

C6349092

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.

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

DUPONT

MODEL 700™ H24

SERIAL NO.
C6349092

ORDER NO.
5716

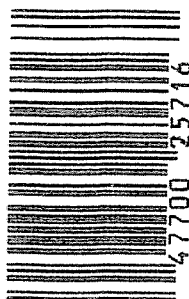
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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5716 C6349092

UPC



0 47700 125716 7

2.04

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349092

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KER
	Magnaflux Bolt	4-2-90		KER
615	Rollmark Caliber	4-2-90		GA
617	Drill and Tap Sight Holes		4/4/90	LB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/2/90	98

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/7/90	RL
	G) Safety Off Force	3	3	3			5/7/90	RL
	H) Trigger Pull Test & Retainability						5/2/90	RL
	I) Firing Pin Indent	.0205	.020	.0205			5/7/90	RL
	J) Assemble Stock						5/8/90	RW
	K) Assemble Swivel Studs						5/11/90	WB
	L) Attach Front and Rear Sight Assemblies						5/8/90	RW
	M) Iron Sight Alignment						5/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/8/90	RW
	O) Attach Scope to Rifle						5/8/90	WB
	P) Detach & Attach Scope 20 Times						5/8/90	WB
640	Gallery Target & Test						5-8-90	DH
	A) Time						5-8-90	DH
	B) Malfunctions						5-8-90	DH
	C) Pierced Primers						5-8-90	DH
	D) Optical Clarity of Scope						5-8-90	DH
645	Inspect for Live Ammo						5-8-90	DH
655	Final Inspection A) Headspace						5/11/90	WB
	B) Trigger Pull	2.39	2.34	2.13	2.22	2.13	5/11/90	WB
	C) Function						5/11/90	WB
660	Pack						6-9-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349092

DATE 5/2/90

TESTER JEF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.49	2.43	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.41	2.40	2.34	
PULL #3	2.50	2.43	2.51	2.13	
PULL #4	2.37	2.42	2.36	2.22	
PULL #5	2.38	2.36	2.42	2.13	
TOTAL	12.25	12.11	12.02		
AVG.	2.45	2.422	2.404		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.31		
PULL #2	3.35	3.27		
PULL #3	3.29	3.33		
PULL #4	3.20	3.53		
PULL #5	3.29	3.49		
TOTAL	16.60	16.93		
AVG.	3.32	3.386		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.37		4.49
PULL #2	4.38	4.23		4.39
PULL #3	4.40	4.42		4.44
PULL #4	4.14	4.38		4.50
PULL #5	4.20	4.33		4.39
TOTAL	21.62	21.73		22.21
AVG.	4.324	4.346		4.442

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349892
9 May 1998

CENTROIDAL DISTANCES

0 TO 1	.366175
1 TO 2	.743034
1 TO 3	.321972
1 TO 4	.540693
1 TO 5	.390151

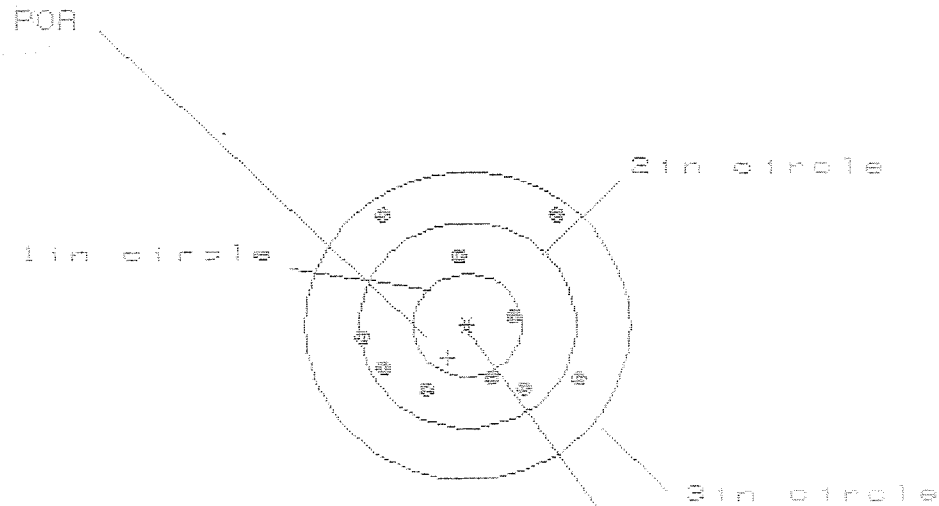
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1752
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .24894
THE ANR FOR THIS RIFLE IS: .865

9 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6349092

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.926

VS= 1.662

GS= 2.304

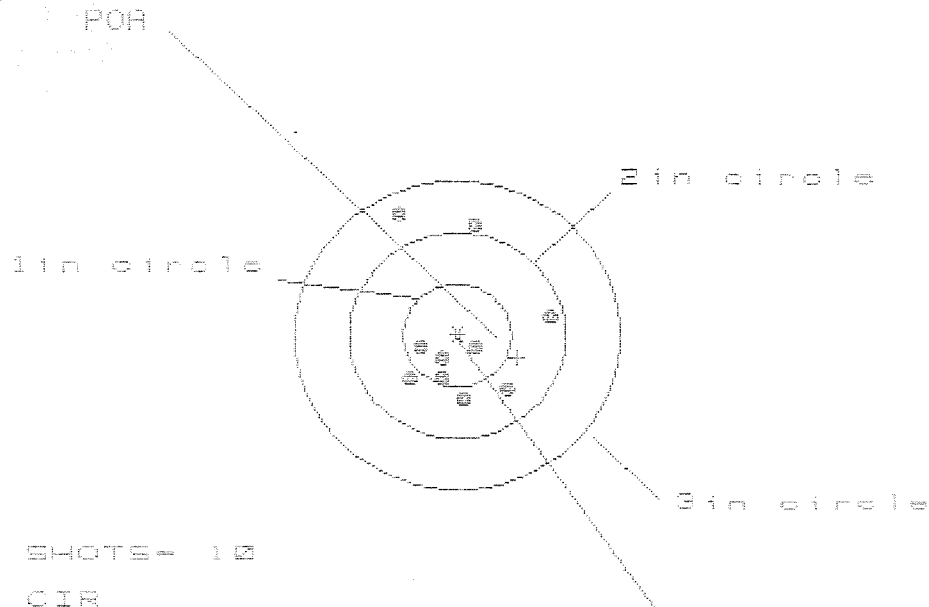
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.985	1.077	.997
MINIMUM X	:	-.941	-.849	-.929
MAXIMUM Y	:	1.033	1.147	.956
MINIMUM Y	:	-.629	-.514	-.371
CENTROID X	:	.178	.086	.167
CENTROID Y	:	.320	.205	.062
POR TO CENTROID in.	:	.366	.223	.178
MIN RADIUS	:	.385	.504	.383
MEAN RADIUS	:	.876	.811	.720
MAX RADIUS	:	1.325	1.316	1.025
HORIZONTAL SPREAD	:	1.926	1.926	1.926
VERTICAL SPREAD	:	1.662	1.661	1.327
EXTREME SPREAD	:	2.304	2.304	1.966
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.345

VS= 1.763

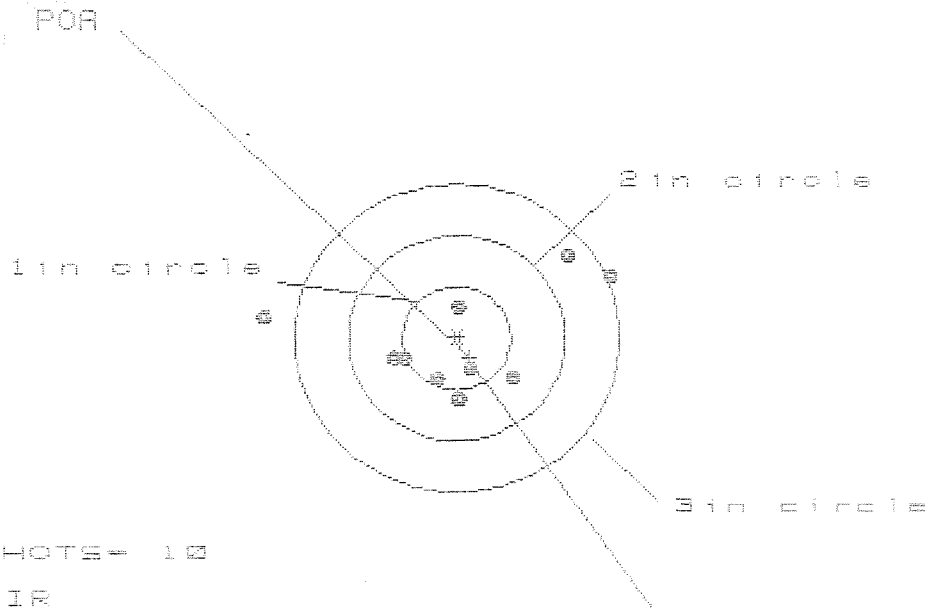
GS= 1.915

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.830	.772	.784
MINIMUM X	:	-.515	-.513	-.501
MAXIMUM Y	:	1.176	1.185	.441
MINIMUM Y	:	-.587	-.456	-.388
CENTROID X	:	-.558	-.500	-.512
CENTROID Y	:	.218	.087	-.061
POA TO CENTROID in.	:	.599	.508	.515
MIN RADIUS	:	.191	.080	.173
MEAN RADIUS	:	.631	.512	.396
MAX RADIUS	:	1.284	1.188	.899
HORIZONTAL SPREAD	:	1.345	1.285	1.285
VERTICAL SPREAD	:	1.763	1.641	.749
EXTREME SPREAD	:	1.915	1.644	1.395
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 3.151

VS= 1.447

CS= 3.188

CENTROID *

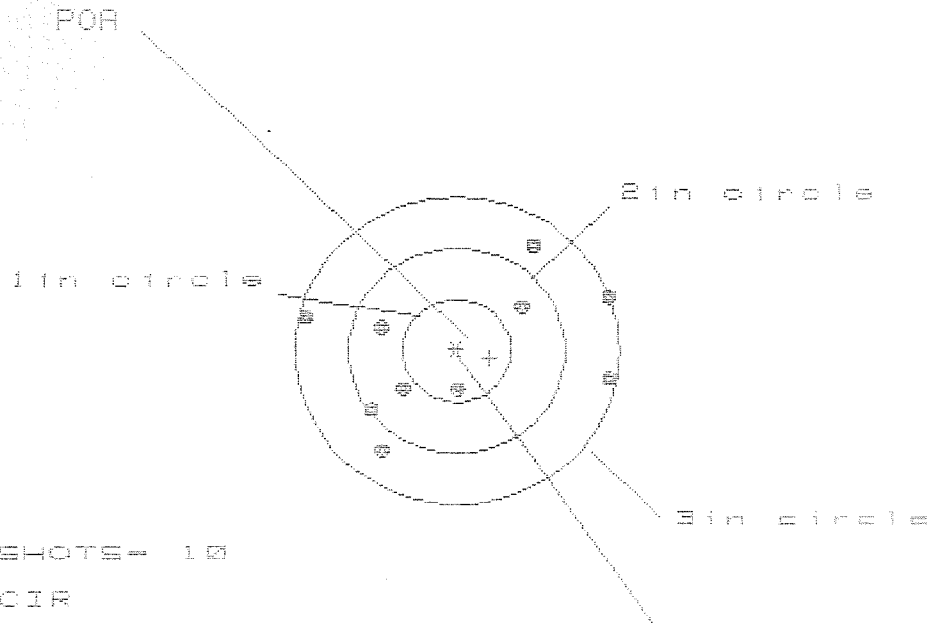
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.407	1.214	.962
MINIMUM X	:	-1.744	-.814	-.662
MAXIMUM Y	:	.812	.834	.915
MINIMUM Y	:	-.635	-.613	-.531
CENTROID X	:	-.117	.076	-.075
CENTROID Y	:	.191	.169	.087
POR TO CENTROID in.	:	.224	.185	.116
MIN RADIUS	:	.290	.285	.202
MEAN RADIUS	:	.802	.704	.569
MAX RADIUS	:	1.755	1.378	1.328
HORIZONTAL SPREAD	:	3.151	2.028	1.624
VERTICAL SPREAD	:	1.447	1.447	1.447
EXTREME SPREAD	:	3.188	2.173	1.888
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.732

VS= 1.988

GS= 2.791

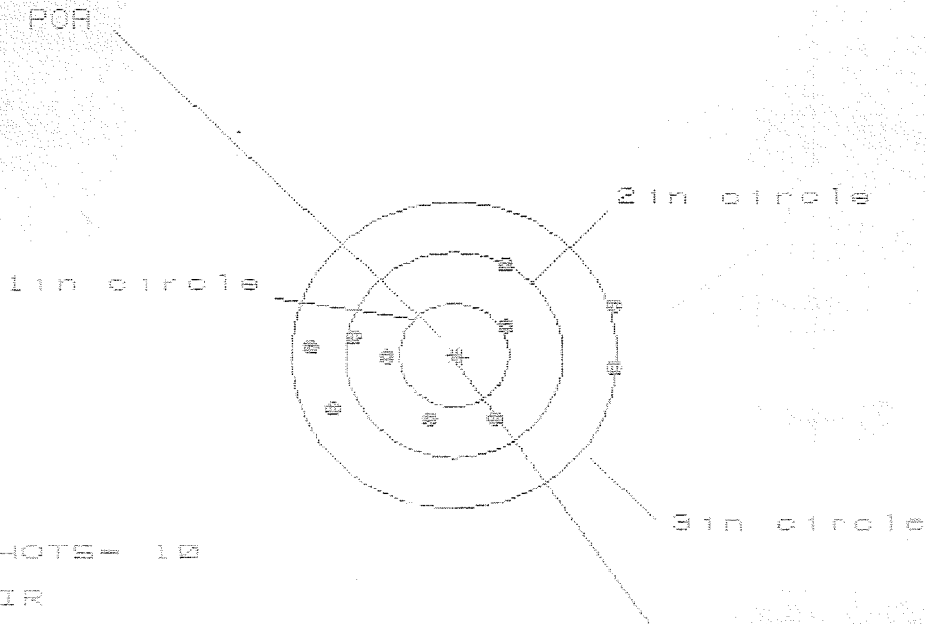
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.376	1.518	1.367
MINIMUM X	:	-1.356	-1.203	-.775
MAXIMUM Y	:	1.012	1.070	1.123
MINIMUM Y	:	-.976	-.918	-.865
CENTROID X	:	-.304	-.457	-.306
CENTROID Y	:	.075	.017	-.036
POA TO CENTROID in.	:	.313	.457	.308
MIN RADIUS	:	.344	.330	.234
MEAN RADIUS	:	1.008	.927	.884
MAX RADIUS	:	1.473	1.531	1.376
HORIZONTAL SPREAD	:	2.732	2.721	2.142
VERTICAL SPREAD	:	1.988	1.988	1.988
EXTREME SPREAD	:	2.791	2.791	2.414
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 5

HS= 2.839

VS= 1.486

GS= 2.850

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.470
MINIMUM X	-1.369
MAXIMUM Y	.884
MINIMUM Y	-.602
CENTROID X	-.075
CENTROID Y	.023
POA TO CENTROID in.	.078
MIN RADIUS	.589
MEAN RADIUS	1.008
MAX RADIUS	1.504
HORIZONTAL SPREAD	2.839
VERTICAL SPREAD	1.486
EXTREME SPREAD	2.850
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	5