

C6523386

MODEL 700™ M24

Model SMS™

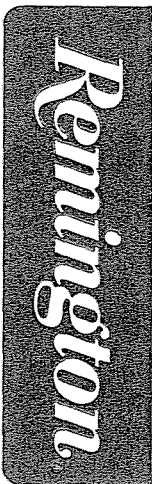
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

Remington®
REG. U.S. PAT. & TM. OFF.

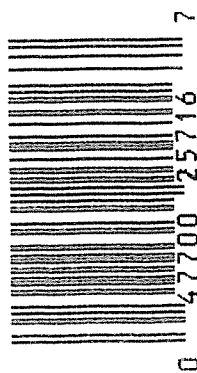
MODEL 700™ M24

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

SERIAL NO.
C6523386

ORDER NO.
5716

LPC



5716 C6523386

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6523386*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	<i>RW</i>
600	Proof	9 24	90	<i>RW</i>
607	Check Headspace	9 24	90	<i>RW</i>
610	Dis-assemble Gun	9 24	90	<i>RW</i>
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90 <i>LL</i>	<i>LL</i>
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel <i>RIB</i>		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TA
	Apply Coating (Bolt)		10-2-90	TA
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		10/15/90	<i>RL</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/16/90	W.B
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			10/16/90	W.B
	H) Trigger Pull Test & Retainability						10/15/90	JH
	I) Firing Pin Indent	.021	.021	.021			10/16/90	W.B
	J) Assemble Stock						10/16/90	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						10/16/90	RW
	M) Iron Sight Alignment						10/16/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/16/90	RW
	O) Attach Scope to Rifle						10/16/90	RW
	P) Detach & Attach Scope 20 Times						10/16/90	RW
640	Gallery Target & Test						10-19-90	AC
	A) Time						10-19-90	AC
	B) Malfunctions						10-19-90	AC
	C) Pierced Primers						10-19-90	AC
	D) Optical Clarity of Scope						10-19-90	AC
645	Inspect for Live Ammo						10-19-90	AC
655	Final Inspection							
	A) Headspace						10/24/90	GS
	B) Trigger Pull	2.33	2.30	2.27	2.31	2.24	10/24/90	GS
	C) Function						10/21/90	GS
660	Pack						12/14/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523386

DATE 10/15/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.54	2.43	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.45	2.48	2.30	
PULL #3	2.53	2.54	2.41	2.27	
PULL #4	2.37	2.37	2.50	2.31	
PULL #5	2.46	2.41	2.30	2.24	
TOTAL	12.35	12.31	12.12		
AVG.	2.47	2.46	2.424		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.37		
PULL #2	3.26	3.37		
PULL #3	3.22	3.27		
PULL #4	3.20	3.24		
PULL #5	3.16	3.14		
TOTAL	16.23	16.39		
AVG.	3.24	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.26		4.35
PULL #2	4.20	4.31		4.36
PULL #3	4.24	4.25		4.31
PULL #4	4.25	4.25		4.33
PULL #5	4.24	4.35		4.31
TOTAL	21.14	21.42		21.66
AVG.	4.228	4.284		4.332

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523386
22 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0771298
1 TO	2	.450211
1 TO	3	.327393
1 TO	4	.191638
1 TO	5	.342077

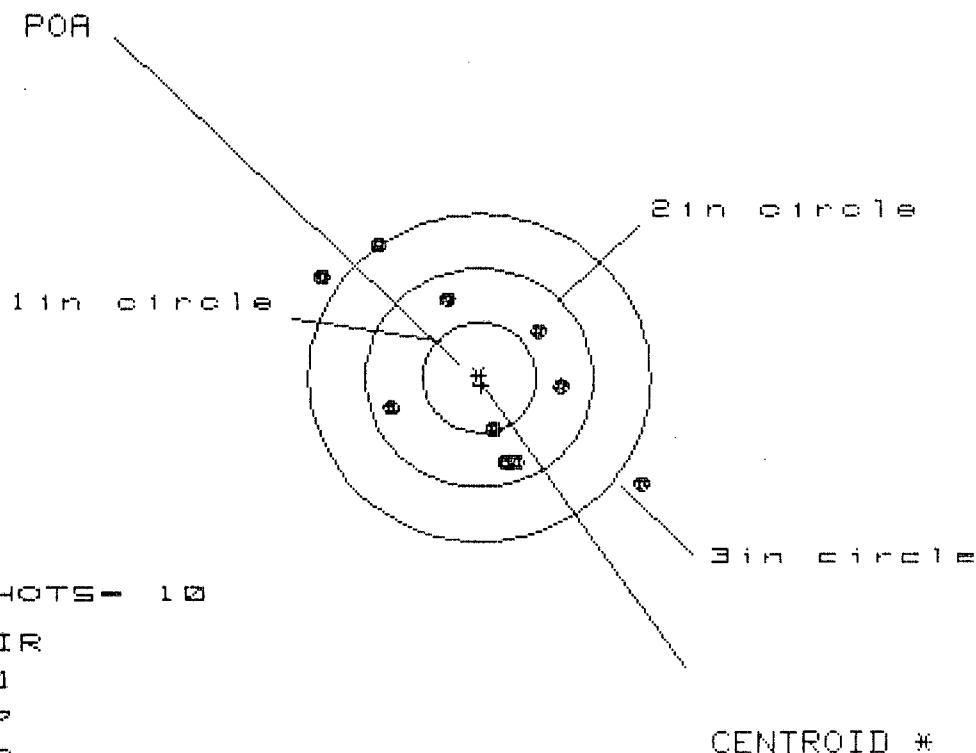
$f_{\bar{x}}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .205706
THE AMR FOR THIS RIFLE IS: .9148

22 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523386

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in - 8

HS= 2.731

VS= 2.244

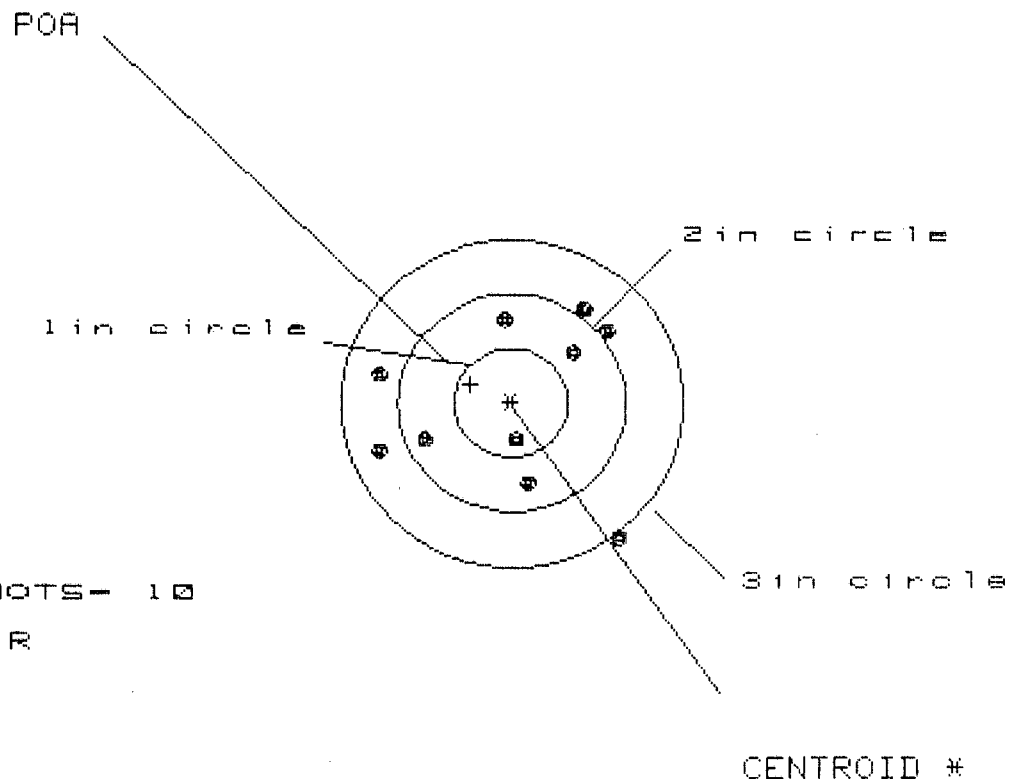
GS= 3.372

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.396	.837	.690
MINIMUM X	-1.335	-1.180	-.837
MAXIMUM Y	1.235	1.123	1.230
MINIMUM Y	-1.009	-.892	-.785
CENTROID X	-.018	-.173	-.026
CENTROID Y	.075	.187	.080
POA TO CENTROID in.	.077	.255	.084
MIN RADIUS	.497	.646	.503
MEAN RADIUS	.997	.929	.827
MAX RADIUS	1.723	1.458	1.488
HORIZONTAL SPREAD	2.731	2.017	1.527
VERTICAL SPREAD	2.244	2.015	2.015
EXTREME SPREAD	3.372	2.418	2.335
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

22 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523386

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.181

VS= 2.084

GS= 2.637

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.982	.913	.776
MINIMUM X	-1.199	-1.090	-1.145
MAXIMUM Y	.899	.767	.787
MINIMUM Y	-1.185	-.834	-.814
CENTROID X	.361	.252	.389
CENTROID Y	-.168	-.036	-.057
POA TO CENTROID in.	.398	.255	.393
MIN RADIUS	.323	.470	.434
MEAN RADIUS	.951	.884	.840
MAX RADIUS	1.539	1.179	1.288
HORIZONTAL SPREAD	2.181	2.003	1.922
VERTICAL SPREAD	2.084	1.601	1.601
EXTREME SPREAD	2.637	2.251	2.251
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

22 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B6

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.319

VS= 1.730

GS= 3.343

PATTERN #

3

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.550	1.353	.923
MINIMUM X	:	-1.769	-1.008	-.839
MAXIMUM Y	:	.663	.692	.641
MINIMUM Y	:	-1.067	-1.038	-.952
CENTROID X	:	.287	.484	.315
CENTROID Y	:	-.044	-.073	-.160
POA TO CENTROID in.	:	.291	.489	.353
MIN RADIUS	:	.427	.407	.523
MEAN RADIUS	:	1.005	.916	.830
MAX RADIUS	:	1.789	1.520	1.002
HORIZONTAL SPREAD	:	3.319	2.361	1.762
VERTICAL SPREAD	:	1.730	1.730	1.592
EXTREME SPREAD	:	3.343	2.480	1.818
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

22 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523386

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.311

VS= 2.584

GS= 2.800

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.015	1.054
MINIMUM X	:	-1.125	-.993	-.954
MAXIMUM Y	:	1.302	1.160	.857
MINIMUM Y	:	-1.282	-.878	-.733
CENTROID X	:	.100	-.032	-.071
CENTROID Y	:	.226	.368	.223
POA TO CENTROID in.	:	.247	.370	.234
MIN RADIUS	:	.112	.236	.213
MEAN RADIUS	:	.868	.753	.681
MAX RADIUS	:	1.747	1.201	1.064
HORIZONTAL SPREAD	:	2.311	2.008	2.008
VERTICAL SPREAD	:	2.584	2.038	1.590
EXTREME SPREAD	:	2.800	2.168	2.014
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523386

CENTERFIRE PATTERNS

5

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.828

VS= 2.085

GS= 2.356

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.882	.858	.726
MINIMUM X	:	-.946	-.970	-.863
MAXIMUM Y	:	1.371	.578	.508
MINIMUM Y	:	-.714	-.562	-.428
CENTROID X	:	.298	.322	.215
CENTROID Y	:	-.056	-.208	-.138
POR TO CENTROID in.	:	.303	.383	.255
MIN RADIUS	:	.162	.270	.151
MEAN RADIUS	:	.753	.681	.619
MAX RADIUS	:	1.388	1.030	.958
HORIZONTAL SPREAD	:	1.828	1.828	1.589
VERTICAL SPREAD	:	2.085	1.140	.936
EXTREME SPREAD	:	2.356	1.976	1.713
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	