

C6523331

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

Remington®

MODEL 700™ M24

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

SERIAL NO.
C6523331

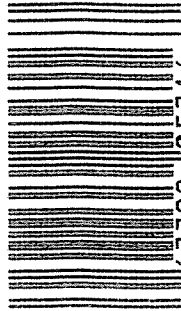
ORDER NO.
5716

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



5716 C6523331

LIPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523331

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	SL
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel <i>AB</i>		10/19/90	WB
620	Apply Coatings (Barrel Action)		11/5/90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-90	MI

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			11/12/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/12/90	WB
	H) Trigger Pull Test & Retainability						11-12-90	JH
	I) Firing Pin Indent	.021	.022	.022			11/12/90	WB
	J) Assemble Stock						11/14/90	RW
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/14/90	RW
	M) Iron Sight Alignment						11/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	RW
	O) Attach Scope to Rifle						11/14/90	RW
	P) Detach & Attach Scope 20 Times						11/14/90	RW
640	Gallery Target & Test						11-15-90	DH
	A) Time						11-15-90	DH
	B) Malfunctions						11-15-90	DH
	C) Pierced Primers						11-15-90	DH
	D) Optical Clarity of Scope						11-15-90	DH
645	Inspect for Live Ammo						11-15-90	DH
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.85	2.65	2.70	2.64	2.69	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523331

DATE 11-12-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.44	2.37	2.85	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.40	2.37	2.65	
PULL #3	2.18	2.39	2.36	2.70	
PULL #4	2.27	2.40	2.37	2.64	
PULL #5	2.41	2.39	2.32	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.38		
PULL #2	3.43	3.42		
PULL #3	3.41	3.41		
PULL #4	3.49	3.39		
PULL #5	3.49	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.35		4.41
PULL #2	4.28	4.37		4.40
PULL #3	4.36	4.33		4.39
PULL #4	4.33	4.40		4.38
PULL #5	4.35	4.39		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6523331
 15 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.107912
1 TO	2	.435202
1 TO	3	.326741
1 TO	4	.174725
1 TO	5	.0865852

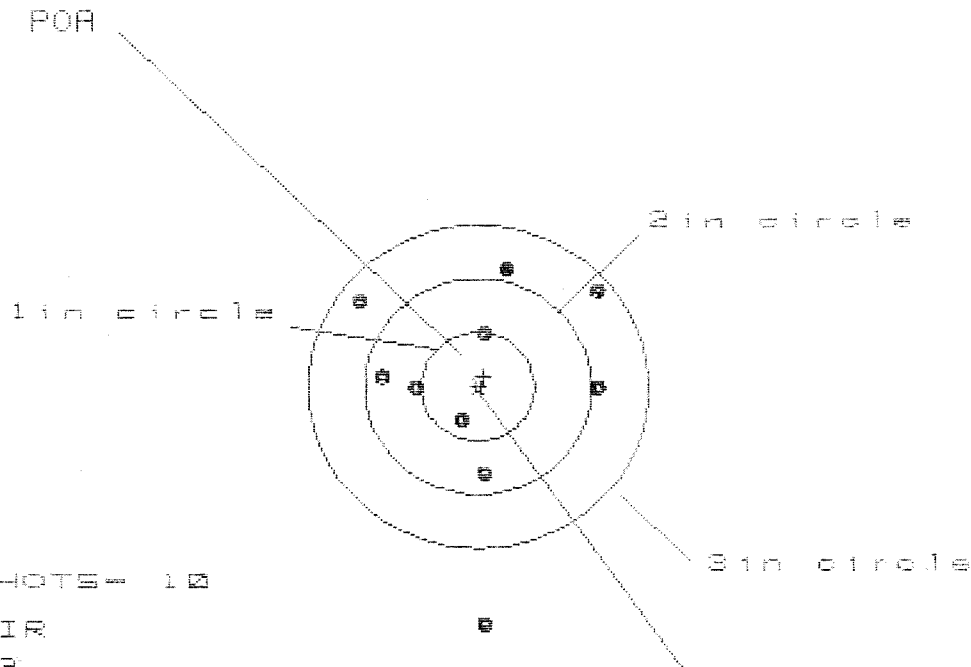
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0998
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1902
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214798
 THE AMR FOR THIS RIFLE IS: 1.027

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523331

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.131

VS = 3.284

GS = 3.292

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.099	1.100	1.228
MINIMUM X	-1.032	-1.031	-0.903
MAXIMUM Y	1.099	.857	.943
MINIMUM Y	-2.185	-1.078	-0.992
CENTROID X	-0.053	-0.054	-0.182
CENTROID Y	-0.094	.148	.062
POA TO CENTROID in.	.108	.158	.192
MIN RADIUS	.318	.234	.360
MEAN RADIUS	1.007	.856	.787
MAX RADIUS	2.185	1.241	1.245
HORIZONTAL SPREAD	2.131	2.131	2.131
VERTICAL SPREAD	3.284	1.935	1.935
EXTREME SPREAD	3.292	2.277	2.277
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523331

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.969

VS = 2.219

GS = 3.076

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.628	1.002	.857
MINIMUM X	:	-1.341	-1.160	-.893
MAXIMUM Y	:	1.042	.946	.927
MINIMUM Y	:	-1.177	-1.273	-1.292
CENTROID X	:	.296	.115	.260
CENTROID Y	:	-.354	-.258	-.239
POA TO CENTROID in.	:	.461	.283	.353
MIN RADIUS	:	.391	.401	.346
MEAN RADIUS	:	1.013	.897	.859
MAX RADIUS	:	1.841	1.497	1.443
HORIZONTAL SPREAD	:	2.969	2.162	1.750
VERTICAL SPREAD	:	2.219	2.219	2.219
EXTREME SPREAD	:	3.076	2.370	2.351
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1998

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 3.194

VS= 1.900

GS= 3.526

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.993	1.240	1.138
MINIMUM X	:	-1.201	-.980	-1.082
MAXIMUM Y	:	1.187	1.119	.976
MINIMUM Y	:	-.713	-.781	-.641
CENTROID X	:	.221	0.000	.102
CENTROID Y	:	-.272	-.204	-.344
POA TO CENTROID in.	:	.351	.204	.359
MIN RADIUS	:	.605	.446	.525
MEAN RADIUS	:	1.032	.879	.811
MAX RADIUS	:	2.085	1.466	1.306
HORIZONTAL SPREAD	:	3.194	2.220	2.220
VERTICAL SPREAD	:	1.900	1.900	1.617
EXTREME SPREAD	:	3.526	2.801	2.311
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Nov 1990

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.580

VS = 2.620

GS = 3.502

PATTERN #

4

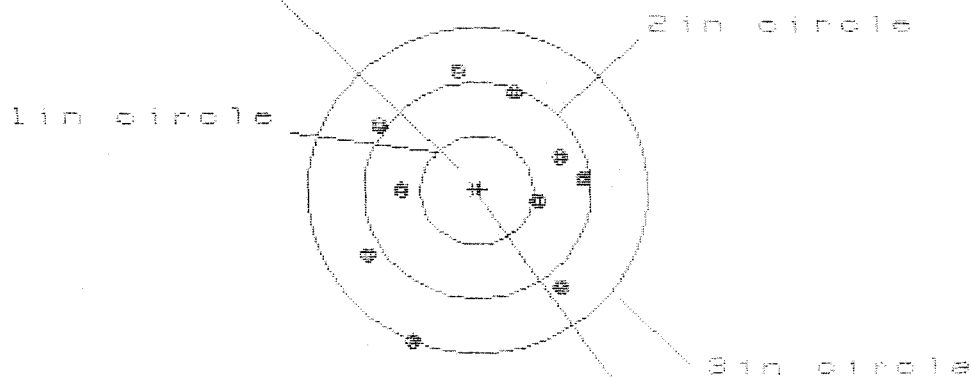
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.330	1.192	.575
MINIMUM X	:	-1.250	-.806	-.657
MAXIMUM Y	:	1.284	1.387	1.270
MINIMUM Y	:	-1.335	-1.193	-1.310
CENTROID X	:	.067	.205	.056
CENTROID Y	:	-.221	-.364	-.247
POA TO CENTROID in.	:	.231	.418	.253
MIN RADIUS	:	.235	.052	.230
MEAN RADIUS	:	1.104	1.000	.940
MAX RADIUS	:	1.792	1.518	1.431
HORIZONTAL SPREAD	:	2.580	1.998	1.232
VERTICAL SPREAD	:	2.620	2.580	2.580
EXTREME SPREAD	:	3.502	2.858	2.647
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 May 1998

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.881

VS= 2.519

GS= 2.548

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.920	.856	.939
MINIMUM X	-.961	-1.025	-.943
MAXIMUM Y	1.090	.932	.795
MINIMUM Y	-1.429	-1.094	-.862
CENTROID X	-.032	.032	-.051
CENTROID Y	-.010	.148	.285
POA TO CENTROID in.	.033	.152	.290
MIN RADIUS	.510	.494	.635
MEAN RADIUS	.981	.895	.837
MAX RADIUS	1.540	1.279	1.277
HORIZONTAL SPREAD	1.881	1.881	1.881
VERTICAL SPREAD	2.519	2.026	1.657
EXTREME SPREAD	2.548	2.224	1.986
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	