

C6349218

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Remington[®]

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

MODEL 700TM H24

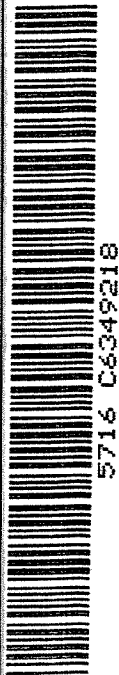
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6349218

ORDER NO.
5716

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

Ø1



RC51

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349218

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12 90		RW
600	Proof	1 12 90		f
607	Check Headspace	1 12 90		f
610	Dis-assemble Gun	1 12 90		RW
612	Magnaflux Barrel Action	1-16-90		KER
	Magnaflux Bolt	1-17-90		KER
615	Rollmark Caliber	1-17-90		ES
617	Drill and Tap Sight Holes	1-19-90		LB
618	Polish Barrel RB	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-30-90	TJA
	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		12/1/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2-1-90	RL
	G) Safety Off Force	3	3	3			2-1-90	RL
	H) Trigger Pull Test & Retainability						12/1/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			2-1-90	RL
	J) Assemble Stock						3/1/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						3/1/90	RL
	M) Iron Sight Alignment						3/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/1/90	RW
	O) Attach Scope to Rifle						3/1/90	WB
	P) Detach & Attach Scope 20 Times						3/1/90	WB
640	Gallery Target & Test						3-2-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						3-2-90	A
655	Final Inspection							
	A) Headspace						16 Mar 90	RL
	B) Trigger Pull	228	226	227	230	230	16 Mar 90	RL
	C) Function						16 Mar 90	RL
660	Pack						19 Mar 90	RL

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349218
DATE 1/7/90
TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.35	2.12	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.41	2.24	2.26	
PULL #3	2.29	2.37	2.13	2.27	
PULL #4	2.36	2.44	2.08	2.30	
PULL #5	2.19	2.29	2.18	2.30	
TOTAL	11.41	11.86	10.75	11.41	
AVG.	2.282	2.372	2.15	2.282	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.30		
PULL #2	3.56	3.41		
PULL #3	3.43	3.39		
PULL #4	3.38	3.35		
PULL #5	3.32	3.33		
TOTAL	17.13	16.88		
AVG.	3.426	3.376		

	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		4.24
PULL #2	4.24	4.19		4.33
PULL #3	4.23	4.06		4.37
PULL #4	4.32	4.22		4.31
PULL #5	4.06	4.00		4.25
TOTAL	20.99	20.64		21.50
AVG.	4.198	4.128		4.30

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349218
3 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.314951
1 TO	2	.452866
1 TO	3	.469141
1 TO	4	.15741
1 TO	5	.346931

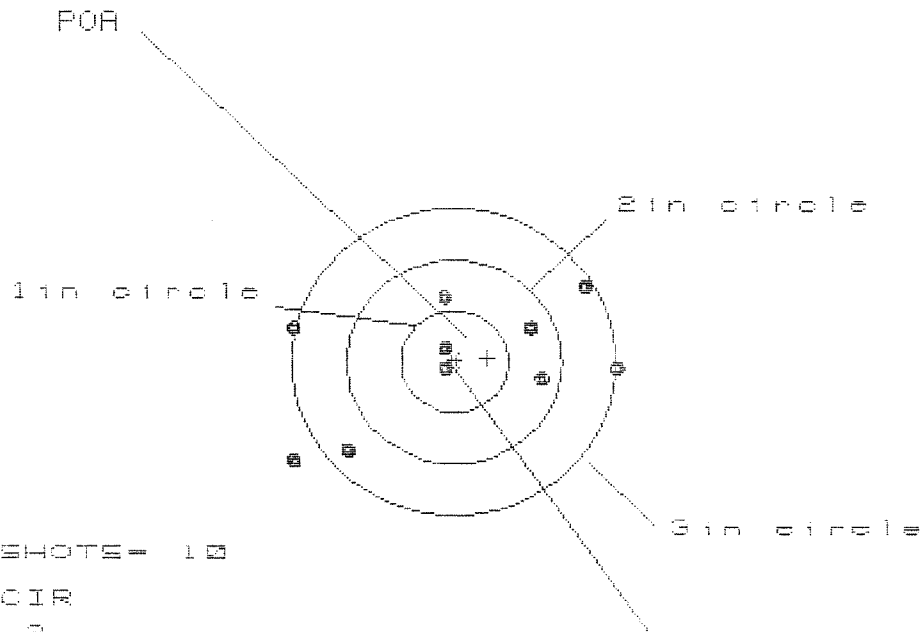
POA <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0426
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0794
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0901062
THE AMP FOR THIS RIFLE IS: 1.044

2 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349218

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.036

VS= 1.724

GS= 3.195

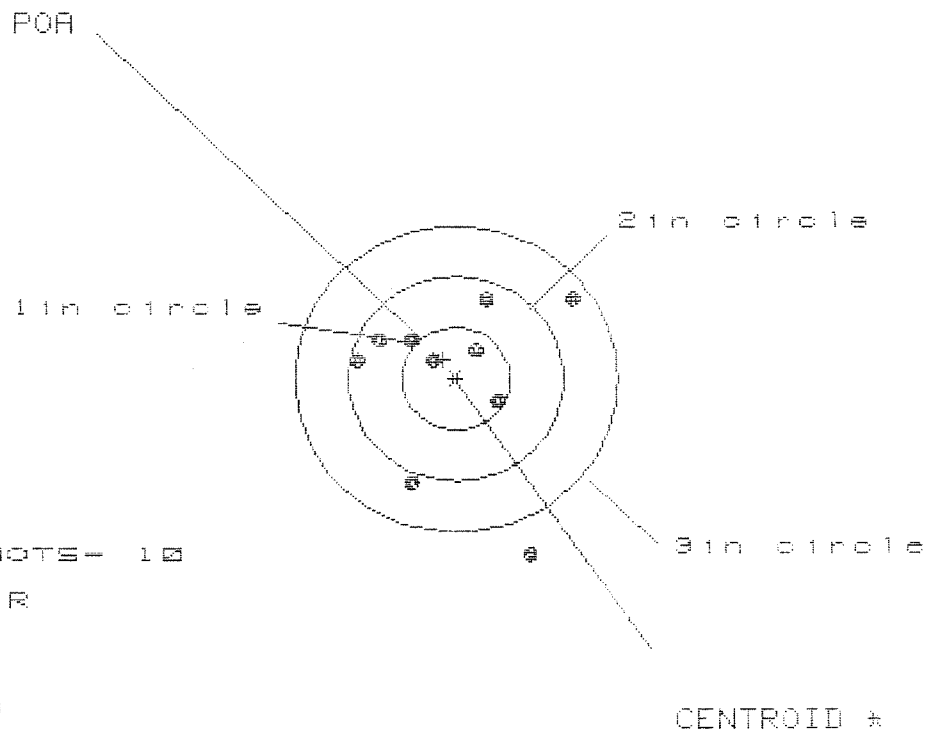
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.501	1.336	1.124
MINIMUM X	-1.535	-1.700	-1.411
MAXIMUM Y	.755	.648	.676
MINIMUM Y	-.969	-.988	-.960
CENTROID X	-.313	-.148	.064
CENTROID Y	-.035	.072	.044
POA TO CENTROID in.	.315	.165	.078
MIN RADIUS	.085	.210	.423
MEAN RADIUS	1.007	.912	.804
MAX RADIUS	1.767	1.715	1.707
HORIZONTAL SPREAD	3.036	3.036	2.535
VERTICAL SPREAD	1.724	1.636	1.636
EXTREME SPREAD	3.195	3.056	2.779
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

2 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8348218

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.984

VS= 2.493

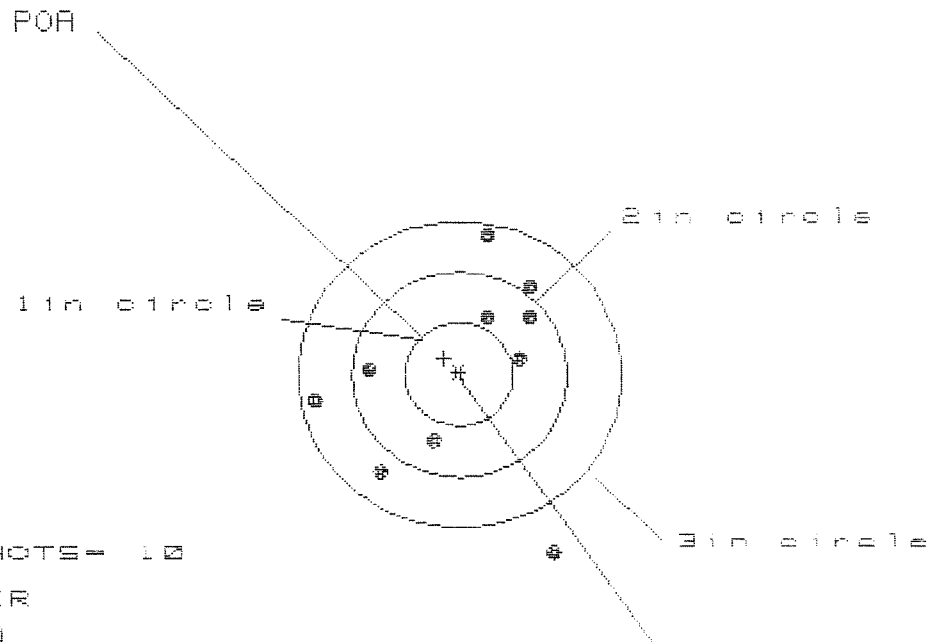
GS= 2.547

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.090	1.168	.569
MINIMUM X	-.894	-.816	-.670
MAXIMUM Y	.800	.612	.679
MINIMUM Y	-1.693	-1.166	-1.089
CENTROID X	.115	.037	-.109
CENTROID Y	-.183	.005	-.072
POA TO CENTROID in.	.217	.037	.131
MIN RADIUS	.244	.108	.065
MEAN RADIUS	.828	.668	.577
MAX RADIUS	1.834	1.319	1.100
HORIZONTAL SPREAD	1.984	1.984	1.239
VERTICAL SPREAD	2.493	1.778	1.768
EXTREME SPREAD	2.547	2.304	1.892
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 2.162

VS= 3.109

GS= 3.162

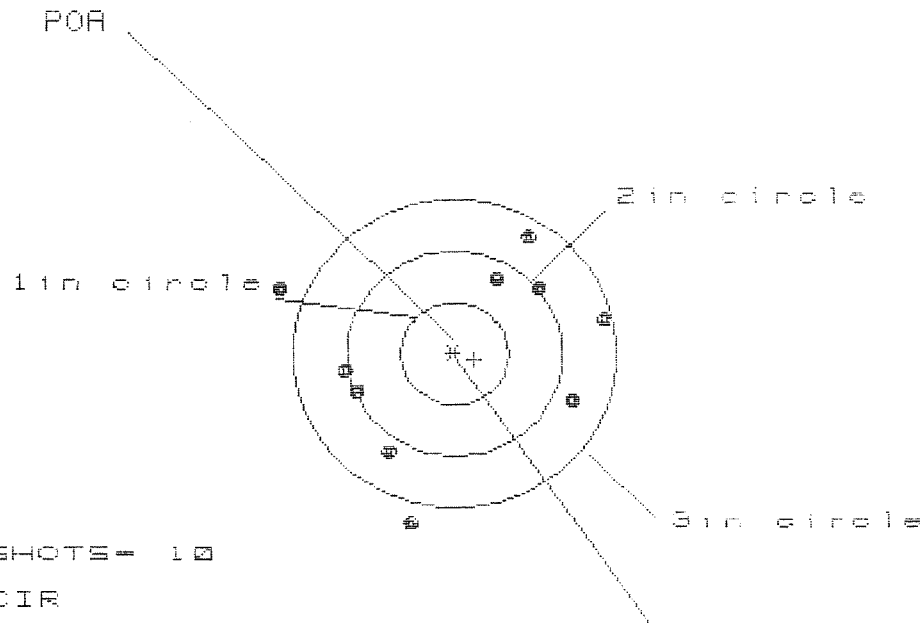
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.832	.754	.798
MINIMUM X	:	-1.338	-1.238	-1.194
MAXIMUM Y	:	1.371	1.178	.761
MINIMUM Y	:	-1.738	-1.129	-.982
CENTROID X	:	.140	.048	.004
CENTROID Y	:	-.157	.036	-.111
POA TO CENTROID in.	:	.210	.060	.111
MIN RADIUS	:	.563	.499	.642
MEAN RADIUS	:	1.036	.918	.879
MAX RADIUS	:	1.927	1.317	1.219
HORIZONTAL SPREAD	:	2.162	1.992	1.992
VERTICAL SPREAD	:	3.109	2.387	1.743
EXTREME SPREAD	:	3.162	2.525	2.256
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Mar 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 3.004

VS= 2.817

GS= 3.016

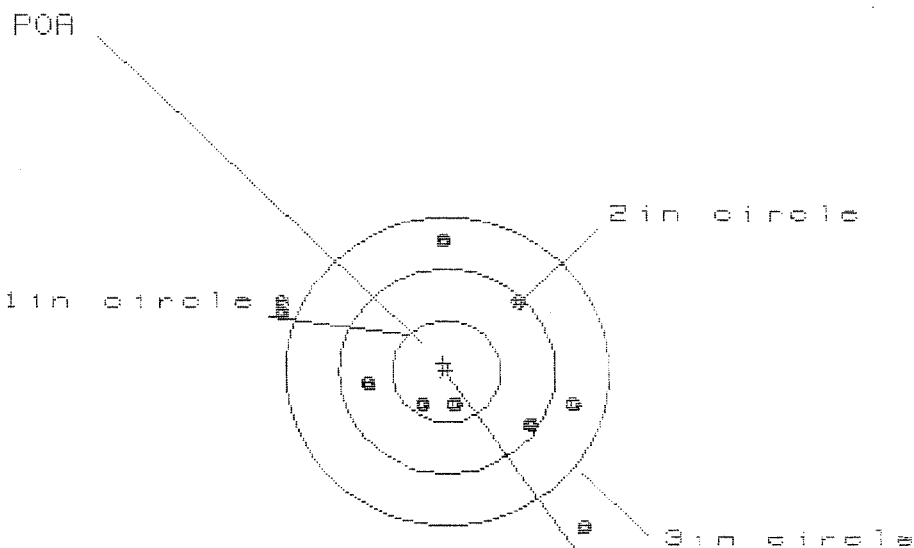
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.257	1.195
MINIMUM X	:	-1.573	-1.169	-1.240
MAXIMUM Y	:	1.179	1.247	1.051
MINIMUM Y	:	-1.638	-1.570	-1.076
CENTROID X	:	-.186	-.012	.059
CENTROID Y	:	.058	-.010	.186
POA TO CENTROID in.	:	.195	.016	.195
MIN RADIUS	:	.884	.885	.677
MEAN RADIUS	:	1.242	1.182	1.088
MAX RADIUS	:	1.688	1.669	1.353
HORIZONTAL SPREAD	:	3.004	2.426	2.426
VERTICAL SPREAD	:	2.817	2.817	2.127
EXTREME SPREAD	:	3.016	3.007	2.457
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.789

VS= 2.776

GS= 3.588

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.245	1.287	1.111
MINIMUM X	:	-1.544	-1.405	-1.524
MAXIMUM Y	:	1.236	1.065	1.133
MINIMUM Y	:	-1.540	-.657	-.589
CENTROID X	:	.031	-.108	.068
CENTROID Y	:	-.080	.091	.023
POA TO CENTROID in.	:	.086	.141	.072
MIN RADIUS	:	.330	.527	.424
MEAN RADIUS	:	1.105	1.021	.933
MAX RADIUS	:	1.980	1.508	1.606
HORIZONTAL SPREAD	:	2.789	2.692	2.635
VERTICAL SPREAD	:	2.776	1.722	1.722
EXTREME SPREAD	:	3.588	2.898	2.806
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	