

C6348722

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



GUN SERIAL # C6348722

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26	89	RW
610	Dis-assemble Gun	9 26	89	RW
612	Magnaflux Barrel Action	9/29/89		KCR
	Magnaflux Bolt	9/29/89		KCR
615	Rollmark Caliber	9/29/89		G.S.
7	Drill and Tap Sight Holes	9 29	89	LB
618	Polish Barrel RB	9 29	89	BT
620	Apply Coatings (Barrel Action)		10-11-89	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/12/89	RW
	C) Inspect Ejector Hole for Chamfer		10/12/89	RW
	D) Oil Firing Pin Ass'y		10/12/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		23 Oct 89	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/23/89	JA
	G) Safety Off Force	3	3	3			10/23/89	JA
	H) Trigger Pull Test & Retainability						23 Oct 89	JA
	I) Firing Pin Indent	.0205	.0205	.020			10/23/89	JA
	J) Assemble Stock						11/6/89	JA
	K) Assemble Swivel Studs						10 Nov 89	JA
	L) Attach Front and Rear Sight Assemblies						11/6/89	JA
	M) Iron Sight Alignment						11/6/89	JA
	N) Detach Front & Rear Sights & place in numbered container						11/6/89	JA
	O) Attach Scope to Rifle						11-7-89	JA
	P) Detach & Attach Scope 20 Times						11-7-89	JA
640	Gallery Target & Test						11-8-89	JA
	A) Time						11-8-89	JA
	B) Malfunctions						11-8-89	JA
	C) Pierced Primers						11-8-89	JA
	D) Optical Clarity of Scope						11-8-89	JA
645	Inspect for Live Ammo						11-8-89	JA
655	Final Inspection							
	A) Headspace						10 Nov 89	JA
	B) Trigger Pull	274	272	288	279	276	10 Nov 89	JA
	C) Function						10 Nov 89	JA
660	Pack						14 Dec 89	JA

SWS TRIGGER PULL TEST

TIME

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 8722

DATE 3-23-90

TESTER J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.22	2.44	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.31	2.42	
PULL #3	2.36	2.34	2.57	
PULL #4	2.33	2.49	2.52	
PULL #5	2.39	2.44	2.55	
TOTAL	11.81	12.02	12.61	
AVG.	2.362	2.404	2.522	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.25	
PULL #2	3.24	3.27	
PULL #3	3.24	3.15	
PULL #4	3.34	3.26	
PULL #5	3.28	3.20	
TOTAL	16.34	16.13	
AVG.	3.268	3.226	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.38		
PULL #2	4.43	4.31		
PULL #3	4.33	4.33		
PULL #4	4.36	4.37		
PULL #5	4.38	4.42		
TOTAL	21.96	21.81		
AVG.	4.392	4.362		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348722
8 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.0488365
1 TO	2	.279932
1 TO	3	.388631
1 TO	4	.308649
1 TO	5	.749777

4+3 (----POA
5

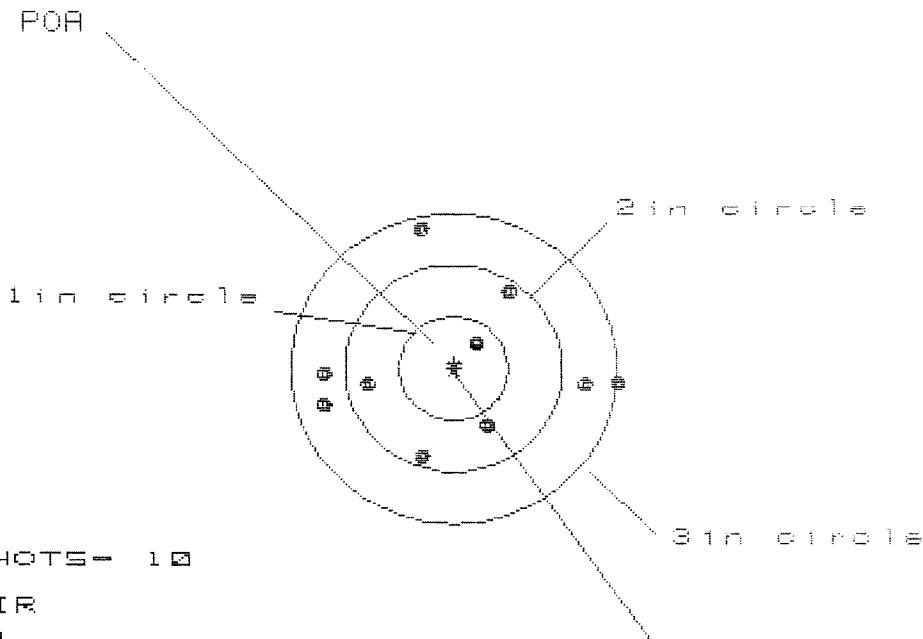
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.103
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .22621
THE AMR FOR THIS RIFLE IS: .8716

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B726

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.678

VS= 2.119

GS= 2.684

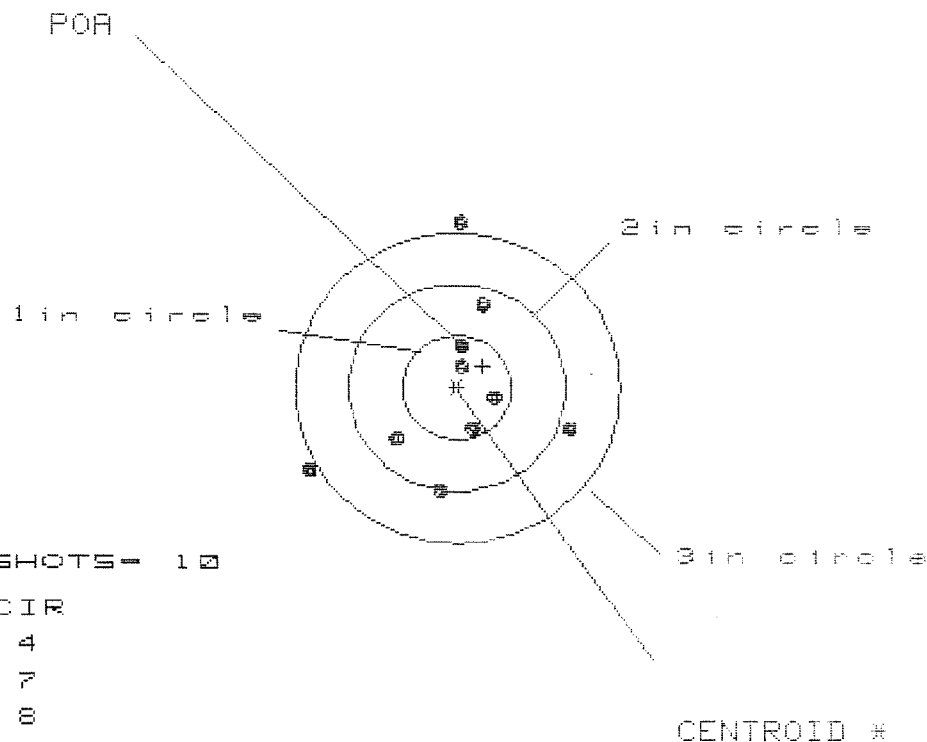
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.469	1.381	1.362
MINIMUM X	-1.209	-1.046	-1.065
MAXIMUM Y	1.300	1.280	.859
MINIMUM Y	-.819	-.839	-.678
CENTROID X	-.009	-.172	-.153
CENTROID Y	-.048	-.028	-.189
POA TO CENTROID in.	.048	.174	.243
MIN RADIUS	.373	.488	.574
MEAN RADIUS	1.001	.942	.882
MAX RADIUS	1.479	1.394	1.363
HORIZONTAL SPREAD	2.678	2.427	2.427
VERTICAL SPREAD	2.119	2.119	1.537
EXTREME SPREAD	2.684	2.433	2.433
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

8 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348722

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 2.383

VS= 2.585

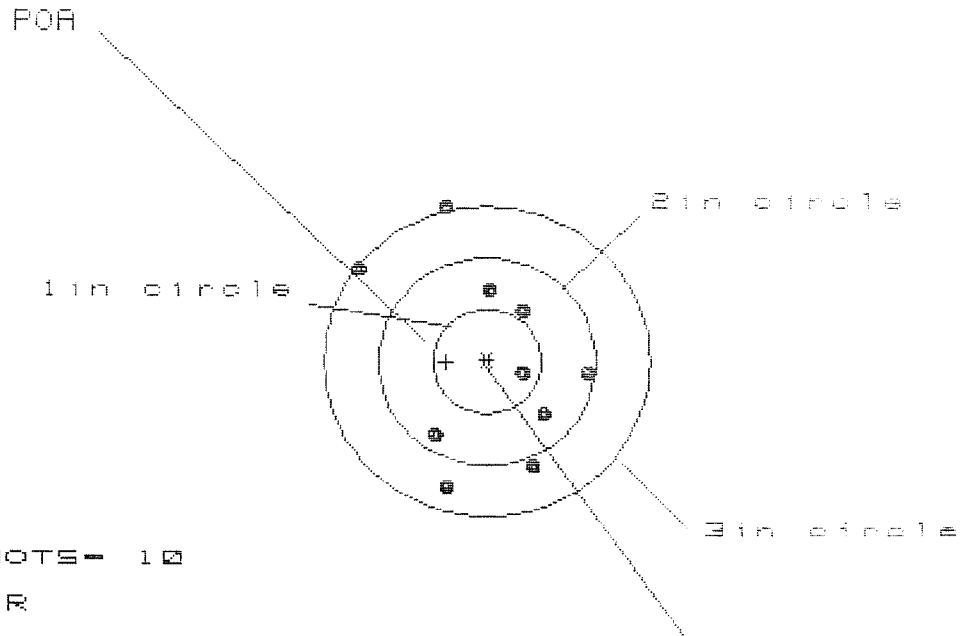
GS= 2.760

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	1.079	.916
MINIMUM X	:	-1.313	-1.304	-.716
MAXIMUM Y	:	1.621	1.000	.927
MINIMUM Y	:	-.964	-.784	-.857
CENTROID X	:	-.238	-.247	-.084
CENTROID Y	:	-.209	-.389	-.316
POA TO CENTROID in.	:	.316	.460	.327
MIN RADIUS	:	.218	.271	.217
MEAN RADIUS	:	.829	.738	.622
MAX RADIUS	:	1.623	1.428	.951
HORIZONTAL SPREAD	:	2.383	2.383	1.632
VERTICAL SPREAD	:	2.585	1.784	1.784
EXTREME SPREAD	:	2.760	2.416	1.837
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Nov 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.140

VS= 2.656

GS= 2.656

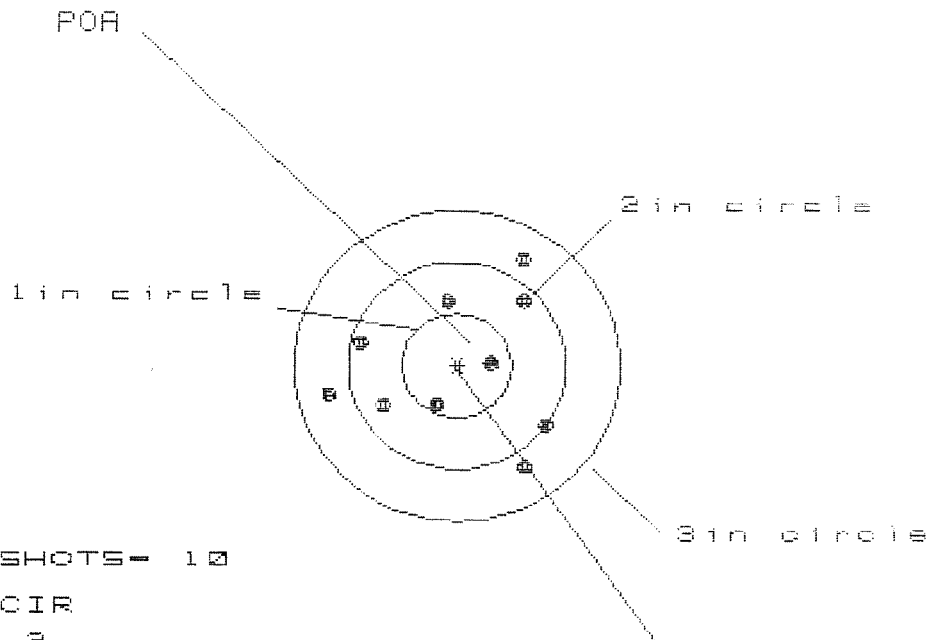
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.969	.926	.774
MINIMUM X	:	-1.171	-1.214	-.676
MAXIMUM Y	:	1.479	1.048	.985
MINIMUM Y	:	-1.177	-1.013	-.882
CENTROID X	:	.376	.419	.571
CENTROID Y	:	.005	-.159	-.290
FOR TO CENTROID in.	:	.376	.449	.641
MIN RADIUS	:	.290	.248	.228
MEAN RADIUS	:	.947	.861	.732
MAX RADIUS	:	1.530	1.604	1.059
HORIZONTAL SPREAD	:	2.140	2.140	1.450
VERTICAL SPREAD	:	2.656	2.061	1.867
EXTREME SPREAD	:	2.656	2.486	1.905
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1989

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.946

VS= 2.020

GS= 2.141

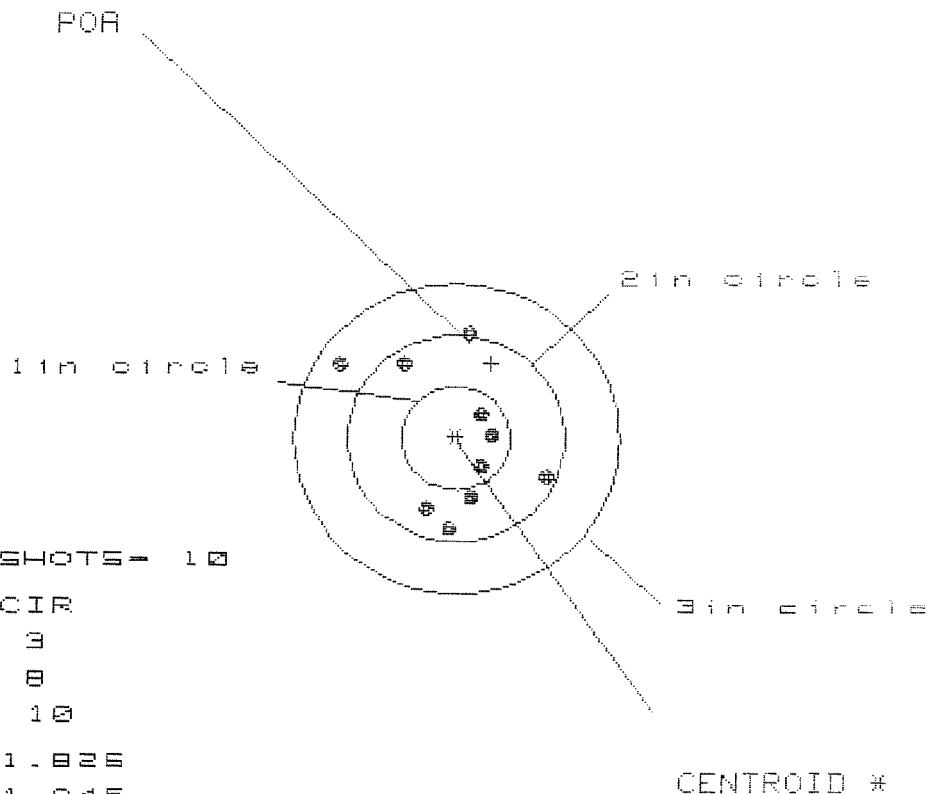
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.868	.733
MINIMUM X	:	-1.145	-1.078	-.915
MAXIMUM Y	:	1.002	.889	.846
MINIMUM Y	:	-1.017	-.680	-.723
CENTROID X	:	-.317	-.384	-.249
CENTROID Y	:	-.028	.086	.129
POA TO CENTROID in.	:	.318	.393	.280
MIN RADIUS	:	.321	.396	.283
MEAN RADIUS	:	.844	.803	.747
MAX RADIUS	:	1.181	1.134	1.030
HORIZONTAL SPREAD	:	1.946	1.946	1.648
VERTICAL SPREAD	:	2.020	1.569	1.569
EXTREME SPREAD	:	2.141	2.141	1.892
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

8 Nov 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.826

VS= 1.945

GS= 2.113

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.793	.678	.679
MINIMUM X	:	-1.033	-.617	-.616
MAXIMUM Y	:	1.069	1.148	.928
MINIMUM Y	:	-.876	-.797	-.654
CENTROID X	:	-.327	-.212	-.213
CENTROID Y	:	-.727	-.806	-.949
POA TO CENTROID in.	:	.797	.833	.973
MIN RADIUS	:	.348	.240	.114
MEAN RADIUS	:	.737	.646	.556
MAX RADIUS	:	1.255	1.148	1.114
HORIZONTAL SPREAD	:	1.826	1.295	1.295
VERTICAL SPREAD	:	1.945	1.945	1.582
EXTREME SPREAD	:	2.113	1.955	1.672
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington[®]

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

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

MODEL 700TM H24

SERIAL NO.
C6348722
ORDER NO.
5716

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

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5716 C6348722

UPC



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