

C6523379

MODEL 700TM M24

Model **SMS** TM

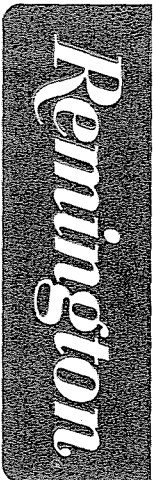
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6520379

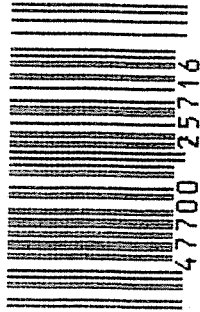
ORDER NO.
5716

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



5716 C6520379

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523379

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	LS.
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TSA
	Apply Coating (Bolt)		10-2-90	TSA
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/19/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/24/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			10/24/90	WB
	H) Trigger Pull Test & Retainability						10/24/90	9M
	I) Firing Pin Indent	.0215	.021	.021			10/24/90	WB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/18/90	JSB
	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	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10/30/90	NF
655	Final Inspection							
	A) Headspace						3/18/90	JSB
	B) Trigger Pull	252	285	288	258	257	3/18/90	JSB
	C) Function						3/18/90	JSB
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 26523379DATE 10/19/90TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.34	2.19	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.34	2.33	2.85	
PULL #3	2.50	2.27	2.33	2.88	
PULL #4	2.33	2.23	2.47	2.58	
PULL #5	2.33	2.32	2.30	2.57	
TOTAL	11.84	11.50	11.62		
AVG.	2.368	2.3	2.324		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.42		
PULL #2	3.27	3.25		
PULL #3	3.17	3.24		
PULL #4	3.22	3.28		
PULL #5	3.37	3.33		
TOTAL	16.32	16.52		
AVG.	3.264	3.304		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.31		4.24
PULL #2	4.41	4.35		4.22
PULL #3	4.35	4.40		4.43
PULL #4	4.33	4.38		4.28
PULL #5	4.35	4.40		4.42
TOTAL	21.81	21.84		21.59
AVG.	4.362	4.368		4.318

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523379
31 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.511423
1 TO	2	.671465
1 TO	3	.346344
1 TO	4	.49105
1 TO	5	.246789

1st <----POA

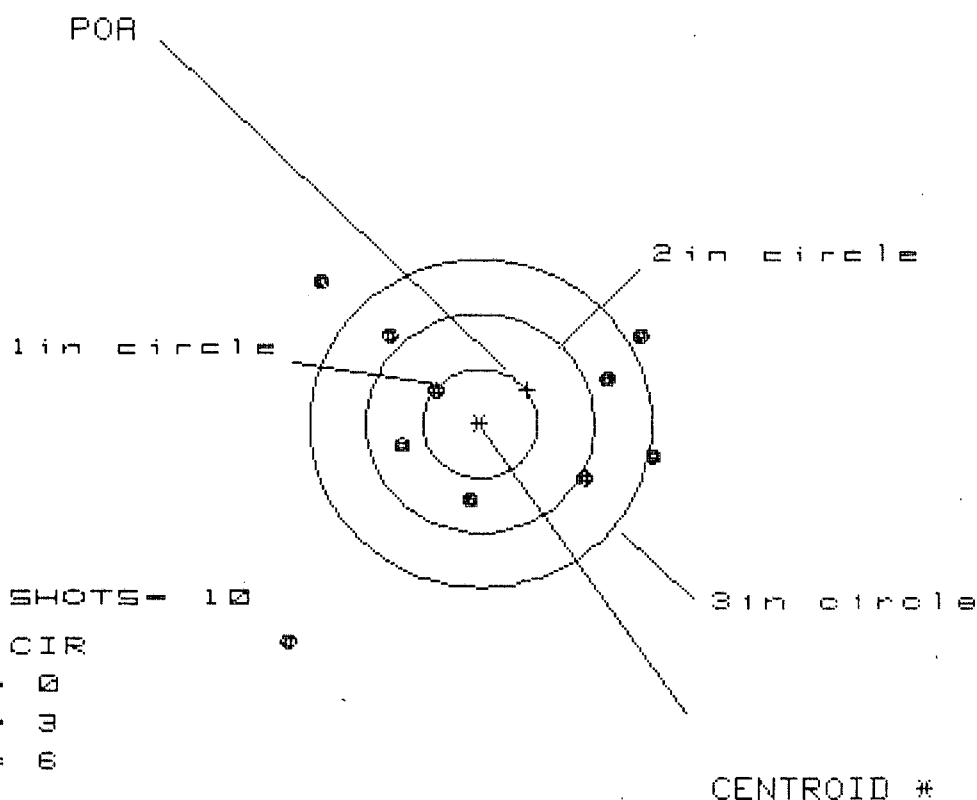
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0956
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.157
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .183816
THE AMR FOR THIS RIFLE IS: .9806

31 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523379

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.197

VS= 3.258

GS= 4.203

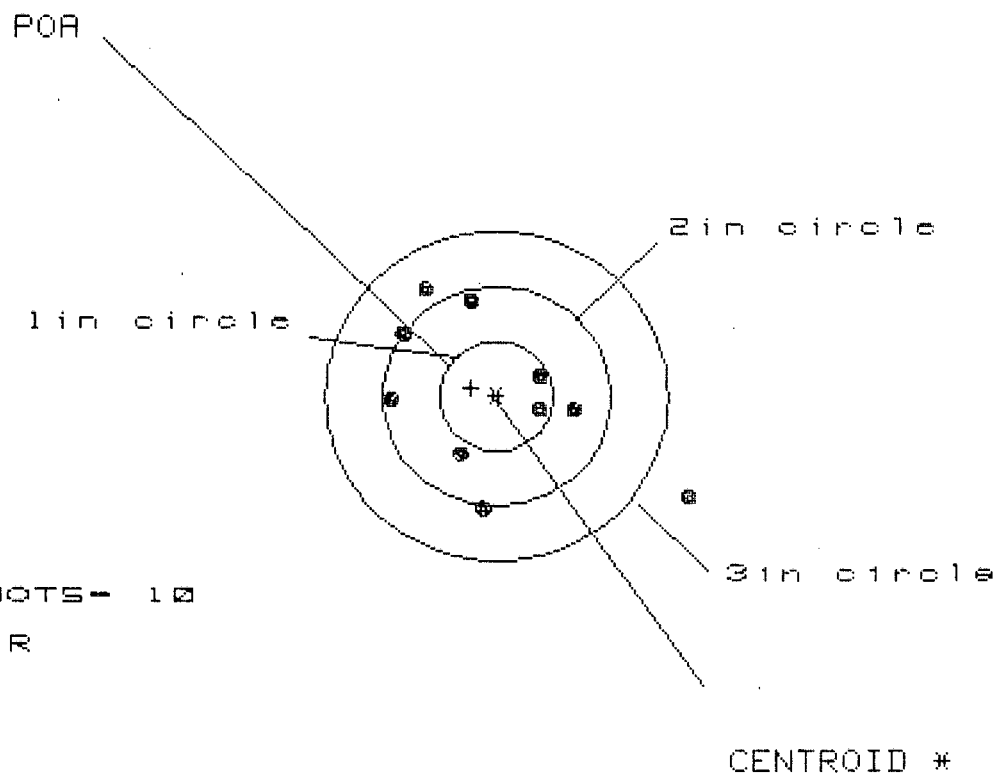
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.491	1.302	1.105
MINIMUM X	:	-1.705	-1.580	-1.142
MAXIMUM Y	:	1.300	1.083	.748
MINIMUM Y	:	-1.958	-.895	-.760
CENTROID X	:	-.412	-.223	-.026
CENTROID Y	:	-.303	-.086	-.221
POR TO CENTROID in.	:	.512	.239	.223
MIN RADIUS	:	.502	.598	.771
MEAN RADIUS	:	1.287	1.138	1.019
MAX RADIUS	:	2.596	1.916	1.360
HORIZONTAL SPREAD	:	3.197	2.882	2.247
VERTICAL SPREAD	:	3.258	1.978	1.508
EXTREME SPREAD	:	4.203	3.286	2.501
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.579

VS= 2.051

GS= 2.998

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X : 1.646 .815 .758

MINIMUM X : -.933 -.751 -.808

MAXIMUM Y : 1.014 .912 .939

MINIMUM Y : -1.037 -1.139 -1.025

CENTROID X : .221 .039 .096

CENTROID Y : -.079 .023 -.091

POA TO CENTROID in.: .235 .045 .132

MIN RADIUS : .385 .590 .505

MEAN RADIUS : .916 .809 .767

MAX RADIUS : 1.887 1.141 1.025

HORIZONTAL SPREAD : 2.579 1.566 1.566

VERTICAL SPREAD : 2.051 2.051 1.964

EXTREME SPREAD : 2.998 2.115 1.967

NUMBER IN ONE INCH CIRCLE = 2

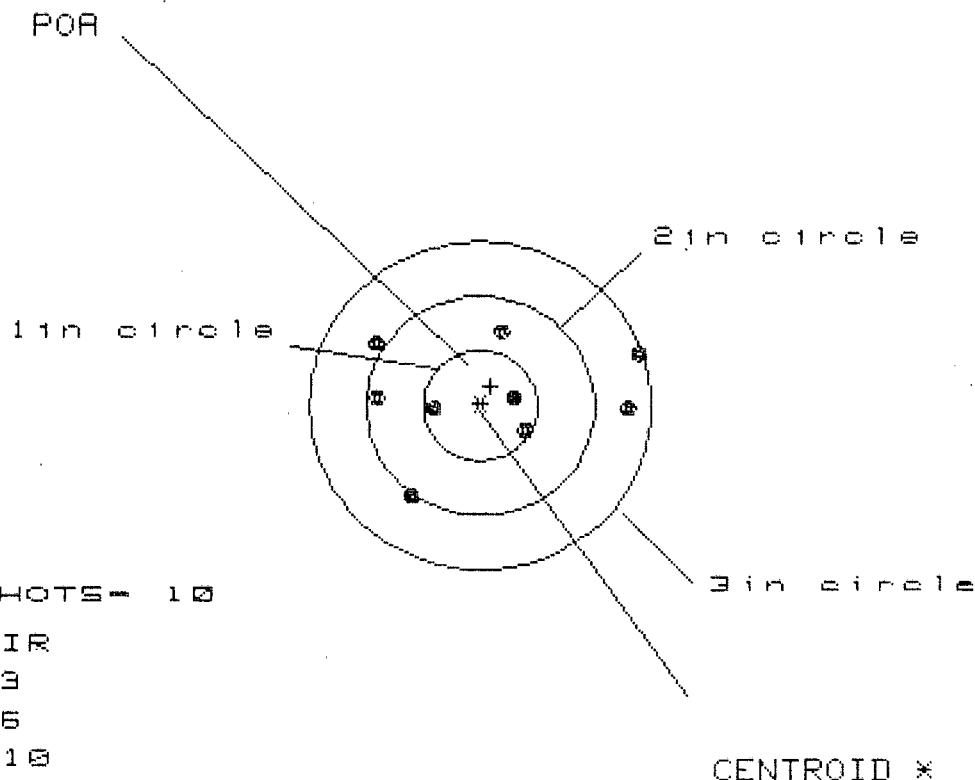
NUMBER IN TWO INCH CIRCLE = 6

NUMBER IN THREE INCH CIRCLE = 9

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in = 10

HS= 2.292

VS= 1.572

GS= 2.397

CENTROID *

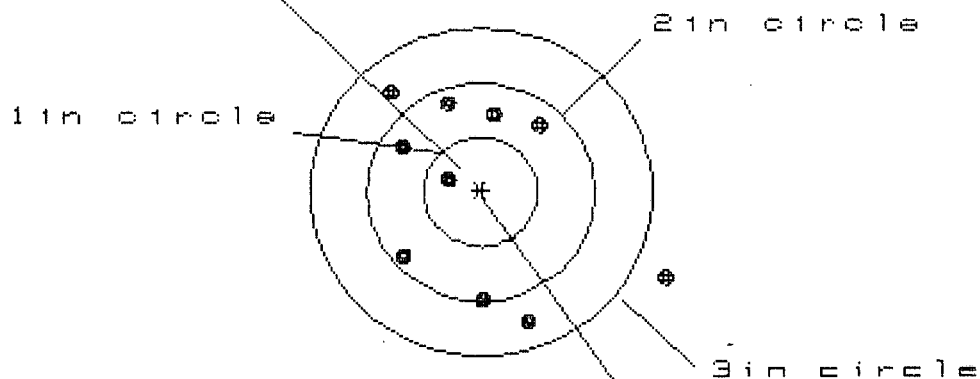
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.473	.697
MINIMUM X	:	-.953	-.804	-.620
MAXIMUM Y	:	.711	.767	.777
MINIMUM Y	:	-.861	-.805	-.795
CENTROID X	:	-.089	-.238	-.422
CENTROID Y	:	-.178	-.234	-.244
POA TO CENTROID in.	:	.199	.334	.487
MIN RADIUS	:	.265	.255	.090
MEAN RADIUS	:	.859	.783	.671
MAX RADIUS	:	1.430	1.475	.914
HORIZONTAL SPREAD	:	2.292	2.277	1.317
VERTICAL SPREAD	:	1.572	1.572	1.572
EXTREME SPREAD	:	2.397	2.334	1.755
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.403

VS= 2.126

GS= 2.931

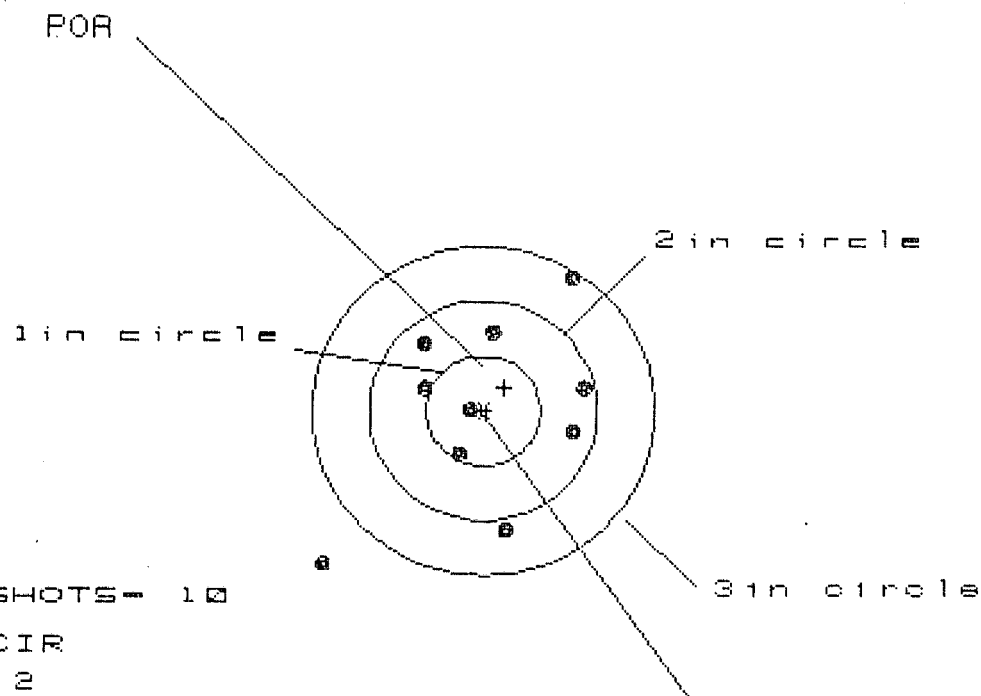
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.596	.668	.743
MINIMUM X	:	-.807	-.630	-.555
MAXIMUM Y	:	.891	.804	.639
MINIMUM Y	:	-1.235	-1.322	-1.193
CENTROID X	:	-.015	-.192	-.267
CENTROID Y	:	-.014	.073	.238
POA TO CENTROID in.	:	.021	.206	.358
MIN RADIUS	:	.311	.117	.154
MEAN RADIUS	:	.958	.818	.703
MAX RADIUS	:	1.779	1.452	1.228
HORIZONTAL SPREAD	:	2.403	1.298	1.298
VERTICAL SPREAD	:	2.126	2.126	1.832
EXTREME SPREAD	:	2.931	2.457	2.018
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.357

VS= 2.556

GS= 3.393

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.928	.770	.850
MINIMUM X	:	-1.429	-.706	-.626
MAXIMUM Y	:	1.201	1.051	.711
MINIMUM Y	:	-1.355	-1.249	-1.118
CENTROID X	:	-.183	-.025	-.105
CENTROID Y	:	-.211	-.061	-.192
POR TO CENTROID in.	:	.280	.066	.219
MIN RADIUS	:	.078	.291	.158
MEAN RADIUS	:	.883	.768	.687
MAX RADIUS	:	1.969	1.250	1.124
HORIZONTAL SPREAD	:	2.357	1.476	1.476
VERTICAL SPREAD	:	2.556	2.300	1.829
EXTREME SPREAD	:	3.393	2.379	1.858
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	