

C6522154

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6522154

DATE 10-26-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.44	2.51	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.25	2.42	
PULL #3	2.37	2.25	2.37	
PULL #4	2.39	2.30	2.44	
PULL #5	2.30	2.30	2.51	
TOTAL	11.90	11.61	12.19	
AVG.	2.38	2.32	2.43	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.06	3.17	
PULL #2	3.00	3.25	
PULL #3	3.01	3.22	
PULL #4	2.98	3.00	
PULL #5	2.96	3.18	
TOTAL	15.01	15.82	
AVG.	3.00	3.16	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	3.94	4.08	
PULL #2	4.10	3.90	4.12	
PULL #3	4.08	3.90	3.95	
PULL #4	4.00	3.94	3.98	
PULL #5	4.02	3.96	4.08	
TOTAL	20.26	19.64	20.21	
AVG.	4.05	3.92	4.04	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522154

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

BARBER - M24 0003783

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			11/28	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			11/28	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.48	2.35	2.33	2.28	2.25	11/28	WB
	C) Function							
660	Pack							

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522154

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/90	KJ
600	Proof		10/1/90	KJ
607	Check Headspace		10/1/90	KJ
610	Dis-assemble Gun		10/1/90	KJ
612	Magnaflux Barrel Action		10-3-90	KR
	Magnaflux Bolt		10-3-90	KR
615	Rollmark Caliber		10-3-90	PS
617	Drill and Tap Sight Holes		10/4/90	KJ
618	Polish Barrel RCB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/9/90	KS
	D) Oil Firing Pin Ass'y		11/9/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	JS

BARBER - M24 0003785

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			11/8/90	WLB
	G) Safety Off Force	2	2	2			11/8/90	WLB
	H) Trigger Pull Test & Retainability						11/9/90	JH
	I) Firing Pin Indent	0205	0205	0205			11/9/90	WLB
	J) Assemble Stock						11/14/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/10/90	KS
	M) Iron Sight Alignment						11/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/10/90	KS
	O) Attach Scope to Rifle						11/14/90	KS
	P) Detach & Attach Scope 20 Times						11/14/90	KS
640	Gallery Target & Test						11/12/90	NF
	A) Time						11/12/90	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11/12/90	NF
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.14	2.41	2.43	2.48	2.47	11/19-90	DH
	C) Function						11-19-90	DH
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. C6522154

DATE 11-9-90

TESTER JRC

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.58	290	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.49	280	2.41	
PULL #3	2.49	2.20	279	2.43	
PULL #4	2.28	2.18	293	2.48	
PULL #5	2.36	2.34	275	2.47	
TOTAL	11.55	11.71		11.93	
AVG.	2.31	2.342		2.386	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.35		
PULL #2	3.28	3.12		
PULL #3	3.20	3.39		
PULL #4	3.38	3.25		
PULL #5	3.38	3.12		
TOTAL	16.43	16.23		
AVG.	3.286	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.28		4.17
PULL #2	4.48	4.42		4.43
PULL #3	4.49	4.34		4.39
PULL #4	4.44	4.45		4.43
PULL #5	4.49	4.46		4.50
TOTAL	22.34	21.95		21.92
AVG.	4.468	4.39		4.384

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522154
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.456478
1 TO	2	.57171
1 TO	3	.369121
1 TO	4	.585109
1 TO	5	.568360

#1 <----PCF

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0272
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0429.50
THE AMR FOR THIS RIFLE IS: .0986

13 Nov 1999

FILE:/PATTERNING/CENTERFIRE_PATT/03522154

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

WE= 2.316

VS= 2.284

GS= 2.725

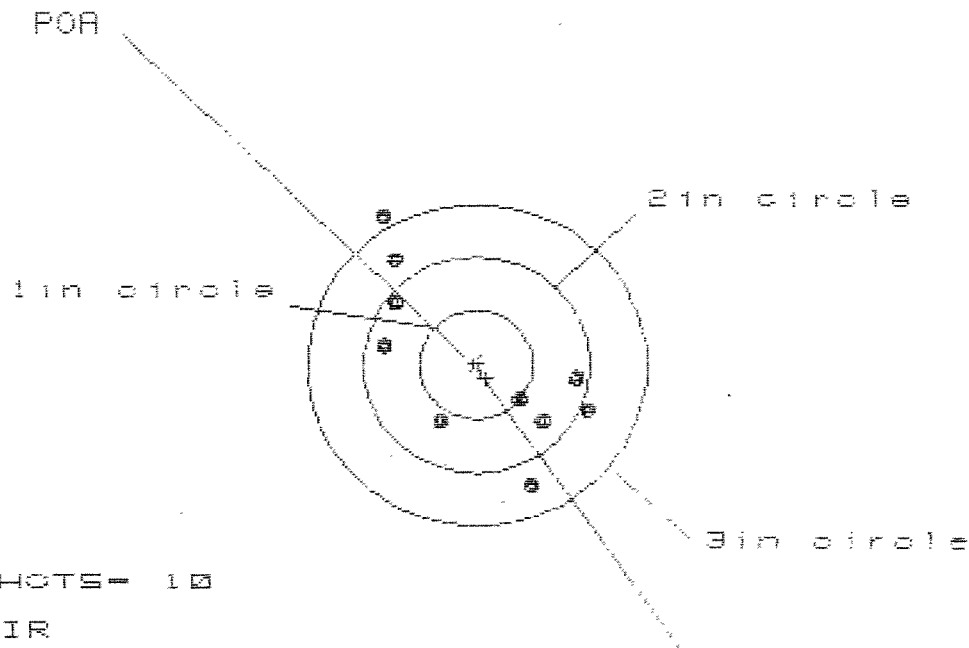
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.093	.992	.536
MINIMUM X	-1.233	-1.112	-.986
MAXIMUM Y	1.218	1.122	.977
MINIMUM Y	-1.066	-1.162	-.840
CENTROID X	.444	.323	.199
CENTROID Y	-.106	-.019	.135
POA TO CENTROID in.	.456	.323	.241
MIN RADIUS	.295	.255	.292
MEAN RADIUS	.861	.806	.716
MAX RADIUS	1.387	1.528	1.041
HORIZONTAL SPREAD	2.316	2.104	1.524
VERTICAL SPREAD	2.284	2.284	1.817
EXTREME SPREAD	2.725	2.665	1.895
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

13 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522154

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.838

VS= 2.534

GS= 2.817

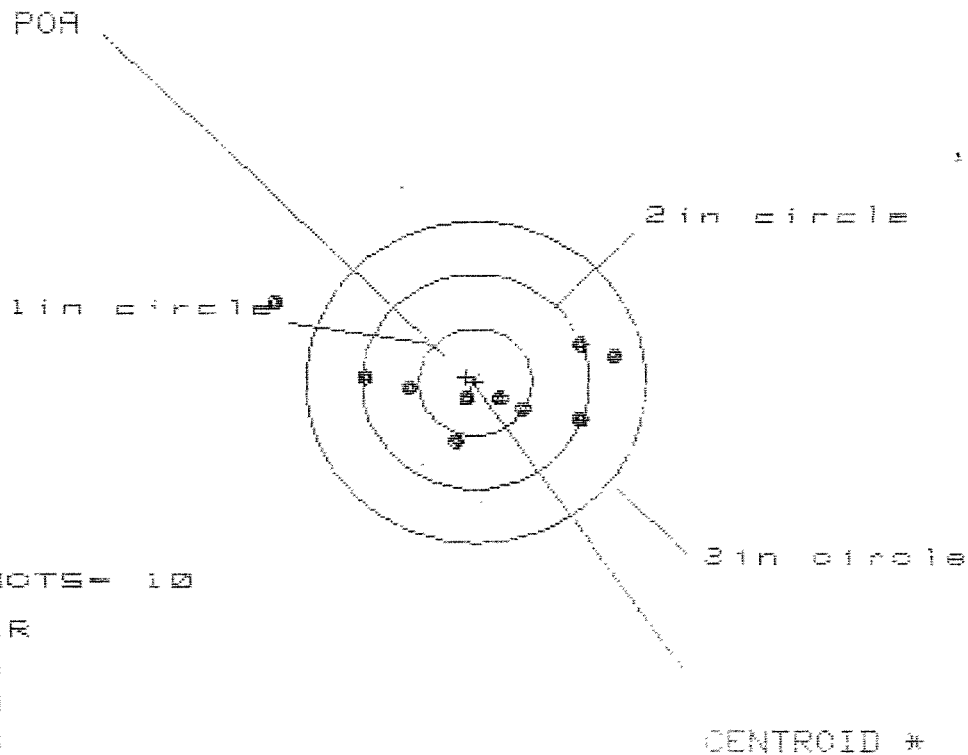
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.942	.936
MINIMUM X	-.808	-.896	-.852
MAXIMUM Y	1.393	1.096	.973
MINIMUM Y	-1.141	-.986	-.495
CENTROID X	-.082	.006	-.038
CENTROID Y	.118	-.037	.086
POR TO CENTROID in.	.144	.037	.094
MIN RADIUS	.452	.288	.398
MEAN RADIUS	.958	.849	.837
MAX RADIUS	1.603	1.355	1.230
HORIZONTAL SPREAD	1.838	1.838	1.838
VERTICAL SPREAD	2.534	2.082	1.468
EXTREME SPREAD	2.817	2.377	2.226
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522154

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.994

VS= 1.304

GS= 3.041

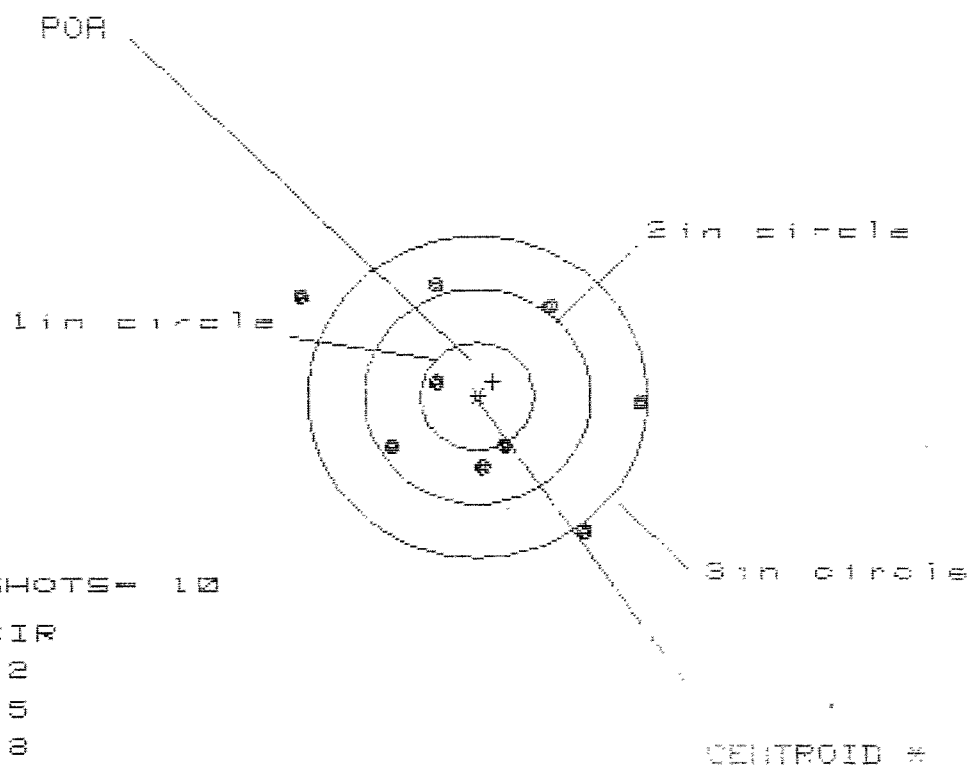
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.250	1.056	.832
MINIMUM X	:	-1.744	-1.177	-1.045
MAXIMUM Y	:	.776	.480	.521
MINIMUM Y	:	-.528	-.441	-.400
CENTROID X	:	.079	.273	.141
CENTROID Y	:	-.051	-.138	-.179
POA TO CENTROID in.	:	.095	.306	.228
MIN RADIUS	:	.194	.080	.134
MEAN RADIUS	:	.814	.651	.582
MAX RADIUS	:	1.909	1.184	1.059
HORIZONTAL SPREAD	:	2.994	2.233	1.877
VERTICAL SPREAD	:	1.304	.921	.921
EXTREME SPREAD	:	3.041	2.242	1.909
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522154

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

LE = 2.970

VS = 2.367

GS = 3.298

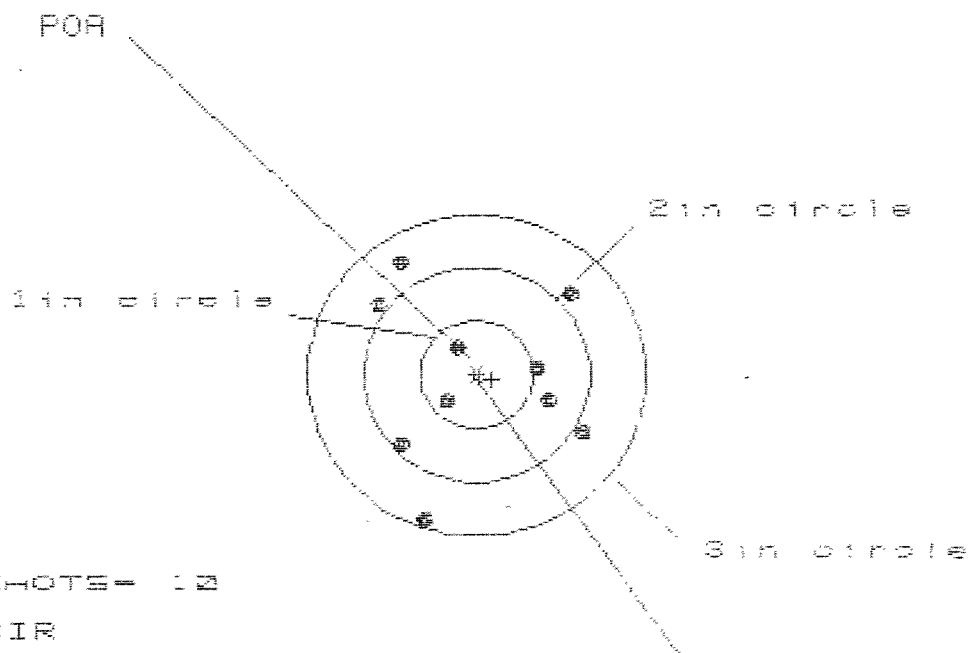
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.267	1.360
MINIMUM X	:	-1.533	-.906	-.813
MAXIMUM Y	:	1.069	1.170	1.021
MINIMUM Y	:	-1.298	-1.197	-1.736
CENTROID X	:	-.140	.030	-.063
CENTROID Y	:	-.142	-.243	-.094
POA TO CENTROID in.	:	.199	.245	.112
MIN RADIUS	:	.362	.338	.425
MEAN RADIUS	:	.980	.895	.815
MAX RADIUS	:	1.785	1.409	1.367
HORIZONTAL SPREAD	:	2.970	2.173	2.173
VERTICAL SPREAD	:	2.367	2.367	1.757
EXTREME SPREAD	:	3.298	2.670	2.209
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522154

CENTERFIRE PATTERNS

5



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

1st = 1.795

2nd = 2.389

3rd = 2.457

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.967	.919	.927
MINIMUM X	:	-.818	-.866	-.959
MAXIMUM Y	:	1.076	.930	.740
MINIMUM Y	:	-1.313	-.788	-.672
CENTROID X	:	-.135	-.087	.005
CENTROID Y	:	.045	.191	.075
POA TO CENTROID in.	:	.142	.210	.075
MIN RADIUS	:	.331	.260	.394
MEAN RADIUS	:	.830	.817	.758
MAX RADIUS	:	1.381	1.188	1.169
HORIZONTAL SPREAD	:	1.785	1.785	1.785
VERTICAL SPREAD	:	2.389	1.718	1.412
EXTREME SPREAD	:	2.457	2.297	2.152
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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

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

DUPONT

MODEL 700™ M24

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

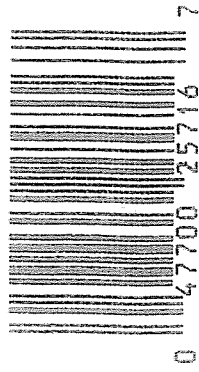
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06522154

ORDER NO.
5716



5716 06522154

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