

C6523389

MODEL 706™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TH M24

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

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

SERIAL NO. C6523389

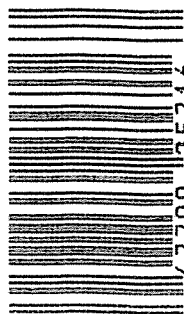
ORDER NO. 5716

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



5716 C6523389

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523389

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 2	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	LG
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel <i>RB</i>		9/25/90	WB
620	Apply Coatings (Barrel Action)		10-8-90	TJA
	Apply Coating (Bolt)			
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		10-27-90	DH

op. #	OP. NAME	READINGS					DATE	INIT
605 nt.	F) Safety On Force	4	4	4			10/24/90	WLB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			10/24/90	WLB
	H) Trigger Pull Test & Retainability						10/27/90	DH
	I) Firing Pin Indent	.0205	.0205	.0205			10/27/90	WLB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/10/91	YS
	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						3/10/91	YS
	B) Trigger Pull	280	263	241	236	231	3/10/91	YS
	C) Function						3/10/91	YS
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. C6523389

DATE 10-27-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.36	2.43	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.28	2.58	2.63	
PULL #3	2.44	2.26	2.59	2.41	
PULL #4	2.45	2.25	2.56	2.36	
PULL #5	2.45	2.33	2.63	2.31	
TOTAL	12.26	11.48	12.79		
AVG.	2.45	2.29	2.55		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.75	3.00		
PULL #2	3.34	3.26		
PULL #3	3.27	3.27		
PULL #4	3.33	3.27		
PULL #5	3.34	3.29		
TOTAL	16.43	16.09		
AVG.	3.28	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.33		4.40
PULL #2	4.19	4.24		4.18
PULL #3	4.22	4.29		4.35
PULL #4	4.38	4.27		4.29
PULL #5	4.34	4.27		4.33
TOTAL	21.40	21.40		21.55
AVG.	4.28	4.28		4.31

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523389
31 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.10017
1 TO	2	.113159
1 TO	3	.222713
1 TO	4	.0454863
1 TO	5	.0972522

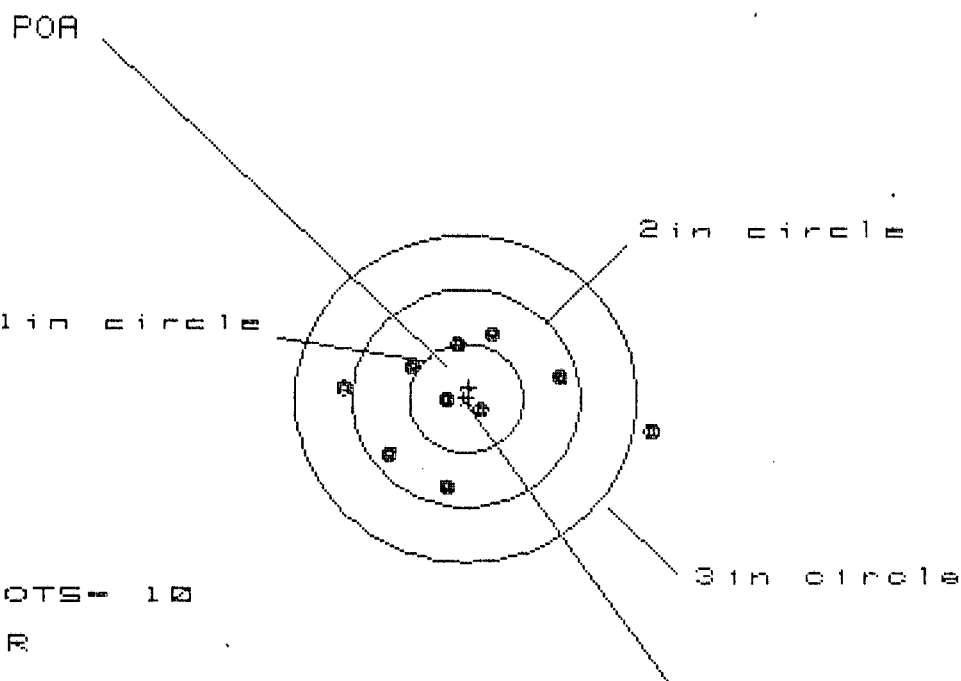
400 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0622
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0631307
THE AMR FOR THIS RIFLE IS: .8238

31 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523389

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in - 9

HS- 2.687

VS= 1.490

GS= 2.724

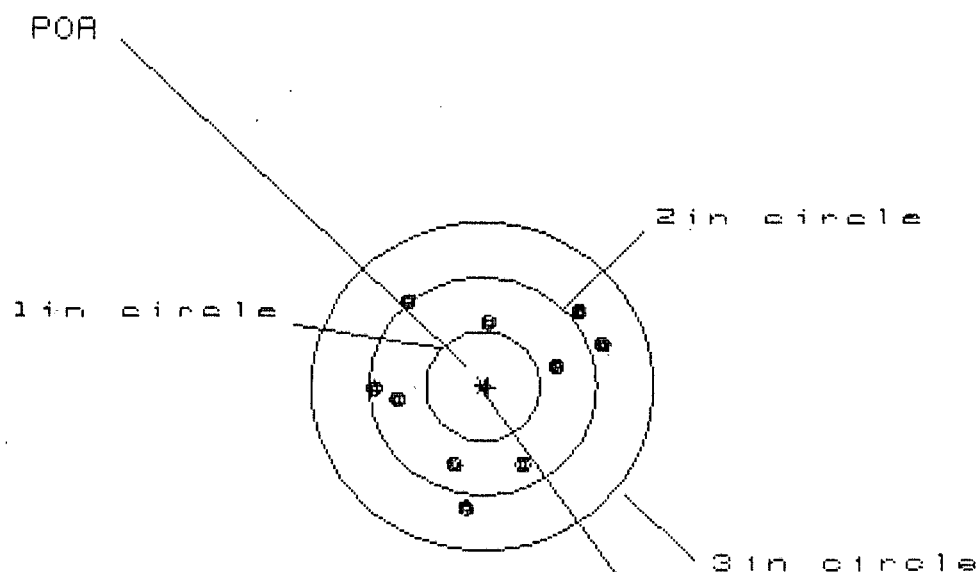
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	.967	.852
MINIMUM X	:	-1.092	-.915	-.596
MAXIMUM Y	:	.645	.611	.623
MINIMUM Y	:	-.845	-.879	-.867
CENTROID X	:	-.025	-.202	-.087
CENTROID Y	:	-.097	-.063	-.075
POA TO CENTROID in.	:	.100	.211	.115
MIN RADIUS	:	.189	.066	.144
MEAN RADIUS	:	.737	.612	.574
MAX RADIUS	:	1.625	.980	.879
HORIZONTAL SPREAD	:	2.687	1.882	1.448
VERTICAL SPREAD	:	1.490	1.490	1.490
EXTREME SPREAD	:	2.724	1.883	1.602
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.004

VS= 1.930

GS= 2.062

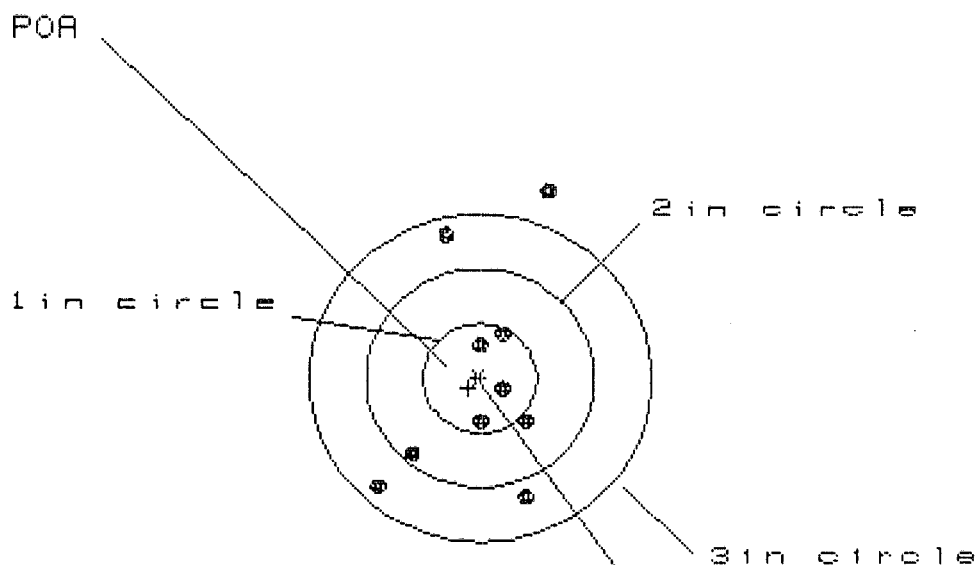
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	.996	1.098
MINIMUM X	:	-.993	-1.008	-.906
MAXIMUM Y	:	.819	.695	.768
MINIMUM Y	:	-1.111	-.864	-.791
CENTROID X	:	-.047	-.032	-.134
CENTROID Y	:	.014	.138	.065
POA TO CENTROID in.	:	.049	.141	.149
MIN RADIUS	:	.624	.501	.581
MEAN RADIUS	:	.885	.850	.824
MAX RADIUS	:	1.120	1.026	1.143
HORIZONTAL SPREAD	:	2.004	2.004	2.004
VERTICAL SPREAD	:	1.930	1.559	1.559
EXTREME SPREAD	:	2.062	2.043	2.043
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 1.458

VS= 2.847

GS= 3.036

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.569	.484	.458
MINIMUM X	-.889	-.826	-.852
MAXIMUM Y	1.710	1.505	.754
MINIMUM Y	-1.137	-.947	-.759
CENTROID X	.099	.036	.062
CENTROID Y	.088	-.102	-.298
POA TO CENTROID in.	.133	.108	.296
MIN RADIUS	.221	.223	.071
MEAN RADIUS	.862	.741	.623
MAX RADIUS	1.802	1.519	1.028
HORIZONTAL SPREAD	1.458	1.310	1.310
VERTICAL SPREAD	2.847	2.452	1.513
EXTREME SPREAD	3.036	2.549	1.747
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

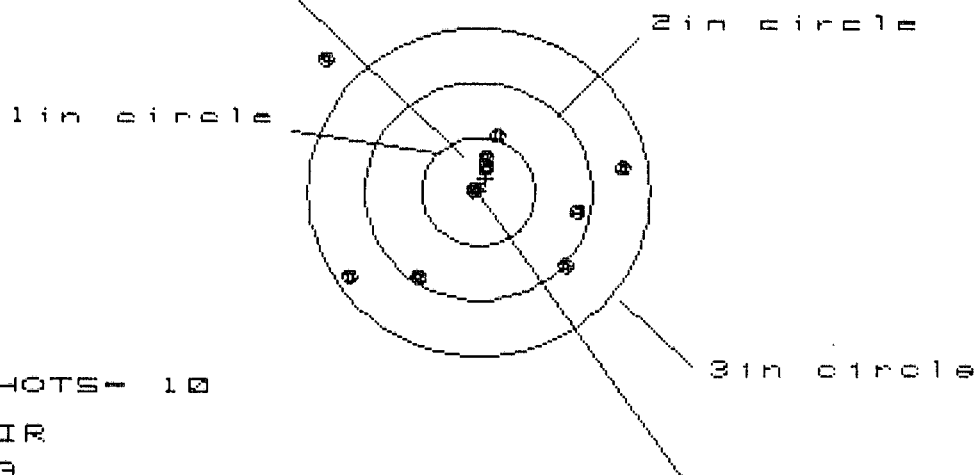
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.553

VS= 1.950

GS= 2.832

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.226	1.079	.918
MINIMUM X	:	-1.327	-1.280	-.847
MAXIMUM Y	:	1.196	.689	.613
MINIMUM Y	:	-.754	-.621	-.698
CENTROID X	:	-.063	.084	.245
CENTROID Y	:	-.122	-.255	-.179
POA TO CENTROID in.	:	.137	.268	.303
MIN RADIUS	:	.086	.253	.369
MEAN RADIUS	:	.834	.744	.648
MAX RADIUS	:	1.786	1.418	1.097
HORIZONTAL SPREAD	:	2.553	2.359	1.765
VERTICAL SPREAD	:	1.950	1.310	1.310
EXTREME SPREAD	:	2.832	2.531	1.994
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.245

VS= 1.791

GS= 2.552

PATTERN #	:	5	5	5
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.373	1.078	1.029
MINIMUM X	:	-.872	-.719	-.768
MAXIMUM Y	:	.870	.954	.850
MINIMUM Y	:	-.921	-.837	-.838
CENTROID X	:	-.018	-.171	-.122
CENTROID Y	:	-.194	-.278	-.174
POA TO CENTROID in.	:	.194	.326	.212
MIN RADIUS	:	.201	.283	.305
MEAN RADIUS	:	.801	.692	.663
MAX RADIUS	:	1.571	1.110	1.093
HORIZONTAL SPREAD	:	2.245	1.797	1.797
VERTICAL SPREAD	:	1.791	1.791	1.688
EXTREME SPREAD	:	2.552	1.926	1.926
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	