

C6523322

MODEL 700™ M24

Model **SMS**™

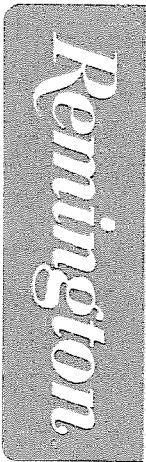
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

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

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

MODEL 700TM M24	SERIAL NO. C6523322
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.	ORDER NO. 5716

Ø1


5716 C6523322

UPC


0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523322

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3	90	RW
600	Proof	10 3	90	RW
607	Check Headspace	10 3	90	RW
610	Dis-assemble Gun	10 3	90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	LS
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-13-90	TSH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-90	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/7/90	RW
	G) Safety Off Force	3	2.5	3			11/7/90	RW
	H) Trigger Pull Test & Retainability						11-7-90	JM
	I) Firing Pin Indent	.021	.021	.0205			11/7/90	RW
	J) Assemble Stock						11/7/90	RW
	K) Assemble Swivel Studs						11-20-90	JDS
	L) Attach Front and Rear Sight Assemblies						11/7/90	RW
	M) Iron Sight Alignment						11/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/7/90	RW
	O) Attach Scope to Rifle						11/7/90	RW
	P) Detach & Attach Scope 20 Times						11/7/90	RW
640	Gallery Target & Test						11/8/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11/8/90	NF
655	Final Inspection							
	A) Headspace						11-20-90	JDS
	B) Trigger Pull	242	231	243	245	252	11-20-90	JDS
	C) Function						11-26-90	JDS
660	Pack						12/14/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523322

DATE 11-7-90

TESTER JEF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.40	2.42	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.42	2.43	2.31	
PULL #3	2.50	2.24	2.46	2.43	
PULL #4	2.50	2.41	2.47	2.45	
PULL #5	2.36	2.40	2.46	2.52	
TOTAL	11.88	11.87	12.24		
AVG.	2.376	2.374	2.448		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.40		
PULL #2	3.43	3.37		
PULL #3	3.44	3.42		
PULL #4	3.42	3.42		
PULL #5	3.41	3.39		
TOTAL	16.98	17.00		
AVG.	3.396	3.4		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.41		4.39
PULL #2	4.33	4.37		4.40
PULL #3	4.29	4.40		4.40
PULL #4	4.29	4.42		4.39
PULL #5	4.22	4.38		4.30
TOTAL	21.48	21.98		21.88
AVG.	4.296	4.396		4.376

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523322
9 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.174897
1 TO	2	.1703
1 TO	3	.230835
1 TO	4	.258817
1 TO	5	.233212

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136577
THE AMR FOR THIS RIFLE IS: .910

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523322

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.074

VS= 2.196

GS= 2.271

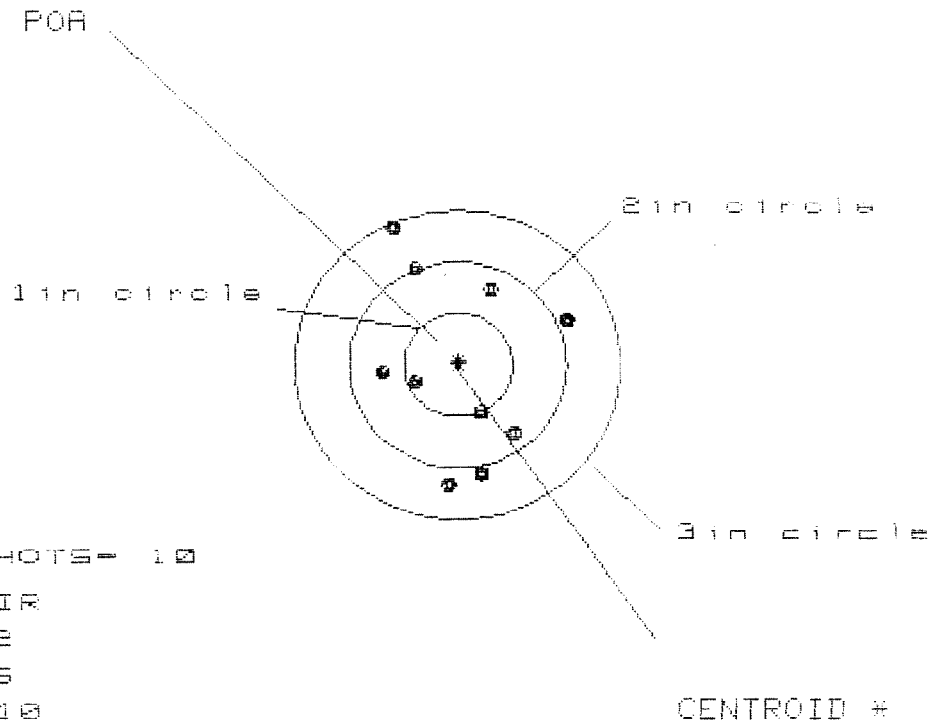
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.928	1.003	1.073
MINIMUM X	-1.145	-1.071	-1.001
MAXIMUM Y	1.051	.795	.666
MINIMUM Y	-1.145	-1.028	-.399
CENTROID X	.185	.090	.020
CENTROID Y	-.058	-.175	-.046
POA TO CENTROID in.	.174	.197	.050
MIN RADIUS	.185	.269	.329
MEAN RADIUS	.812	.759	.711
MAX RADIUS	1.247	1.171	1.080
HORIZONTAL SPREAD	2.074	2.074	2.074
VERTICAL SPREAD	2.196	1.823	1.065
EXTREME SPREAD	2.271	2.190	2.121
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

5 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523322

CENTERFIRE PATTERNS # 2



HS = 1.715

VS = 2.513

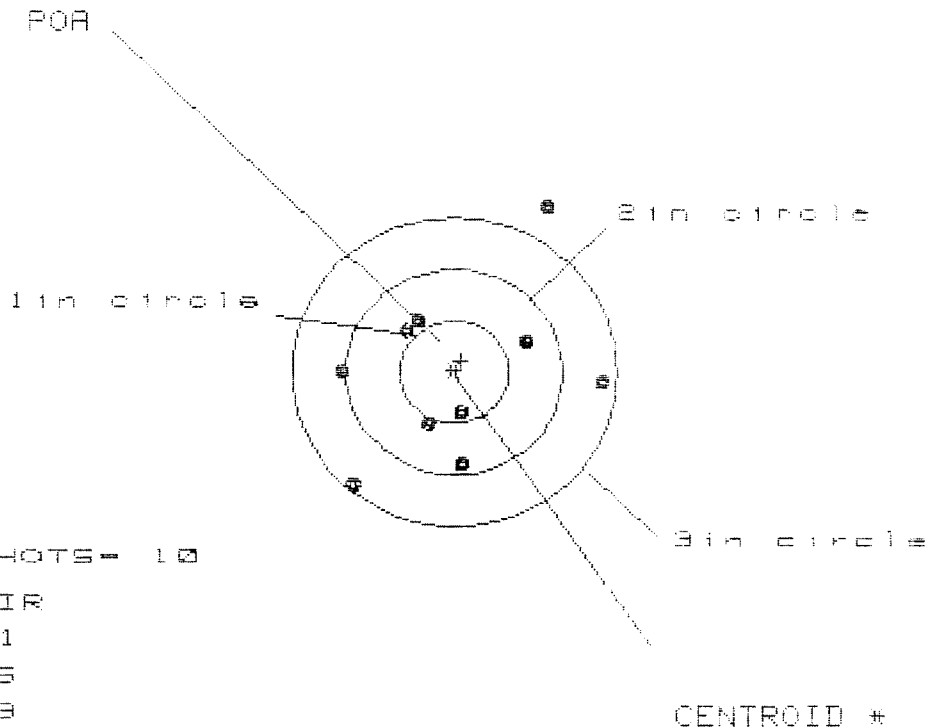
GS = 2.565

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.975	.913	.900
MINIMUM X	-.740	-.802	-.815
MAXIMUM Y	1.370	1.042	.910
MINIMUM Y	-1.143	-.990	-.992
CENTROID X	-.004	.058	.071
CENTROID Y	-.037	-.190	-.066
POA TO CENTROID in.	.038	.198	.097
MIN RADIUS	.370	.292	.402
MEAN RADIUS	.887	.797	.779
MAX RADIUS	1.480	1.135	1.029
HORIZONTAL SPREAD	1.715	1.715	1.715
VERTICAL SPREAD	2.513	2.032	1.910
EXTREME SPREAD	2.565	2.061	1.988
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523322

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.412

VS= 2.623

GS= 3.160

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.397
MINIMUM X	-1.015
MAXIMUM Y	1.567
MINIMUM Y	-1.056
CENTROID X	-.061
CENTROID Y	-.105
POA TO CENTROID in.	.122
MIN RADIUS	.376
MEAN RADIUS	.941
MAX RADIUS	1.767
HORIZONTAL SPREAD	2.412
VERTICAL SPREAD	2.623
EXTREME SPREAD	3.160
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08528382

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.828

VS = 1.153

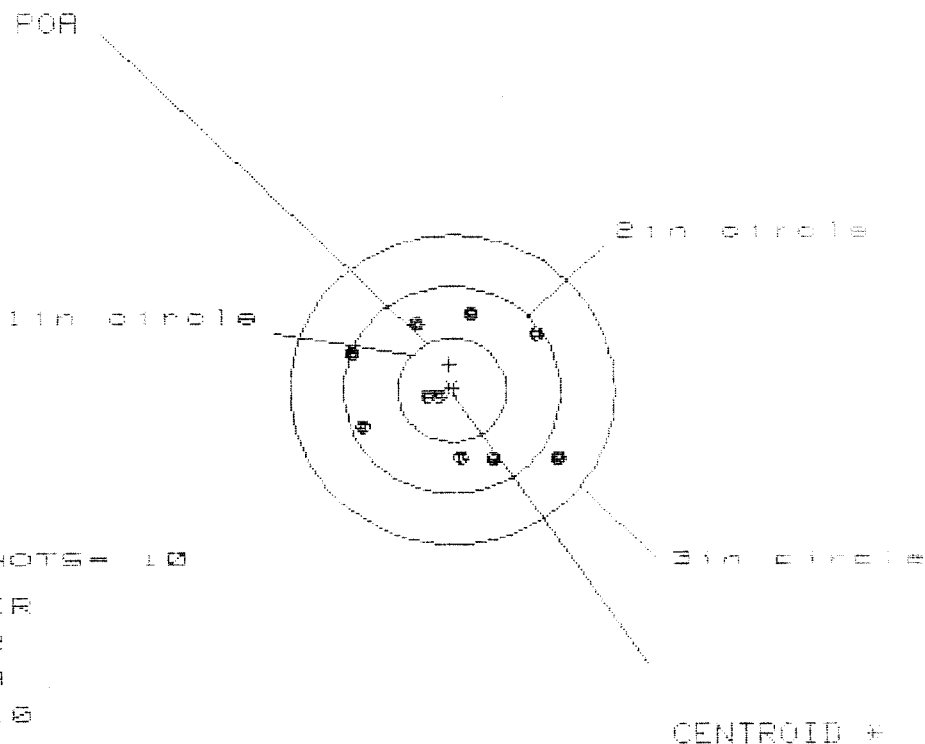
GS = 1.984

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.816	.704	.564
MINIMUM X	:	-1.012	-1.122	-.972
MAXIMUM Y	:	.539	.502	.537
MINIMUM Y	:	-.614	-.651	-.616
CENTROID X	:	-.016	.096	.238
CENTROID Y	:	-.243	-.206	-.241
POA TO CENTROID in.	:	.243	.228	.338
MIN RADIUS	:	.158	.240	.132
MEAN RADIUS	:	.718	.669	.593
MAX RADIUS	:	1.064	1.157	1.002
HORIZONTAL SPREAD	:	1.828	1.826	1.536
VERTICAL SPREAD	:	1.153	1.153	1.153
EXTREME SPREAD	:	1.984	1.984	1.691
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06583322

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HE = 1.877

VS = 1.460

GS = 2.099

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.959	.922	.621
MINIMUM X	-.918	-.811	-.696
MAXIMUM Y	.788	.718	.780
MINIMUM Y	-.673	-.742	-.680
CENTROID X	.027	-.080	-.195
CENTROID Y	-.246	-.177	-.239
POA TO CENTROID in.	.248	.194	.309
MIN RADIUS	.104	.079	.049
MEAN RADIUS	.732	.666	.598
MAX RADIUS	1.147	1.048	.921
HORIZONTAL SPREAD	1.877	1.733	1.317
VERTICAL SPREAD	1.460	1.460	1.460
EXTREME SPREAD	2.099	1.872	1.643
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	