

C6349163

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349163

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	NEW Barrel 10/30/89 Magnaflux Barrel Action	REJECT	10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force						
	G) Safety Off Force						
	H) Trigger Pull Test & Retainability						
	I) Firing Pin Indent						
	J) Assemble Stock						
	K) Assemble Swivel Studs						
	L) Attach Front and Rear Sight Assemblies						
	M) Iron Sight Alignment						
	N) Detach Front & Rear Sights & place in numbered container						
	O) Attach Scope to Rifle						
	P) Detach & Attach Scope 20 Times						
640	Gallery Target & Test						
	A) Time						
	B) Malfunctions						
	C) Pierced Primers						
	D) Optical Clarity of Scope						
645	Inspect for Live Ammo						
655	Final Inspection A) Headspace						
	B) Trigger Pull						
	C) Function						
660	Pack						

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349163

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		11-2 89	RW
600	Proof		11-2 89	RW
607	Check Headspace		11-2 89	RW
610	Dis-assemble Gun		11-2 89	RW
612	Magnaflux Barrel Action		11-9-89	KCR
	Magnaflux Bolt		11-9-89	KCR
615	Rollmark Caliber			
17	Drill and Tap Sight Holes		11 9 89	YB
618	Polish Barrel RB		11 9 89	BT
620	Apply Coatings (Barrel Action)		11-17-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Dec 89	QDS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4 Dec 89	JDS
	G) Safety Off Force	3	3	3			4 Dec 89	JDS
	H) Trigger Pull Test & Retainability						4 Dec 89	JDS
	I) Firing Pin Indent	.021	.0215	.022			4 Dec 89	JDS
	J) Assemble Stock						12/4/89	RW
	K) Assemble Swivel Studs						6 Dec 89	JDS
	L) Attach Front and Rear Sight Assemblies						12/4/89	RW
	M) Iron Sight Alignment						12/4/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/89	RW
	O) Attach Scope to Rifle						4 Dec 89	JDS
	P) Detach & Attach Scope 20 Times						4 Dec 89	JDS
640	Gallery Target & Test						12-5-89	
	A) Time						12-5-89	
	B) Malfunctions						12-5-89	
	C) Pierced Primers						12-5-89	
	D) Optical Clarity of Scope						12-5-89	
645	Inspect for Live Ammo						12-5-89	
655	Final Inspection							
	A) Headspace						6 Dec 89	JDS
	B) Trigger Pull	2.79	2.75	2.73	2.70	2.71	6 Dec 89	JDS
	C) Function						6 Dec 89	JDS
660	Pack						15 Dec 89	JDS

RC-32

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349163

DATE 13 Mar 90

TESTER QSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.56		2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.58		2.79	
PULL #3	2.60	2.63		2.78	
PULL #4	2.56	2.50		2.74	
PULL #5	2.53	2.61		2.52	
TOTAL	12.61	12.88			
AVG.	2.522	2.576			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.14		
PULL #2	3.39	3.39		
PULL #3	3.42	3.42		
PULL #4	3.40	3.47		
PULL #5	3.15	3.40		
TOTAL	16.61	16.82		
AVG.	3.322	3.364		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.64	4.50		
PULL #2	4.50	4.44		
PULL #3	4.48	4.40		
PULL #4	4.42	4.41		
PULL #5	4.43	4.47		
TOTAL	22.87	22.22		
AVG.	4.578	4.444		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349163
5 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.381177
1 TO	2	.433046
1 TO	3	.672536
1 TO	4	.92618
1 TO	5	.570639

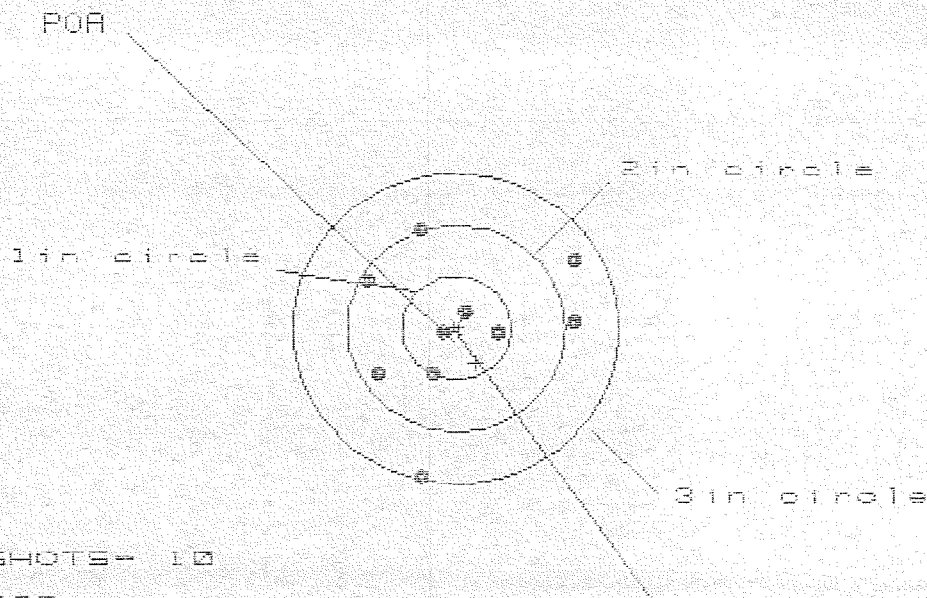
$\bar{x} = -0.429$ $\bar{y} = -0.1112$ $\bar{r} = 0.443178$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.429
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .443178
THE AMR FOR THIS RIFLE IS: .8526

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CB3481C3

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.936

VS= 2.369

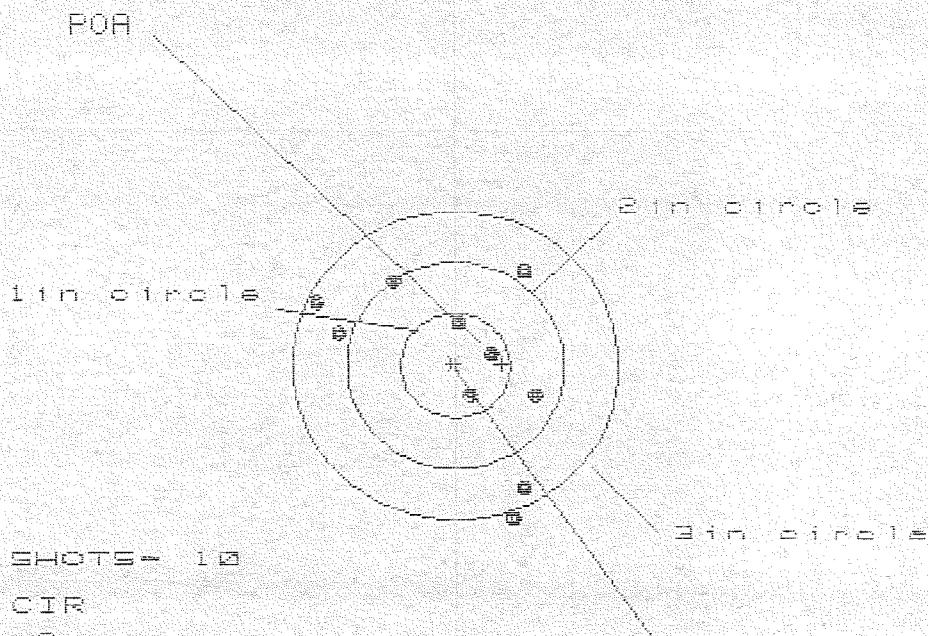
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PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	1.042	1.150
MINIMUM X	:	-.850	-.894	-.764
MAXIMUM Y	:	.948	.790	.856
MINIMUM Y	:	-1.421	-.605	-.539
CENTROID X	:	-.180	-.144	-.274
CENTROID Y	:	.336	.494	.428
POA TO CENTROID in.	:	.381	.514	.509
MIN RADIUS	:	.144	.088	.162
MEAN RADIUS	:	.777	.704	.635
MAX RADIUS	:	1.458	1.166	1.151
HORIZONTAL SPREAD	:	1.936	1.936	1.914
VERTICAL SPREAD	:	2.369	1.395	1.395
EXTREME SPREAD	:	2.529	2.131	1.964
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C83481B3

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 1.987

VS= 2.399

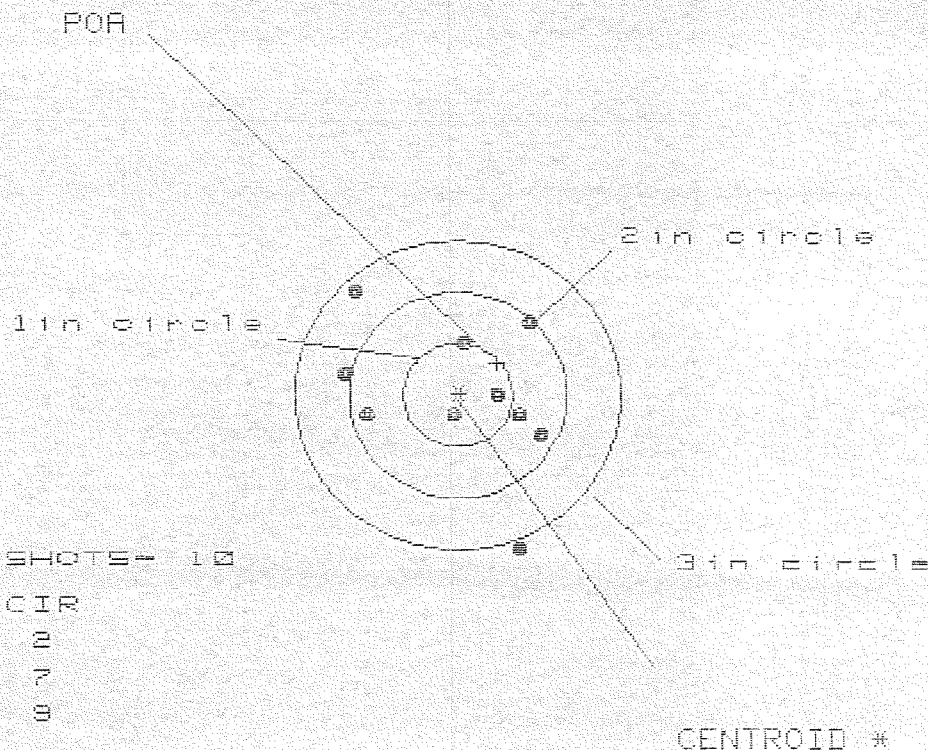
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PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.773	.621
MINIMUM X	:	-1.273	-1.214	-1.130
MAXIMUM Y	:	.948	.787	.840
MINIMUM Y	:	-1.451	-1.323	-1.270
CENTROID X	:	-.428	-.487	-.335
CENTROID Y	:	-.019	.142	.099
POA TO CENTROID in.	:	.429	.507	.347
MIN RADIUS	:	.320	.239	.273
MEAN RADIUS	:	.935	.854	.776
MAX RADIUS	:	1.545	1.477	1.366
HORIZONTAL SPREAD	:	1.987	1.987	1.751
VERTICAL SPREAD	:	2.399	2.110	2.110
EXTREME SPREAD	:	2.724	2.562	2.294
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6349163

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.840

VS= 2.507

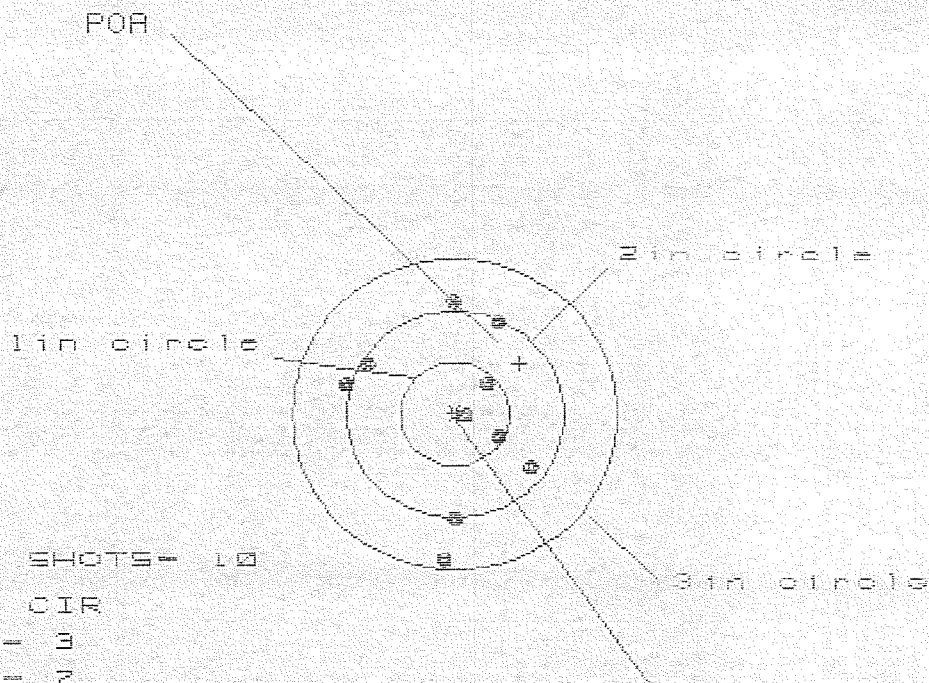
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PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.797	.855	.740
MINIMUM X	:	-1.040	-.985	-1.100
MAXIMUM Y	:	.973	.803	.692
MINIMUM Y	:	-1.534	-.514	-.414
CENTROID X	:	-.360	-.418	-.303
CENTROID Y	:	-.312	-.142	-.242
POA TO CENTROID in.	:	.476	.441	.388
MIN RADIUS	:	.184	.349	.268
MEAN RADIUS	:	.841	.759	.670
MAX RADIUS	:	1.620	1.217	1.109
HORIZONTAL SPREAD	:	1.840	1.840	1.840
VERTICAL SPREAD	:	2.507	1.317	1.046
EXTREME SPREAD	:	2.919	2.205	1.922
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Dec 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08349160

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.754

VS= 2.475

GS= 2.477

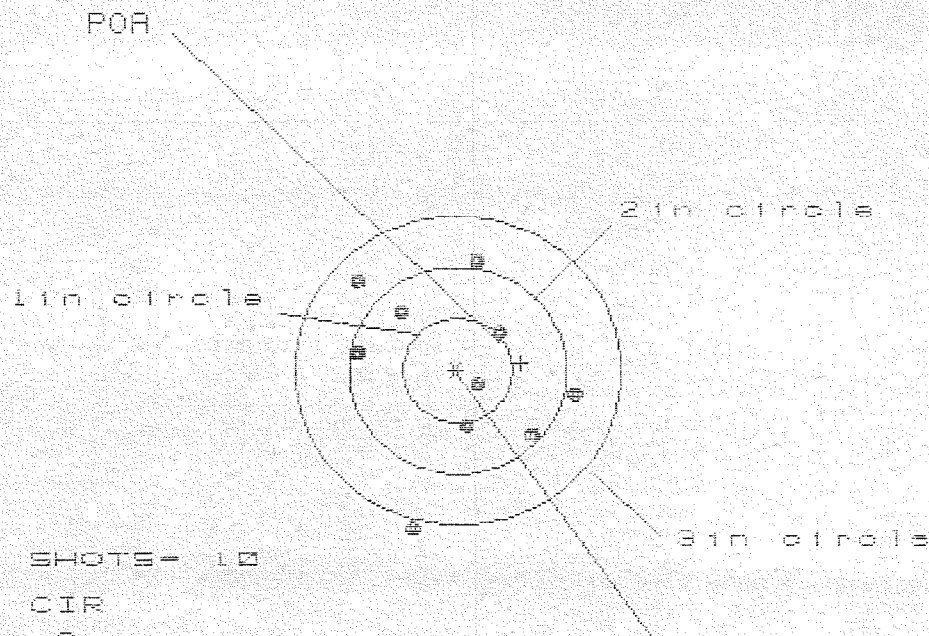
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.703	.694	.695
MINIMUM X	:	-1.051	-1.060	-1.059
MAXIMUM Y	:	1.101	.948	.961
MINIMUM Y	:	-1.374	-1.151	-1.032
CENTROID X	:	-.595	-.586	-.587
CENTROID Y	:	-.492	-.339	-.458
POA TO CENTROID in.	:	.772	.677	.744
MIN RADIUS	:	.082	.163	.079
MEAN RADIUS	:	.833	.764	.729
MAX RADIUS	:	1.377	1.151	1.088
HORIZONTAL SPREAD	:	1.754	1.754	1.754
VERTICAL SPREAD	:	2.475	2.099	1.893
EXTREME SPREAD	:	2.477	2.099	1.943
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Dec 1988

FILE: PATTERNING/CENTERFIRE_PATT/06349163

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.946

VS= 2.622

GS= 2.691

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.052
MINIMUM X	-0.894
MAXIMUM Y	1.059
MINIMUM Y	-1.563
CENTROID X	-0.582
CENTROID Y	-0.069
POA TO CENTROID in.	.586
MIN RADIUS	.240
MEAN RADIUS	.878
MAX RADIUS	1.609
HORIZONTAL SPREAD	1.946
VERTICAL SPREAD	2.622
EXTREME SPREAD	2.691
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9



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

MODEL 700™ H24	SERIAL NO. C6349163
	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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