

06523371

MODEL 700TH M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700[™] M24

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

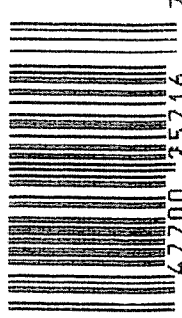
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6523371

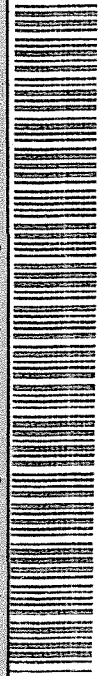
ORDER NO.
5716

01



UPC

0 47700 25716 7



5716 C6523371

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

06523371

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24 90		RW
600	Proof	9 24 90		RW
607	Check Headspace	9 24 90		RW
610	Dis-assemble Gun	9 24 90		RW
612	Magnaflux Barrel Action	9-25-90		KR
	Magnaflux Bolt	9-25-90		KR
615	Rollmark Caliber	9-25-90		JS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel		9/28/90	WS
620	Apply Coatings (Barrel Action)		10-2-90	JA
	Apply Coating (Bolt)		10-2-90	JA
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		10/10/90	WS

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/10/90	WB
	G) Safety Off Force	2	2	2			10/10/90	WB
	H) Trigger Pull Test & Retainability						10/10/90	WB
	I) Firing Pin Indent	.0225	.0225	.0225			10/10/90	WB
	J) Assemble Stock						10/10/90	RW
	K) Assemble Swivel Studs						2 NOV 90	LS
	L) Attach Front and Rear Sight Assemblies						10/10/90	RW
	M) Iron Sight Alignment						10/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/10/90	RW
	O) Attach Scope to Rifle						10/10/90	RW
	P) Detach & Attach Scope 20 Times						10/10/90	RW
640	Gallery Target & Test						10-12-90	DH
	A) Time						10-12-90	AC
	B) Malfunctions						10-12-90	AC
	C) Pierced Primers						10-12-90	AC
	D) Optical Clarity of Scope						10-12-90	AC
645	Inspect for Live Ammo						10-12-90	AC
655	Final Inspection							
	A) Headspace						2 NOV 90	LS
	B) Trigger Pull	265	231	232	241	239	2 NOV 90	LS
	C) Function						2 NOV 90	LS
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. C6523371

DATE 10/19/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.44	2.43	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.49	2.36	234	
PULL #3	2.43	2.41	2.39	232	
PULL #4	2.49	2.44	2.25	241	
PULL #5	2.41	2.38	2.36	234	
TOTAL	12.25	12.16	11.79		
AVG.	2.45	2.43	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.11		
PULL #2	3.14	3.13		
PULL #3	3.17	3.14		
PULL #4	3.12	3.00		
PULL #5	3.15	3.15		
TOTAL	15.75	15.53		
AVG.	3.15	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.30		4.21
PULL #2	4.18	4.18		4.07
PULL #3	4.29	4.20		4.14
PULL #4	4.34	4.20		4.09
PULL #5	4.35	4.10		4.10
TOTAL	21.51	20.98		20.61
AVG.	4.30	4.20		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523371
12 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.338421
1 TO	2	.526047
1 TO	3	.220737
1 TO	4	.139058
1 TO	5	.308934

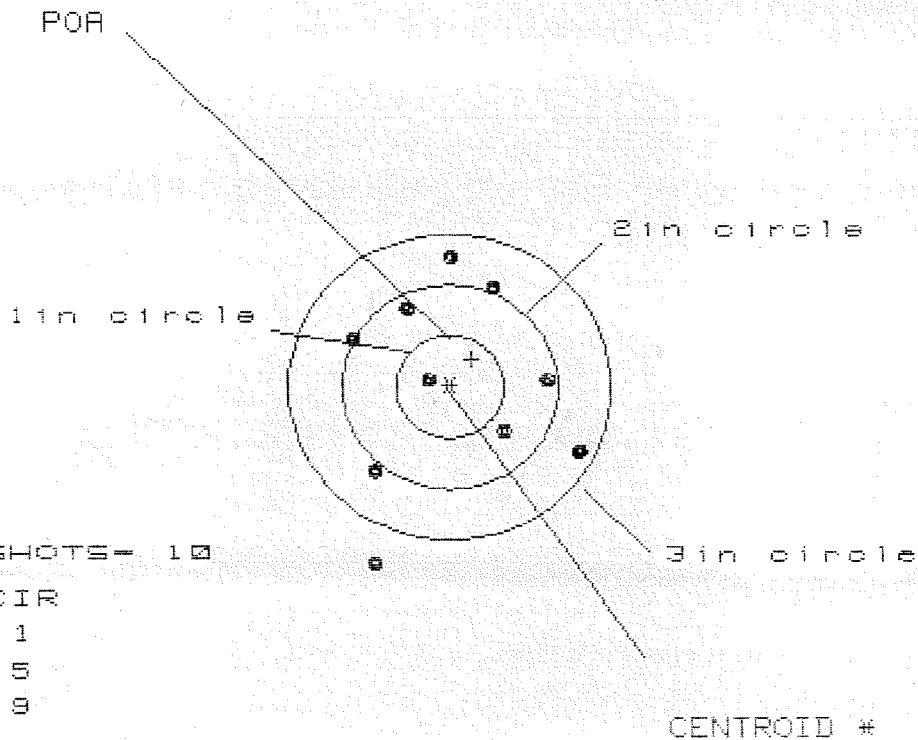
<----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.114
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118952
THE AMR FOR THIS RIFLE IS: .8728

12 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523371

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.051

VS = 2.980

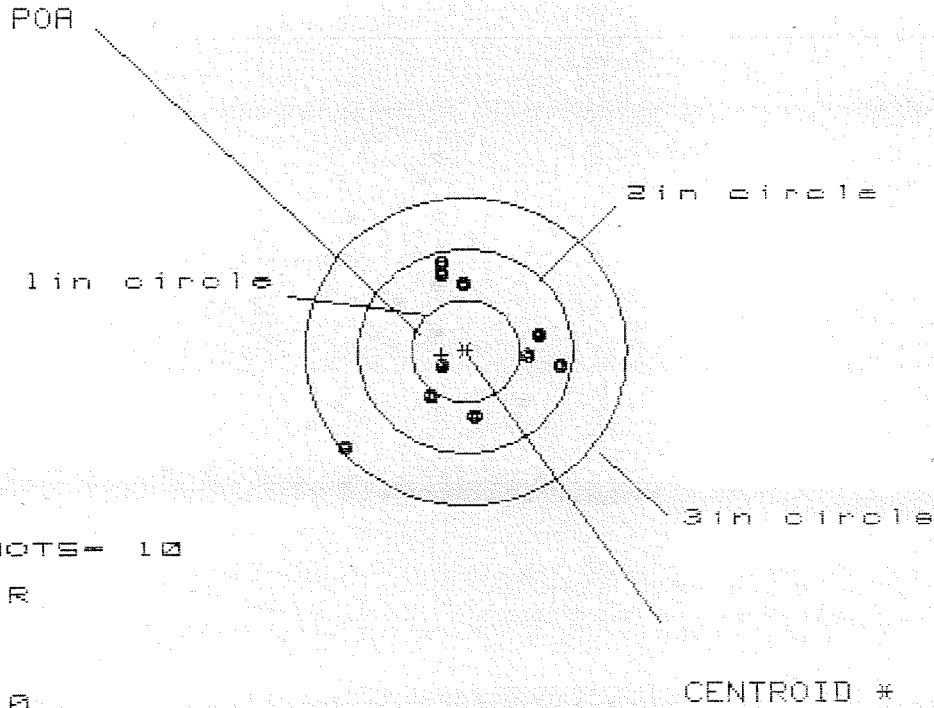
GS = 3.060

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.159	1.081	.921
MINIMUM X	-.892	-.970	-.835
MAXIMUM Y	1.250	1.057	.956
MINIMUM Y	-1.730	-1.043	-1.144
CENTROID X	-.200	-.122	-.257
CENTROID Y	-.273	-.080	.021
POA TO CENTROID in.	.338	.146	.258
MIN RADIUS	.267	.329	.257
MEAN RADIUS	1.021	.906	.826
MAX RADIUS	1.869	1.350	1.313
HORIZONTAL SPREAD	2.051	2.051	1.756
VERTICAL SPREAD	2.980	2.100	2.100
EXTREME SPREAD	3.060	2.309	2.211
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

12 Oct 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS = 1.956

VS = 1.798

GS = 2.116

PATTERN #

2

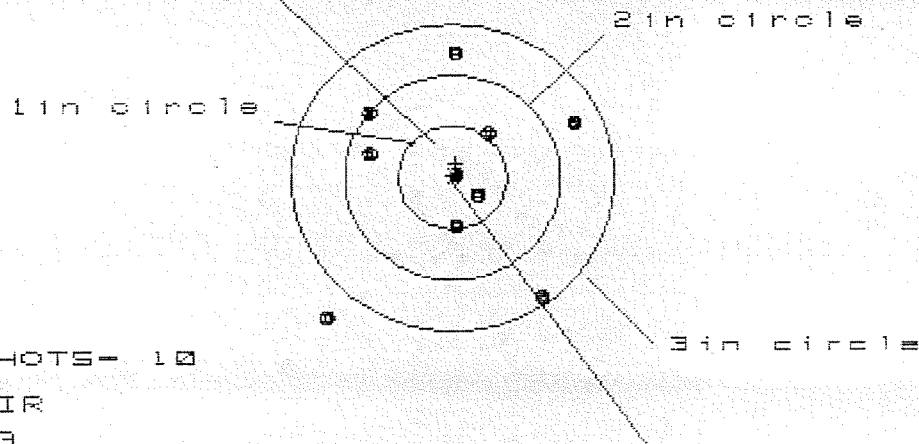
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.759	.686
MINIMUM X	-1.077	-.472	-.377
MAXIMUM Y	.842	.736	.704
MINIMUM Y	-.956	-.721	-.753
CENTROID X	.225	.345	.250
CENTROID Y	.037	.143	.175
POA TO CENTROID in.	.228	.373	.305
MIN RADIUS	.247	.407	.366
MEAN RADIUS	.742	.656	.633
MAX RADIUS	1.440	.821	.754
HORIZONTAL SPREAD	1.956	1.231	1.063
VERTICAL SPREAD	1.798	1.457	1.457
EXTREME SPREAD	2.116	1.497	1.483
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.337

VS= 2.531

GS= 2.986

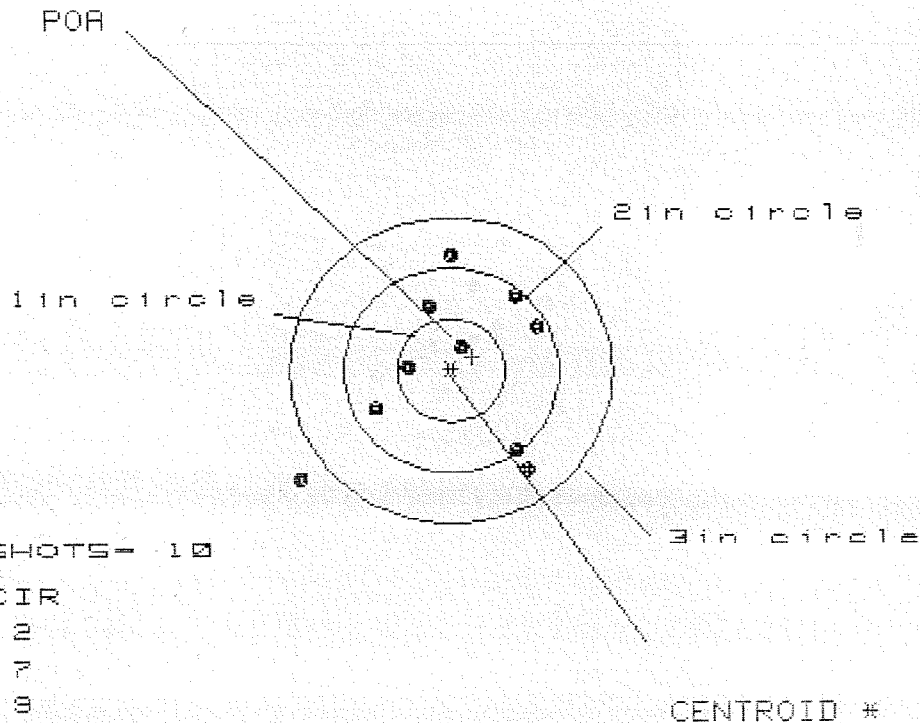
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	1.031	1.124
MINIMUM X	-1.175	-0.878	-0.785
MAXIMUM Y	1.193	1.045	0.884
MINIMUM Y	-1.338	-1.282	-0.730
CENTROID X	-0.031	0.100	0.007
CENTROID Y	-0.131	0.017	0.178
POA TO CENTROID in.	0.135	0.102	0.178
MIN RADIUS	0.036	0.173	0.291
MEAN RADIUS	0.869	0.765	0.683
MAX RADIUS	1.781	1.482	1.143
HORIZONTAL SPREAD	2.337	1.909	1.909
VERTICAL SPREAD	2.531	2.327	1.614
EXTREME SPREAD	2.986	2.485	1.918
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



HS= 2.196
 VS= 2.125
 GS= 2.701

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.774	.616	.685
MINIMUM X	-1.422	-.870	-.801
MAXIMUM Y	1.109	.996	.857
MINIMUM Y	-1.016	-1.113	-1.056
CENTROID X	-.196	-.038	-.107
CENTROID Y	-.134	-.021	.118
POA TO CENTROID in.	.237	.044	.159
MIN RADIUS	.222	.128	.045
MEAN RADIUS	.903	.785	.690
MAX RADIUS	1.748	1.241	1.171
HORIZONTAL SPREAD	2.196	1.486	1.486
VERTICAL SPREAD	2.125	2.109	1.913
EXTREME SPREAD	2.701	2.241	2.019
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
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 = 2

2in = 7

3in = 10

HS = 2.333

VS = 1.885

GS = 2.539

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.379	.858	.774
MINIMUM X	-.954	-.801	-.885
MAXIMUM Y	1.031	1.047	.859
MINIMUM Y	-.854	-.838	-.707
CENTROID X	.032	-.121	-.037
CENTROID Y	-.069	-.085	-.216
POA TO CENTROID in.	.076	.148	.219
MIN RADIUS	.287	.173	.163
MEAN RADIUS	.829	.755	.670
MAX RADIUS	1.387	1.247	1.133
HORIZONTAL SPREAD	2.333	1.659	1.659
VERTICAL SPREAD	1.885	1.885	1.566
EXTREME SPREAD	2.539	1.958	1.958
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	