

C6349004

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

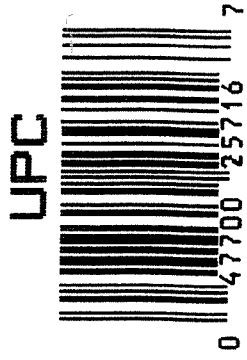
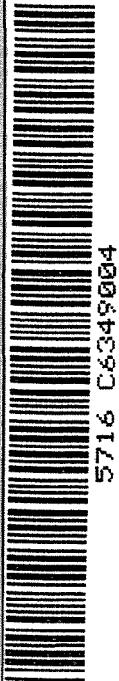
Remington®

DUPONT

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

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

MODEL 700™ H24	SERIAL NO. C6349004
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off; Marca Registrada Marque Deposee.	ORDER NO. 5716



RL 50

M-24

INTERCHANGEABILITY

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349004

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		1/5/90	CS
17	Drill and Tap Sight Holes		1/8/90	LB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	JA
	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		2/1/90	LD

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	1-26-90	JH
	G) Safety Off Force	4	4	4	1-26-90	JH
	H) Trigger Pull Test & Retainability				2/27/90	JS
	I) Firing Pin Indent	.024	.023	.0235	1-26-90	JH
	J) Assemble Stock				2/27/90	RW
	K) Assemble Swivel Studs				3/13/90	WB
	L) Attach Front and Rear Sight Assemblies				2/27/90	RW
	M) Iron Sight Alignment				2/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container				2/27/90	RW
	O) Attach Scope to Rifle				2/27/90	WB
	P) Detach & Attach Scope 20 Times				2/27/90	WB
640	Gallery Target & Test				2-27-90	A
	A) Time				"	A
	B) Malfunctions				"	A
	C) Pierced Primers				"	A
	D) Optical Clarity of Scope				"	A
645	Inspect for Live Ammo				2-27-90	A
655	Final Inspection					
	A) Headspace				16 MAR 90	JS
	B) Trigger Pull	222	216	223	16 MAR 90	JS
	C) Function				16 MAR 90	JS
660	Pack				20 MAR 90	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349004
DATE 25 Jan 90
TESTER ES

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	228	246	218	222	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	225	216	228	216	
PULL #3	225	214	231	223	
PULL #4	218	208	237	230	
PULL #5	216	210	226	220	
TOTAL	1112	1094	1140	1111	
AVG.	222.4	218.8	228	222.2	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	293	286		
PULL #2	289	288		
PULL #3	291	276		
PULL #4	287	278		
PULL #5	281	240		
TOTAL	1431	1418		
AVG.	286.2	283.6		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	3.95		4.06
PULL #2	4.06	4.00		3.89
PULL #3	4.05	3.93		4.02
PULL #4	4.04	3.70		4.04
PULL #5	4.02	3.93		3.95
TOTAL	20.19	19.51		19.96
AVG.	4.038	3.902		3.992

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349004
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.227633
1 TO	2	.70271
1 TO	3	.233694
1 TO	4	.45334
1 TO	5	.359134

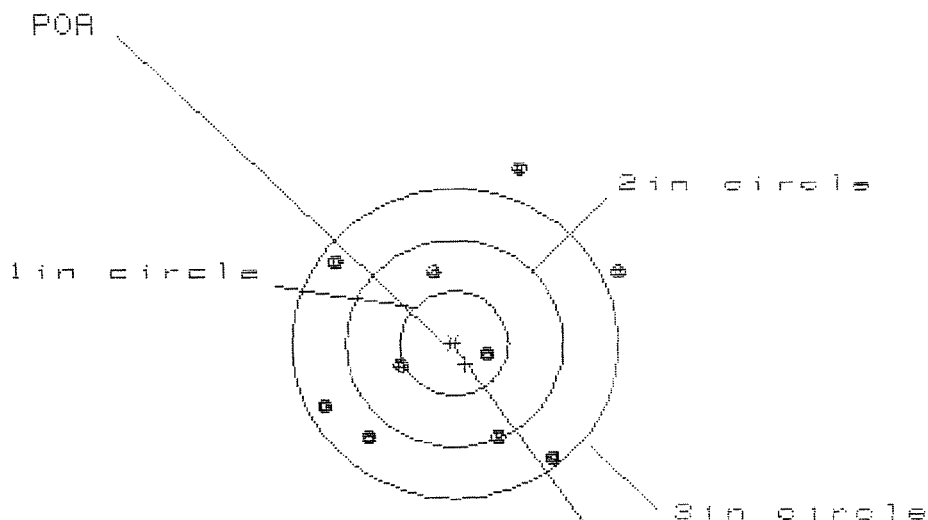
$\frac{1}{5}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1328
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1388
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .192097
THE AMR FOR THIS RIFLE IS: 1.02

27 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349004

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.710

VS= 2.870

GS= 3.006

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.530	1.595	1.180
MINIMUM X	-1.180	-1.115	-.916
MAXIMUM Y	1.743	.993	1.099
MINIMUM Y	-1.127	-.933	-.827
CENTROID X	-.101	-.166	-.365
CENTROID Y	.204	.010	-.096
POA TO CENTROID in.	.227	.166	.377
MIN RADIUS	.265	.349	.224
MEAN RADIUS	1.126	1.025	.901
MAX RADIUS	1.838	1.808	1.441
HORIZONTAL SPREAD	2.710	2.710	2.096
VERTICAL SPREAD	2.870	1.926	1.926
EXTREME SPREAD	3.006	3.006	2.770
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349004

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 10

HS= 2.468

VS= 2.089

GS= 2.744

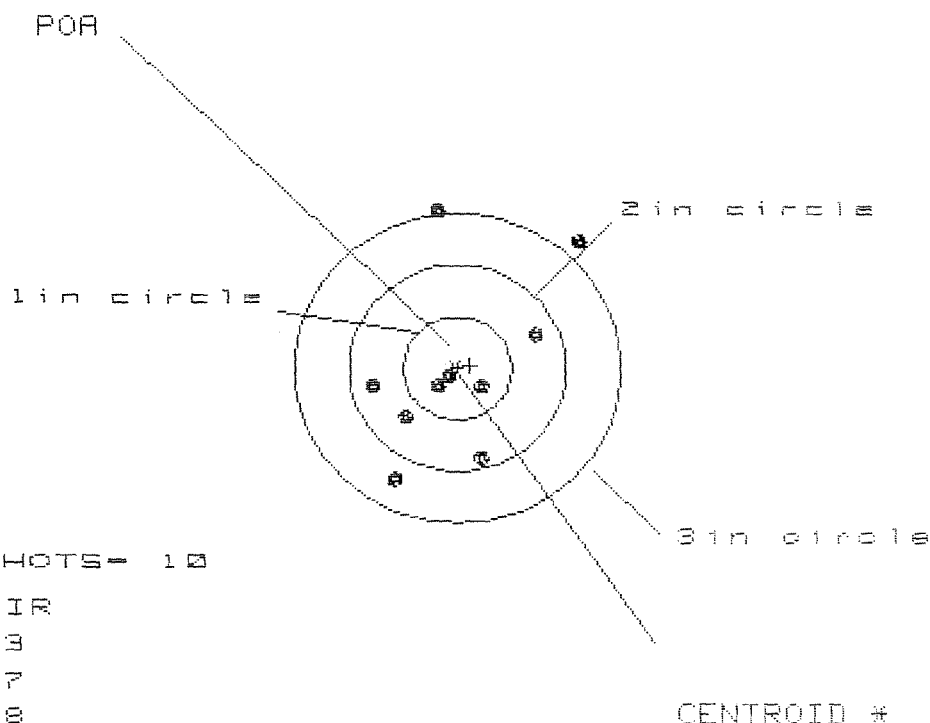
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.121	.971	.935
MINIMUM X	:	-1.347	-1.276	-1.155
MAXIMUM Y	:	1.007	1.062	1.177
MINIMUM Y	:	-1.082	-1.027	-.912
CENTROID X	:	-.052	.097	-.024
CENTROID Y	:	-.497	-.552	-.667
POA TO CENTROID in.	:	.500	.560	.668
MIN RADIUS	:	.815	.660	.716
MEAN RADIUS	:	1.137	1.088	1.047
MAX RADIUS	:	1.434	1.432	1.273
HORIZONTAL SPREAD	:	2.468	2.247	2.090
VERTICAL SPREAD	:	2.089	2.089	2.089
EXTREME SPREAD	:	2.744	2.744	2.408
NUMBER IN ONE INCH CIRCLE	:		0	
NUMBER IN TWO INCH CIRCLE =	:		3	
NUMBER IN THREE INCH CIRCLE =	:		10	

27 Feb 1938

FILE:/PATTERNING/CENTERFIRE_PATT/06349004

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 1.073

VS= 2.634

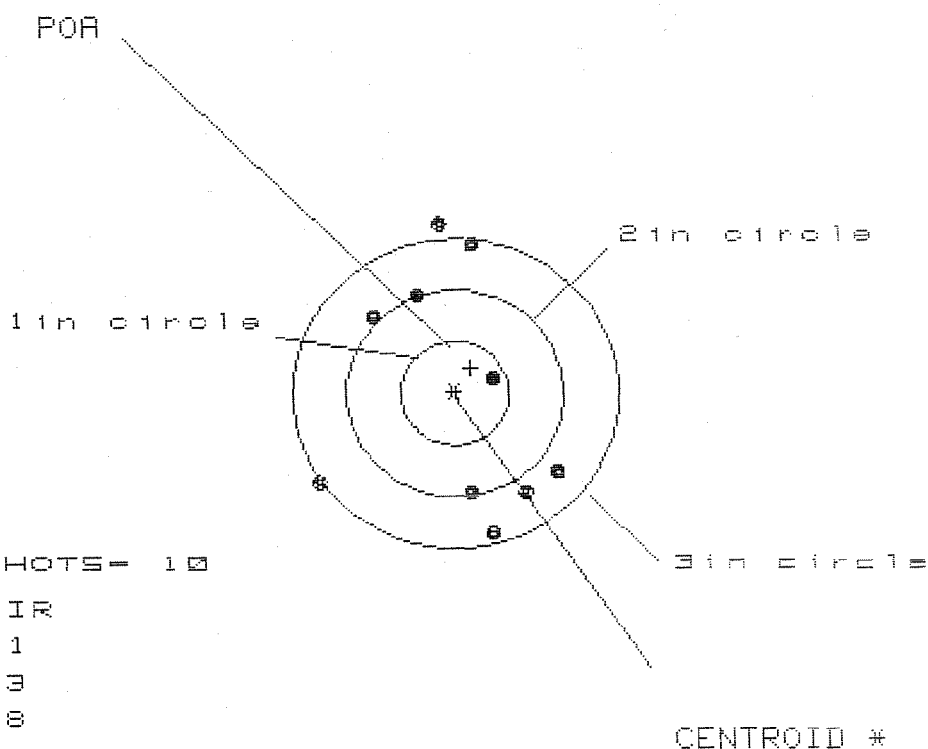
GS= 2.944

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.137	.815	.804
MINIMUM X	:	-.736	-.610	-.621
MAXIMUM Y	:	1.532	1.673	.686
MINIMUM Y	:	-1.102	-.961	-.752
CENTROID X	:	-.119	-.245	-.234
CENTROID Y	:	-.029	-.170	-.379
POA TO CENTROID in.	:	.122	.298	.445
MIN RADIUS	:	.123	.046	.225
MEAN RADIUS	:	.832	.684	.564
MAX RADIUS	:	1.704	1.675	1.057
HORIZONTAL SPREAD	:	1.873	1.425	1.405
VERTICAL SPREAD	:	2.634	2.634	1.438
EXTREME SPREAD	:	2.944	2.662	1.936
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349004

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 8

HS = 2.277

VS = 3.040

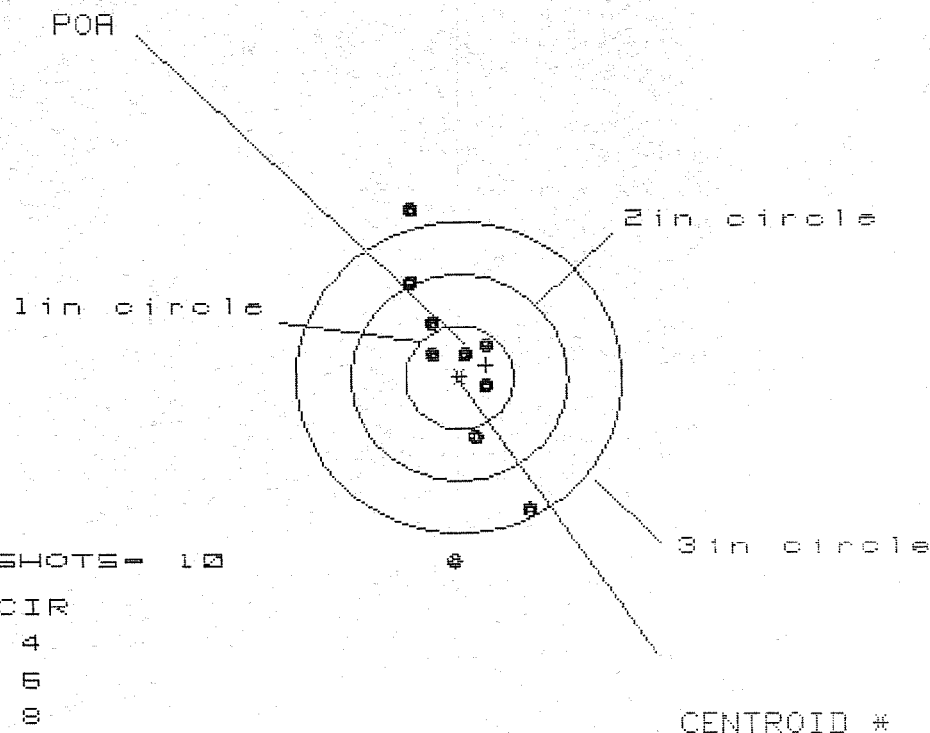
GS = 3.069

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.981	.820
MINIMUM X	:	-1.284	-1.296	-.964
MAXIMUM Y	:	1.671	1.584	1.498
MINIMUM Y	:	-1.369	-1.184	-1.270
CENTROID X	:	-.147	-.135	.026
CENTROID Y	:	-.247	-.432	-.346
POA TO CENTROID in.	:	.287	.453	.347
MIN RADIUS	:	.368	.452	.277
MEAN RADIUS	:	1.179	1.109	1.040
MAX RADIUS	:	1.674	1.587	1.500
HORIZONTAL SPREAD	:	2.277	2.277	1.783
VERTICAL SPREAD	:	3.040	2.768	2.768
EXTREME SPREAD	:	3.069	2.776	2.776
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			8	

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349004

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 1.084

VS= 3.403

GS= 3.423

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.645	.638	.582
MINIMUM X	:	-.439	-.446	-.481
MAXIMUM Y	:	1.629	1.432	.914

MINIMUM Y	:	-1.774	-1.487	-1.308
CENTROID X	:	-.245	-.238	-.182
CENTROID Y	:	-.125	.072	-.107
POA TO CENTROID in.	:	.275	.249	.211
MIN RADIUS	:	.184	.035	.164
MEAN RADIUS	:	.826	.679	.592
MAX RADIUS	:	1.775	1.618	1.432
HORIZONTAL SPREAD	:	1.084	1.084	1.063
VERTICAL SPREAD	:	3.403	2.919	2.222
EXTREME SPREAD	:	3.423	3.114	2.463
NUMBER IN ONE INCH CIRCLE =	:		4	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349004
19 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.136092
1 TO	2	.143126
1 TO	3	.0921954
1 TO	4	.264484
1 TO	5	.307709

$\bar{x}_4$ <----POA

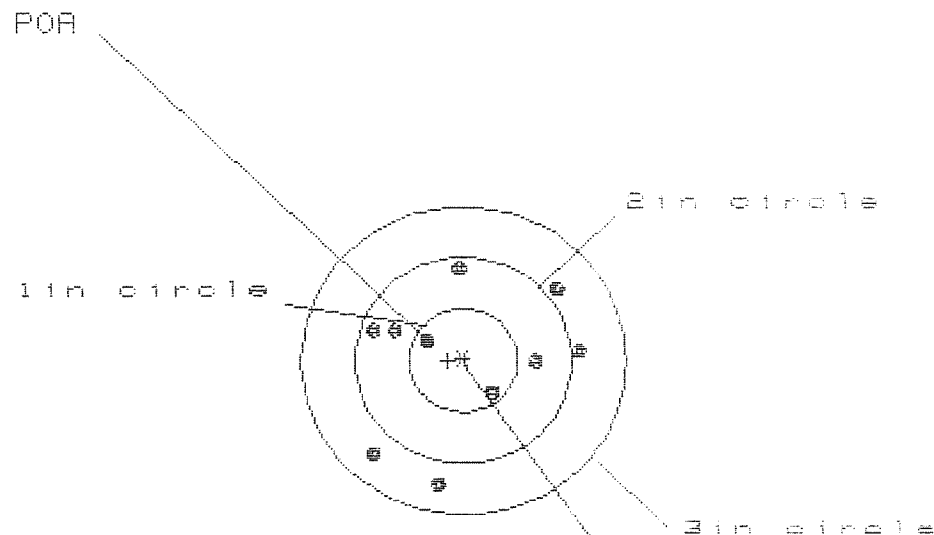
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .13
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0646
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145166

THE AMR FOR THIS RIFLE IS: .8104

17 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349084.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.933

VS= 2.066

GS= 2.307

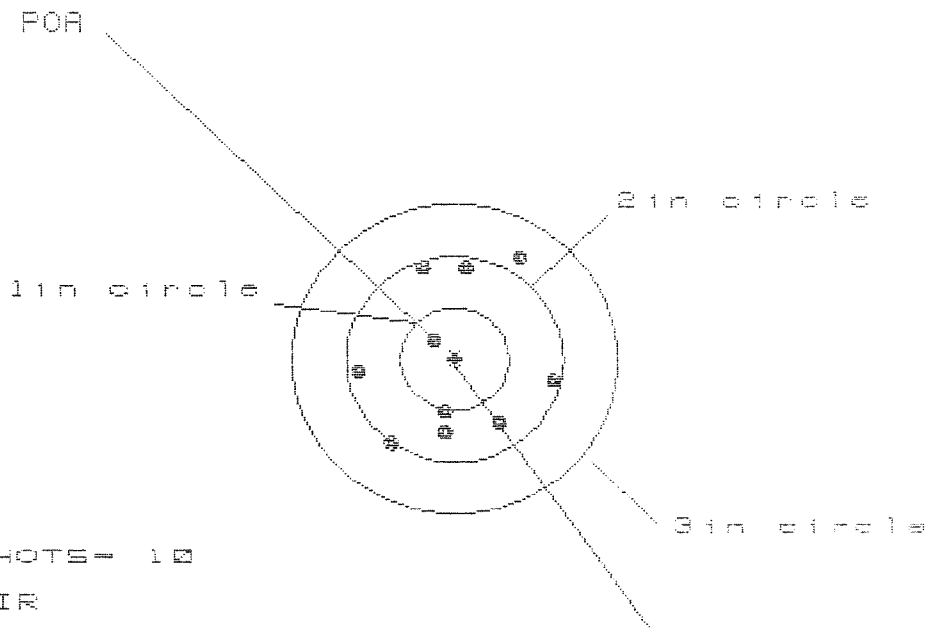
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.103	1.010	.971
MINIMUM X	-.830	-.885	-.924
MAXIMUM Y	.890	.791	.631
MINIMUM Y	-1.175	-1.275	-.611
CENTROID X	.136	.229	.268
CENTROID Y	.005	.104	.264
POA TO CENTROID in.	.136	.251	.376
MIN RADIUS	.425	.471	.495
MEAN RADIUS	.854	.804	.731
MAX RADIUS	1.224	1.313	.993
HORIZONTAL SPREAD	1.933	1.895	1.895
VERTICAL SPREAD	2.066	2.066	1.242
EXTREME SPREAD	2.307	2.132	1.915
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

17 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8545004.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.824

VS= 1.833

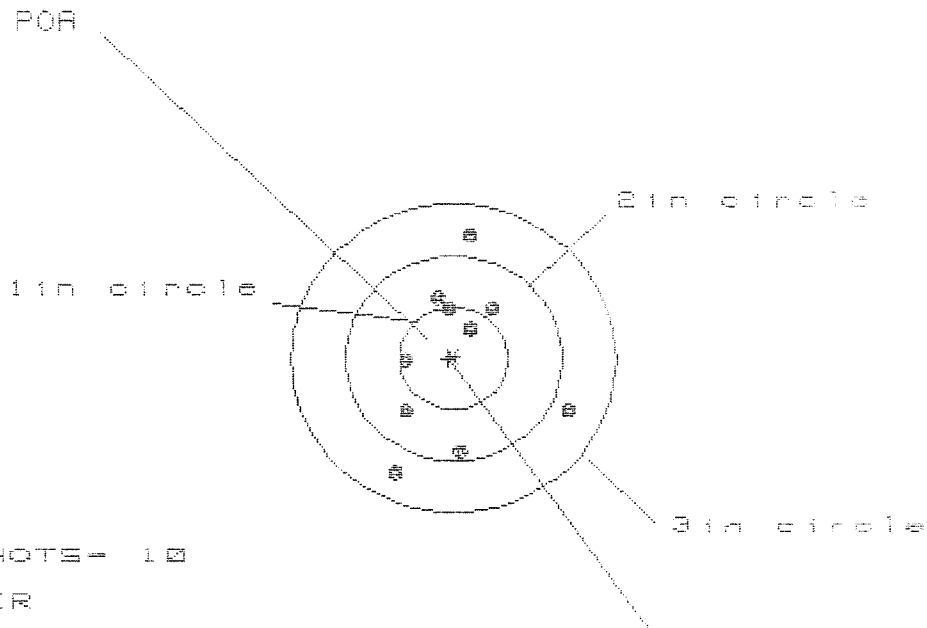
GS= 2.176

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	1.023	.962
MINIMUM X	:	-.869	-.801	-.862
MAXIMUM Y	:	1.013	1.049	.960
MINIMUM Y	:	-.820	-.707	-.708
CENTROID X	:	-.007	-.075	-.014
CENTROID Y	:	.011	-.102	-.013
POA TO CENTROID in.	:	.013	.126	.019
MIN RADIUS	:	.254	.320	.269
MEAN RADIUS	:	.813	.754	.743
MAX RADIUS	:	1.186	1.060	.984
HORIZONTAL SPREAD	:	1.824	1.824	1.824
VERTICAL SPREAD	:	1.833	1.756	1.668
EXTREME SPREAD	:	2.176	1.970	1.827
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6849004.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.501

VS= 2.235

GS= 2.341

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	.948	.954
MINIMUM X	-.587	-.537	-.531
MAXIMUM Y	1.141	1.020	.628
MINIMUM Y	-1.094	-1.049	-.922
CENTROID X	.044	.110	.104
CENTROID Y	.011	.132	.085
POA TO CENTROID in.	.046	.172	.184
MIN RADIUS	.307	.172	.230
MEAN RADIUS	.761	.678	.657
MAX RADIUS	1.241	1.149	1.087
HORIZONTAL SPREAD	1.601	1.485	1.485
VERTICAL SPREAD	2.235	2.069	1.550
EXTREME SPREAD	2.341	2.071	1.621
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

17 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0634502A.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.447

VS= 1.543

GS= 2.580

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.010

.850

.762

MINIMUM X

:

-1.437

-1.083

-1.171

MAXIMUM Y

:

1.038

.989

.522

MINIMUM Y

:

-.505

-.554

-.431

CENTROID X

:

.400

.560

.647

CENTROID Y

:

-.011

.038

-.085

POA TO CENTROID in.:

.400

.561

.653

MIN RADIUS

:

.240

.346

.207

MEAN RADIUS

:

.848

.772

.692

MAX RADIUS

:

1.503

1.213

1.179

HORIZONTAL SPREAD

:

2.447

1.933

1.933

VERTICAL SPREAD

:

1.543

1.543

.953

EXTREME SPREAD

:

2.580

2.043

2.021

NUMBER IN ONE INCH CIRCLE

=

2

NUMBER IN TWO INCH CIRCLE

=

7

NUMBER IN THREE INCH CIRCLE

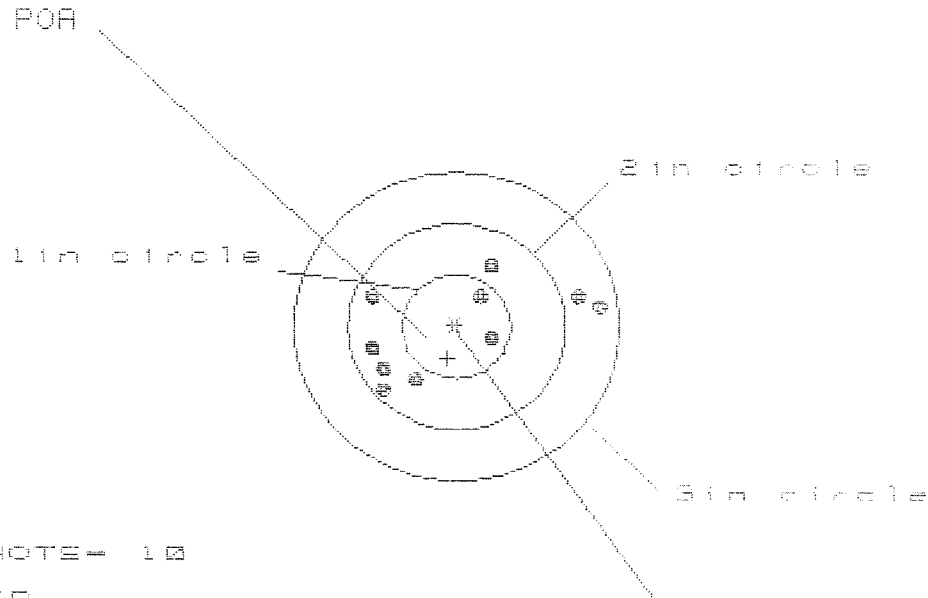
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9

17 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349004.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 2.135

VS = 1.177

GS = 2.150

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.253	.619
MINIMUM X	-.780	-.630	-.473
MAXIMUM Y	.588	.608	.653
MINIMUM Y	-.589	-.569	-.524
CENTROID X	.077	-.073	-.230
CENTROID Y	.307	.287	.242
POA TO CENTROID in.	.316	.296	.334
MIN RADIUS	.312	.446	.396
MEAN RADIUS	.776	.694	.591
MAX RADIUS	1.366	1.304	.900
HORIZONTAL SPREAD	2.135	1.883	1.092
VERTICAL SPREAD	1.177	1.177	1.177
EXTREME SPREAD	2.150	1.989	1.523
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	