

C6523380

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

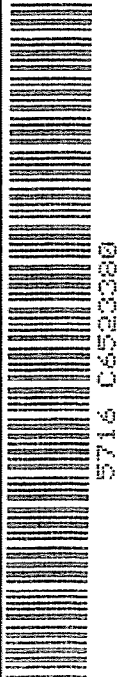
DUPONT
REG. U.S. PAT. & TM. OFF.

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

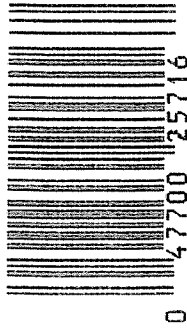
SERIAL NO.
C6520380

ORDER NO.
5716

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



LPC



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M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523380

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	RR
	Magnaflux Bolt		9-25-90	RR
615	Rollmark Caliber		9-25-90	28.0
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel		9/28/90	WB
620	Apply Coatings (Barrel Action)		9-25-90	TA
	Apply Coating (Bolt)		10	TA
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/12/90	28

op. #	OP. NAME	READINGS			DATE	INIT		
635 nt.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{3}{4}$	4 $\frac{3}{4}$	10/12/90	WB		
	G) Safety Off Force	7 $\frac{1}{2}$	7 $\frac{1}{2}$	7 $\frac{1}{2}$	10/12/90	WB		
	H) Trigger Pull Test & Retainability				10/12/90	RL		
	I) Firing Pin Indent	.022	.022-5	.022	10/12/90	WB		
	J) Assemble Stock				10/12/90	RW		
	K) Assemble Swivel Studs				2N8090	JS		
	L) Attach Front and Rear Sight Assemblies				10/12/90	RW		
	M) Iron Sight Alignment				10/12/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				10/12/90	RW		
	O) Attach Scope to Rifle				10/13/90	JS		
	P) Detach & Attach Scope 20 Times				10/13/90	JS		
640	Gallery Target & Test				10-16-90	KT		
	A) Time				10-16-90	KT		
	B) Malfunctions				10-16-90	KT		
	C) Pierced Primers				10-16-90	KT		
	D) Optical Clarity of Scope				10-16-90	KT		
645	Inspect for Live Ammo				10-16-90	KT		
655	Final Inspection							
	A) Headspace				2N8090	JS		
	B) Trigger Pull	222	216	222	227	211	2N8090	JS
	C) Function						2N8090	JS
660	Pack						12/14/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523380

DATE 10-12-90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.30	2.40	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.52	2.38	2.10	
PULL #3	2.36	2.40	2.45	2.22	
PULL #4	2.38	2.34	2.34	2.27	
PULL #5	2.23	2.42	2.30	2.11	
TOTAL	11.82	11.98	11.87		
AVG.	2.364	2.396	2.374		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.31		
PULL #2	3.30	3.54		
PULL #3	3.15	3.43		
PULL #4	3.36	3.26		
PULL #5	3.52	3.25		
TOTAL	16.9	16.79		
AVG.	3.38	3.358		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.29		4.23
PULL #2	4.47	4.45		4.40
PULL #3	4.25	4.50		4.43
PULL #4	4.35	4.46		4.37
PULL #5	4.50	4.52		4.19
TOTAL	21.98	22.22		21.62
AVG.	4.396	4.444		4.324

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523380
17 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0514782
1 TO	2	.187883
1 TO	3	.342348
1 TO	4	.109238
1 TO	5	.13324

POI <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0414082
THE AMR FOR THIS RIFLE IS: 1.062

17 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523380

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.254

VS= 4.039

GS= 4.051

CENTROID *

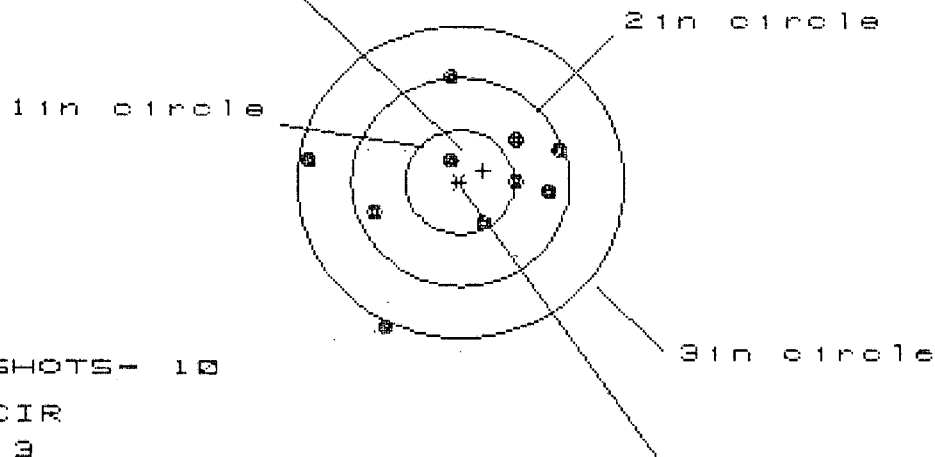
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.026	1.179	1.188
MINIMUM X	:	-1.228	-1.003	-.994
MAXIMUM Y	:	2.139	2.053	1.239
MINIMUM Y	:	-1.900	-1.986	-1.729
CENTROID X	:	-.045	-.270	-.279
CENTROID Y	:	-.025	.061	-.196
POA TO CENTROID in.	:	.051	.277	.341
MIN RADIUS	:	.450	.502	.626
MEAN RADIUS	:	1.357	1.248	1.149
MAX RADIUS	:	2.167	2.055	1.773
HORIZONTAL SPREAD	:	3.254	2.182	2.182
VERTICAL SPREAD	:	4.039	4.039	2.968
EXTREME SPREAD	:	4.051	4.051	2.979
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.236

VS= 2.450

GS= 2.521

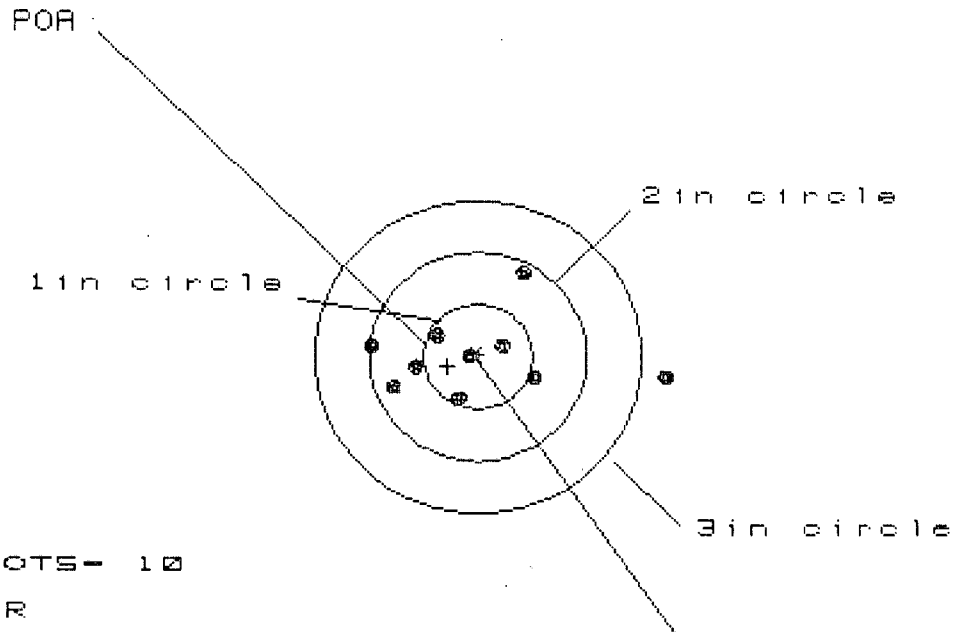
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.825	.649
MINIMUM X	:	-1.339	-1.411	-1.067
MAXIMUM Y	:	1.028	.870	.883
MINIMUM Y	:	-1.422	-.499	-.486
CENTROID X	:	-.211	-.139	.037
CENTROID Y	:	-.113	.045	.032
POA TO CENTROID in.	:	.239	.146	.049
MIN RADIUS	:	.186	.121	.253
MEAN RADIUS	:	.827	.715	.590
MAX RADIUS	:	1.561	1.414	1.161
HORIZONTAL SPREAD	:	2.236	2.236	1.716
VERTICAL SPREAD	:	2.450	1.369	1.369
EXTREME SPREAD	:	2.521	2.236	1.812
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

1 in = 4

2 in = 8

3 in = 9

HS= 2.728

VS= 1.214

GS= 2.746

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.711	.702	.599
MINIMUM X	:	-1.017	-.827	-.687
MAXIMUM Y	:	.835	.811	.822
MINIMUM Y	:	-.379	-.403	-.392
CENTROID X	:	.276	.086	.189
CENTROID Y	:	.094	.118	.107
POA TO CENTROID in.	:	.292	.146	.218
MIN RADIUS	:	.053	.168	.075
MEAN RADIUS	:	.676	.544	.497
MAX RADIUS	:	1.724	1.038	.985
HORIZONTAL SPREAD	:	2.728	1.529	1.286
VERTICAL SPREAD	:	1.214	1.214	1.214
EXTREME SPREAD	:	2.746	1.681	1.681
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 4.211

VS= 3.991

GS= 5.033

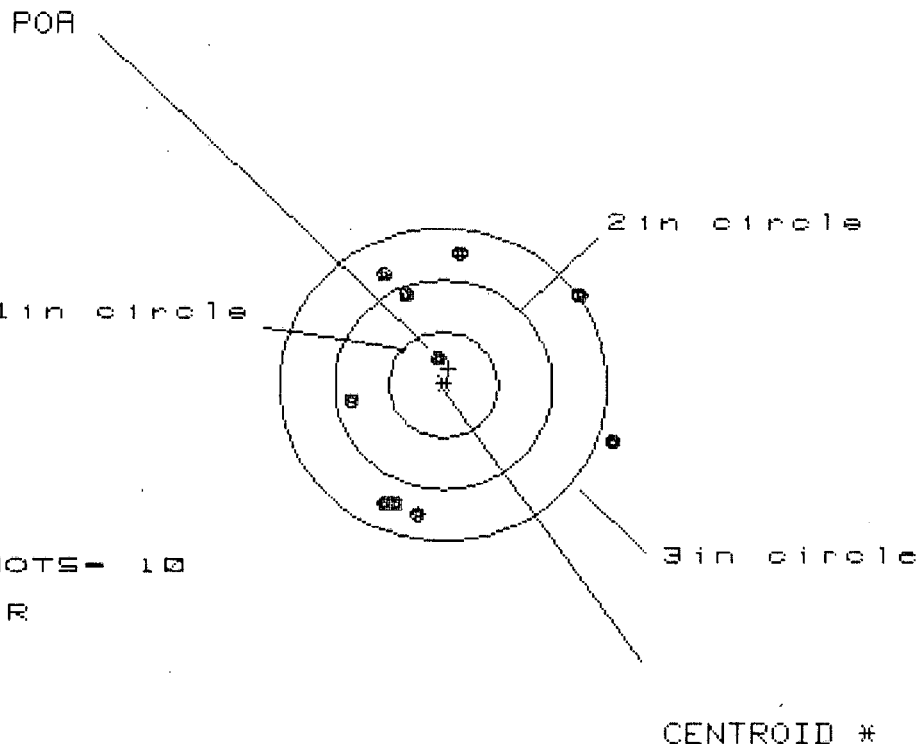
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.769	1.293	1.294
MINIMUM X	:	-1.442	-1.134	-1.133
MAXIMUM Y	:	1.765	.947	.694
MINIMUM Y	:	-2.226	-2.030	-.802
CENTROID X	:	.062	-.246	-.247
CENTROID Y	:	-.003	-.199	.054
POA TO CENTROID in.	:	.062	.317	.253
MIN RADIUS	:	.263	.541	.444
MEAN RADIUS	:	1.302	1.049	.902
MAX RADIUS	:	3.284	2.030	1.468
HORIZONTAL SPREAD	:	4.211	2.427	2.427
VERTICAL SPREAD	:	3.991	2.977	1.496
EXTREME SPREAD	:	5.033	3.241	2.700
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.435

VS = 2.461

GS = 2.702

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.557	1.470	.511
MINIMUM X	-.878	-.705	-.522
MAXIMUM Y	1.229	1.164	1.265
MINIMUM Y	-1.232	-1.297	-1.196
CENTROID X	-.053	-.226	-.409
CENTROID Y	-.158	-.093	-.194
POA TO CENTROID in.	.167	.244	.453
MIN RADIUS	.274	.207	.393
MEAN RADIUS	1.147	1.055	.966
MAX RADIUS	1.663	1.678	1.365
HORIZONTAL SPREAD	2.435	2.175	1.033
VERTICAL SPREAD	2.461	2.461	2.461
EXTREME SPREAD	2.702	2.702	2.488
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		