

~~7700~~ C6348723

M2400062382

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

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

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

MODEL 700™ H24

SERIAL NO.	C6348723
ORDER NO.	5716

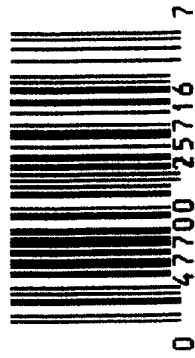
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



5716 C6348723

UPC



RC51

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348723

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	12-20 89	RW
600	Proof		12-20 89	A
607	Check Headspace		12-20 89	A
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action		1-5-90	KCR
	Magnaflux Bolt		1-5-90	
615	Rollmark Caliber		1/9/90	CS
617	Drill and Tap Sight Holes		1/10/90	LB
618	Polish Barrel <i>LB</i>		1/10/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/6/90	TS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-26-90	GU
	G) Safety Off Force	3	3	3			1-26-90	GU
	H) Trigger Pull Test & Retainability						2/6/90	GU
	I) Firing Pin Indent	.0225	.0225	.0225			1-26-90	GU
	J) Assemble Stock						1-31-90	RU
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						1-31-90	RU
	M) Iron Sight Alignment						1-31-90	- RU
	N) Detach Front & Rear Sights & place in numbered container						1-31-90	RU
	O) Attach Scope to Rifle						2-23-90	GU
	P) Detach & Attach Scope 20 Times						2-23-90	GU
640	Gallery Target & Test						2-27-90	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						2-27-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace							
	B) Trigger Pull	2.74	2.75	2.74	2.74	2.78	3/13/90	GS
	C) Function						3/13/90	WB
660	Pack						60/11/11/90	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348723
DATE 26 Jan 90
TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	249	234	221	274	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	229	219	223	275	
PULL #3	216	227	219	274	
PULL #4	227	217	218	274	
PULL #5	215	223	222	278	
TOTAL	1136	1120	1102		
AVG.	2.274	2.24	2.204		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	359	344		
PULL #2	357	339		
PULL #3	361	333		
PULL #4	344	332		
PULL #5	342	331		
TOTAL	1763	1689		
AVG.	3.526	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	422	432		414
PULL #2	417	420		414
PULL #3	422	434		413
PULL #4	421	420		413
PULL #5	415	418		417
TOTAL	2097	2124		2071
AVG.	4.194	4.248		4.142

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348723
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.04272
1 TO	2	.368879
1 TO	3	.2022
1 TO	4	.399125
1 TO	5	.493794

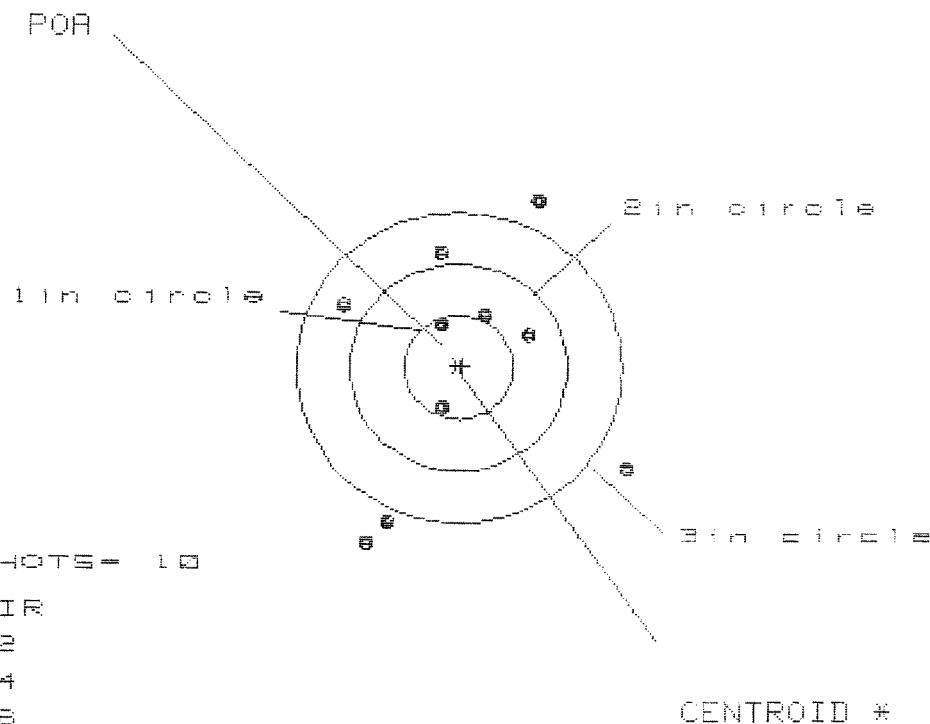
$\bar{x}$ & $\bar{y}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0072912
THE AMR FOR THIS RIFLE IS: 1.13

27 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/05348723

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.594

VS= 3.306

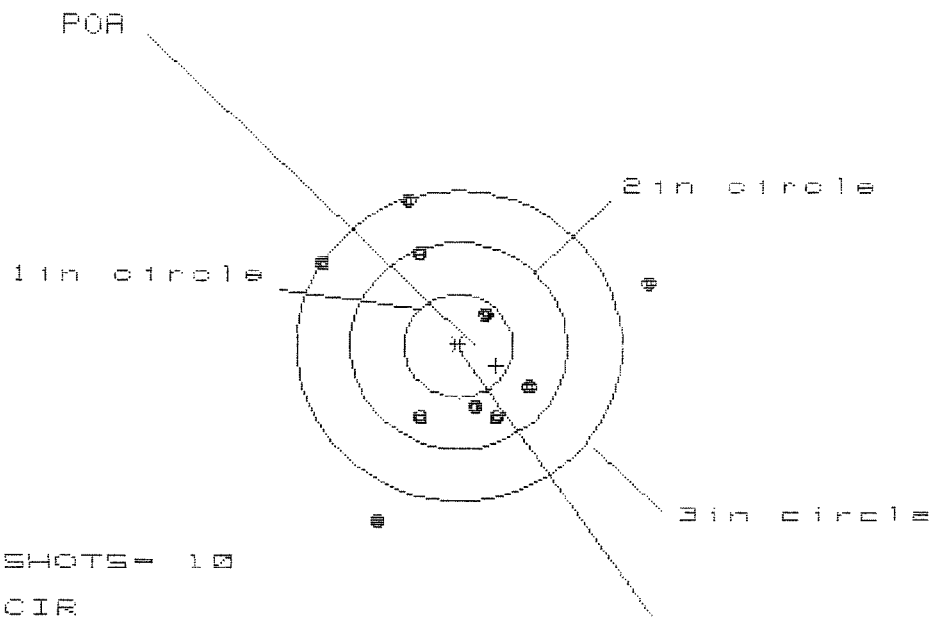
GS= 3.710

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.498	1.397	1.481
MINIMUM X	:	-1.096	-1.197	-1.113
MAXIMUM Y	:	1.621	1.434	1.143
MINIMUM Y	:	-1.685	-1.634	-1.455
CENTROID X	:	-.040	.061	-.023
CENTROID Y	:	-.015	.172	-.097
POA TO CENTROID in.	:	.042	.183	.024
MIN RADIUS	:	.423	.321	.429
MEAN RADIUS	:	1.157	1.036	.982
MAX RADIUS	:	1.913	1.818	1.778
HORIZONTAL SPREAD	:	2.594	2.594	2.594
VERTICAL SPREAD	:	3.306	3.068	2.596
EXTREME SPREAD	:	3.710	3.376	3.019
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

27 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08348723

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 7

HS = 2.929

VS = 3.154

GS = 3.417

CENTROID *

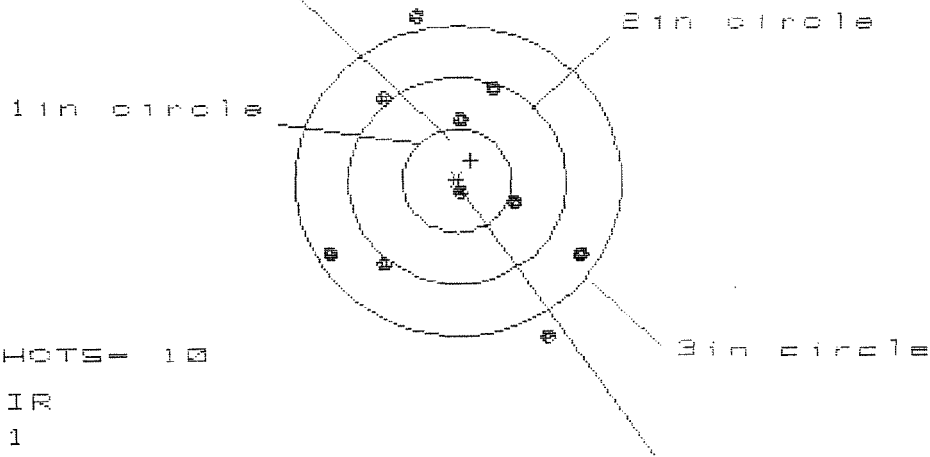
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.703	1.618	.798
MINIMUM X	:	-1.226	-1.311	-1.109
MAXIMUM Y	:	1.445	1.255	1.313
MINIMUM Y	:	-1.709	-.930	-.872
CENTROID X	:	-.346	-.261	-.464
CENTROID Y	:	.191	.381	.323
POA TO CENTROID in.	:	.395	.462	.565
MIN RADIUS	:	.434	.243	.448
MEAN RADIUS	:	1.096	1.005	.922
MAX RADIUS	:	1.872	1.684	1.355
HORIZONTAL SPREAD	:	2.929	2.929	1.898
VERTICAL SPREAD	:	3.154	2.185	2.185
EXTREME SPREAD	:	3.417	2.932	2.258
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

27 Feb 1998

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.323

VS = 3.108

GS = 3.335

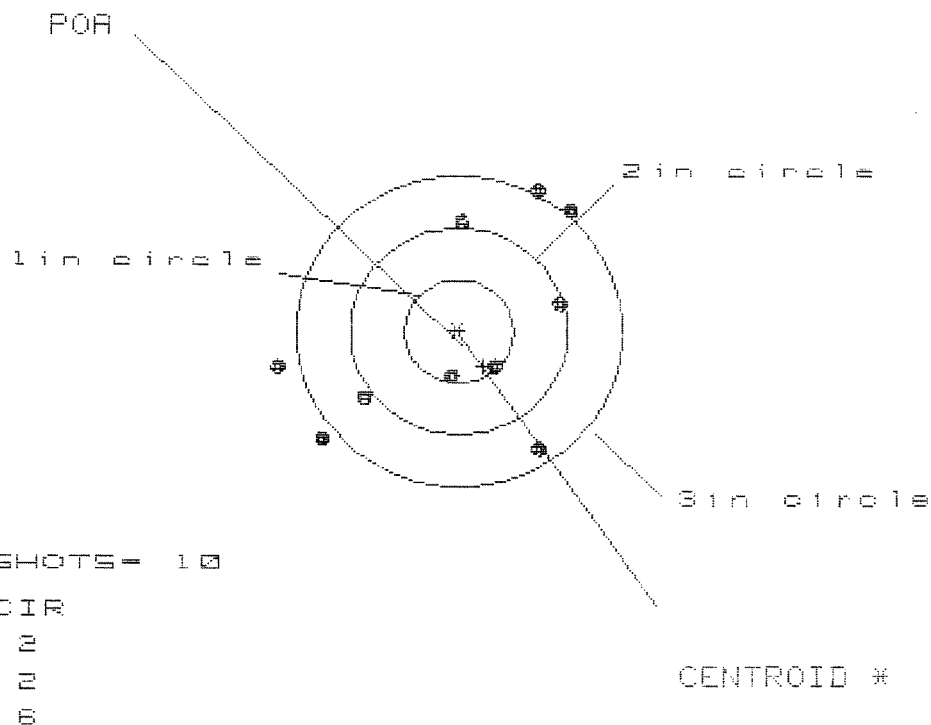
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.266	1.234
MINIMUM X	:	-1.152	-1.057	-1.089
MAXIMUM Y	:	1.609	1.443	.906
MINIMUM Y	:	-1.499	-.975	-.795
CENTROID X	:	-.126	-.221	-.189
CENTROID Y	:	-.198	-.032	-.212
POA TO CENTROID in.	:	.235	.223	.284
MIN RADIUS	:	.060	.250	.090
MEAN RADIUS	:	1.035	.955	.878
MAX RADIUS	:	1.726	1.528	1.406
HORIZONTAL SPREAD	:	2.323	2.323	2.323
VERTICAL SPREAD	:	3.108	2.418	1.701
EXTREME SPREAD	:	3.335	2.756	2.353
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

27 Feb 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 2

3 in = 6

HS= 2.721

VS= 2.515

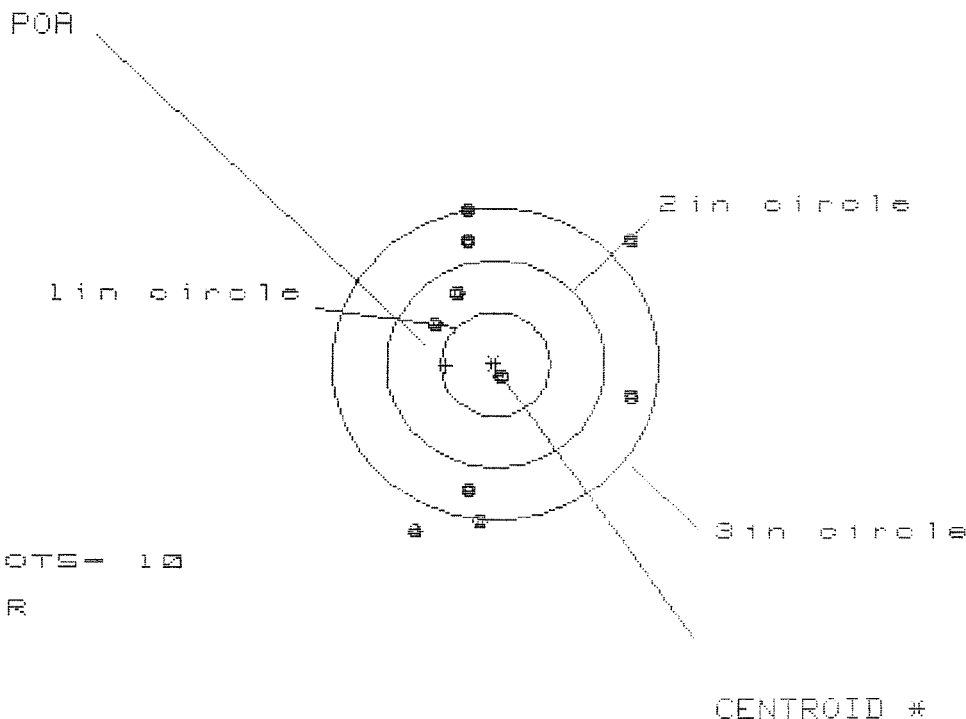
GS= 3.120

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	.842	.666
MINIMUM X	:	-1.691	-1.410	-1.203
MAXIMUM Y	:	1.409	1.377	1.244
MINIMUM Y	:	-1.106	-1.138	-1.071
CENTROID X	:	-.230	-.042	.134
CENTROID Y	:	.336	.368	.501
POA TO CENTROID in.	:	.407	.371	.518
MIN RADIUS	:	.429	.423	.539
MEAN RADIUS	:	1.177	1.101	1.007
MAX RADIUS	:	1.715	1.764	1.441
HORIZONTAL SPREAD	:	2.721	2.252	1.869
VERTICAL SPREAD	:	2.515	2.515	2.515
EXTREME SPREAD	:	3.120	3.120	2.568
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

27 Feb 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.073

VS= 3.126

GS= 3.487

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.183	1.117
MINIMUM X	:	-1.801	-1.616	-1.472
MAXIMUM Y	:	1.471	1.287	1.410
MINIMUM Y	:	-1.655	-1.702	-1.579
CENTROID X	:	.453	.542	.398
CENTROID Y	:	.013	.197	.074
POA TO CENTROID in.	:	.454	.577	.405
MIN RADIUS	:	.144	.330	.220
MEAN RADIUS	:	1.184	1.103	1.031
MAX RADIUS	:	1.839	1.716	1.581
HORIZONTAL SPREAD	:	2.073	1.799	1.799
VERTICAL SPREAD	:	3.126	2.989	2.989
EXTREME SPREAD	:	3.487	3.020	2.993
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	