

CB523430

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

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.

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

SERIAL NO.
C6523430

ORDER NO.
5716

UPC

0 47700 25716 7

5716 C6523430

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523430

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	K.R
	Magnaflux Bolt		9-26-90	K.R
615	Rollmark Caliber		9-26-90	GL
617	Drill and Tap Sight Holes		9/28/90	W.B
618	Polish Barrel RW		10/1/90	W.B
620	Apply Coatings (Barrel Action)		10-5-90	TH
	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		10/17/90	RW

op. #	BARBER - M24 0027933	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			10/18/90	W/B
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			10/18/90	W/B
	H) Trigger Pull Test & Retainability						10/17/90	JS
	I) Firing Pin Indent	1.020	1.0205	1.0205			10/18/90	W/B
	J) Assemble Stock						10/22/90	RW
	K) Assemble Swivel Studs						2/28/90	JS
	L) Attach Front and Rear Sight Assemblies						10/22/90	RW
	M) Iron Sight Alignment						10/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/90	RW
	O) Attach Scope to Rifle						10/22/90	RW
	P) Detach & Attach Scope 20 Times						10/22/90	RW
640	Gallery Target & Test						10-24-90	KT
	A) Time						10-24-90	KT
	B) Malfunctions						10-24-90	KT
	C) Pierced Primers						10-24-90	KT
	D) Optical Clarity of Scope						10-24-90	KT
645	Inspect for Live Ammo						10-24-90	KT
655	Final Inspection							
	A) Headspace						2/28/90	JS
	B) Trigger Pull	227	220	231	206	222	2/28/90	JS
	C) Function						2/28/90	JS
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. C6523430

DATE 10/19/0

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.25	2.42	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.34	2.43	2.20	
PULL #3	2.35	2.40	2.39	2.31	
PULL #4	2.25	2.37	2.36	2.06	
PULL #5	2.35	2.17	2.37	2.22	
TOTAL	11.76	11.53	11.97		
AVG.	2.352	2.306	2.394		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.28		
PULL #2	3.36	3.16		
PULL #3	3.33	3.47		
PULL #4	3.35	3.50		
PULL #5	3.18	3.31		
TOTAL	16.42	16.72		
AVG.	3.284	3.344		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.29		4.29
PULL #2	4.40	4.48		4.35
PULL #3	4.50	4.33		4.43
PULL #4	4.27	4.49		4.43
PULL #5	4.41	4.41		4.33
TOTAL	21.99	22.00		21.83
AVG.	4.398	4.4		4.366

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523430
25 Oct 1998

CENTROIDAL DISTANCES

0 TO	1	.437224
1 TO	2	.137768
1 TO	3	.440093
1 TO	4	.374204
1 TO	5	.455334

$\frac{4}{25}$ (----FOR

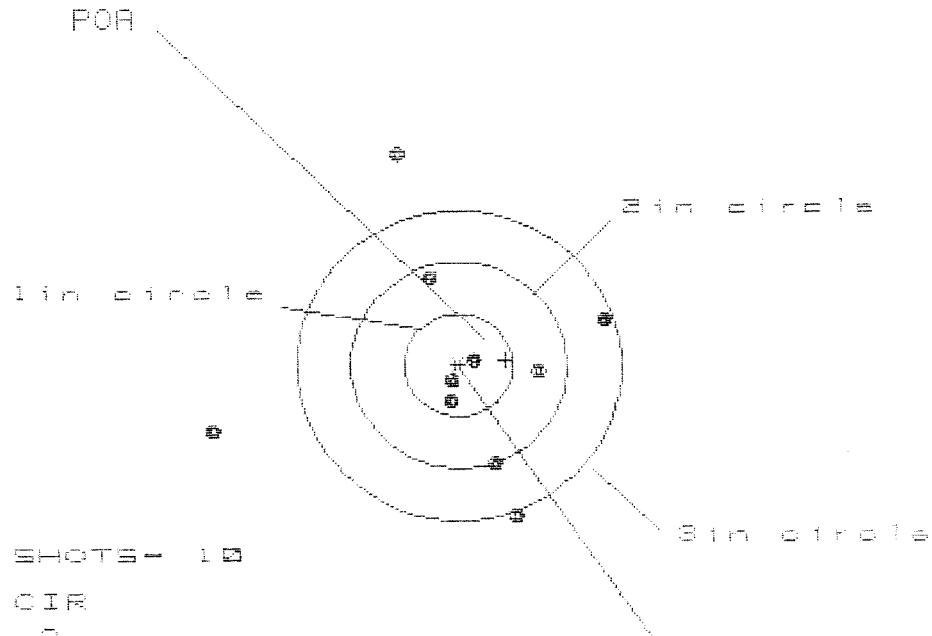
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1898
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0076
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189952

THE AMR FOR THIS RIFLE IS: 1.066

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523430

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HM = 3.590

VM = 3.505

GM = 3.772

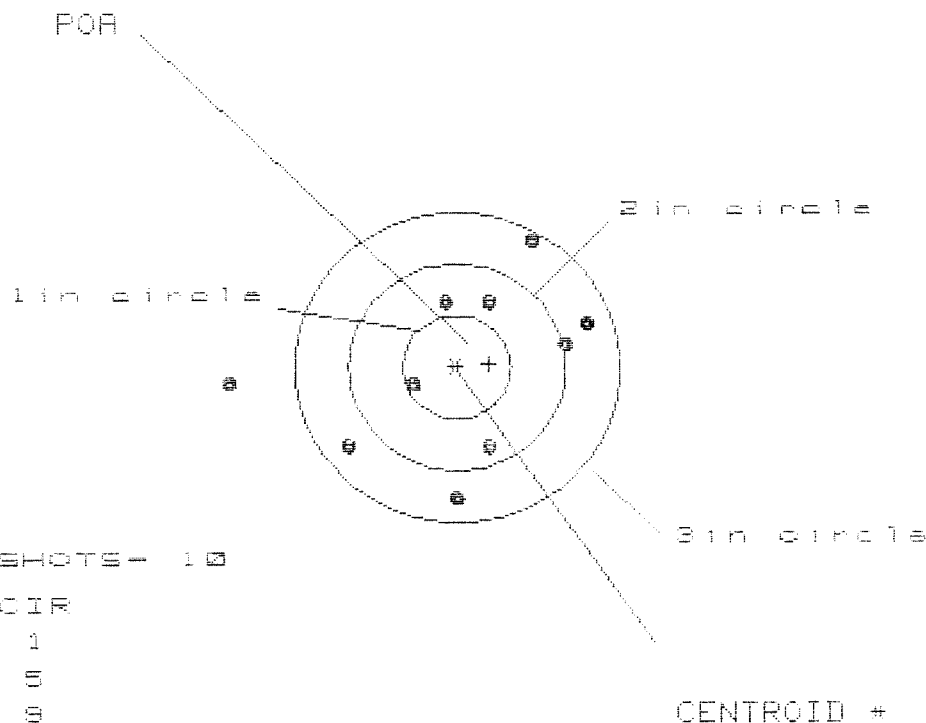
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.374	1.128	1.026
MINIMUM X	-2.216	-.813	-.575
MAXIMUM Y	2.070	1.997	1.079
MINIMUM Y	-1.435	-1.568	-1.258
CENTROID X	-.434	-.188	-.086
CENTROID Y	-.053	.020	-.229
POR TO CENTROID in.	.437	.189	.245
MIN RADIUS	.111	.144	.332
MEAN RADIUS	1.067	.927	.752
MAX RADIUS	2.312	2.156	1.277
HORIZONTAL SPREAD	3.590	1.941	1.681
VERTICAL SPREAD	3.505	3.505	2.337
EXTREME SPREAD	3.772	3.682	2.467
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523430

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.2002

VS = 2.447

GS = 3.346

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.237
MINIMUM X	:	-2.055
MAXIMUM Y	:	1.212
MINIMUM Y	:	-1.235
CENTROID X	:	-.298
CENTROID Y	:	-.031
POA TO CENTROID in.	:	.300
MIN RADIUS	:	.413
MEAN RADIUS	:	1.088
MAX RADIUS	:	2.061
HORIZONTAL SPREAD	:	3.292
VERTICAL SPREAD	:	2.447
EXTREME SPREAD	:	3.346
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	9

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523430

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 4

3 in = 6

HS = 2.858

VS = 2.645

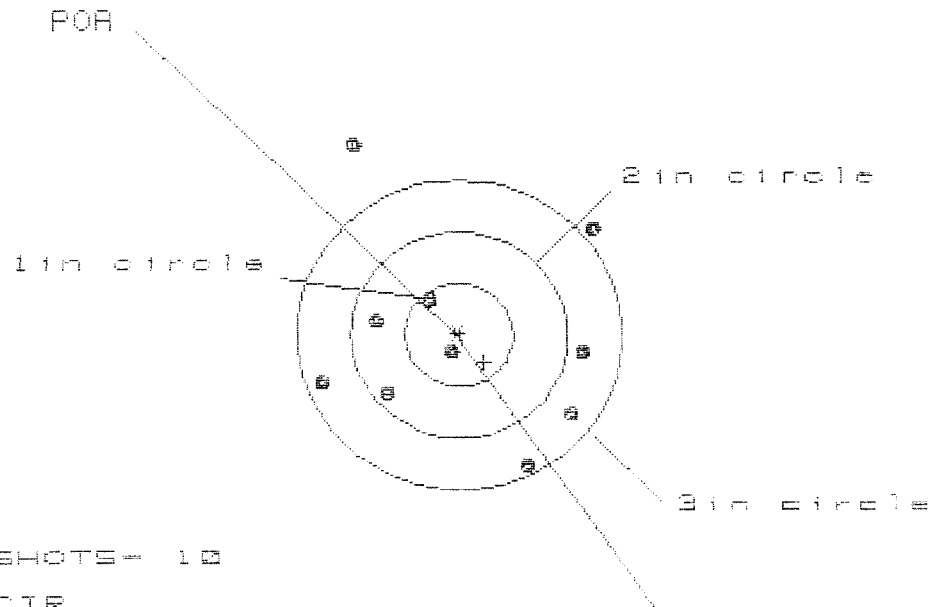
GS = 2.912

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.303
MINIMUM X	-1.555
MAXIMUM Y	1.185
MINIMUM Y	-1.460
CENTROID X	-0.003
CENTROID Y	-0.142
POA TO CENTROID in.	0.142
MIN RADIUS	0.337
MEAN RADIUS	0.954
MAX RADIUS	1.682
HORIZONTAL SPREAD	2.858
VERTICAL SPREAD	2.645
EXTREME SPREAD	2.912
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	6

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523430

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

H = 0.400

V = 0.007

G = 0.400

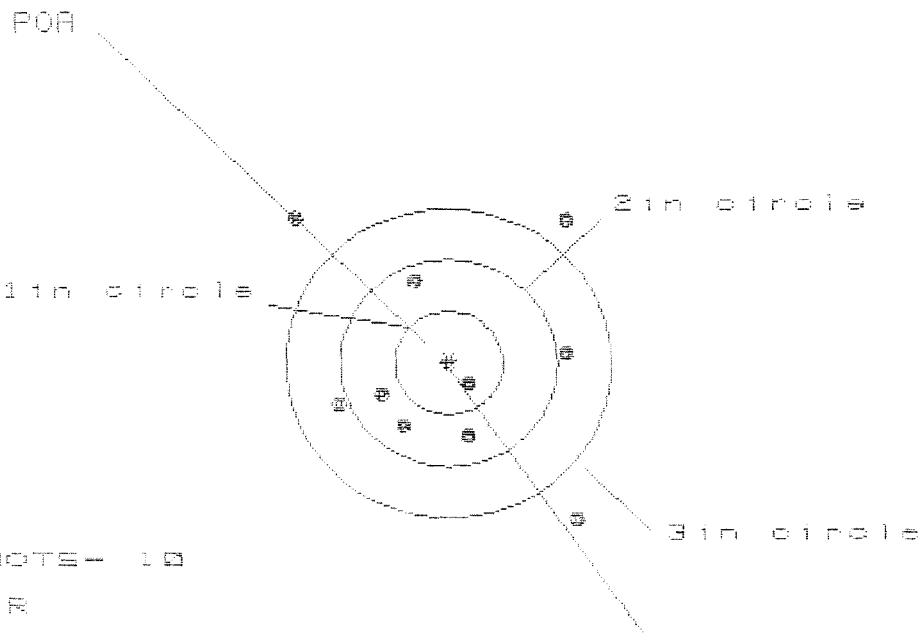
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	1.082	1.177
MINIMUM X	-1.242	-1.350	-1.214
MAXIMUM Y	1.809	1.275	.700
MINIMUM Y	-1.278	-1.077	-.918
CENTROID X	-.232	-.124	-.260
CENTROID Y	.262	.061	-.098
POA TO CENTROID in.	.350	.139	.278
MIN RADIUS	.217	.213	.188
MEAN RADIUS	1.109	.999	.893
MAX RADIUS	2.050	1.672	1.216
HORIZONTAL SPREAD	2.432	2.432	2.391
VERTICAL SPREAD	3.087	2.352	1.618
EXTREME SPREAD	3.468	2.862	2.412
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523430

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HBI = 0.882

VBI = 0.880

GBI = 0.884

CENTROID #

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.158	1.006	1.071
MINIMUM X	-1.375	-1.169	-1.044
MAXIMUM Y	1.445	1.600	1.426
MINIMUM Y	-1.545	-1.390	-1.679
CENTROID X	.018	.170	.045
CENTROID Y	.002	-.153	.021
POA TO CENTROID in.	.018	.229	.049
MIN RADIUS	.329	.111	.324
MEAN RADIUS	1.113	.986	.909
MAX RADIUS	1.961	1.859	1.784
HORIZONTAL SPREAD	2.533	2.175	2.115
VERTICAL SPREAD	2.990	2.990	2.105
EXTREME SPREAD	3.884	2.991	2.906
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		