

C6523324

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.

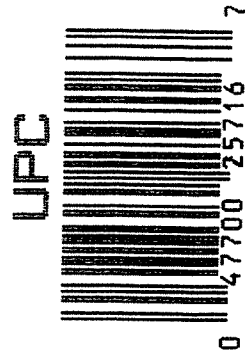
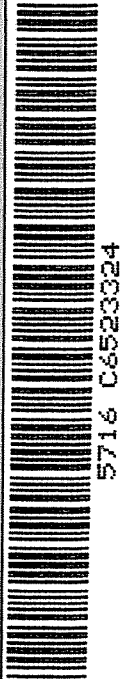
MODEL 700™ M24

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

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

SERIAL NO. C6523324	ORDER NO. 5716
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Ø1



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523324

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	GL
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel	LB	10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4			11/6/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/6/90	WB
	H) Trigger Pull Test & Retainability						11-6-90	JH
	I) Firing Pin Indent	.0205	.021	.021			11/6/90	WB
	J) Assemble Stock						11/6/90	RW
	K) Assemble Swivel Studs						11/19/90	Q28
	L) Attach Front and Rear Sight Assemblies						11/6/90	RW
	M) Iron Sight Alignment						11/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/6/90	RW
	O) Attach Scope to Rifle						11/6/90	RW
	P) Detach & Attach Scope 20 Times						11/6/90	RW
640	Gallery Target & Test						11-7-90	KT
	A) Time						11-7-90	KT
	B) Malfunctions						11-7-90	KT
	C) Pierced Primers						11-7-90	KT
	D) Optical Clarity of Scope						11-7-90	KT
645	Inspect for Live Ammo						11-7-90	KT
655	Final Inspection							
	A) Headspace						11/19/90	Q28
	B) Trigger Pull	295	295	296	296	283	11/19/90	Q28
	C) Function						11/19/90	Q28
660	Pack						12/18/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523324

DATE 11-6-90

TESTER JLD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.45	2.42	295	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.37	2.41	295	
PULL #3	2.38	2.43	2.40	296	
PULL #4	2.40	2.38	2.30	296	
PULL #5	2.42	2.39	2.41	283	
TOTAL	11.98	12.02	11.94		
AVG.	2.396	2.404	2.388		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.35		
PULL #2	3.38	3.37		
PULL #3	3.36	3.38		
PULL #4	3.36	3.38		
PULL #5	3.35	3.37		
TOTAL	16.88	16.85		
AVG.	3.376	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.24		4.26
PULL #2	4.20	4.17		4.21
PULL #3	4.20	4.10		4.22
PULL #4	4.22	4.23		4.21
PULL #5	4.24	4.23		4.21
TOTAL	21.06	20.97		21.11
AVG.	4.212	4.194		4.222

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523324
8 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0665733
1 TO	2	.156627
1 TO	3	.0734302
1 TO	4	.298511
1 TO	5	.145908

34 <----POA

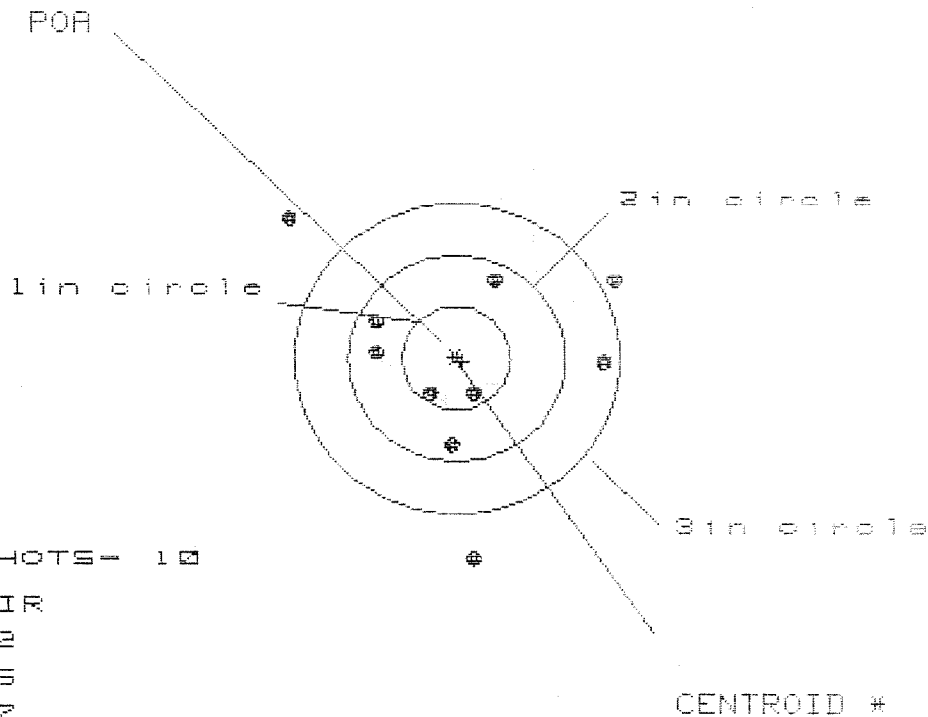
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0484
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0593795

THE AMR FOR THIS RIFLE IS: .8524

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/05523324

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.043

VS = 3.273

GS = 3.685

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.470	1.295	1.288
MINIMUM X	-1.573	-.962	-.969
MAXIMUM Y	1.379	.960	.743
MINIMUM Y	-1.894	-1.741	-.933
CENTROID X	-.056	.119	.126
CENTROID Y	.036	-.117	.100
POR TO CENTROID in.	.066	.167	.161
MIN RADIUS	.361	.186	.402
MEAN RADIUS	1.110	.990	.987
MAX RADIUS	2.092	1.742	1.472
HORIZONTAL SPREAD	3.043	2.257	2.257
VERTICAL SPREAD	3.273	2.701	1.676
EXTREME SPREAD	3.685	2.991	2.289
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

8 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523324

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 18

IN CIR

1 in = 1

2 in = 8

3 in = 8

HS= 1.727

VS= 2.846

CS= 2.846

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.893

.858

.927

MINIMUM X

-.834

-.869

-.800

MAXIMUM Y

1.993

1.298

.259

MINIMUM Y

-.853

-.632

-.469

CENTROID X

.100

.135

.066

CENTROID Y

.022

-.199

-.352

POA TO CENTROID in.

.102

.241

.368

MIN RADIUS

.412

.212

.174

MEAN RADIUS

.865

.658

.513

MAX RADIUS

2.018

1.411

.963

HORIZONTAL SPREAD

1.727

1.727

1.727

VERTICAL SPREAD

2.846

1.930

.728

EXTREME SPREAD

2.848

2.176

1.728

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

8

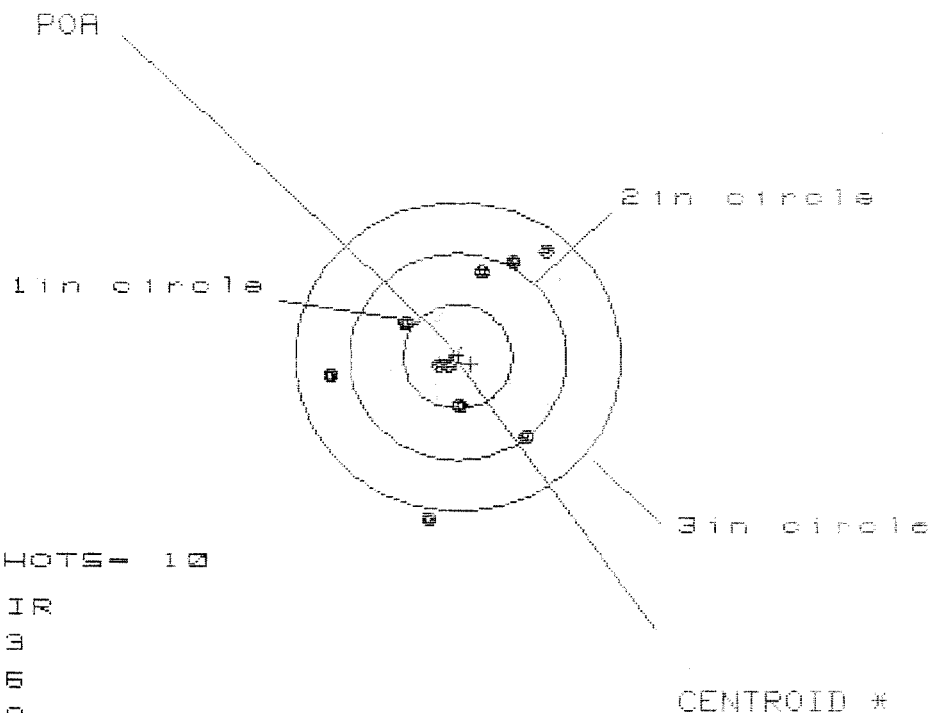
NUMBER IN THREE INCH CIRCLE =

9

6 Nov 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 1.941

VS = 2.567

GS = 2.792

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.770	.733	.659
MINIMUM X	-1.171	-1.208	-1.116
MAXIMUM Y	.987	.811	.857
MINIMUM Y	-1.580	-.904	-.883
CENTROID X	-.120	-.083	-.175
CENTROID Y	.072	.248	.147
POA TO CENTROID in.	.140	.262	.228
MIN RADIUS	.123	.282	.145
MEAN RADIUS	.826	.751	.676
MAX RADIUS	1.614	1.266	1.150
HORIZONTAL SPREAD	1.941	1.941	1.775
VERTICAL SPREAD	2.567	1.715	1.660
EXTREME SPREAD	2.792	2.277	2.050
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

8 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523324

CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS = 1.808

VS = 1.447

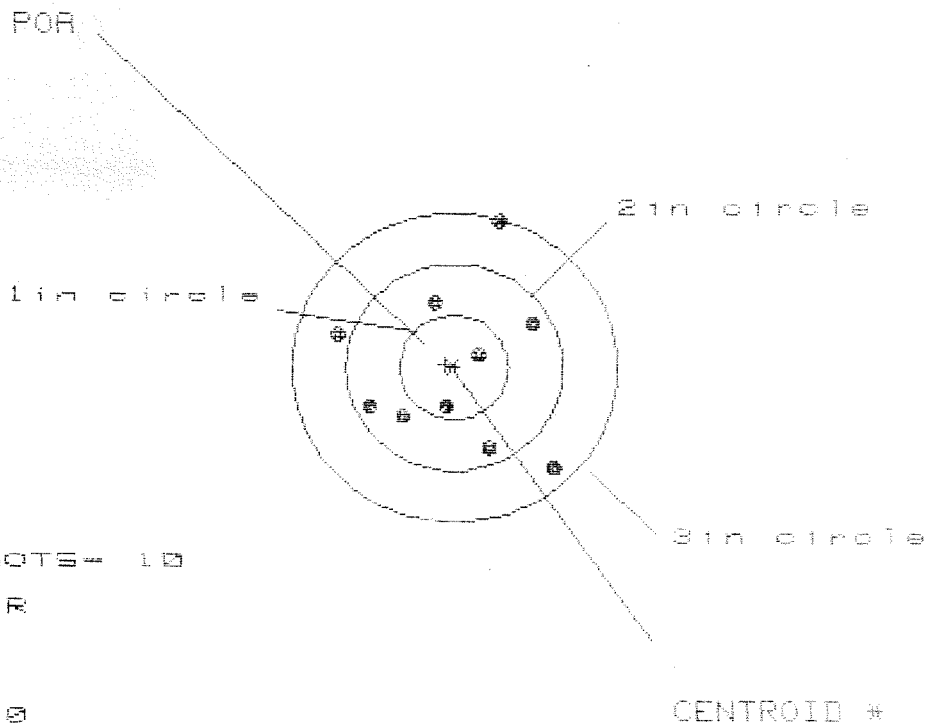
GS = 2.018

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.571	.434	.481
MINIMUM X	-1.236	-.650	-.603
MAXIMUM Y	.813	.791	.759
MINIMUM Y	-.634	-.656	-.557
CENTROID X	.241	.379	.332
CENTROID Y	.066	.087	-.011
POB TO CENTROID in.	.250	.389	.332
MIN RADIUS	.089	.056	.080
MEAN RADIUS	.613	.517	.459
MAX RADIUS	1.252	.875	.781
HORIZONTAL SPREAD	1.808	1.084	1.084
VERTICAL SPREAD	1.447	1.447	1.317
EXTREME SPREAD	2.018	1.648	1.427
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08323324

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

H0 = 1.978

V0 = 2.349

G0 = 2.406

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.895	.937	.872
MINIMUM X	-1.083	-1.041	-.923
MAXIMUM Y	1.415	.792	.695
MINIMUM Y	-.934	-.777	-.695
CENTROID X	.077	.035	-.083
CENTROID Y	-.024	-.161	-.084
POA TO CENTROID in.	.080	.184	.117
MIN RADIUS	.283	.269	.378
MEAN RADIUS	.848	.762	.703
MAX RADIUS	1.464	1.218	1.018
HORIZONTAL SPREAD	1.978	1.978	1.795
VERTICAL SPREAD	2.349	1.569	1.390
EXTREME SPREAD	2.406	2.323	1.804
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	