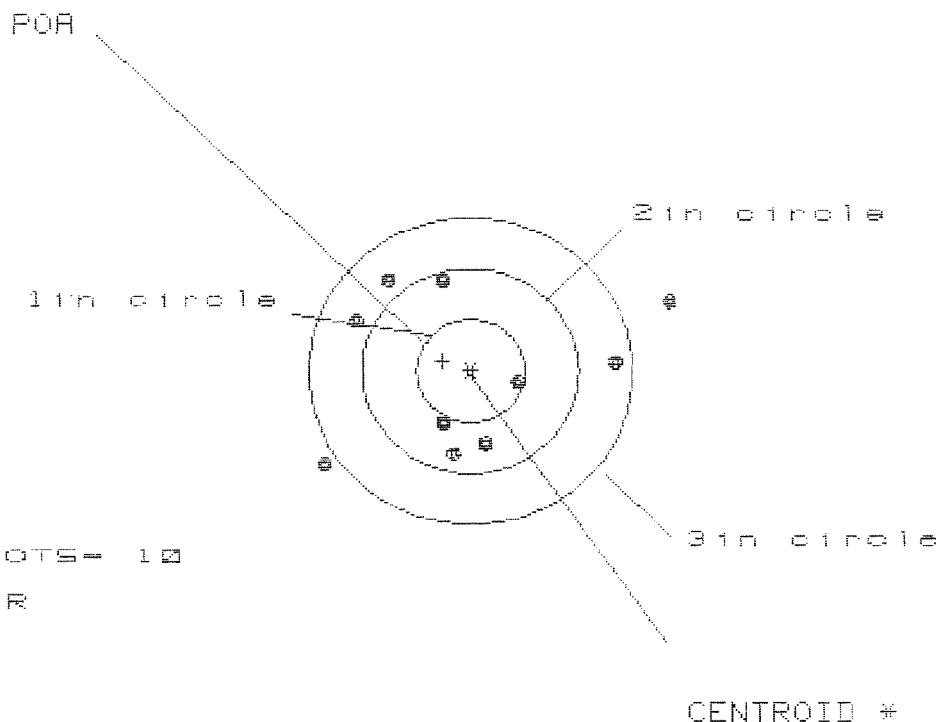
GS = 2.827

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.790	.884
MINIMUM X	-1.078	-.990	-.896
MAXIMUM Y	1.410	1.253	.476
MINIMUM Y	-1.414	-1.384	-1.227
CENTROID X	.206	.118	.024
CENTROID Y	-.263	-.106	-.263
POA TO CENTROID in.	.334	.159	.264
MIN RADIUS	.170	.201	.168
MEAN RADIUS	.896	.786	.706
MAX RADIUS	1.619	1.593	1.512
HORIZONTAL SPREAD	1.867	1.780	1.780
VERTICAL SPREAD	2.824	2.637	1.703
EXTREME SPREAD	2.827	2.637	2.300
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

8 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349177

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.204

VS= 1.795

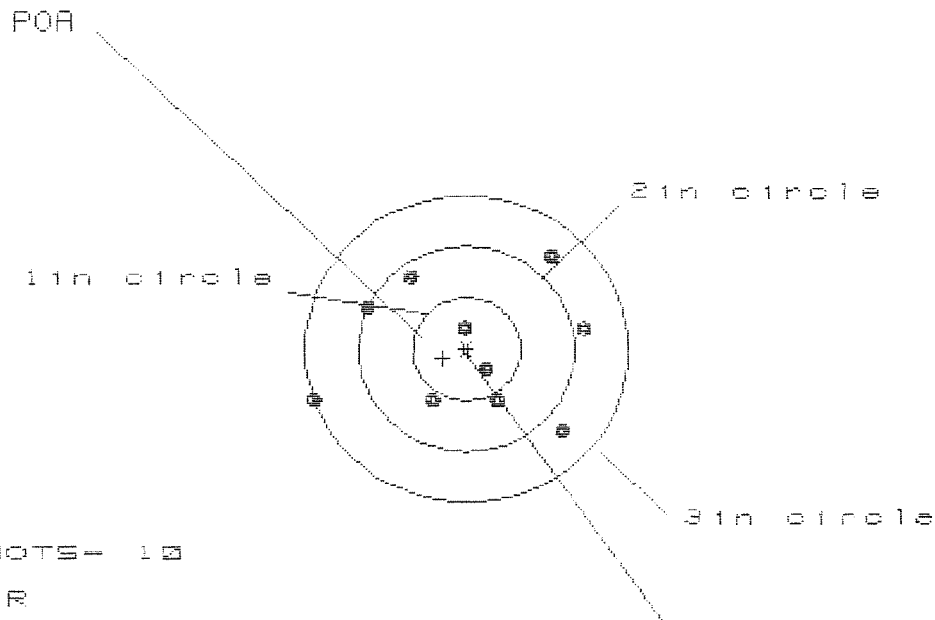
GS= 3.561

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.888	1.525	1.386
MINIMUM X	:	-1.316	-1.106	-.942
MAXIMUM Y	:	.914	.989	.888
MINIMUM Y	:	-.881	-.806	-.843
CENTROID X	:	.259	.049	.188
CENTROID Y	:	-.092	-.167	-.066
POA TO CENTROID in.	:	.275	.174	.199
MIN RADIUS	:	.483	.456	.558
MEAN RADIUS	:	1.071	.945	.891
MAX RADIUS	:	2.004	1.532	1.387
HORIZONTAL SPREAD	:	3.204	2.631	2.328
VERTICAL SPREAD	:	1.795	1.795	1.731
EXTREME SPREAD	:	3.561	2.800	2.356
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.478

VS= 1.685

GS= 2.576

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.051	.892	.989
MINIMUM X	-1.428	-1.097	-1.000
MAXIMUM Y	.872	.822	.714
MINIMUM Y	-.813	-.863	-.689
CENTROID X	.218	.377	.288
CENTROID Y	.093	.143	.251
POA TO CENTROID in.	.237	.403	.376
MIN RADIUS	.197	.236	.121
MEAN RADIUS	.848	.772	.717
MAX RADIUS	1.498	1.162	1.038
HORIZONTAL SPREAD	2.479	1.989	1.989
VERTICAL SPREAD	1.685	1.685	1.403
EXTREME SPREAD	2.576	2.245	1.998
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

6 Mar 1998

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.390

VS= 2.679

GS= 2.900

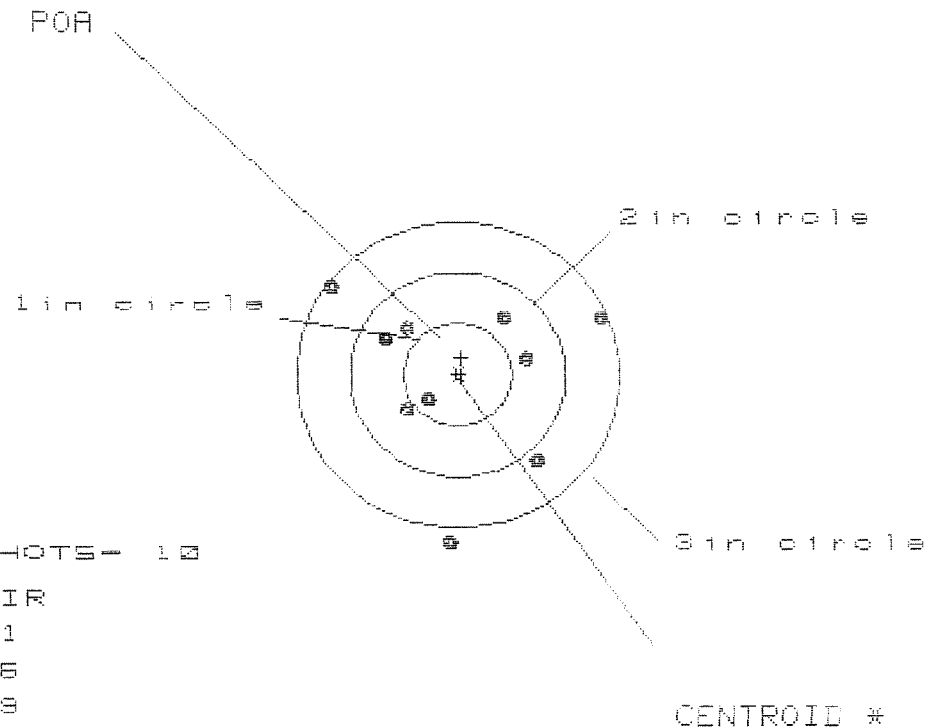
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.181	1.203	1.054
MINIMUM X	-1.209	-1.187	-0.984
MAXIMUM Y	1.615	1.560	1.467
MINIMUM Y	-1.064	-0.885	-0.978
CENTROID X	.294	.272	.421
CENTROID Y	.456	.277	.370
POA TO CENTROID in.	.543	.388	.560
MIN RADIUS	.202	.057	.148
MEAN RADIUS	1.006	.905	.860
MAX RADIUS	1.626	1.569	1.467
HORIZONTAL SPREAD	2.390	2.390	2.038
VERTICAL SPREAD	2.679	2.445	2.445
EXTREME SPREAD	2.900	2.693	2.491
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

6 Mar 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.465

VS= 2.579

GS= 2.804

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	1.278	1.129
MINIMUM X	-1.178	-1.187	-.840
MAXIMUM Y	.896	.709	.494
MINIMUM Y	-1.683	-1.051	-.962
CENTROID X	-.029	-.021	.127
CENTROID Y	-.161	.026	-.063
POA TO CENTROID in.	.164	.033	.142
MIN RADIUS	.321	.472	.504
MEAN RADIUS	.939	.846	.778
MAX RADIUS	1.685	1.383	1.233
HORIZONTAL SPREAD	2.465	2.465	1.970
VERTICAL SPREAD	2.579	1.760	1.456
EXTREME SPREAD	2.804	2.566	1.983
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		