

C6349211

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead

Remington[®]

Remington

REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM H24

SERIAL NO. C6349211

ORDER NO. 5716

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

01

5716 C6349211

UPC

0 47700 25716 7

GUN SERIAL # C6349211

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	R
607	Check Headspace	1 12	90	R
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		68
617	Drill and Tap Sight Holes	1-19-90		LB
618	Polish Barrel RB	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-20-90	TSA
	Apply Coating (Bolt)		1-20-90	TSA
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		2/1/90	WB

op. #	BARBER M24 0110268	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3	4	4	2-1-90	JL
	G) Safety Off Force	4	4	4	2-1-90	JL
	H) Trigger Pull Test & Retainability				1/26/90	JS
	I) Firing Pin Indent	.021	.022	.021	2-1-90	JL
	J) Assemble Stock				2/26/90	RW
	K) Assemble Swivel Studs				3/15/90	WB
	L) Attach Front and Rear Sight Assemblies				2/26/90	RW
	M) Iron Sight Alignment				2/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container				2/26/90	RW
	O) Attach Scope to Rifle				2/25/90	WB
	P) Detach & Attach Scope 20 Times				2/27/90	WB
640	Gallery Target & Test				2-27-90	AC
	A) Time				2-27-90	AC
	B) Malfunctions				2-27-90	AC
	C) Pierced Primers				2-27-90	AC
	D) Optical Clarity of Scope				2-27-90	AC
645	Inspect for Live Ammo				2-27-90	AC
655	Final Inspection					
	A) Headspace				16 MAR 90	JS
	B) Trigger Pull	230	235	241	230 245	16 MAR 90 JS
	C) Function				16 MAR 90	JS
660	Pack				25 MAR 90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349211DATE 1 Feb 80TESTER RS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.11	2.16	2.30	2.30 2.30	MIN. SETTING,
PULL #2	2.03	2.21	2.36	2.35	NO AVG. OF 5
PULL #3	2.35	2.17	2.38	2.41	READINGS ACCEPT-
PULL #4	2.31	2.17	2.38	2.30	ABLE LESS THAN 2#
PULL #5	2.26	2.26	2.35	2.43	
TOTAL	11.06	10.97	11.77	11.81	
AVG.	2.212	2.194	2.354	2.362	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.78	2.88		
PULL #2	2.83	2.78		
PULL #3	2.86	2.86		
PULL #4	3.01	2.78		
PULL #5	2.89	2.85		
TOTAL	14.37	14.15		
AVG.	2.874	2.83		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	3.92		3.83
PULL #2	3.89	3.65		3.93
PULL #3	3.84	3.96		3.78
PULL #4	3.87	3.96		4.08
PULL #5	3.98	3.96		3.94
TOTAL	19.82	19.45		19.56
AVG.	3.964	3.89		3.912

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349211
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.39802
1 TO	2	.70621
1 TO	3	.48936
1 TO	4	.448803
1 TO	5	.936899

5 2
4 <----POA
1

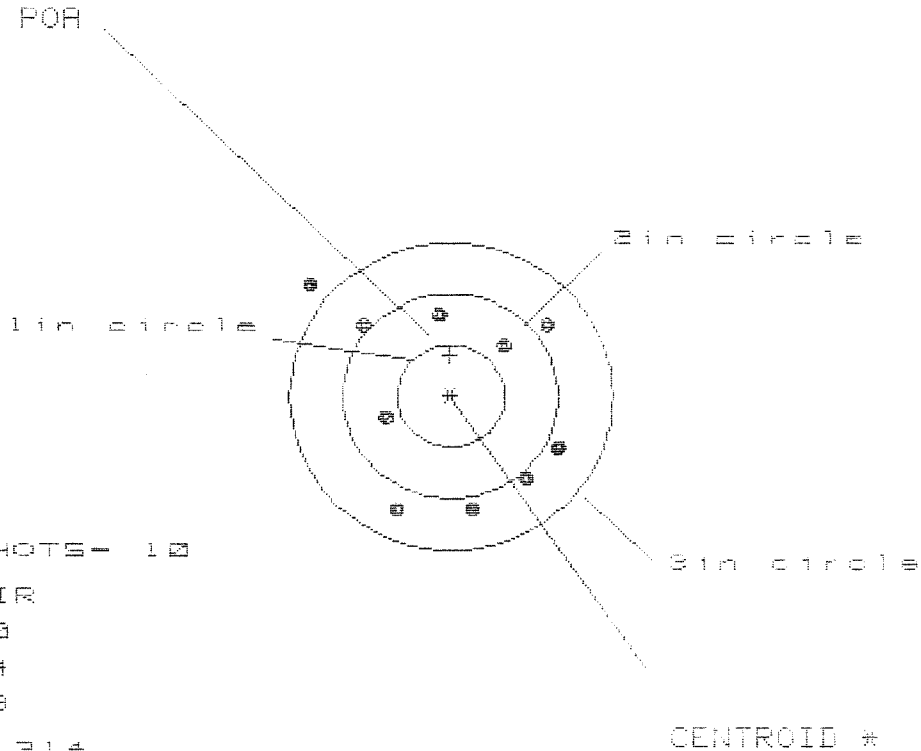
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0398
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0789638

THE AMR FOR THIS RIFLE IS: .9166

27 Feb 1988

FILE:\PATTERNING\CENTERFIRE_PATT\06349211

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 10

2 in = 4

3 in = 0

HS = 0.314

VS = 2.209

GS = 2.786

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.969	.819	.737
MINIMUM X	-1.345	-.908	-.990
MAXIMUM Y	1.079	.871	.754
MINIMUM Y	-1.131	-1.011	-1.128
CENTROID X	.004	.154	.236
CENTROID Y	-.398	-.517	-.480
POA TO CENTROID in.	.398	.540	.464
MIN RADIUS	.607	.720	.620
MEAN RADIUS	1.044	.956	.919
MAX RADIUS	1.724	1.190	1.185
HORIZONTAL SPREAD	2.314	1.727	1.727
VERTICAL SPREAD	2.209	1.882	1.882
EXTREME SPREAD	2.796	2.249	2.069
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

07 Feb 1998

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.888

VS= 2.338

GS= 2.641

CENTROID #

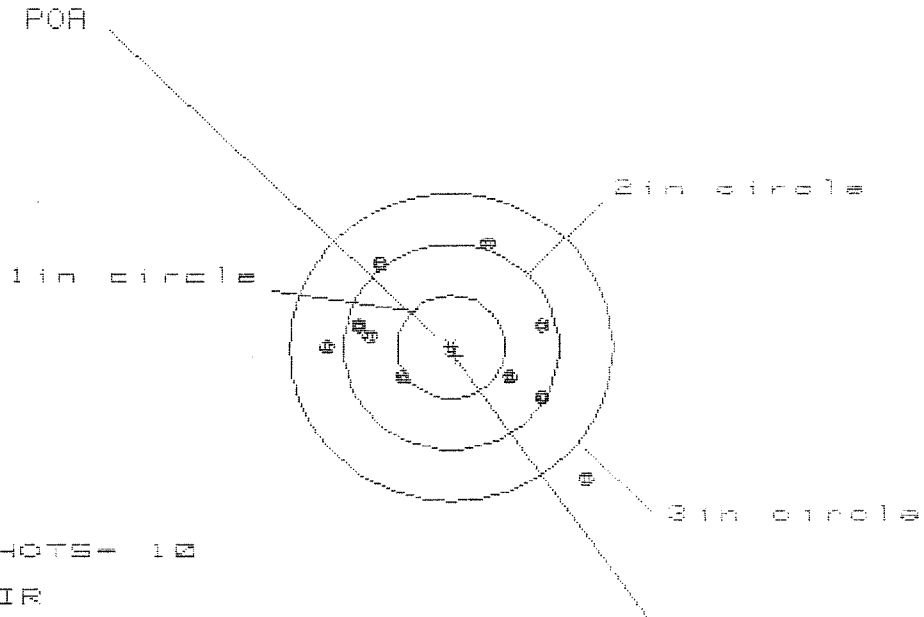
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.823	.776	.737
MINIMUM X	:	-1.043	-.952	-.991
MAXIMUM Y	:	1.251	1.130	.849
MINIMUM Y	:	-1.087	-.547	-.405
CENTROID X	:	.081	-.010	.029
CENTROID Y	:	.304	.425	.283
POA TO CENTROID in.	:	.314	.425	.285
MIN RADIUS	:	.050	.118	.090
MEAN RADIUS	:	.790	.742	.659
MAX RADIUS	:	1.363	1.173	1.124
HORIZONTAL SPREAD	:	1.866	1.728	1.728
VERTICAL SPREAD	:	2.338	1.677	1.254
EXTREME SPREAD	:	2.641	2.019	2.019
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Feb 1998

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CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 6

2 in = 6

3 in = 9

HS = 2.387

VS = 2.350

GS = 2.843

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.212	1.019	.889
MINIMUM X	:	-1.175	-1.040	-.809
MAXIMUM Y	:	1.057	.914	.897
MINIMUM Y	:	-1.293	-.632	-.649
CENTROID X	:	-.044	-.179	-.049
CENTROID Y	:	.089	.232	.249
POA TO CENTROID in.	:	.099	.293	.254
MIN RADIUS	:	.514	.529	.620
MEAN RADIUS	:	.971	.862	.843
MAX RADIUS	:	1.772	1.163	1.067
HORIZONTAL SPREAD	:	2.387	2.059	1.698
VERTICAL SPREAD	:	2.350	1.546	1.546
EXTREME SPREAD	:	2.843	2.078	2.013
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.8330

VS = 1.903

GS = 2.211

PATTERN #

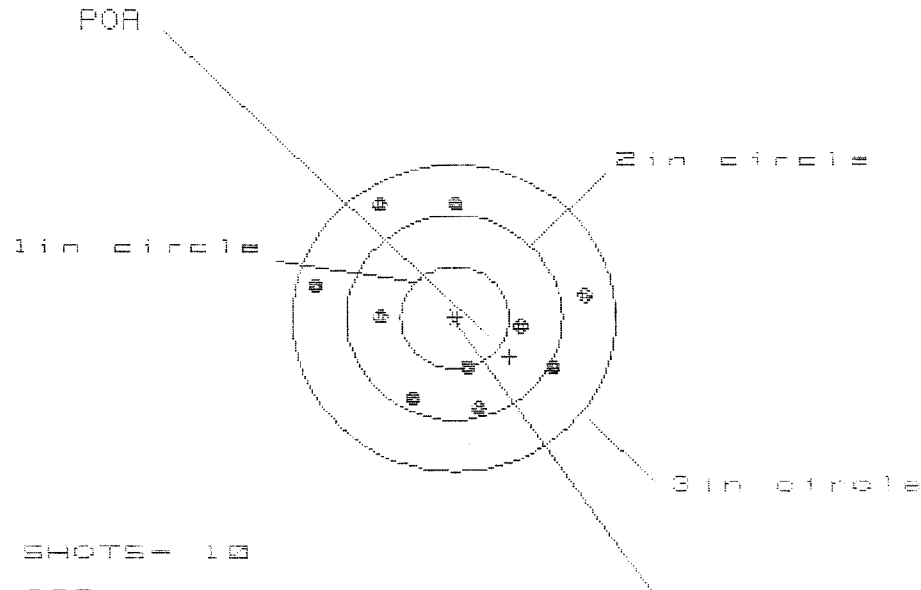
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.746	.824	.698
MINIMUM X	-1.085	-1.006	-1.793
MAXIMUM Y	.849	.732	.642
MINIMUM Y	-1.054	-.962	-1.052
CENTROID X	.272	.194	.320
CENTROID Y	-.038	.079	.169
POB TO CENTROID in.	.275	.210	.362
MIN RADIUS	.298	.379	.295
MEAN RADIUS	.831	.775	.695
MAX RADIUS	1.267	1.237	1.054
HORIZONTAL SPREAD	1.830	1.830	1.491
VERTICAL SPREAD	1.903	1.694	1.694
EXTREME SPREAD	2.211	2.188	1.759
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

27 Feb 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS = 2.497

VS = 1.923

GS = 2.498

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.170	1.022	.917
MINIMUM X	-1.327	-.845	-.945
MAXIMUM Y	1.075	1.107	1.245
MINIMUM Y	-.848	-.816	-.678
CENTROID X	-.512	-.364	-.259
CENTROID Y	.384	.352	.214
POA TO CENTROID in.	.640	.507	.396
MIN RADIUS	.521	.476	.375
MEAN RADIUS	.947	.882	.779
MAX RADIUS	1.359	1.389	1.262
HORIZONTAL SPREAD	2.497	1.867	1.862
VERTICAL SPREAD	1.923	1.923	1.923
EXTREME SPREAD	2.498	2.239	1.928
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		