

06523490

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

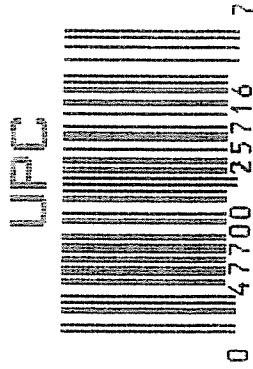
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
C6523490

ORDER NO.
5716

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



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523490

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KL
600	Proof		10/2/90	KL
607	Check Headspace		10/2/90	KL
610	Dis-assemble Gun		10/2/90	KL
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	LS
617	Drill and Tap Sight Holes		10/8/90	FB
618	Polish Barrel <i>RB</i>		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	LA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/90	DL

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	11/1/90	WLB
	G) Safety Off Force	2	2	2	11/1/90	WLB
	H) Trigger Pull Test & Retainability				10/31/90	JH
	I) Firing Pin Indent	.021	.0205	.0205	11/1/90	WLB
	J) Assemble Stock				11/1/90	JA
	K) Assemble Swivel Studs				11/14/90	JS
	L) Attach Front and Rear Sight Assemblies				11/1/90	JA
	M) Iron Sight Alignment				11/1/90	JA
	N) Detach Front & Rear Sights & place in numbered container				11/1/90	JA
	O) Attach Scope to Rifle				11/1/90	JA
	P) Detach & Attach Scope 20 Times				11/1/90	JA
640	Gallery Target & Test				11/1/90	AF
	A) Time				"	AF
	B) Malfunctions				"	AF
	C) Pierced Primers				"	AF
	D) Optical Clarity of Scope				"	AF
645	Inspect for Live Ammo				11/1/90	AF
655	Final Inspection					
	A) Headspace				11/14/90	JS
	B) Trigger Pull	255	262	259	255 262	11/14/90 JS
	C) Function				11/14/90	JS
660	Pack				12-17-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C 6523490

DATE 10/31/90

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.43	2.40	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.38	2.36	2.62	
PULL #3	2.47	2.37	2.38	2.59	
PULL #4	2.38	2.38	2.40	2.55	
PULL #5	2.40	2.40	2.40	2.62	
TOTAL	12.06	11.96	11.94		
AVG.	2.412	2.392	2.388		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.37		
PULL #2	3.37	3.40		
PULL #3	3.34	3.33		
PULL #4	3.36	3.35		
PULL #5	3.32	3.42		
TOTAL	16.8	16.87		
AVG.	3.36	3.374		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.19		4.48
PULL #2	4.11	4.49		4.49
PULL #3	4.15	4.48		4.20
PULL #4	4.14	4.15		4.48
PULL #5	4.13	4.51		4.24
TOTAL	20.82	21.82		21.89
AVG.	4.164	4.364		4.378

84 2-1 10
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523490
2 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.194733
1	TO	2	.230419
1	TO	3	.168962
1	TO	4	.0259422
1	TO	5	.353645

52 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0768
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0780656
THE AMR FOR THIS RIFLE IS: .9732

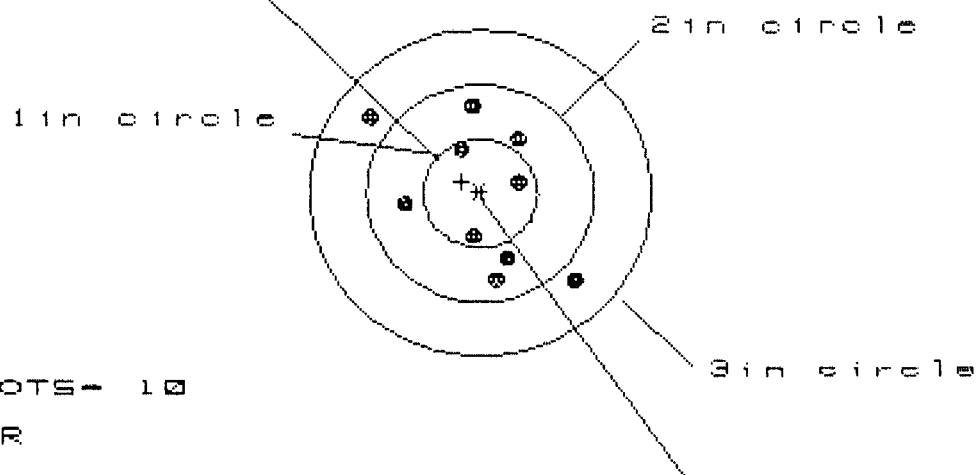
2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523490

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.744

VS= 1.644

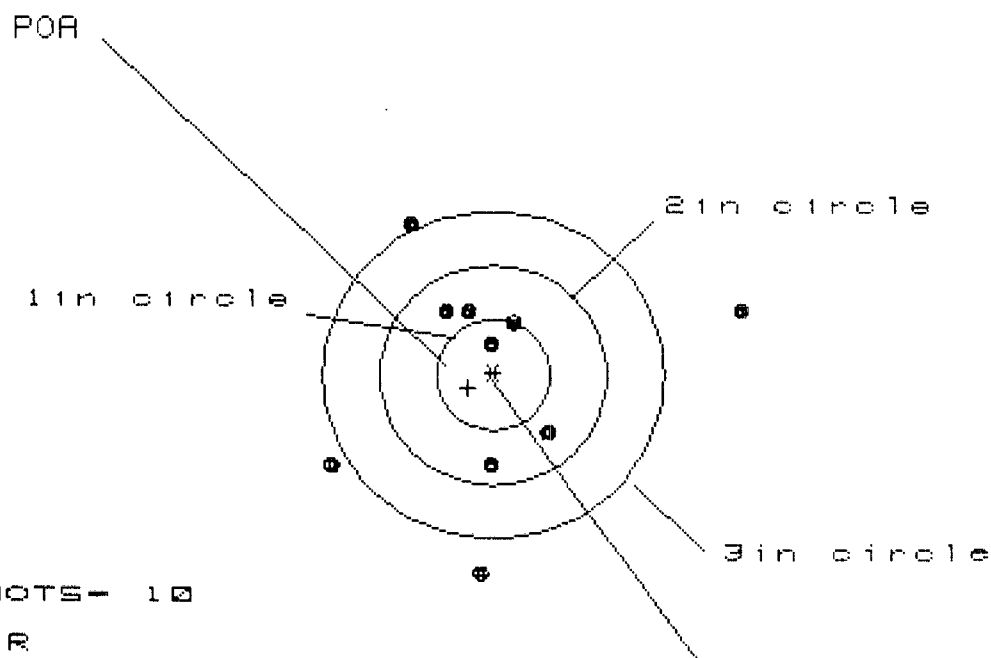
GS= 2.309

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.715	.286
MINIMUM X	:	-.926	-.740	-.650
MAXIMUM Y	:	.854	.935	.847
MINIMUM Y	:	-.790	-.709	-.797
CENTROID X	:	.164	.267	.177
CENTROID Y	:	-.105	-.186	-.098
POA TO CENTROID in.	:	.194	.325	.203
MIN RADIUS	:	.324	.284	.309
MEAN RADIUS	:	.696	.632	.580
MAX RADIUS	:	1.179	1.003	.849
HORIZONTAL SPREAD	:	1.744	1.455	.936
VERTICAL SPREAD	:	1.644	1.644	1.644
EXTREME SPREAD	:	2.309	1.855	1.659
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 3.628

VS= 3.196

GS= 3.893

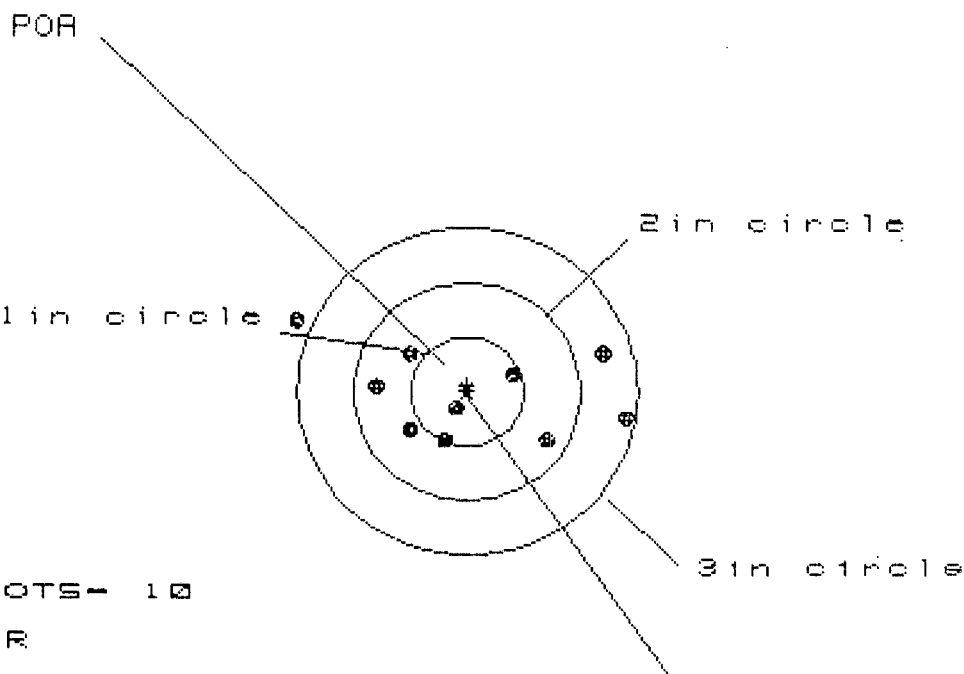
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.199	.760	.779
MINIMUM X	:	-1.429	-1.185	-1.166
MAXIMUM Y	:	1.412	1.482	1.267
MINIMUM Y	:	-1.784	-1.714	-.955
CENTROID X	:	.222	-.022	-.041
CENTROID Y	:	.118	.048	.263
POA TO CENTROID in.	:	.252	.053	.266
MIN RADIUS	:	.236	.382	.265
MEAN RADIUS	:	1.085	.963	.815
MAX RADIUS	:	2.286	1.721	1.491
HORIZONTAL SPREAD	:	3.628	1.945	1.945
VERTICAL SPREAD	:	3.196	3.196	2.222
EXTREME SPREAD	:	3.893	3.250	2.325
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.834

VS= 1.166

GS= 2.987

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.366	1.203	1.147
MINIMUM X	:	-1.468	-.973	-.823
MAXIMUM Y	:	.700	.480	.459
MINIMUM Y	:	-.467	-.389	-.410
CENTROID X	:	.002	.165	.015
CENTROID Y	:	-.057	-.134	-.113
POA TO CENTROID in.	:	.057	.213	.114
MIN RADIUS	:	.188	.291	.159
MEAN RADIUS	:	.817	.730	.638
MAX RADIUS	:	1.626	1.214	1.235
HORIZONTAL SPREAD	:	2.834	2.176	1.970
VERTICAL SPREAD	:	1.166	.869	.869
EXTREME SPREAD	:	2.987	2.196	2.001
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

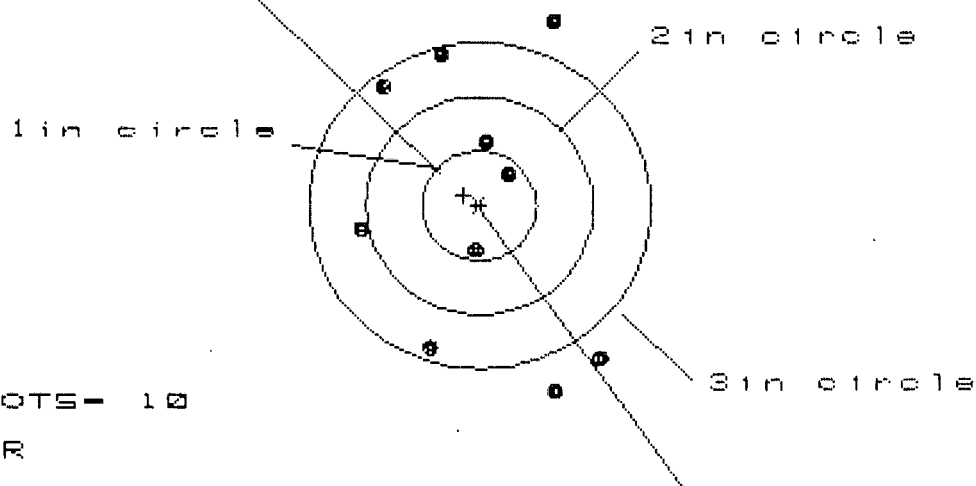
2 Nov 1998

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 3

3 in - 7

HS- 2.090

VS- 3.407

GS- 3.407

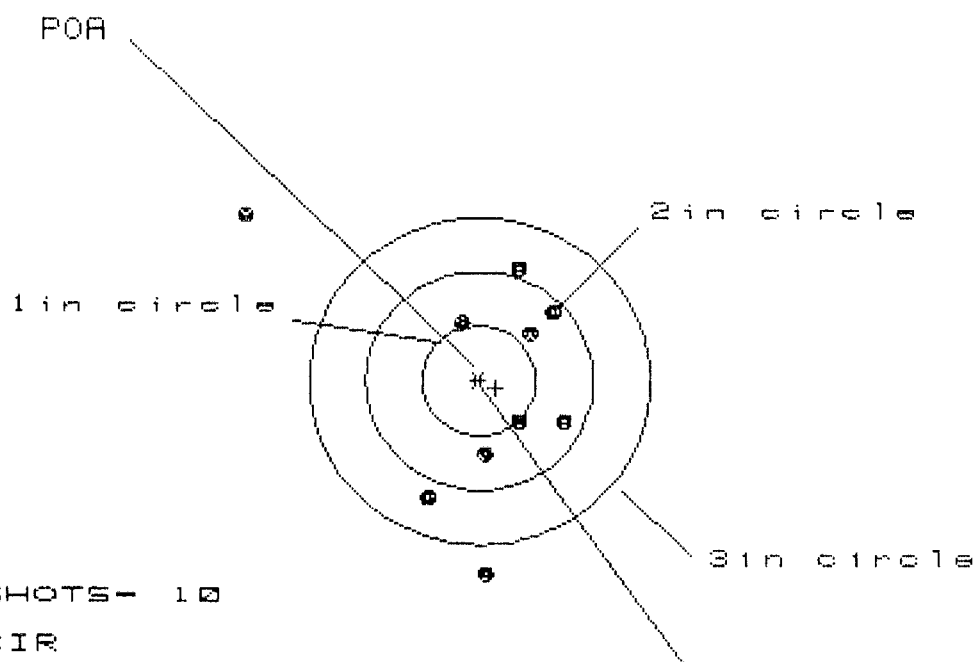
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.034	1.106	1.195
MINIMUM X	:	-1.056	-.984	-.895
MAXIMUM Y	:	1.682	1.490	1.352
MINIMUM Y	:	-1.725	-1.613	-1.426
CENTROID X	:	.141	.069	-.020
CENTROID Y	:	-.093	.099	-.088
POA TO CENTROID in.	:	.169	.121	.090
MIN RADIUS	:	.370	.338	.460
MEAN RADIUS	:	1.198	1.102	1.038
MAX RADIUS	:	1.843	1.955	1.861
HORIZONTAL SPREAD	:	2.090	2.090	2.090
VERTICAL SPREAD	:	3.407	3.103	2.778
EXTREME SPREAD	:	3.407	3.128	3.128
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.843

VS= 3.352

GS= 3.965

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.764	.533	.509
MINIMUM X	:	-2.079	-.643	-.667
MAXIMUM Y	:	1.580	1.235	1.035
MINIMUM Y	:	-1.772	-1.596	-1.074
CENTROID X	:	-.145	.086	.110
CENTROID Y	:	.067	-.109	.091
POA TO CENTROID in.	:	.160	.138	.142
MIN RADIUS	:	.484	.216	.406
MEAN RADIUS	:	1.070	.844	.737
MAX RADIUS	:	2.611	1.608	1.264
HORIZONTAL SPREAD	:	2.843	1.176	1.176
VERTICAL SPREAD	:	3.352	2.831	2.109
EXTREME SPREAD	:	3.965	2.852	2.255
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	