

C6523409

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

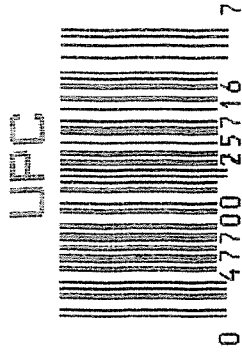
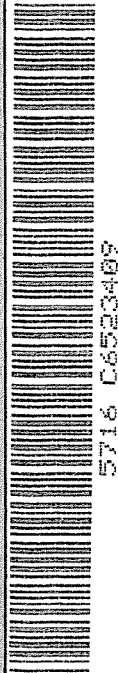
MODEL 700[™] M24

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

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

SERIAL NO.
C6523409

ORDER NO.
5716



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523409

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	DS
617	Drill and Tap Sight Holes		10/8/90	LB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/8/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/8/90	KS
	D) Oil Firing Pin Ass'y		11/8/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4 1/4			11/7/90	KS
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			11/7/90	KS
	H) Trigger Pull Test & Retainability						11-7-90	JH
	I) Firing Pin Indent	.020	.020	.021			11/7/90	KS
	J) Assemble Stock						11/8/90	KS
	K) Assemble Swivel Studs						11-9-90	DH
	L) Attach Front and Rear Sight Assemblies						11/8/90	KS
	M) Iron Sight Alignment						11/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/8/90	KS
	O) Attach Scope to Rifle						11/8/90	KS
	P) Detach & Attach Scope 20 Times						11/8/90	KS
640	Gallery Target & Test						11-9-90	A
	A) Time						11-9-90	A
	B) Malfunctions						11-9-90	A
	C) Pierced Primers						11-9-90	A
	D) Optical Clarity of Scope						11-9-90	A
645	Inspect for Live Ammo						11-9-90	A
655	Final Inspection						11-9-90	DH
	A) Headspace						11-9-90	DH
	B) Trigger Pull	222	222	228	228	227	11-9-90	DH
	C) Function						11-9-90	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. C6523409DATE 11-7-90TESTER JRP.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.34	2.27	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.27	2.18	2.22	
PULL #3	2.27	2.36	2.20	2.28	
PULL #4	2.28	2.19	2.30	2.28	
PULL #5	2.25	2.26	2.28	2.27	
TOTAL	11.49	11.42	11.23		
AVG.	2.298	2.284	2.246		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.28		
PULL #2	3.46	3.35		
PULL #3	3.42	3.36		
PULL #4	3.35	3.36		
PULL #5	3.36	3.29		
TOTAL	17.71	16.64		
AVG.	3.542	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.41		4.45
PULL #2	4.20	4.30		4.40
PULL #3	4.14	4.29		4.40
PULL #4	4.50	4.44		4.43
PULL #5	4.39	4.40		4.49
TOTAL	21.56	21.84		22.17
AVG.	4.312	4.368		4.434

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523409
9 Nov 1990

CENTROIDAL DISTANCES

Ø TO	1	.198116
1 TO	2	.272237
1 TO	3	.153052
1 TO	4	.291084
1 TO	5	.126531

5
4 <----PDR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0526
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0974
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110696
THE AMR FOR THIS RIFLE IS: .8006

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523409

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.242

VS = 2.529

GS = 2.529

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.365	.404	.448
MINIMUM X	-.877	-.838	-.794
MAXIMUM Y	1.337	1.004	.874
MINIMUM Y	-1.192	-1.044	-1.080
CENTROID X	-.021	-.060	-.104
CENTROID Y	.197	.049	.179
POA TO CENTROID in.	.198	.077	.207
MIN RADIUS	.112	.126	.168
MEAN RADIUS	.738	.668	.606
MAX RADIUS	1.382	1.101	1.081
HORIZONTAL SPREAD	1.242	1.242	1.242
VERTICAL SPREAD	2.529	2.048	1.954
EXTREME SPREAD	2.529	2.107	1.959
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

9 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523489

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 1.954

VS = 3.191

GS = 3.319

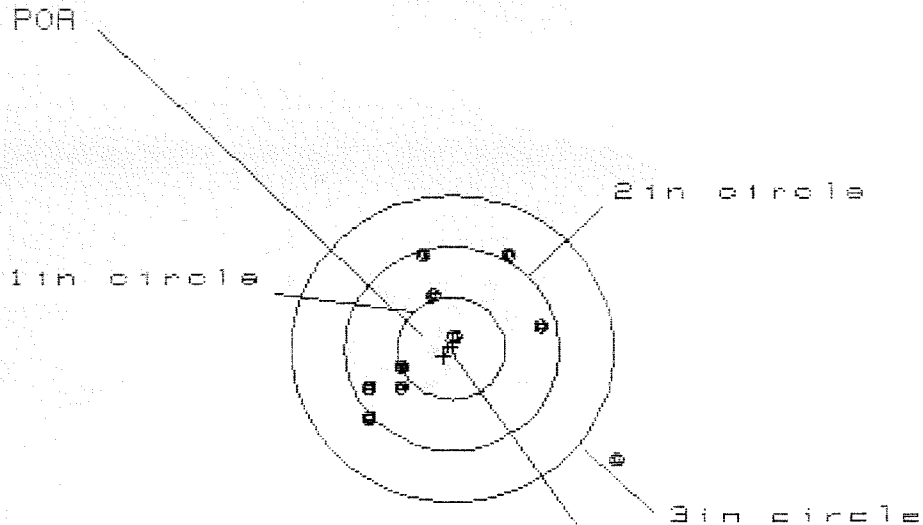
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.819	.693	.649
MINIMUM X	-1.135	-.638	-.682
MAXIMUM Y	1.771	.957	.804
MINIMUM Y	-1.420	-1.223	-.729
CENTROID X	.082	.208	.252
CENTROID Y	-.055	-.252	-.099
POA TO CENTROID in.	.099	.327	.271
MIN RADIUS	.091	.143	.176
MEAN RADIUS	.777	.618	.521
MAX RADIUS	2.104	1.271	.976
HORIZONTAL SPREAD	1.954	1.331	1.331
VERTICAL SPREAD	3.191	2.180	1.533
EXTREME SPREAD	3.319	2.198	1.755
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

9 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 2.303

VS = 2.030

GS = 2.670

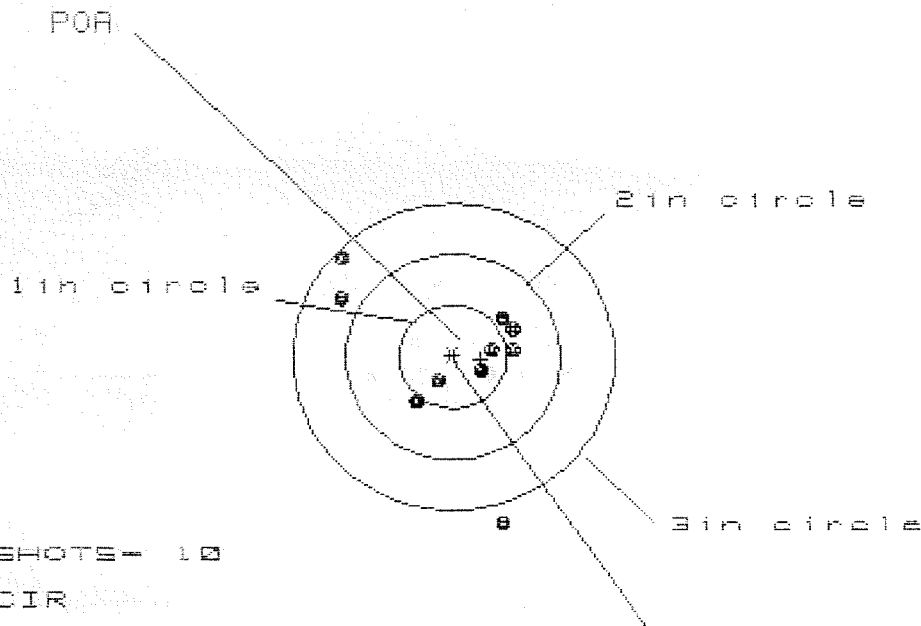
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.542	.999	1.083
MINIMUM X	-.761	-.589	-.505
MAXIMUM Y	.946	.825	.896
MINIMUM Y	-1.084	-.828	-.725
CENTROID X	.074	-.098	-.182
CENTROID Y	.077	.198	.095
POA TO CENTROID in.	.107	.220	.205
MIN RADIUS	.093	.154	.247
MEAN RADIUS	.840	.690	.628
MAX RADIUS	1.885	1.067	1.103
HORIZONTAL SPREAD	2.303	1.588	1.588
VERTICAL SPREAD	2.030	1.653	1.621
EXTREME SPREAD	2.670	2.076	1.832
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

9 May 1998

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 1.617

VS = 2.686

GS = 3.058

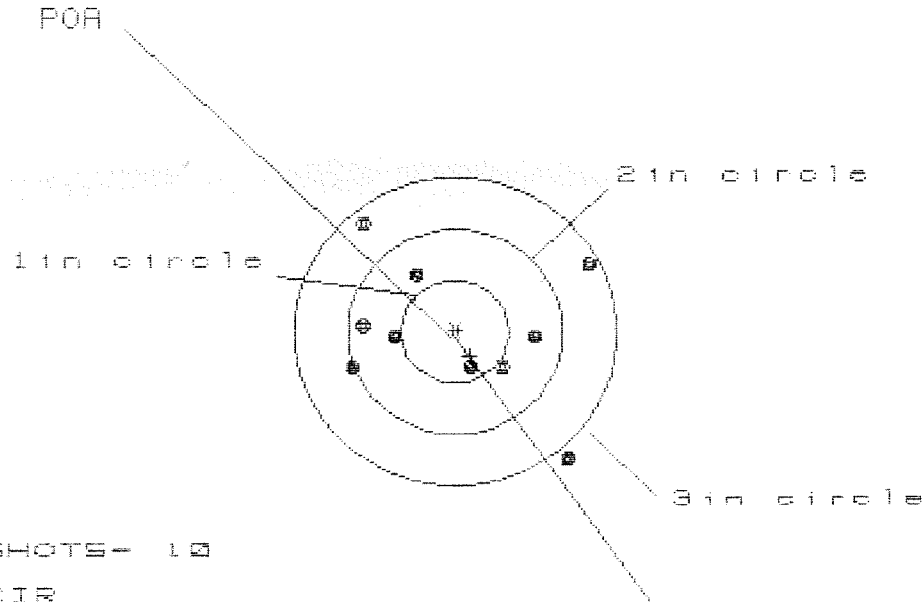
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.550	.600	.480
MINIMUM X	:	-1.067	-1.017	-1.137
MAXIMUM Y	:	1.010	.824	.457
MINIMUM Y	:	-1.676	-.568	-.465
CENTROID X	:	-.258	-.308	-.188
CENTROID Y	:	.028	.214	.111
POA TO CENTROID in.	:	.260	.375	.219
MIN RADIUS	:	.227	.377	.220
MEAN RADIUS	:	.745	.657	.520
MAX RADIUS	:	1.736	1.266	1.225
HORIZONTAL SPREAD	:	1.617	1.617	1.617
VERTICAL SPREAD	:	2.686	1.392	.922
EXTREME SPREAD	:	3.058	1.804	1.672
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.164

VS= 2.310

GS= 2.948

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.223	1.336	.974
MINIMUM X	-.941	-.828	-.661
MAXIMUM Y	1.055	.915	.983
MINIMUM Y	-1.255	-.522	-.454
CENTROID X	-.140	-.253	-.420
CENTROID Y	.240	.380	.312
POA TO CENTROID in.	.278	.456	.523
MIN RADIUS	.411	.440	.261
MEAN RADIUS	.903	.816	.706
MAX RADIUS	1.613	1.441	1.121
HORIZONTAL SPREAD	2.164	2.164	1.635
VERTICAL SPREAD	2.310	1.437	1.437
EXTREME SPREAD	2.948	2.378	1.897
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		