

05349144

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

C6349144

REPAIRED 9/27/97

NEW BARREL ACTION

NEW SERIAL #

C6665805

Scanned
0602

GUN SERIAL # C6349144

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 - 9	89	RW
600	Proof	10 - 9	89	A.C.
607	Check Headspace	10 - 9	89	RW
610	Dis-assemble Gun	10 - 9	89	RW
612	Magnaflux Barrel Action		10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	10 1689		LB
618	Polish Barrel RB	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/89	958

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11/3/89	AL
	G) Safety Off Force	3	3	3			11/3/89	RL
	H) Trigger Pull Test & Retainability						3/15/89	JS
	I) Firing Pin Indent	.0215	.022	.022			11/3/89	QJ
	J) Assemble Stock						11/3/89	RW
	K) Assemble Swivel Studs						7/10/89	JS
	L) Attach Front and Rear Sight Assemblies						11/3/89	RW
	M) Iron Sight Alignment						11/3/89	RW
	N) Detach Front & Rear Sights & place in numbered container						11/3/89	RW
	O) Attach Scope to Rifle						11/6/89	QJ
	P) Detach & Attach Scope 20 Times						11/6/89	QJ
640	Gallery Target & Test						11-7-89	AC
	A) Time						11-7-89	AC
	B) Malfunctions						11-7-89	AC
	C) Pierced Primers						11-7-89	AC
	D) Optical Clarity of Scope						11-7-89	AC
645	Inspect for Live Ammo						11-7-89	AC
655	Final Inspection							
	A) Headspace						7/10/89	JS
	B) Trigger Pull	251	263	269	275	264	7/10/89	JS
	C) Function						7/10/89	JS
660	Pack						14/10/89	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. 06349144

DATE 4-10-90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.47		2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.34		2.55	
PULL #3	2.48	2.53		2.54	
PULL #4	2.49	2.54		2.58	
PULL #5	2.46	2.41		2.39	
TOTAL	12.33	12.29		12.62	
AVG.	2.466	2.458		2.524	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.43		
PULL #2	3.37	3.41		
PULL #3	3.38	3.19		
PULL #4	3.37	3.48		
PULL #5	3.46	3.43		
TOTAL	16.91	16.94		
AVG.	3.382	3.388		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.28		
PULL #2	4.33	4.32		
PULL #3	4.28	4.29		
PULL #4	4.31	4.35		
PULL #5	4.09	4.24		
TOTAL	21.26	21.48		
AVG.	4.252	4.296		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349144
17 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.0737835
1 TO	2	.265068
1 TO	3	.0940479
1 TO	4	.216393
1 TO	5	.944031

5

3

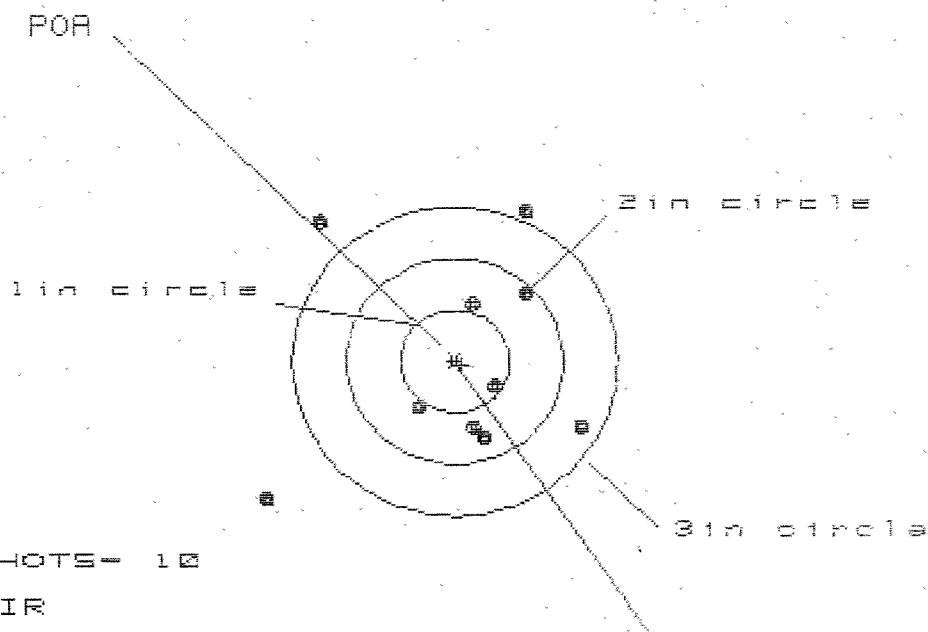
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1388
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .298
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .308750
THE AMR FOR THIS RIFLE IS: .8548

7 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8345144.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 7

HS= 2.956

VS= 2.781

GS= 3.720

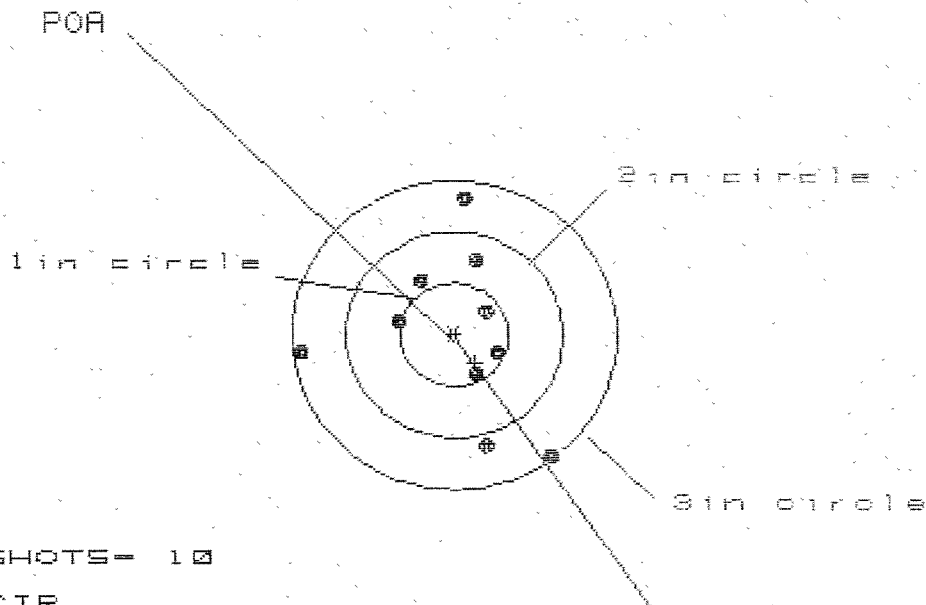
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.176	.979	.794
MINIMUM X	-1.780	-1.473	-.704
MAXIMUM Y	1.441	1.292	1.446
MINIMUM Y	-1.340	-.840	-.696
CENTROID X	-.062	.135	.320
CENTROID Y	.040	.189	.035
POA TO CENTROID in.	.074	.232	.322
MIN RADIUS	.419	.387	.197
MEAN RADIUS	1.082	.932	.770
MAX RADIUS	2.228	1.920	1.479
HORIZONTAL SPREAD	2.956	2.452	1.498
VERTICAL SPREAD	2.781	2.132	2.132
EXTREME SPREAD	3.720	3.189	2.179
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

7 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8345144.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.355

VS= 2.564

GS= 2.709

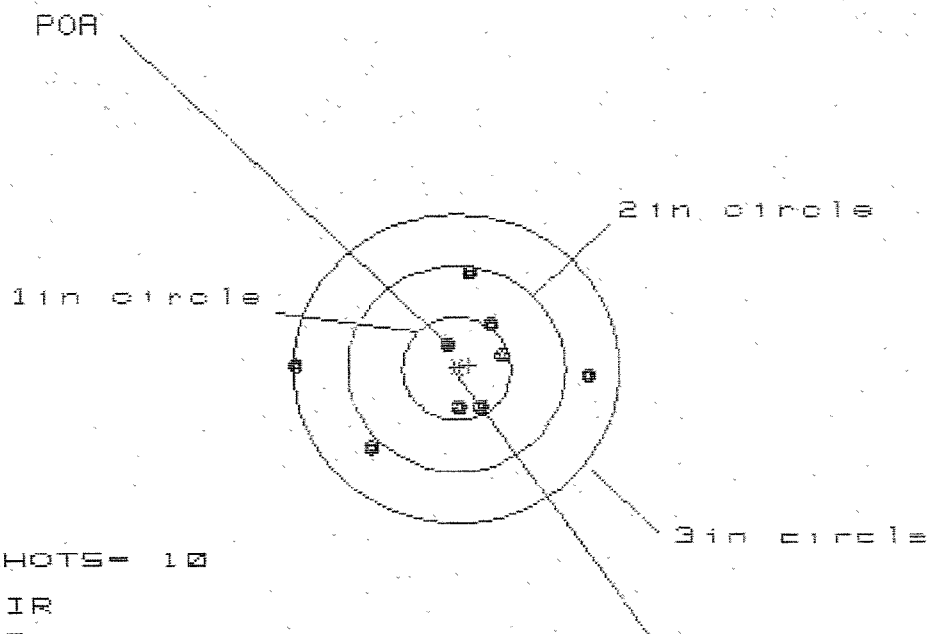
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.449	.284
MINIMUM X	:	-1.422	-1.318	-.613
MAXIMUM Y	:	1.378	1.246	1.212
MINIMUM Y	:	-1.186	-1.174	-1.208
CENTROID X	:	-.192	-.296	-.131
CENTROID Y	:	.271	.403	.436
POA TO CENTROID in.	:	.332	.500	.456
MIN RADIUS	:	.336	.382	.214
MEAN RADIUS	:	.849	.770	.674
MAX RADIUS	:	1.509	1.346	1.234
HORIZONTAL SPREAD	:	2.355	1.767	.897
VERTICAL SPREAD	:	2.564	2.420	2.420
EXTREME SPREAD	:	2.709	2.434	2.434
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8345144.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.774

VS= 1.729

CS= 2.778

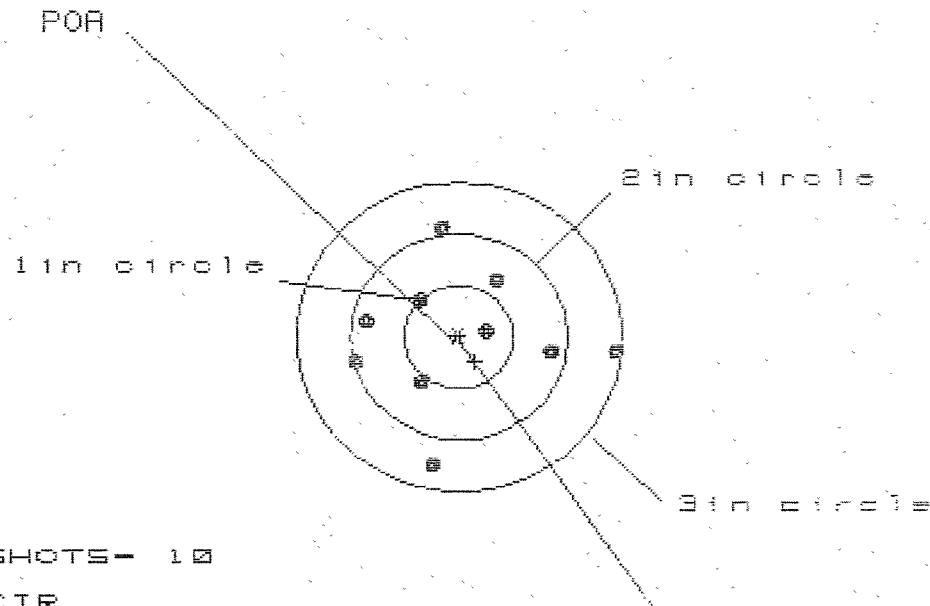
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.241
MINIMUM X	-1.533
MAXIMUM Y	.967
MINIMUM Y	-.762
CENTROID X	-.116
CENTROID Y	-.037
POA TO CENTROID in.	.122
MIN RADIUS	.278
MEAN RADIUS	.734
MAX RADIUS	1.535
HORIZONTAL SPREAD	2.774
VERTICAL SPREAD	1.729
EXTREME SPREAD	2.778
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

7 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B144.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.430

VS= 2.256

GS= 2.436

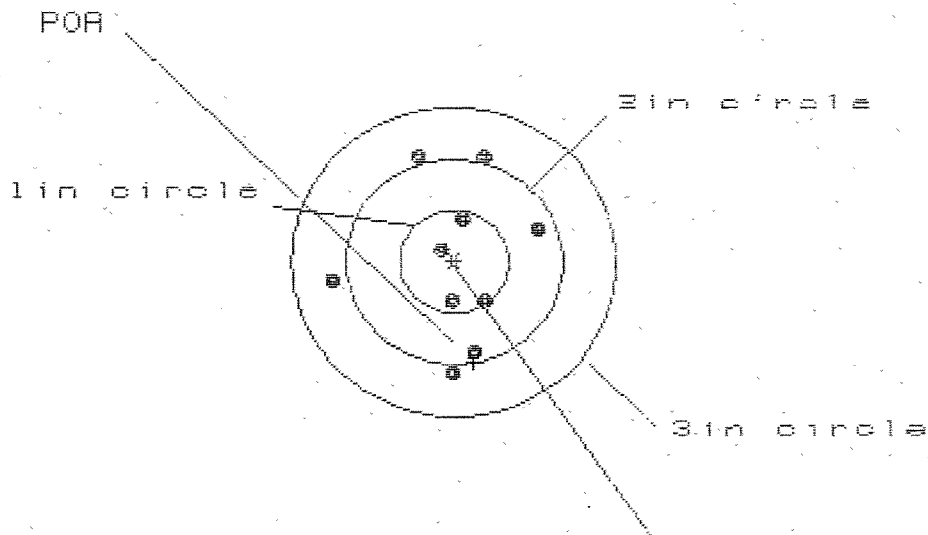
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.489	1.029	1.017
MINIMUM X	-.941	-.776	-.788
MAXIMUM Y	1.057	1.046	.895
MINIMUM Y	-1.198	-1.210	-.621
CENTROID X	-.147	-.312	-.380
CENTROID Y	.239	.251	.482
POA TO CENTROID in.	.281	.401	.502
MIN RADIUS	.253	.379	.269
MEAN RADIUS	.842	.755	.681
MAX RADIUS	1.492	1.214	1.049
HORIZONTAL SPREAD	2.430	1.805	1.805
VERTICAL SPREAD	2.256	2.256	1.516
EXTREME SPREAD	2.436	2.257	1.814
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

7 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6349144.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 5

3 in - 10

HS- 1.985

VS- 2.137

GS- 2.165

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.821	.691	.629
MINIMUM X	:	-1.164	-.496	-.342
MAXIMUM Y	:	1.057	1.038	1.095
MINIMUM Y	:	-1.080	-1.099	-.969
CENTROID X	:	-.177	-.047	.015
CENTROID Y	:	.977	.996	.866
POA TO CENTROID in.	:	.993	.997	.868
MIN RADIUS	:	.211	.308	.299
MEAN RADIUS	:	.767	.715	.648
MAX RADIUS	:	1.176	1.150	1.102
HORIZONTAL SPREAD	:	1.985	1.187	.971
VERTICAL SPREAD	:	2.137	2.137	2.064
EXTREME SPREAD	:	2.165	2.165	2.091
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	




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

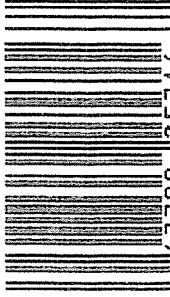
MODEL 700™ M24

SERIAL NO.
C6349144

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6349144