

06523342

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

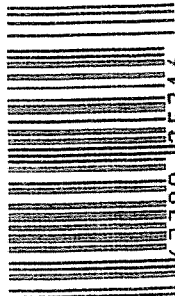
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6523342	01
ORDER NO. 5716	



5716 C6523342

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523342

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KH
600	Proof		10/2/90	KH
607	Check Headspace		10/2/90	KH
610	Dis-assemble Gun		10/2/90	KH
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	GL
617	Drill and Tap Sight Holes		10/8/90	LB
618	Polish Barrel RB		10/9/90	LB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	3 ³ / ₄	3 ³ / ₄			11/9/90	WB
	G) Safety Off Force	2	2	2			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-9-90	9/1
	I) Firing Pin Indent	.021	.021	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	KS
	K) Assemble Swivel Studs						11-9-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	KS
	M) Iron Sight Alignment						11/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	KS
	O) Attach Scope to Rifle						11/9/90	KS
	P) Detach & Attach Scope 20 Times						11/9/90	KS
640	Gallery Target & Test						11-12-90	KT
	A) Time						11-12-90	KT
	B) Malfunctions						11-12-90	KT
	C) Pierced Primers						11-12-90	KT
	D) Optical Clarity of Scope						11-12-90	KT
645	Inspect for Live Ammo						11-12-90	KT
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.13	2.07	2.00	2.04	2.06	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. 26523342

DATE 11-9-90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.47	2.20	213	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.48	2.25	207	
PULL #3	2.32	2.47	2.20	2.00	
PULL #4	2.48	2.27	2.35	2.04	
PULL #5	2.45	2.19	2.30	2.06	
TOTAL	12.04	11.88	11.30		
AVG.	2.408	2.376	2.26		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.31		
PULL #2	3.35	3.34		
PULL #3	3.33	3.28		
PULL #4	3.32	3.28		
PULL #5	3.30	3.32		
TOTAL	16.55	16.53		
AVG.	3.31	3.306		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.27		4.48
PULL #2	4.41	4.39		4.48
PULL #3	4.42	4.42		4.41
PULL #4	4.45	4.43		4.46
PULL #5	4.41	4.44		4.43
TOTAL	22.11	21.95		22.26
AVG.	4.422	4.39		4.452

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523342
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.12621
1 TO	2	.283593
1 TO	3	.09717
1 TO	4	.100846
1 TO	5	.131605

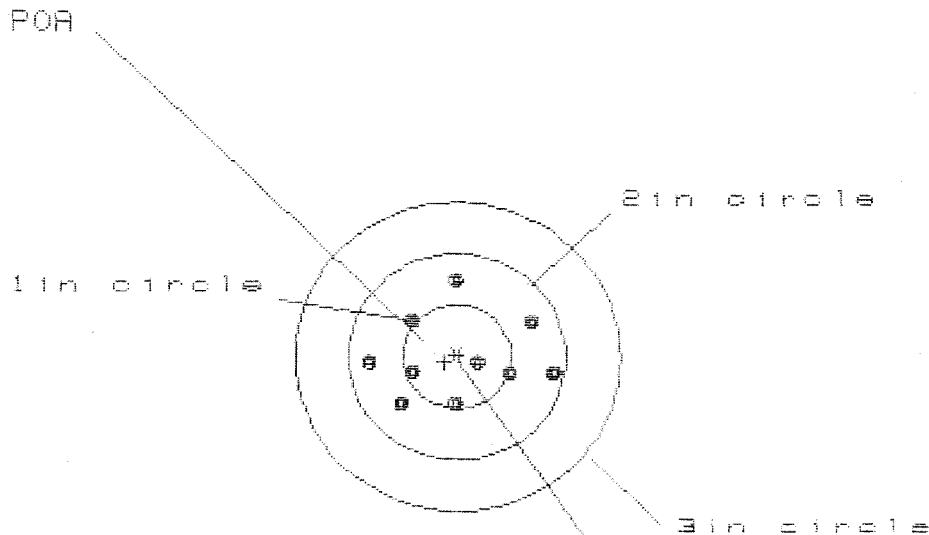
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0000
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0820731
THE AMR FOR THIS RIFLE IS: .8492

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523342

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 10

3 in = 10

HS = 1.702

VS = 1.174

GS = 1.704

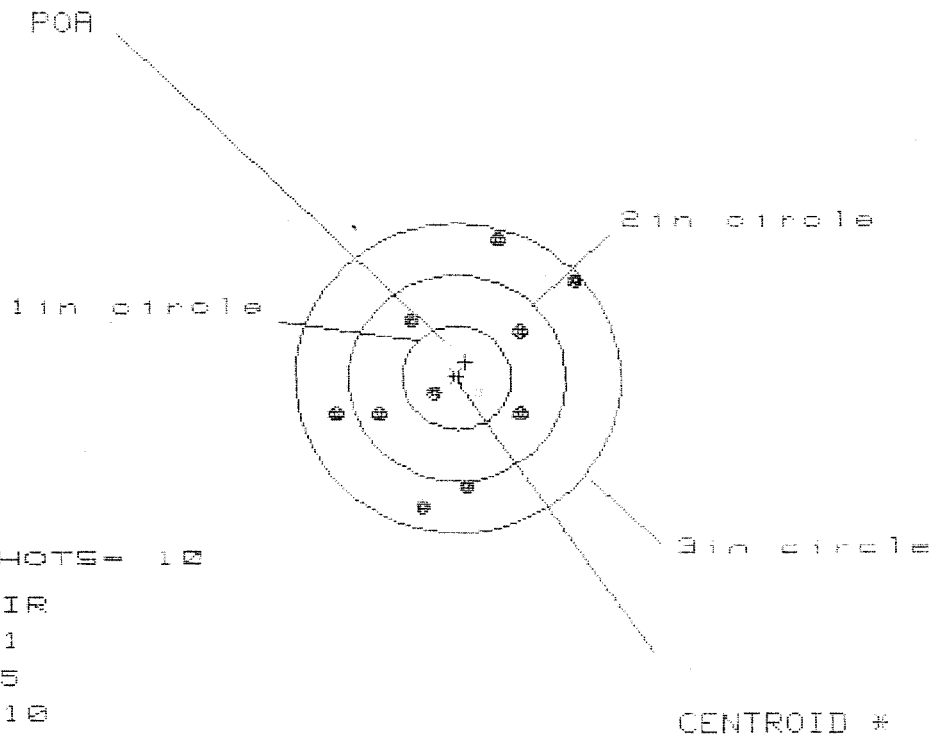
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.767	.679
MINIMUM X	-.803	-.703	-.537
MAXIMUM Y	.728	.715	.707
MINIMUM Y	-.446	-.459	-.467
CENTROID X	.115	.015	.103
CENTROID Y	.052	.065	.073
POA TO CENTROID in.	.126	.067	.126
MIN RADIUS	.142	.243	.159
MEAN RADIUS	.597	.559	.535
MAX RADIUS	.907	.843	.761
HORIZONTAL SPREAD	1.702	1.470	1.216
VERTICAL SPREAD	1.174	1.174	1.174
EXTREME SPREAD	1.704	1.526	1.445
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

13 Nov 1938

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

H = 2.173

V = 2.546

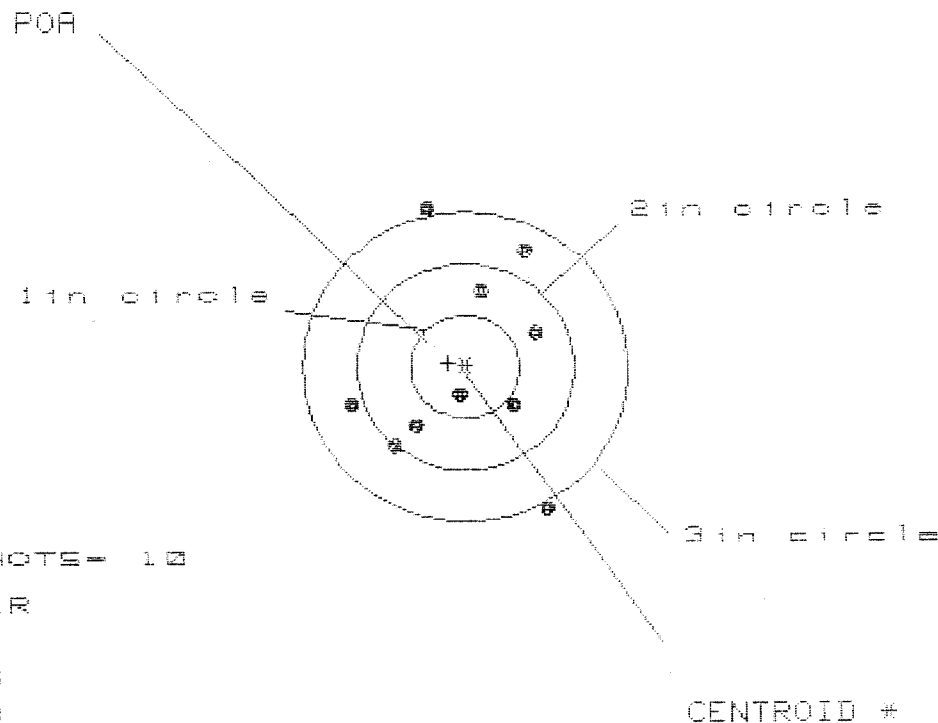
G = 2.663

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.090	.737	.885
MINIMUM X	:	-1.083	-.962	-.894
MAXIMUM Y	:	1.335	1.438	.844
MINIMUM Y	:	-1.211	-1.188	-.928
CENTROID X	:	-.082	-.203	-.271
CENTROID Y	:	-.152	-.255	-.435
POA TO CENTROID in.	:	.173	.326	.512
MIN RADIUS	:	.261	.110	.159
MEAN RADIUS	:	.942	.859	.756
MAX RADIUS	:	1.429	1.539	1.126
HORIZONTAL SPREAD	:	2.173	1.699	1.699
VERTICAL SPREAD	:	2.546	2.546	1.772
EXTREME SPREAD	:	2.663	2.663	1.963
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 1.744

VS = 2.854

GS = 3.043

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.715
MINIMUM X	-1.029
MAXIMUM Y	1.534
MINIMUM Y	-1.320
CENTROID X	.154
CENTROID Y	-.037
POA TO CENTROID in.	.158
MIN RADIUS	.295
MEAN RADIUS	.958
MAX RADIUS	1.571
HORIZONTAL SPREAD	1.744
VERTICAL SPREAD	2.854
EXTREME SPREAD	3.043
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

13 May 1998

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CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.421

VS = 3.263

GS = 3.291

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.841	.769
MINIMUM X	:	-.564	-.588	-.568
MAXIMUM Y	:	1.319	1.103	.936
MINIMUM Y	:	-1.944	-1.530	-1.392
CENTROID X	:	.064	.088	.152
CENTROID Y	:	.139	.355	.217
POR TO CENTROID in.	:	.153	.364	.265
MIN RADIUS	:	.479	.271	.417
MEAN RADIUS	:	.981	.834	.797
MAX RADIUS	:	1.949	1.530	1.394
HORIZONTAL SPREAD	:	1.421	1.421	1.329
VERTICAL SPREAD	:	3.263	2.633	2.328
EXTREME SPREAD	:	3.291	2.697	2.474
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

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.429

VS= 2.699

GS= 3.267

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.780	.409	.418
MINIMUM X	-.648	-.451	-.399
MAXIMUM Y	1.678	1.149	1.045
MINIMUM Y	-1.021	-.835	-.425
CENTROID X	.153	-.044	-.096
CENTROID Y	-.074	-.260	-.156
POA TO CENTROID in.	.170	.264	.183
MIN RADIUS	.192	.126	.126
MEAN RADIUS	.768	.501	.455
MAX RADIUS	2.446	1.150	1.045
HORIZONTAL SPREAD	2.429	.860	.818
VERTICAL SPREAD	2.699	1.984	1.470
EXTREME SPREAD	3.267	2.034	1.527
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		