

C6636259

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

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

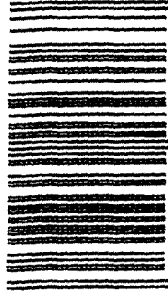
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. C6636259	06
ORDER NO. 5716	



5716 C6636259

UPC

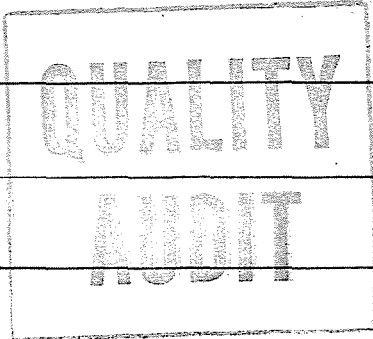


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CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636259

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 8 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KA
	C) Inspect Ejector Hole for Chamfer		8/22/91	KA
	D) Oil Firing Pin Ass'y		8/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-26-91	DH
	G) Safety Off Force	2 1/4	2	2			8-26-91	DH
	H) Trigger Pull Test & Retainability						8/24/91	JU
	I) Firing Pin Indent	.020	.020	.021			8-26-91	DH
	J) Assemble Stock						8/27/91	KK
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/27/91	KK
	M) Iron Sight Alignment						8/27/91	KK
	N) Detach Front & Rear Sights & place in numbered container						8/27/91	KK
	O) Attach Scope to Rifle						8/27/91	KK
	P) Detach & Attach Scope 20 Times						8/27/91	KK
640	Gallery Target & Test						8-27-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-27-91	NF
655	Final Inspection							
	A) Headspace						9-13-91	AC
	B) Trigger Pull	2.20	2.25	2.15	2.18	2.22	9/13/91	JU
	C) Function						9-13-91	AC
660	Pack						9-17-91	DH

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rk Test OK	
TEST		
TGT		
PROOF	9-13-91 A.C.	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 6259

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
✓	1st	Ejector sticking	KS
	8/27		
	2nd	REAMED EJECTOR HOLE POLISHED EJECTOR	KS
	8/27/91		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636259

DATE 8-24-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.34	2.50	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.28	2.44	2.25	
PULL #3	2.18	2.32	2.42	2.15	
PULL #4	2.44	2.54	2.53	2.18	
PULL #5	2.40	2.54	2.55	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.27		
PULL #2	3.20	3.36		
PULL #3	3.59	3.49		
PULL #4	3.40	3.46		
PULL #5	3.26	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.56	4.53		4.41
PULL #2	4.46	4.40		4.41
PULL #3	4.41	4.45		4.48
PULL #4	4.58	4.49		4.34
PULL #5	4.54	4.39		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636259
27 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.0940319
1 TO 2	.3588883
1 TO 3	.66751
1 TO 4	.12243
1 TO 5	.0731095

$\frac{3}{4}$ 3 <----POB

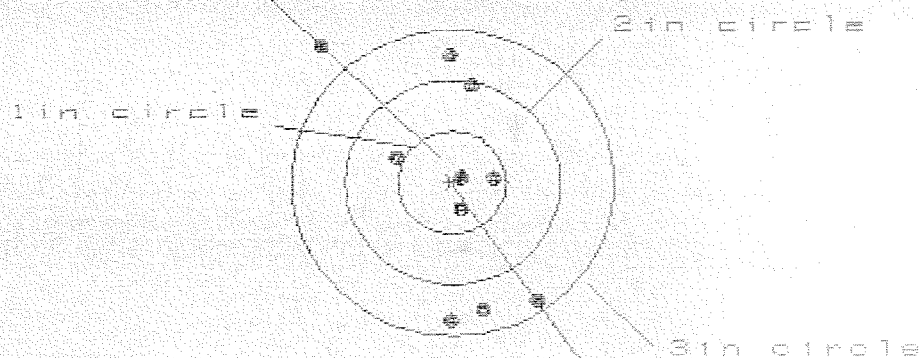
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0478
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0696
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844334
THE AMR FOR THIS RIFLE IS: .9492

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B36259

CENTERFIRE PATTERNS # 1

POB



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.004

VS= 2.739

GS= 3.227

CENTROID #

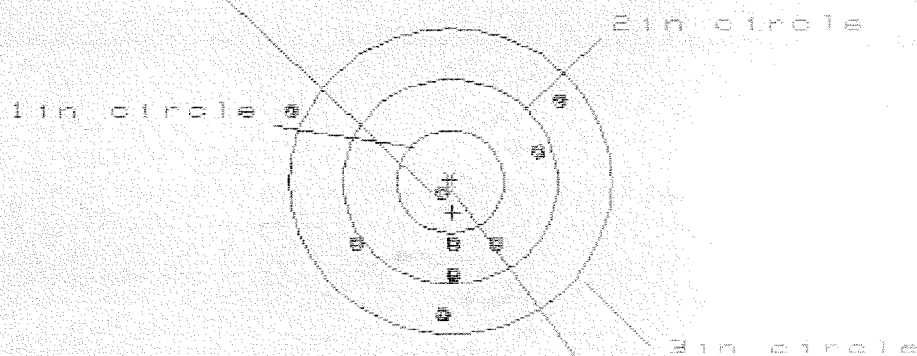
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.823	.692	.299
MINIMUM X	:	-1.181	-.635	-.549
MAXIMUM Y	:	1.382	1.437	1.313
MINIMUM Y	:	-1.357	-1.204	-1.328
CENTROID X	:	-.079	.052	-.034
CENTROID Y	:	-.051	-.204	-.080
POB TO CENTROID in.	:	.094	.211	.087
MIN RADIUS	:	.056	.118	.073
MEAN RADIUS	:	.929	.828	.757
MAX RADIUS	:	1.818	1.450	1.329
HORIZONTAL SPREAD	:	2.004	1.327	.848
VERTICAL SPREAD	:	2.739	2.641	2.641
EXTREME SPREAD	:	3.227	2.642	2.642
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08636259

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.492

VS = 3.478

GS = 3.484

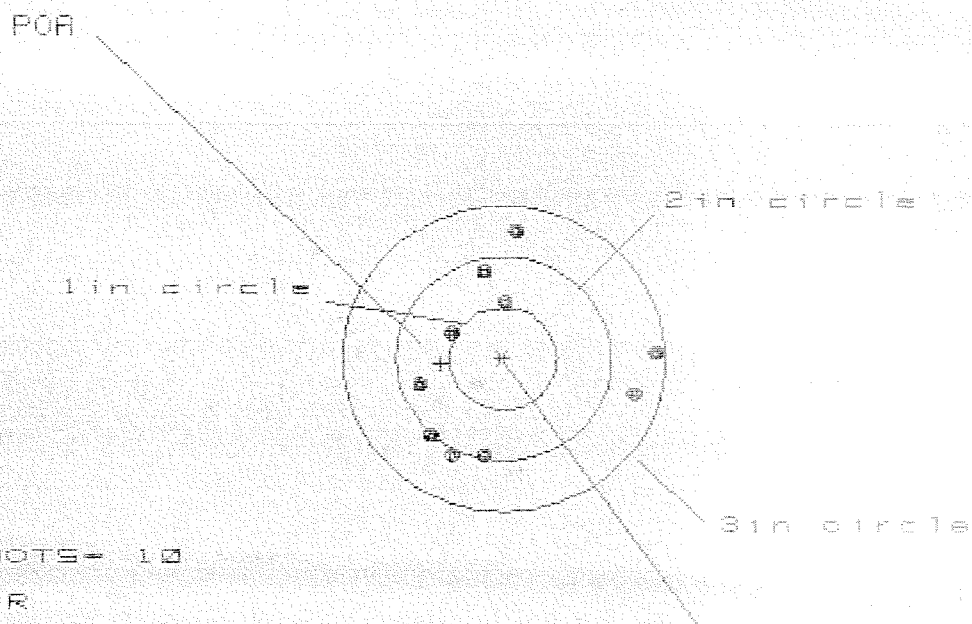
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.015	1.031	.849
MINIMUM X	-1.477	-1.461	-1.011
MAXIMUM Y	2.221	1.865	1.184
MINIMUM Y	-1.256	-1.010	-.891
CENTROID X	-.020	-.036	.146
CENTROID Y	.303	.057	-.062
POA TO CENTROID in.	.304	.067	.159
MIN RADIUS	.144	.139	.291
MEAN RADIUS	1.068	.870	.733
MAX RADIUS	2.226	1.744	1.457
HORIZONTAL SPREAD	2.492	2.492	1.860
VERTICAL SPREAD	3.478	2.075	2.075
EXTREME SPREAD	3.484	2.495	2.339
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/06636259

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.196

VS= 2.187

CS= 2.276

CENTROID *

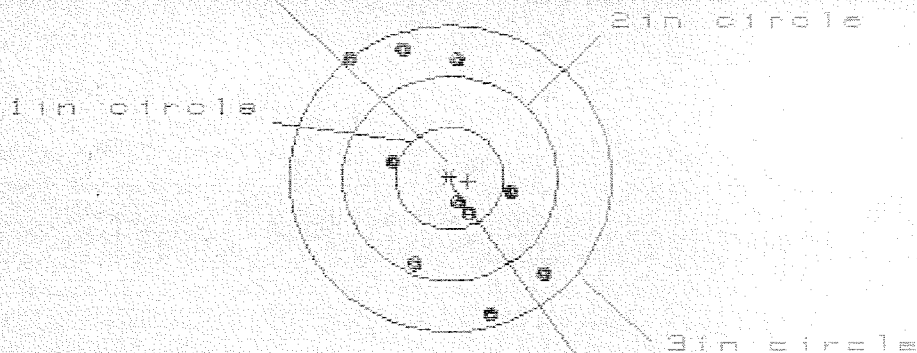
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.424	1.356	1.393
MINIMUM X	:	-.772	-.614	-.577
MAXIMUM Y	:	1.293	1.293	1.025
MINIMUM Y	:	-.904	-.894	-.733
CENTROID X	:	.582	.424	.387
CENTROID Y	:	.042	.032	-.129
POA TO CENTROID in.	:	.584	.425	.408
MIN RADIUS	:	.563	.430	.515
MEAN RADIUS	:	.973	.893	.824
MAX RADIUS	:	1.426	1.385	1.399
HORIZONTAL SPREAD	:	2.196	1.970	1.970
VERTICAL SPREAD	:	2.187	2.187	1.758
EXTREME SPREAD	:	2.276	2.276	1.972
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.780

VS= 2.577

CS= 2.842

CENTROID #

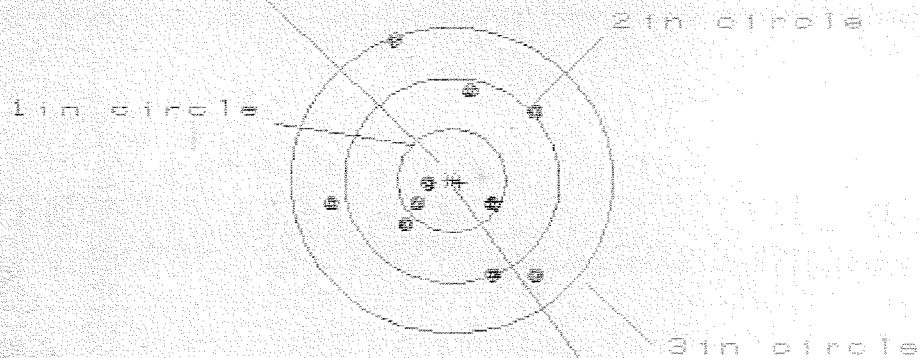
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.861	.759	.795
MINIMUM X	-.919	-.640	-.604
MAXIMUM Y	1.269	1.404	1.257
MINIMUM Y	-1.308	-1.173	-.907
CENTROID X	-.169	-.067	-.103
CENTROID Y	.032	-.103	.044
POA TO CENTROID in.	.172	.123	.112
MIN RADIUS	.287	.134	.283
MEAN RADIUS	.939	.829	.810
MAX RADIUS	1.523	1.505	1.355
HORIZONTAL SPREAD	1.780	1.399	1.399
VERTICAL SPREAD	2.577	2.577	2.164
EXTREME SPREAD	2.842	2.707	2.525
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.896

VS= 2.291

GS= 2.642

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.802	.739	.824
MINIMUM X	:	-1.094	-1.157	-1.072
MAXIMUM Y	:	1.368	1.015	.918
MINIMUM Y	:	-.923	-.771	-.837
CENTROID X	:	-.075	-.012	-.097
CENTROID Y	:	.022	-.130	-.033
POA TO CENTROID in.	:	.078	.130	.103
MIN RADIUS	:	.208	.277	.177
MEAN RADIUS	:	.837	.747	.701
MAX RADIUS	:	1.482	1.158	1.116
HORIZONTAL SPREAD	:	1.896	1.896	1.996
VERTICAL SPREAD	:	2.291	1.786	1.755
EXTREME SPREAD	:	2.642	2.090	2.090
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	