

C6523418

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6523418

ORDER NO.
5716

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



5716 C6523418

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523418

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3 90		RW
600	Proof	10 3 90		RW
607	Check Headspace	10 3 90		RW
610	Dis-assemble Gun	10 3 90		RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	GL
617	Drill and Tap Sight Holes		10/11/90	KB
618	Polish Barrel RB		10/12/90	KB
620	Apply Coatings (Barrel Action)		10-12-90	TJA
	Apply Coating (Bolt)			
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		11/5/90	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			11/5/90	WB
	G) Safety Off Force	2	2	2			11/5/90	WB
	H) Trigger Pull Test & Retainability						11/5/90	JH
	I) Firing Pin Indent	.0715	.072	.0715			11/5/90	WB
	J) Assemble Stock						11/5/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/5/90	RW
	M) Iron Sight Alignment						11/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/5/90	RW
	O) Attach Scope to Rifle						11/5/90	RW
	P) Detach & Attach Scope 20 Times						11/5/90	RW
640	Gallery Target & Test						11-7-90	DH
	A) Time						11-7-90	DH
	B) Malfunctions						11-7-90	DH
	C) Pierced Primers						11-7-90	DH
	D) Optical Clarity of Scope						11-7-90	DH
645	Inspect for Live Ammo						11-7-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	253	231	224	223	224	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/18/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C65 23418DATE 11/5/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.37	2.18	2.25 2.25	MIN. SETTING,
PULL #2	2.34	2.20	2.25	2.20 2.20	NO AVG. OF 5
PULL #3	2.21	2.37	2.30	2.22 2.22	READINGS ACCEPT-
PULL #4	2.24	2.25	2.25	2.22 2.23	ABLE LESS THAN 2#
PULL #5	2.26	2.25	2.32	2.24	
TOTAL	11.33	11.44	11.3		
AVG.	2.266	2.288	2.26		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.40		
PULL #2	3.41	3.42		
PULL #3	3.39	3.41		
PULL #4	3.39	3.40		
PULL #5	3.39	3.36		
TOTAL	17.03	16.99		
AVG.	3.406	3.398		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.37		4.36
PULL #2	4.37	4.24		4.42
PULL #3	4.12	4.23		4.36
PULL #4	4.16	4.50		4.44
PULL #5	4.44	4.31		4.28
TOTAL	21.53	21.65		21.86
AVG.	4.306	4.33		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523418
7 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.100005
1 TO 2	.161524
1 TO 3	.213937
1 TO 4	.196023
1 TO 5	.303727

$\frac{1}{5}$

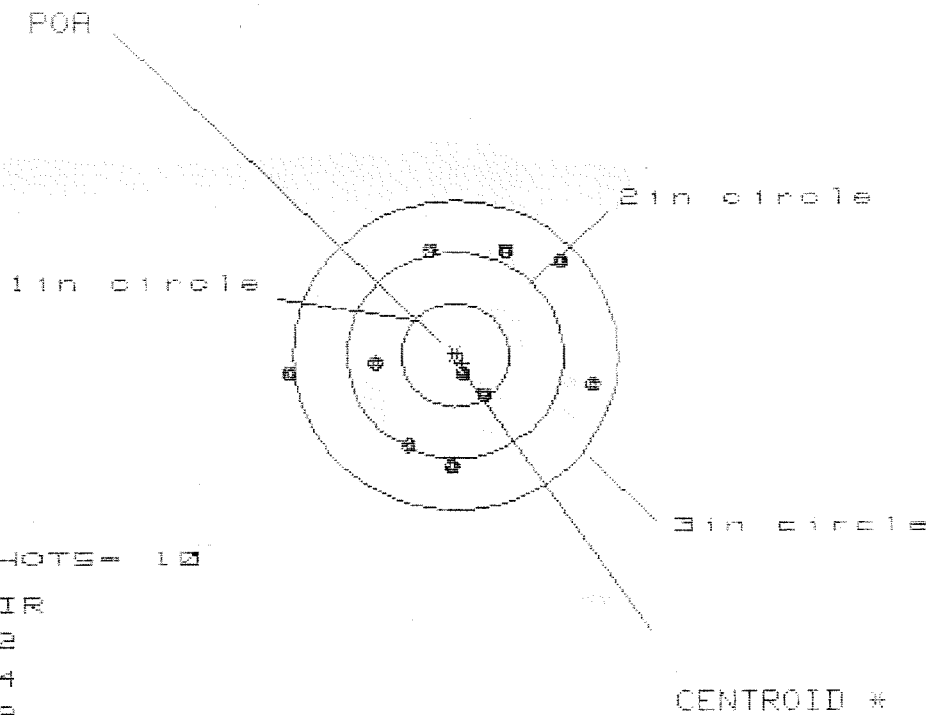
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.007
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212116
THE AMR FOR THIS RIFLE IS: .8534

7 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523418

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.867

VS= 2.116

GS= 2.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.304	1.130	1.235
MINIMUM X	-1.563	-.880	-.775
MAXIMUM Y	1.034	1.016	1.131
MINIMUM Y	-1.082	-1.100	-.985
CENTROID X	-.065	.109	.004
CENTROID Y	.076	.094	-.021
POA TO CENTROID in.	.100	.144	.021
MIN RADIUS	.212	.254	.109
MEAN RADIUS	.980	.911	.831
MAX RADIUS	1.571	1.243	1.243
HORIZONTAL SPREAD	2.867	2.010	2.010
VERTICAL SPREAD	2.116	2.116	2.116
EXTREME SPREAD	2.868	2.306	2.132
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

7 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523418

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.827

VS= 2.500

GS= 2.553

CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.934
MINIMUM X	-.893
MAXIMUM Y	1.343
MINIMUM Y	-1.157
CENTROID X	.096
CENTROID Y	.063
POA TO CENTROID in.	.115
MIN RADIUS	.316
MEAN RADIUS	.799
MAX RADIUS	1.391
HORIZONTAL SPREAD	1.827
VERTICAL SPREAD	2.500
EXTREME SPREAD	2.553
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10

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FILE:/PATTERNING/CENTERFIRE_PATT/08523410

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.762

VS = 1.563

GS = 2.798

CENTROID *

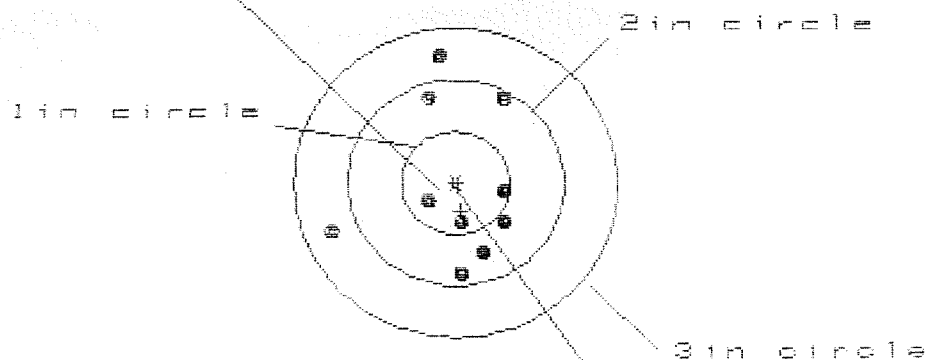
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.546
MINIMUM X	-1.216
MAXIMUM Y	.580
MINIMUM Y	-.983
CENTROID X	.023
CENTROID Y	.271
POA TO CENTROID in.	.272
MIN RADIUS	.278
MEAN RADIUS	.860
MAX RADIUS	1.548
HORIZONTAL SPREAD	2.762
VERTICAL SPREAD	1.563
EXTREME SPREAD	2.798
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6523418

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.622

VS= 2.149

GS= 2.159

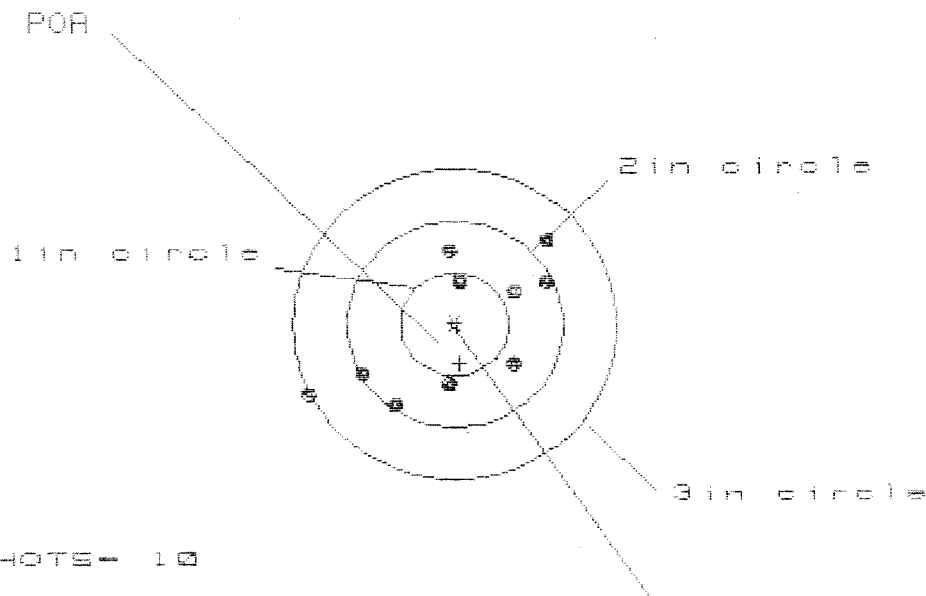
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.491	.475	.332
MINIMUM X	:	-1.131	-1.147	-.449
MAXIMUM Y	:	1.264	.992	.946
MINIMUM Y	:	-.885	-.744	-.790
CENTROID X	:	-.045	-.029	.114
CENTROID Y	:	.271	.130	.176
POA TO CENTROID in.	:	.274	.133	.210
MIN RADIUS	:	.321	.244	.292
MEAN RADIUS	:	.769	.679	.601
MAX RADIUS	:	1.273	1.205	1.019
HORIZONTAL SPREAD	:	1.622	1.622	.780
VERTICAL SPREAD	:	2.149	1.736	1.736
EXTREME SPREAD	:	2.159	2.077	1.776
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6523418

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 8

HS = 2.259

VS = 1.672

GS = 2.707

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.871
MINIMUM X	-1.388
MAXIMUM Y	.863
MINIMUM Y	-.809
CENTROID X	-.044
CENTROID Y	.379
POA TO CENTROID in.	.381
MIN RADIUS	.430
MEAN RADIUS	.859
MAX RADIUS	1.524
HORIZONTAL SPREAD	2.259
VERTICAL SPREAD	1.672
EXTREME SPREAD	2.707
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9