

C6523406

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

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

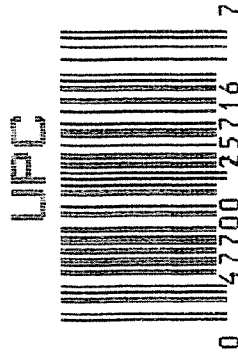
MODEL 700TM H24

SERIAL NO.
06523406

ORDER NO.
5716

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

01



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523406

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3 90	10/3/90	RW
600	Proof	10 3 90	10/3/90	RW
607	Check Headspace	10 3 90	10/3/90	RW
610	Dis-assemble Gun	10 3 90	10/3/90	RW
612	Magnaflux Barrel Action		10/11/90	K.R
	Magnaflux Bolt		10/11/90	K.R
615	Rollmark Caliber		10/11/90	Y.L.
617	Drill and Tap Sight Holes		10/11/90	F.B
618	Polish Barrel <i>R.B</i>		10/12/90	W.B
620	Apply Coatings (Barrel Action)		10-18-90	T.H
	Apply Coating (Bolt)		10-18-90	T.H
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-90	J.L

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	3 ³ / ₄	3 ¹ / ₂	3 ³ / ₄	11/7/90	WLB		
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄	11/7/90	WLB		
	H) Trigger Pull Test & Retainability				11-7-90	SL		
	I) Firing Pin Indent	.0225	.023	.023	11/7/90	WLB		
	J) Assemble Stock				11/9/90	RW		
	K) Assemble Swivel Studs				11-12-90	DH		
	L) Attach Front and Rear Sight Assemblies				11/9/90	RW		
	M) Iron Sight Alignment				11/9/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/9/90	RW		
	O) Attach Scope to Rifle				11/9/90	RW		
	P) Detach & Attach Scope 20 Times				11/9/90	RW		
640	Gallery Target & Test				11-12-90	SL		
	A) Time				11	SL		
	B) Malfunctions				11	SL		
	C) Pierced Primers				11	SL		
	D) Optical Clarity of Scope				11	SL		
645	Inspect for Live Ammo				11-12-90	SL		
655	Final Inspection							
	A) Headspace				11-19-90	DH		
	B) Trigger Pull	2.31	2.25	2.20	2.14	2.21	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. C6523406DATE 11-7-90TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.19	2.15	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.30	2.30	2.25	
PULL #3	2.21	2.23	2.36	2.20	
PULL #4	2.47	2.39	2.30	2.14	
PULL #5	2.43	2.14	2.18	2.21	
TOTAL	11.51	11.25	11.29		
AVG.	2.302	2.25	2.258		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.22		
PULL #2	3.50	3.35		
PULL #3	3.41	3.14		
PULL #4	3.28	3.28		
PULL #5	3.50	3.24		
TOTAL	16.76	16.23		
AVG.	3.352	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.37		4.35
PULL #2	4.28	4.43		4.43
PULL #3	4.36	4.34		4.41
PULL #4	4.36	4.44		4.46
PULL #5	4.29	4.28		4.39
TOTAL	21.71	21.86		22.04
AVG.	4.342	4.372		4.408

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523406
12 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.115434
1 TO	2	.24176
1 TO	3	.343657
1 TO	4	.091586
1 TO	5	.378001

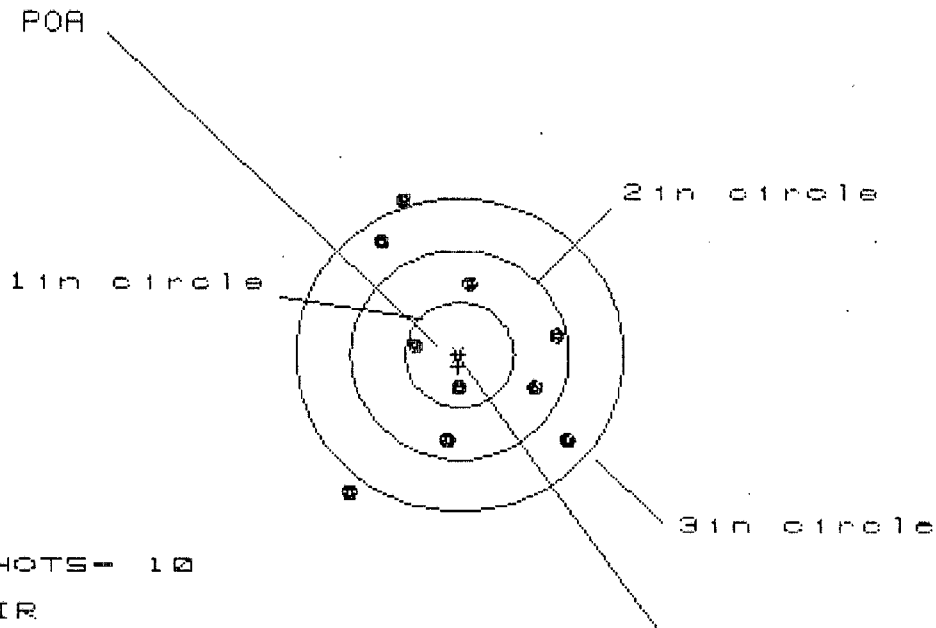
5
34
37 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .142
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .180113
THE AMR FOR THIS RIFLE IS: .9546

12 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523406

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.993

VS= 2.831

GS= 2.867

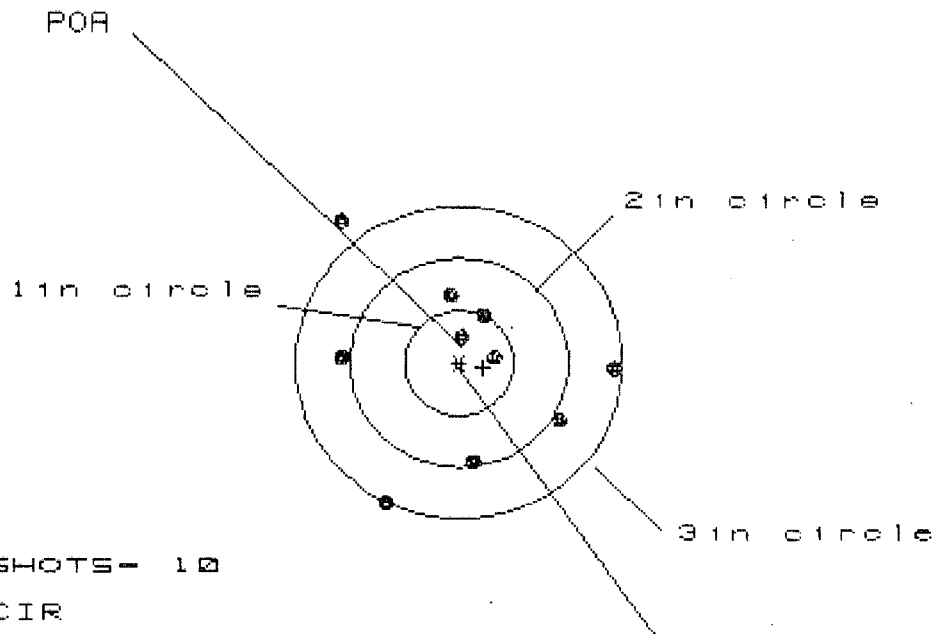
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.024	.916	.839
MINIMUM X	-.969	-.824	-.901
MAXIMUM Y	1.532	1.388	1.088
MINIMUM Y	-1.299	-.967	-.793
CENTROID X	.010	.118	.196
CENTROID Y	.115	.259	.085
POA TO CENTROID in.	.115	.284	.213
MIN RADIUS	.271	.426	.298
MEAN RADIUS	.975	.903	.798
MAX RADIUS	1.620	1.521	1.413
HORIZONTAL SPREAD	1.993	1.740	1.740
VERTICAL SPREAD	2.831	2.355	1.881
EXTREME SPREAD	2.867	2.812	2.562
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.574

VS= 2.676

GS= 2.905

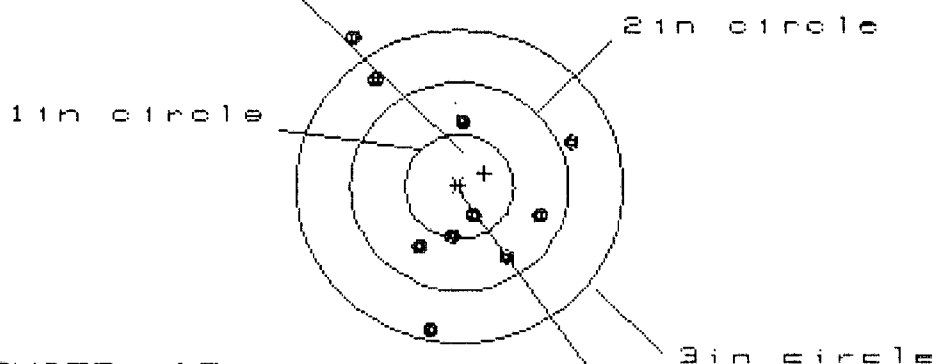
PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.456	1.335	1.234
MINIMUM X	-1.118	-1.239	-1.340
MAXIMUM Y	1.359	.767	.622
MINIMUM Y	-1.317	-1.166	-.946
CENTROID X	-.222	-.101	-.000
CENTROID Y	.047	-.104	.041
POA TO CENTROID in.	.227	.145	.041
MIN RADIUS	.289	.273	.096
MEAN RADIUS	.951	.867	.748
MAX RADIUS	1.742	1.417	1.344
HORIZONTAL SPREAD	2.574	2.574	2.574
VERTICAL SPREAD	2.676	1.933	1.568
EXTREME SPREAD	2.905	2.578	2.578
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.010

VS= 2.741

GS= 2.825

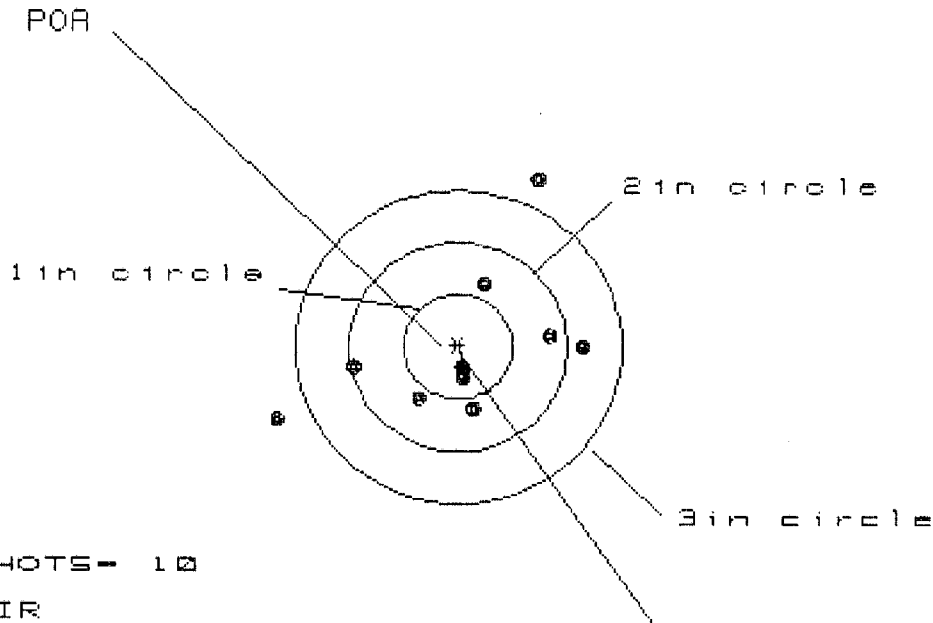
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.961	.915
MINIMUM X	:	-.944	-.882	-.928
MAXIMUM Y	:	1.412	1.167	1.020
MINIMUM Y	:	-1.329	-1.172	-.632
CENTROID X	:	-.232	-.127	-.081
CENTROID Y	:	-.129	-.286	-.139
POA TO CENTROID in.	:	.265	.313	.161
MIN RADIUS	:	.268	.079	.212
MEAN RADIUS	:	.899	.756	.720
MAX RADIUS	:	1.698	1.462	1.379
HORIZONTAL SPREAD	:	2.010	1.843	1.843
VERTICAL SPREAD	:	2.741	2.339	1.652
EXTREME SPREAD	:	2.825	2.395	2.052
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.814

VS= 2.258

GS= 3.309

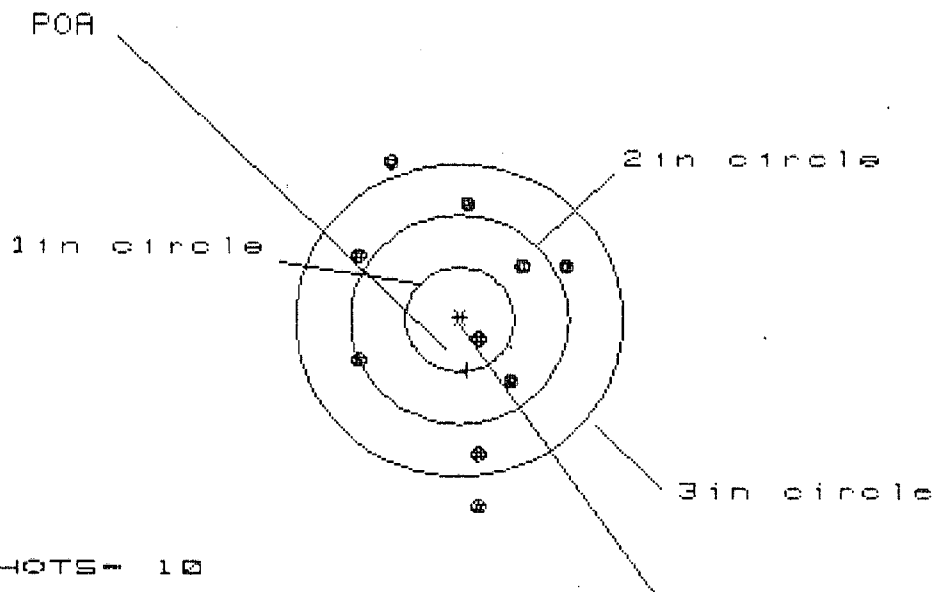
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.111	.922	.988
MINIMUM X	-1.703	-1.189	-1.123
MAXIMUM Y	1.581	1.506	.704
MINIMUM Y	-.677	-.622	-.433
CENTROID X	-.038	.151	.085
CENTROID Y	.193	.268	.080
POA TO CENTROID in.	.196	.307	.116
MIN RADIUS	.156	.303	.137
MEAN RADIUS	.870	.770	.611
MAX RADIUS	1.832	1.596	1.127
HORIZONTAL SPREAD	2.814	2.111	2.111
VERTICAL SPREAD	2.258	2.128	1.137
EXTREME SPREAD	3.309	2.480	2.126
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 1.917

VS= 3.259

GS= 3.360

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	.958	.878
MINIMUM X	-.977	-.959	-1.039
MAXIMUM Y	1.512	1.317	1.079
MINIMUM Y	-1.747	-1.486	-1.321
CENTROID X	-.072	-.090	-.010
CENTROID Y	.484	.679	.514
POA TO CENTROID in.	.490	.685	.514
MIN RADIUS	.267	.429	.247
MEAN RADIUS	1.078	.999	.913
MAX RADIUS	1.755	1.501	1.328
HORIZONTAL SPREAD	1.917	1.917	1.917
VERTICAL SPREAD	3.259	2.803	2.400
EXTREME SPREAD	3.360	2.931	2.404
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	