

C65222205

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

SERIAL NO.
C6522205

ORDER NO.
5716

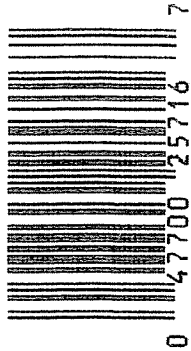
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6522205

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522205
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.28517
1 TO	2	.317043
1 TO	3	.34783
1 TO	4	.154042
1 TO	5	.414706

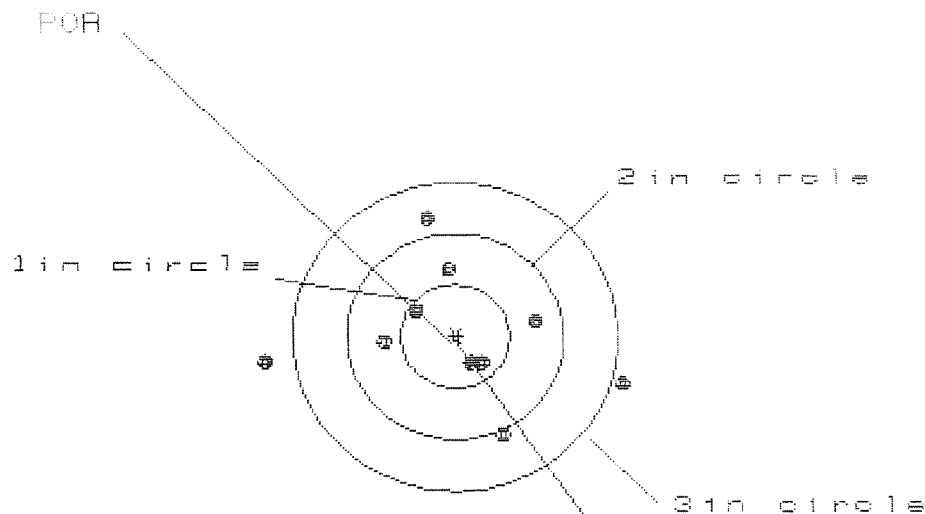
$\frac{H}{25}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0124
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0888693
THE BAK FOR THIS RIFLE IS: 1.082

7 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6322285

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.364

VS= 2.069

GS= 3.373

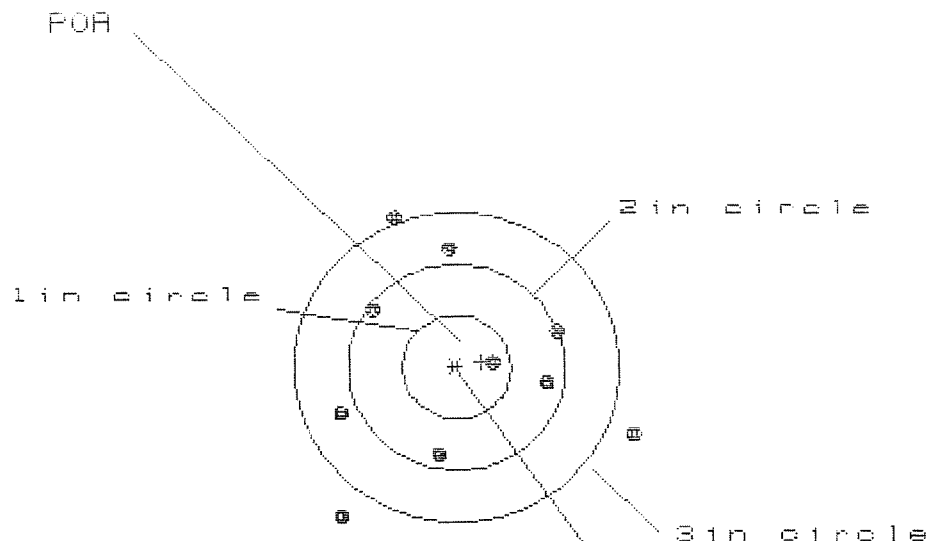
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.584	1.387	.734
MINIMUM X	-1.780	-.842	-.669
MAXIMUM Y	1.137	1.114	1.054
MINIMUM Y	-.932	-.955	-1.015
CENTROID X	-.139	.058	-.115
CENTROID Y	.249	.272	.332
POR TO CENTROID in.	.285	.278	.351
MIN RADIUS	.302	.287	.370
MEAN RADIUS	.874	.768	.665
MAX RADIUS	1.791	1.467	1.090
HORIZONTAL SPREAD	3.364	2.229	1.403
VERTICAL SPREAD	2.069	2.069	2.069
EXTREME SPREAD	3.373	2.431	2.175
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522205

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.752

VS= 2.929

GS= 3.087

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.656	1.535	.975
MINIMUM X	:	-1.096	-1.203	-1.012
MAXIMUM Y	:	1.495	1.335	1.232
MINIMUM Y	:	-1.434	-.990	-1.093
CENTROID X	:	-.229	-.108	-.299
CENTROID Y	:	-.055	.105	.208
POA TO CENTROID in.	:	.236	.150	.365
MIN RADIUS	:	.364	.282	.500
MEAN RADIUS	:	1.143	1.045	.965
MAX RADIUS	:	1.805	1.744	1.320
HORIZONTAL SPREAD	:	2.752	2.738	1.987
VERTICAL SPREAD	:	2.929	2.325	2.325
EXTREME SPREAD	:	3.087	3.087	2.362
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Sep 1998

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 3.351

VS= 3.389

GS= 3.611

CENTROID #

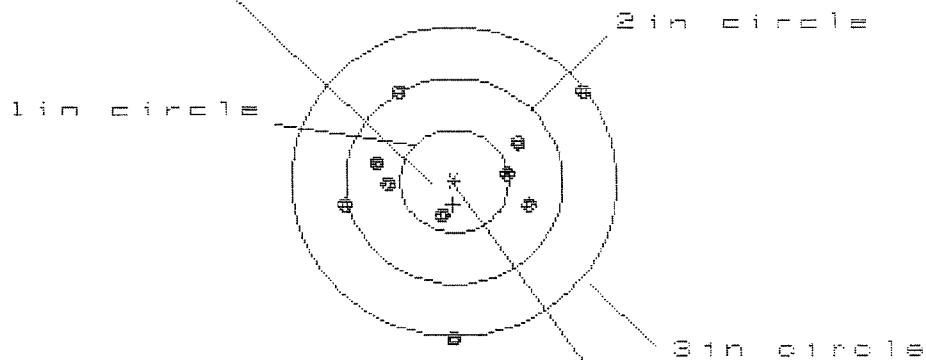
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.619
MINIMUM X	-1.732
MAXIMUM Y	1.549
MINIMUM Y	-1.840
CENTROID X	.066
CENTROID Y	-.032
POA TO CENTROID in.	.074
MIN RADIUS	.152
MEAN RADIUS	1.370
MAX RADIUS	2.049
HORIZONTAL SPREAD	3.351
VERTICAL SPREAD	3.389
EXTREME SPREAD	3.611
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 3
NUMBER IN THREE INCH CIRCLE	= 5

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FILE:/PATTERNING/CENTERFIRE_PATT/C6522205

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.223

VS = 2.366

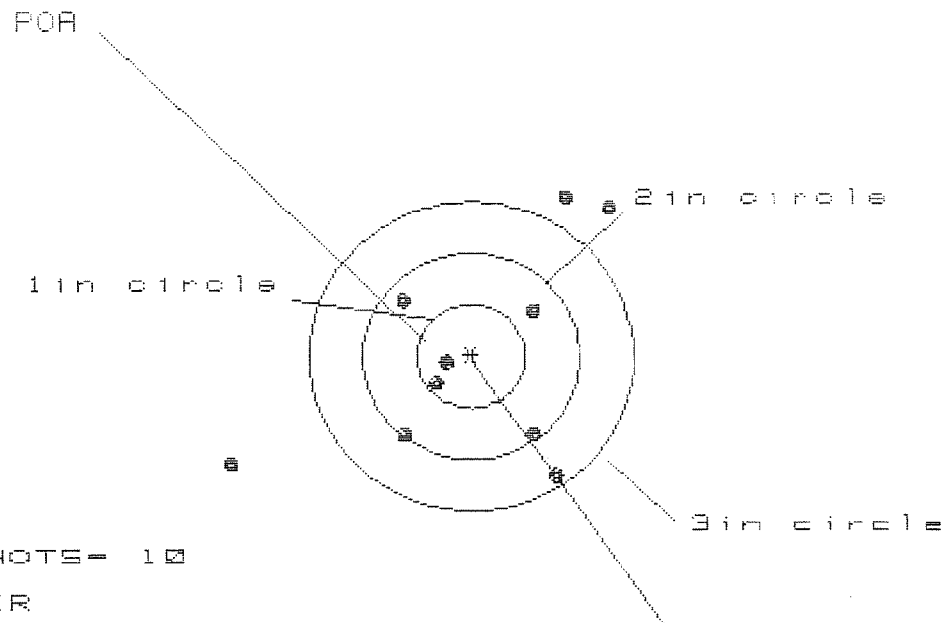
GS = 2.682

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.231	1.226	.811
MINIMUM X	:	-.992	-.997	-.844
MAXIMUM Y	:	.856	.688	.773
MINIMUM Y	:	-1.510	-.449	-.364
CENTROID X	:	.013	.018	-.135
CENTROID Y	:	.224	.392	.307
POA TO CENTROID in.	:	.225	.392	.335
MIN RADIUS	:	.288	.454	.373
MEAN RADIUS	:	.861	.790	.693
MAX RADIUS	:	1.511	1.403	.913
HORIZONTAL SPREAD	:	2.223	2.223	1.655
VERTICAL SPREAD	:	2.366	1.137	1.137
EXTREME SPREAD	:	2.682	2.487	1.733
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.426

VS= 2.714

GS= 4.251

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.229	.985	.775
MINIMUM X	:	-2.197	-.909	-.786
MAXIMUM Y	:	1.564	1.444	1.609
MINIMUM Y	:	-1.150	-1.270	-1.105
CENTROID X	:	.227	.471	.348
CENTROID Y	:	.054	.174	.009
FOR TO CENTROID in.	:	.233	.502	.348
MIN RADIUS	:	.255	.464	.367
MEAN RADIUS	:	1.160	1.039	.919
MAX RADIUS	:	2.447	1.645	1.786
HORIZONTAL SPREAD	:	3.426	1.894	1.561
VERTICAL SPREAD	:	2.714	2.714	2.714
EXTREME SPREAD	:	4.251	2.844	2.747
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522205

DATE 8/31/90

TESTER RJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.28	2.18	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.32	2.12	2.38	
PULL #3	2.32	2.31	2.12	2.56	
PULL #4	2.35	2.31	2.13	2.45	
PULL #5	2.33	2.27	2.14	2.49	
TOTAL	11.56	11.43	10.71		
AVG.	2.312	2.286	2.142		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.08		
PULL #2	3.13	3.12		
PULL #3	3.10	3.13		
PULL #4	3.10	3.08		
PULL #5	3.11	3.13		
TOTAL	15.48	15.54		
AVG.	3.096	3.108		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	3.94		4.13
PULL #2	3.90	4.02		4.11
PULL #3	3.90	4.08		4.06
PULL #4	3.89	4.09		4.05
PULL #5	4.10	4.06		4.08
TOTAL	19.76	20.19		20.43
AVG.	3.952	4.038		4.086

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522205

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	BS.
617	Drill and Tap Sight Holes		8/10/90	FEB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	RA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	CS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/5/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/5/90	WB
	H) Trigger Pull Test & Retainability						8/31/90	GB
	I) Firing Pin Indent	.023	.024	.0235			9/5/90	WB
	J) Assemble Stock						9/5/90	RW
	K) Assemble Swivel Studs						9/9/90	928
	L) Attach Front and Rear Sight Assemblies						9/5/90	RW
	M) Iron Sight Alignment						9/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/90	RW
	O) Attach Scope to Rifle						9/5/90	RW
	P) Detach & Attach Scope 20 Times						9/5/90	RW
640	Gallery Target & Test						9-7-90	AC
	A) Time						9-7-90	AC
	B) Malfunctions						9-7-90	AC
	C) Pierced Primers						9-7-90	AC
	D) Optical Clarity of Scope						9-7-90	AC
645	Inspect for Live Ammo						9-7-90	AC
655	Final Inspection							
	A) Headspace						9/9/90	928
	B) Trigger Pull	252	238	256	245	249	9/9/90	928
	C) Function						9/9/90	928
660	Pack						9-19-90	DM