

C6349210

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



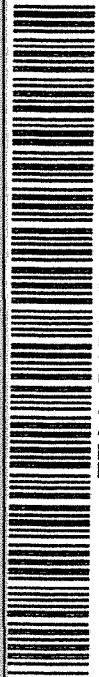

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

SERIAL NO.
C6349210

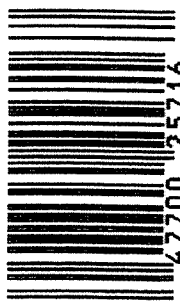
ORDER NO.
5716

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



5716 C6349210

UPC



0 47700 25716 7

RC -10

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349210

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 12 90	RW
600	Proof		1 12 90	K
607	Check Headspace		1 12 90	K
610	Dis-assemble Gun		1 12 90	RW
612	Magnaflux Barrel Action		1-16-90	KCR
	Magnaflux Bolt		1-17-90	KCR
615	Rollmark Caliber		1-17-90	GS
617	Drill and Tap Sight Holes		1-19-90	FB
618	Polish Barrel RB		1-22-90	WB
620	Apply Coatings (Barrel Action)		1-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/24/90 1/24/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/24/90	RW
	C) Inspect Ejector Hole for Chamfer		1/24/90	RW
	D) Oil Firing Pin Ass'y		1/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/1/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2-2-90	JH
	G) Safety Off Force	2	2	2			2-2-90	JH
	H) Trigger Pull Test & Retainability						3/1/90	WB
	I) Firing Pin Indent	.0205	.0205	.0205			2-2-90	JH
	J) Assemble Stock						2/28/90	RW
	K) Assemble Swivel Studs						3/16/90	WB
	L) Attach Front and Rear Sight Assemblies						2/28/90	RW
	M) Iron Sight Alignment						2/28/90	RW
	N) Detach Front & Rear Sights & place in numbered container						2/28/90	RW
	O) Attach Scope to Rifle						2/28/90	WB
	P) Detach & Attach Scope 20 Times						2/28/90	WB
640	Gallery Target & Test						3-1-90	AC
	A) Time						3-1-90	AC
	B) Malfunctions						3-1-90	AC
	C) Pierced Primers						3-1-90	AC
	D) Optical Clarity of Scope						3-1-90	AC
645	Inspect for Live Ammo						3-1-90	AC
655	Final Inspection						3/12/90	WB
	A) Headspace							
	B) Trigger Pull	2.64	2.50	2.59	2.57	2.57	3/12/90	6.8
	C) Function						3/12/90	WB
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349210

DATE 31 Jan 90

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.45	2.55	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.35	2.44	2.50	
PULL #3	2.24	2.36	2.35	2.59	
PULL #4	2.19	2.26	2.42	2.57	
PULL #5	2.19	2.25	2.38	2.57	
TOTAL	11.28	11.67	12.14		
AVG.	2.256	2.334	2.428		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.06		
PULL #2	3.34	3.22		
PULL #3	3.28	3.28		
PULL #4	3.30	3.35		
PULL #5	3.35	3.27		
TOTAL	16.62	16.15		
AVG.	3.324	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.17		4.12
PULL #2	4.24	4.22		4.19
PULL #3	4.24	4.28		4.09
PULL #4	4.17	4.12		4.06
PULL #5	4.24	4.21		4.17
TOTAL	21.03	21.00		20.63
AVG.	4.206	4.20		4.126

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349210
2 Mar 1990

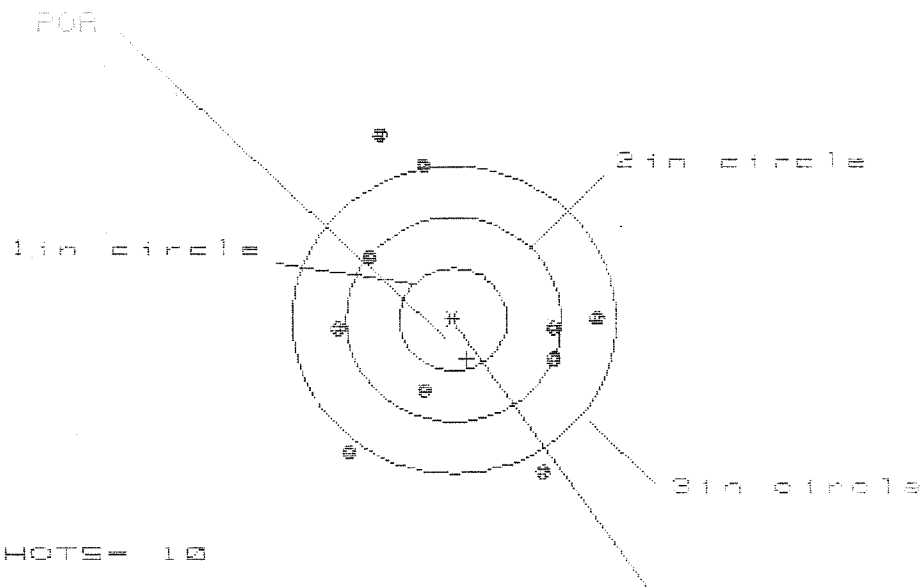
CENTROIDAL DISTANCES

0 TO	1	.405428
1 TO	2	.307747
1 TO	3	.931539
1 TO	4	.771602
1 TO	5	.273543

3 4 <----POA

POA X-COORDINATE FOR THIS RIFLE IS: -.2992
POA Y-COORDINATE FOR THIS RIFLE IS: .0616
POA AVERAGE POI RADIUS FOR THIS RIFLE IS: .305475
POA THIS RIFLE IS: 1.088

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 2.324

VS= 3.251

GS= 3.567

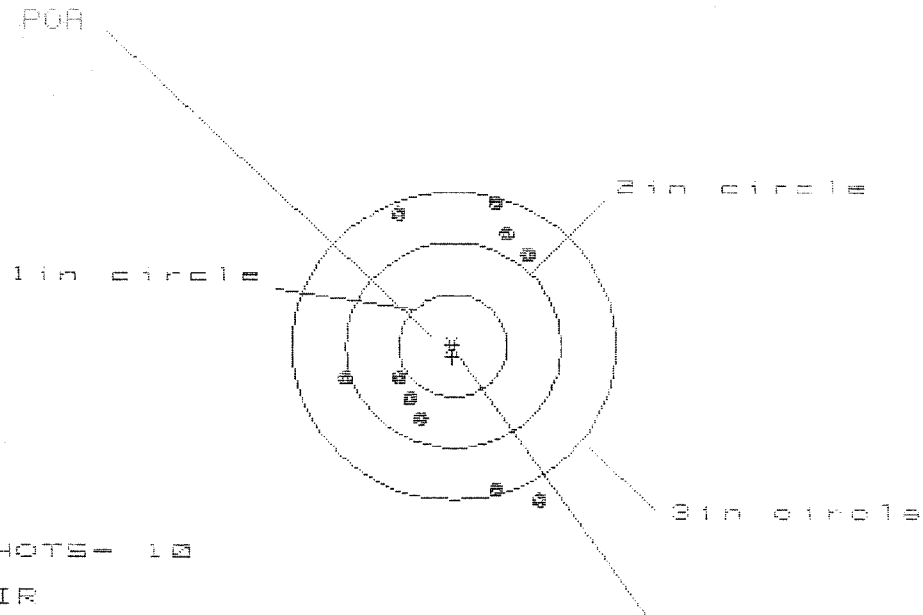
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.281	1.208	1.074
MINIMUM X	:	-1.043	-1.116	-1.250
MAXIMUM Y	:	1.807	1.698	1.557
MINIMUM Y	:	-1.444	-1.243	-1.384
CENTROID X	:	-.124	-.051	.083
CENTROID Y	:	.386	.185	.326
CENTROID IN.	:	.405	.192	.337
SPREAD	:	.707	.566	.734
SPREAD	:	1.272	1.174	1.114
SPREAD	:	1.922	1.731	1.626
SPREAD	:	2.324	2.324	2.324
SPREAD	:	3.251	2.941	2.941
SPREAD	:	3.567	3.133	3.133
ONE INCH CIRCLE	=	0		
TWO INCH CIRCLE	=	4		
THREE INCH CIRCLE	=	6		

1992

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 8

CENTROID %

HS = 1.802

VS = 2.839

GS = 3.068

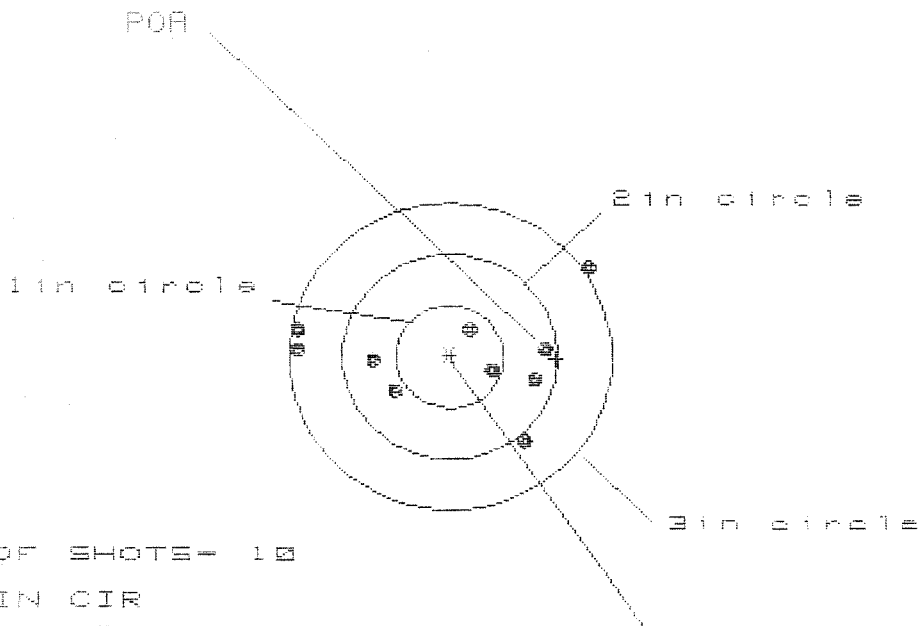
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.735	.799
MINIMUM X	:	-.996	-.906	-.842
MAXIMUM Y	:	1.353	1.188	.994
MINIMUM Y	:	-1.486	-1.551	-1.028
CENTROID X	:	.008	-.082	-.146
CENTROID Y	:	.108	.273	.467
WIND CENTROID Y	:	.108	.285	.489
WIND CENTROID	:	.567	.601	.723
WIND RADIUS	:	1.114	1.042	.964
WIND RADIUS	:	1.691	1.634	1.127
WIND RADIUS SPREAD	:	1.882	1.641	1.641
WIND RADIUS SPREAD	:	2.839	2.739	2.022
WIND RADIUS SPREAD	:	3.068	2.826	2.140
WIND RADIUS SPREAD INCH CIRCLE	=		0	
WIND RADIUS SPREAD INCH CIRCLE	=		3	
WIND RADIUS SPREAD INCH CIRCLE	=		9	

MAY 1988

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CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

CENTROID #

HS= 2.673

VS= 1.724

GS= 2.770

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.238	1.002	.846
MINIMUM X	:	-1.435	-1.297	-1.424
MAXIMUM Y	:	.898	.400	.413
MINIMUM Y	:	-.826	-.726	-.676
CENTROID X	:	-.984	-1.122	-.960
CENTROID Y	:	.028	-.072	-.122
POR TO CENTROID in.	:	.985	1.124	.967
MIN RADIUS	:	.346	.459	.336
MAX RADIUS	:	.922	.856	.766
AVG RADIUS	:	1.530	1.358	1.439
HORIZONTAL SPREAD	:	2.673	2.299	2.264
VERTICAL SPREAD	:	1.724	1.126	1.089
DIAGONAL SPREAD	:	2.770	2.417	2.281
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

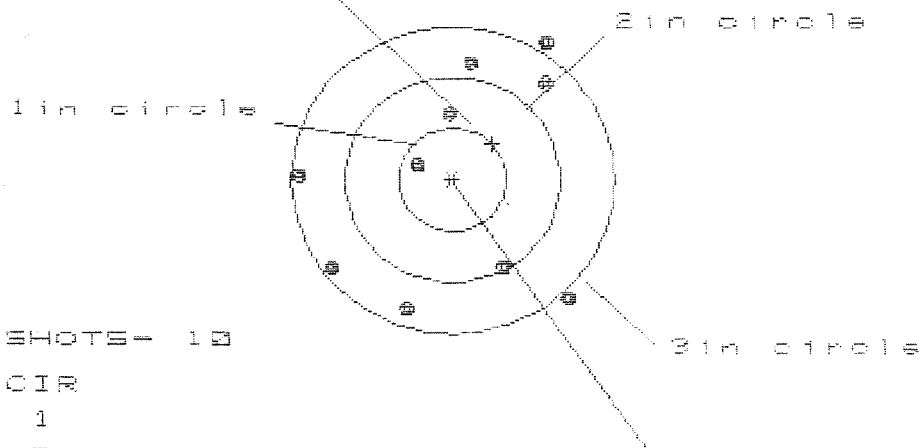
1 MAR 1988

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CENTERFIRE PATTERNS

4

POB



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.514

VS= 2.531

QS= 2.945

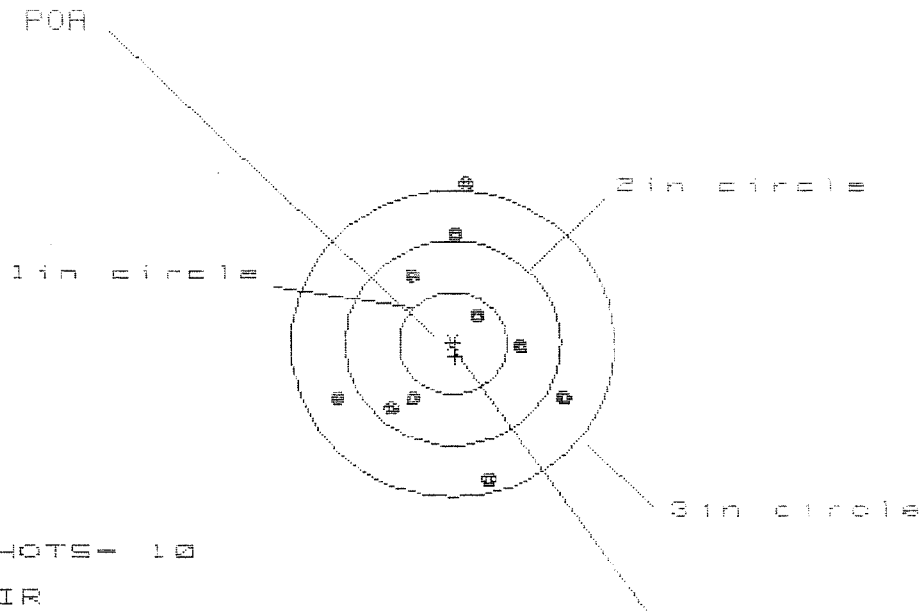
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.104	1.030	1.149
MINIMUM X	:	-1.410	-1.288	-1.168
MAXIMUM Y	:	1.295	1.165	1.135
MINIMUM Y	:	-1.236	-1.366	-1.220
CENTROID X	:	-.371	-.493	-.612
CENTROID Y	:	-.345	-.215	-.360
POA TO CENTROID IN.	:	.507	.538	.711
MIN RADIUS	:	.370	.230	.170
MEAN RADIUS	:	1.172	1.094	1.035
MAX RADIUS	:	1.612	1.505	1.477
HORIZONTAL SPREAD	:	2.514	2.318	2.318
VERTICAL SPREAD	:	2.531	2.531	2.355
EXTENS SPREAD	:	2.945	2.945	2.736
SHOTS IN ONE INCH CIRCLE	=		1	
SHOTS IN TWO INCH CIRCLE	=		3	
SHOTS IN THREE INCH CIRCLE	=		6	

1 Mar 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 0

HS = 2.135

VS = 2.923

GS = 2.926

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.016	1.035	1.074
MINIMUM X	:	-1.119	-1.100	-1.061
MAXIMUM Y	:	1.570	1.286	1.139
MINIMUM Y	:	-1.353	-1.179	-1.622
CENTROID X	:	-.025	-.044	-.083
CENTROID Y	:	.131	-.043	.104
POA TO CENTROID in.	:	.134	.061	.133
MIN RADIUS	:	.309	.457	.368
MEAN RADIUS	:	.962	.885	.833
MAX RADIUS	:	1.579	1.286	1.190
HORIZONTAL SPREAD	:	2.135	2.135	2.135
VERTICAL SPREAD	:	2.923	2.465	1.761
EXTREME SPREAD	:	2.926	2.484	2.136
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	