

C6522351

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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.

01

SERIAL NO.
C6522351

ORDER NO.
5716


5716 C6522351

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

UPC


0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522351
13 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.399846
1 TO	2	.142285
1 TO	3	.0887694
1 TO	4	.241661
1 TO	5	.512712

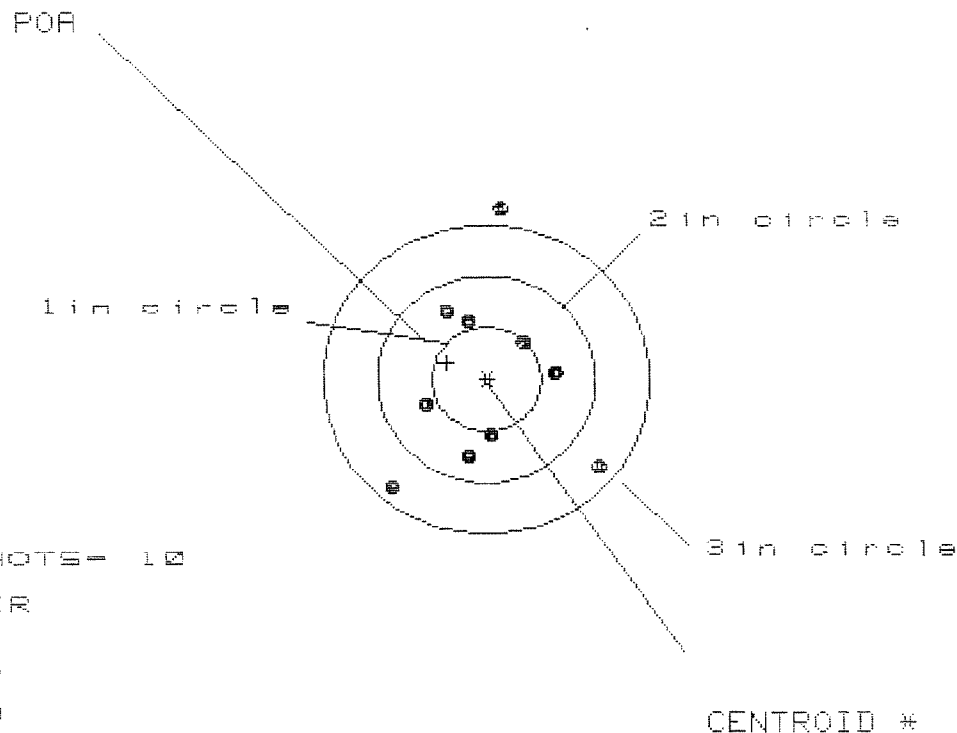
$\frac{S}{T}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3498
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3498
THE AMP FOR THIS RIFLE IS: .8936

13 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522351

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 1.050

VS = 2.700

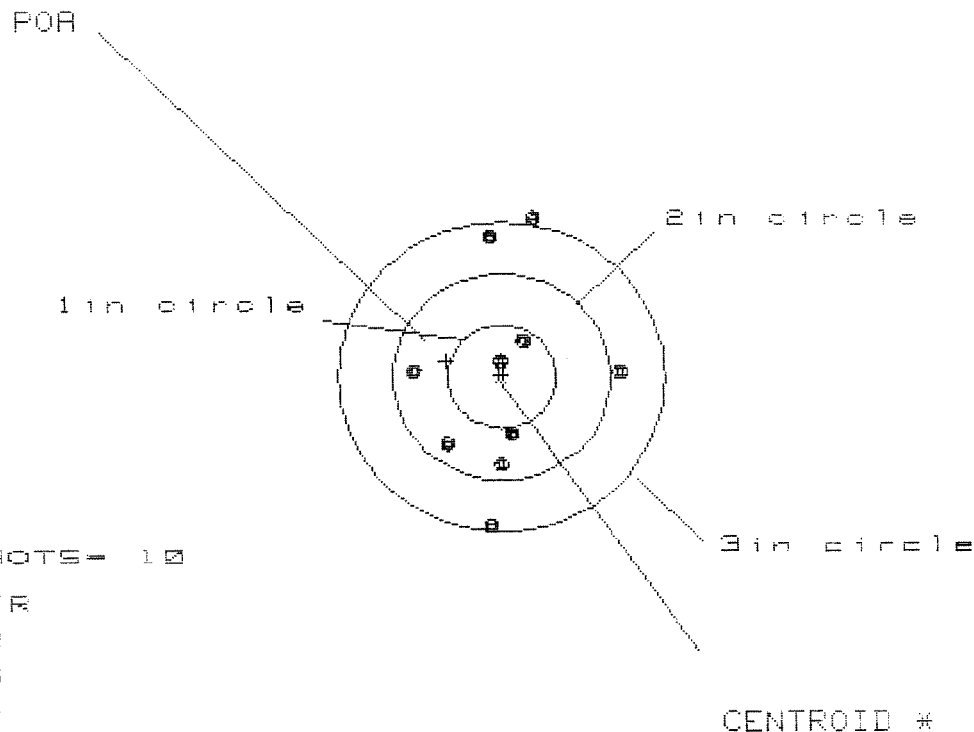
GS = 0.867

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.005	1.014	.908
MINIMUM X	-.855	-.846	-.644
MAXIMUM Y	1.672	.838	.732
MINIMUM Y	-1.036	-.850	-.714
CENTROID X	.366	.357	.463
CENTROID Y	-.161	-.347	-.241
POA TO CENTROID in.	.400	.498	.522
MIN RADIUS	.479	.317	.427
MEAN RADIUS	.859	.753	.691
MAX RADIUS	1.675	1.199	1.155
HORIZONTAL SPREAD	1.860	1.860	1.552
VERTICAL SPREAD	2.700	1.688	1.446
EXTREME SPREAD	2.867	1.968	1.968
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

13 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.876

VS = 2.944

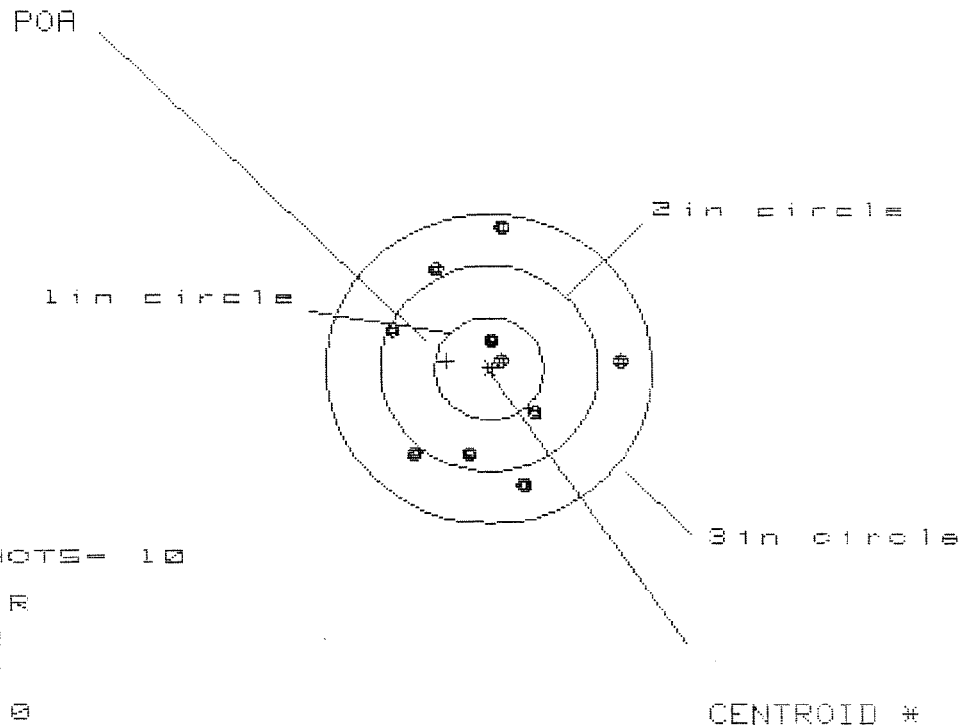
GS = 2.970

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	1.125	1.117
MINIMUM X	:	-.783	-.751	-.759
MAXIMUM Y	:	1.512	1.553	1.395
MINIMUM Y	:	-1.432	-1.264	-.806
CENTROID X	:	.508	.476	.484
CENTROID Y	:	-.152	-.320	-.162
POA TO CENTROID in.	:	.530	.573	.511
MIN RADIUS	:	.154	.314	.158
MEAN RADIUS	:	.900	.818	.753
MAX RADIUS	:	1.540	1.558	1.401
HORIZONTAL SPREAD	:	1.876	1.876	1.876
VERTICAL SPREAD	:	2.944	2.817	2.231
EXTREME SPREAD	:	2.970	2.817	2.233
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.092

VS = 2.498

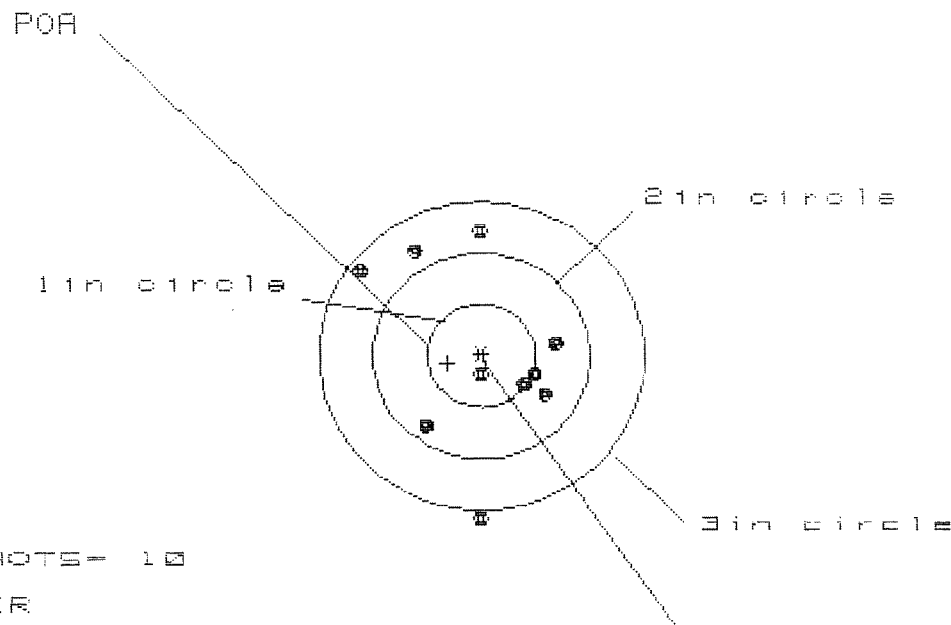
GS = 2.505

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.238	1.254	.544
MINIMUM X	-.854	-.838	-.681
MAXIMUM Y	1.370	1.080	1.113
MINIMUM Y	-1.128	-.976	-.943
CENTROID X	.388	.372	.215
CENTROID Y	-.075	-.227	-.260
POA TO CENTROID in.	.395	.436	.338
MIN RADIUS	.169	.285	.417
MEAN RADIUS	.876	.820	.768
MAX RADIUS	1.378	1.281	1.165
HORIZONTAL SPREAD	2.092	2.092	1.225
VERTICAL SPREAD	2.498	2.056	2.056
EXTREME SPREAD	2.505	2.225	2.225
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.750

VS= 2.786

GS= 2.786

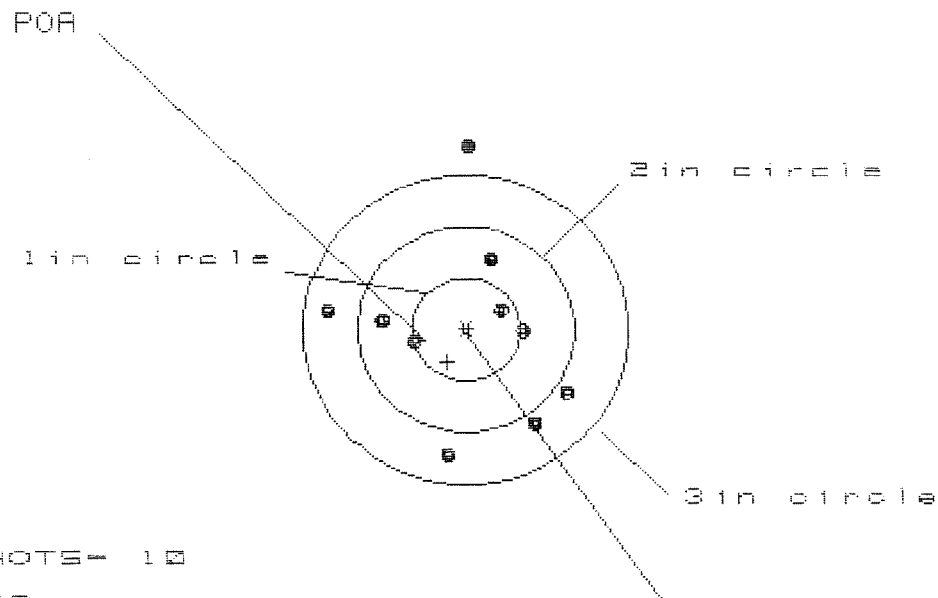
CENTROID *

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.651	.653	.515
MINIMUM X	-1.109	-1.107	-.788
MAXIMUM Y	1.204	1.028	1.110
MINIMUM Y	-1.582	-.861	-.778
CENTROID X	.314	.312	.450
CENTROID Y	.075	.251	.169
POA TO CENTROID in.	.323	.400	.480
MIN RADIUS	.148	.322	.258
MEAN RADIUS	.879	.823	.710
MAX RADIUS	1.583	1.289	1.239
HORIZONTAL SPREAD	1.760	1.760	1.303
VERTICAL SPREAD	2.786	1.889	1.889
EXTREME SPREAD	2.786	2.122	1.954
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.208

VS= 3.063

CS= 3.067

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.965
MINIMUM X	-1.243
MAXIMUM Y	1.807
MINIMUM Y	-1.256
CENTROID X	.173
CENTROID Y	.314
POA TO CENTROID in.	.359
MIN RADIUS	.381
MEAN RADIUS	.954
MAX RADIUS	1.807
HORIZONTAL SPREAD	2.208
VERTICAL SPREAD	3.063
EXTREME SPREAD	3.067
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6527351

DATE 9/12/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.40	2.50	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.35	2.25	2.33	
PULL #3	2.46	2.40	2.49	2.30	
PULL #4	2.45	2.41	2.79	2.34	
PULL #5	2.48	2.33	2.30	2.30	
TOTAL	12.34	11.89	11.83	11.63	
AVG.	2.47	2.38	2.36	2.326	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.05		
PULL #2	3.00	3.09		
PULL #3	3.01	2.95		
PULL #4	3.00	3.02		
PULL #5	3.01	3.08		
TOTAL	15.09	15.19		
AVG.	3.02	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.30		3.91
PULL #2	4.20	4.39		4.12
PULL #3	4.15	4.40		4.07
PULL #4	4.30	4.36		4.01
PULL #5	4.25	4.20		3.90
TOTAL	20.90	21.65		20.01
AVG.	4.18	4.33		4.00

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522351

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCD
	Magnaflux Bolt		8/22/90	KCD
615	Rollmark Caliber		8/22/90	GS.
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/23/90	DA
	Apply Coating (Bolt)		8/23/90	DA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/2/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
605 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			9/12/90	WB
	G) Safety Off Force	2 3/4	2 1/2	2 3/4			9/12/90	WB
	H) Trigger Pull Test & Retainability						9/12/90	WB
	I) Firing Pin Indent	.023	.023	.023			9/12/90	WB
	J) Assemble Stock						9/13/90	RW
	K) Assemble Swivel Studs						9/15/90	LS
	L) Attach Front and Rear Sight Assemblies						9/13/90	RW
	M) Iron Sight Alignment						9/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/13/90	RW
	O) Attach Scope to Rifle						9/13/90	RW
	P) Detach & Attach Scope 20 Times						9/13/90	RW
640	Gallery Target & Test						9-13-90	AC
	A) Time						9-13-90	AC
	B) Malfunctions						9-13-90	AC
	C) Pierced Primers						9-13-90	AC
	D) Optical Clarity of Scope						9-13-90	AC
645	Inspect for Live Ammo						9-13-90	AC
655	Final Inspection							
	A) Headspace						9/15/90	JD
	B) Trigger Pull	2.36	2.33	2.30	2.34	2.30	9-15-90	JP
	C) Function						9/15/90	LS
660	Pack						9/19/90	AE