

C6523339

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6523339

ORDER NO.
5716

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

LPC

0 47700 25716 7



5716 C6523339

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523339

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	GL
617	Drill and Tap Sight Holes		9/28/90	FB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/27/90	DH

op. #	BARBER - M24 0006346 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/27/90	WB
	G) Safety Off Force	3	3	3			10/27/90	WB
	H) Trigger Pull Test & Retainability						10/27/90	DH
	I) Firing Pin Indent	.023	.023	.023			10/27/90	WB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/10/90	JS
	L) Attach Front and Rear Sight Assemblies						10/29/90	RW
	M) Iron Sight Alignment						10/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/90	RW
	O) Attach Scope to Rifle						10/29/90	RW
	P) Detach & Attach Scope 20 Times						10/29/90	RW
640	Gallery Target & Test						10-30-90	KT
	A) Time						10-30-90	KT
	B) Malfunctions						10-30-90	KT
	C) Pierced Primers						10-30-90	KT
	D) Optical Clarity of Scope						10-30-90	KT
645	Inspect for Live Ammo						10-30-90	KT
655	Final Inspection							
	A) Headspace						3/10/90	JS
	B) Trigger Pull	269	256	260	249	248	3/10/90	JS
	C) Function						3/10/90	JS
660	Pack						6-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523339

DATE 10-27-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.69	2.62	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.57	2.62	2.56	
PULL #3	2.66	2.61	2.51	2.60	
PULL #4	2.52	2.65	2.78	2.49	
PULL #5	2.54	2.60	2.52	2.58	
TOTAL	2.69	13.12	13.05		
AVG.	2.53	2.62	2.61		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.01		
PULL #2	3.00	3.11		
PULL #3	3.04	3.15		
PULL #4	3.10	3.17		
PULL #5	3.04	3.16		
TOTAL	15.21	15.60		
AVG.	3.04	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.18		4.07
PULL #2	4.04	4.03		4.08
PULL #3	4.04	4.14		4.00
PULL #4	4.18	4.00		4.04
PULL #5	4.13	4.09		4.07
TOTAL	20.42	20.44		20.26
AVG.	4.08	4.08		4.05

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523339
31 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.355106
1 TO	2	.259509
1 TO	3	.40606
1 TO	4	.32037
1 TO	5	.150615

4
1
2

-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0428
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.228
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .231982

THE AMR FOR THIS RIFLE IS: .9714

31 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523333

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 2.074

VS = 2.781

GS = 2.983

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.820	.848	.827
MINIMUM X	-1.254	-1.163	-1.184
MAXIMUM Y	1.319	1.035	.871
MINIMUM Y	-1.462	-1.315	-1.222
CENTROID X	.028	-.063	-.042
CENTROID Y	-.354	-.501	-.336
POA TO CENTROID in.	.355	.505	.339
MIN RADIUS	.159	.237	.100
MEAN RADIUS	.826	.750	.651
MAX RADIUS	1.553	1.326	1.266
HORIZONTAL SPREAD	2.074	2.011	2.011
VERTICAL SPREAD	2.781	2.350	2.093
EXTREME SPREAD	2.983	2.350	2.188
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

31 Oct 1990

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS= 2.570

VS= 3.798

GS= 4.201

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.121	1.215
MINIMUM X	:	-1.024	-.852	-.758
MAXIMUM Y	:	1.690	1.492	1.204
MINIMUM Y	:	-2.107	-2.306	-1.253
CENTROID X	:	.211	.039	-.055
CENTROID Y	:	-.538	-.340	-.052
POA TO CENTROID in.	:	.578	.342	.076
MIN RADIUS	:	.387	.478	.353
MEAN RADIUS	:	1.270	1.115	.934
MAX RADIUS	:	2.362	2.425	1.901
HORIZONTAL SPREAD	:	2.570	1.973	1.973
VERTICAL SPREAD	:	3.798	3.798	2.457
EXTREME SPREAD	:	4.201	3.982	2.459
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.560

VS = 2.590

GS = 2.994

CENTROID *

PATTERN #

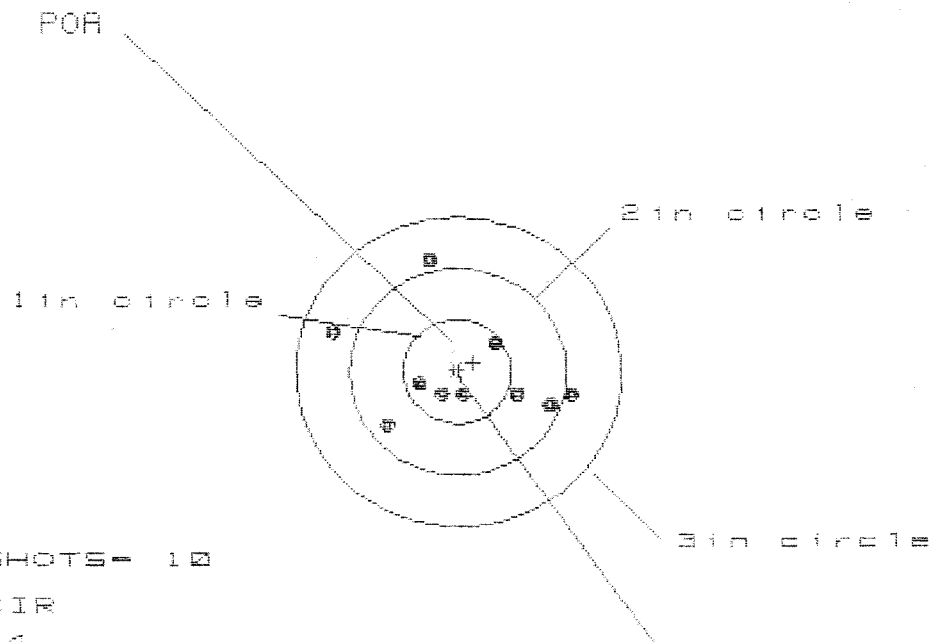
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.175	1.098	.874
MINIMUM X	-1.385	-1.462	-1.325
MAXIMUM Y	.930	.746	.594
MINIMUM Y	-1.660	-1.291	-.548
CENTROID X	.035	.112	-.026
CENTROID Y	.052	.236	.398
POA TO CENTROID in.	.063	.261	.398
MIN RADIUS	.404	.302	.220
MEAN RADIUS	1.051	.926	.822
MAX RADIUS	1.797	1.695	1.325
HORIZONTAL SPREAD	2.560	2.560	2.198
VERTICAL SPREAD	2.590	2.037	1.132
EXTREME SPREAD	2.994	2.932	2.280
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.175

VS = 1.640

GS = 2.253

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.034
MINIMUM X	-1.142
MAXIMUM Y	1.106
MINIMUM Y	-0.534
CENTROID X	-0.146
CENTROID Y	-0.085
POA TO CENTROID in.	.169
MIN RADIUS	.261
MEAN RADIUS	.707
MAX RADIUS	1.203
HORIZONTAL SPREAD	2.176
VERTICAL SPREAD	1.640
EXTREME SPREAD	2.253
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 3.280

VS = 2.093

GS = 3.748

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.259	1.035	.865
MINIMUM X	:	-2.021	-1.258	-1.129
MAXIMUM Y	:	1.221	1.155	.725
MINIMUM Y	:	-.872	-.938	-.793
CENTROID X	:	.086	.310	.181
CENTROID Y	:	-.215	-.149	-.294
POA TO CENTROID in.	:	.231	.344	.345
MIN RADIUS	:	.220	.130	.116
MEAN RADIUS	:	1.003	.851	.749
MAX RADIUS	:	2.106	1.551	1.174
HORIZONTAL SPREAD	:	3.280	2.293	1.994
VERTICAL SPREAD	:	2.093	2.093	1.518
EXTREME SPREAD	:	3.748	2.521	2.251
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	