

06523436

MODEL 700™ M24

Model **SMS**™

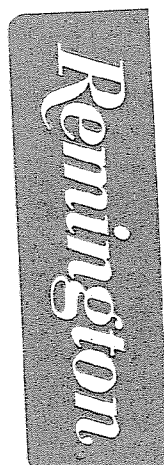
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

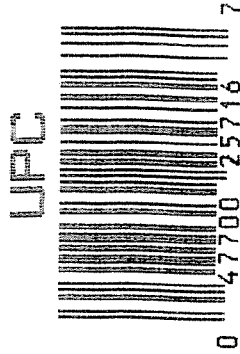
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6523436

ORDER NO.
5716

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



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523436

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	LL
617	Drill and Tap Sight Holes		10/11/90	LB
618	Polish Barrel <i>RVB</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	JA
	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		10/23/90	RW
	D) Oil Firing Pin Ass'y		10/23/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/9/90	WB
	G) Safety Off Force	3	3	3			11/9/90	WB
	H) Trigger Pull Test & Retainability						10-8-90	JH
	I) Firing Pin Indent	.021	.021	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	RW
	K) Assemble Swivel Studs						11-9-90	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						11-9-90	KT
	A) Time						11-9-90	KT
	B) Malfunctions						11-9-90	KT
	C) Pierced Primers						11-9-90	KT
	D) Optical Clarity of Scope						11-9-90	KT
645	Inspect for Live Ammo						11-9-90	KT
655	Final Inspection							
	A) Headspace						11-9-90	DH
	B) Trigger Pull	276	283	281	284	279	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. 06523436

DATE 11-8-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.43	2.50	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.44	2.46	2.83	
PULL #3	2.36	2.41	2.52	2.81	
PULL #4	2.38	2.48	2.45	2.84	
PULL #5	2.37	2.40	2.51	2.79	
TOTAL	11.87	12.16	12.44		
AVG.	2.374	2.432	2.488		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.22		
PULL #2	3.34	3.49		
PULL #3	3.35	3.48		
PULL #4	3.34	3.23		
PULL #5	3.19	3.48		
TOTAL	16.68	16.90		
AVG.	3.336	3.38		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.32		4.19
PULL #2	4.31	4.31		4.28
PULL #3	4.02	4.36		4.39
PULL #4	4.27	4.37		4.45
PULL #5	4.32	4.36		4.37
TOTAL	21.27	21.72		21.68
AVG.	4.254	4.344		4.336

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523436
9 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.181618
1 TO	2	.085703
1 TO	3	.383788
1 TO	4	.0968762
1 TO	5	.175285

$\frac{3}{45}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142526

THE AMR FOR THIS RIFLE IS: 1.261

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523436

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 7

HS = 4.876

VS = 2.184

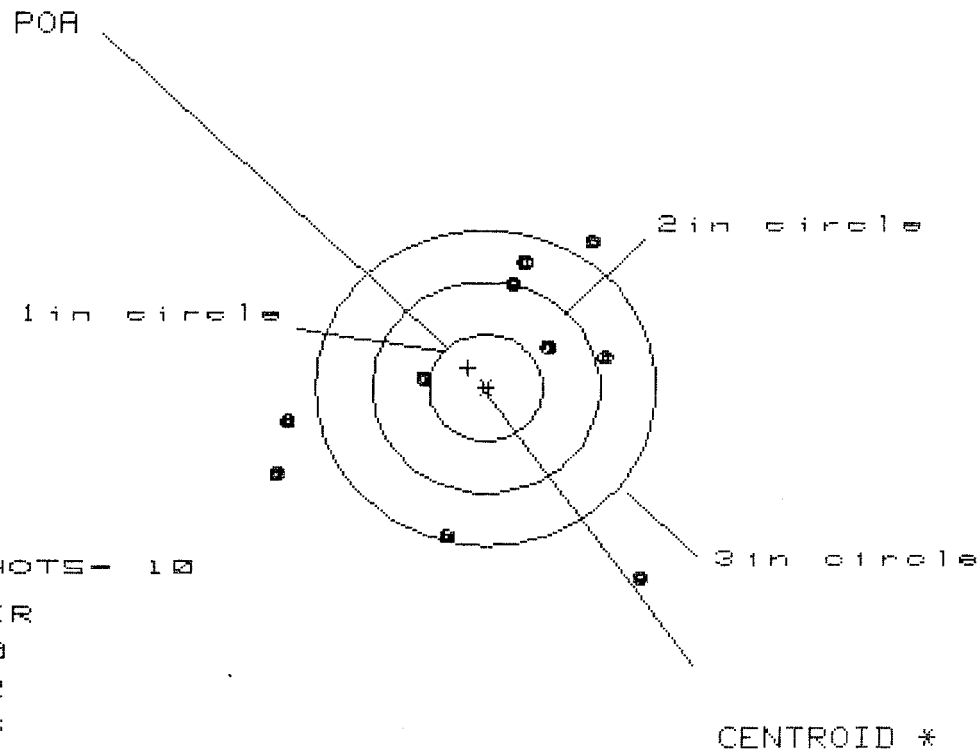
GS = 4.917

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.248	1.956	.886
MINIMUM X	:	-2.628	-1.266	-1.022
MAXIMUM Y	:	1.521	1.463	1.469
MINIMUM Y	:	-.663	-.721	-.715
CENTROID X	:	.069	.361	.117
CENTROID Y	:	-.168	-.111	-.117
POA TO CENTROID in.	:	.182	.378	.165
MIN RADIUS	:	.255	.203	.250
MEAN RADIUS	:	1.110	.897	.771
MAX RADIUS	:	2.679	1.957	1.790
HORIZONTAL SPREAD	:	4.876	3.222	1.828
VERTICAL SPREAD	:	2.184	2.184	2.184
EXTREME SPREAD	:	4.917	3.517	2.773
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523436

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 6

HS= 3.268

VS= 3.210

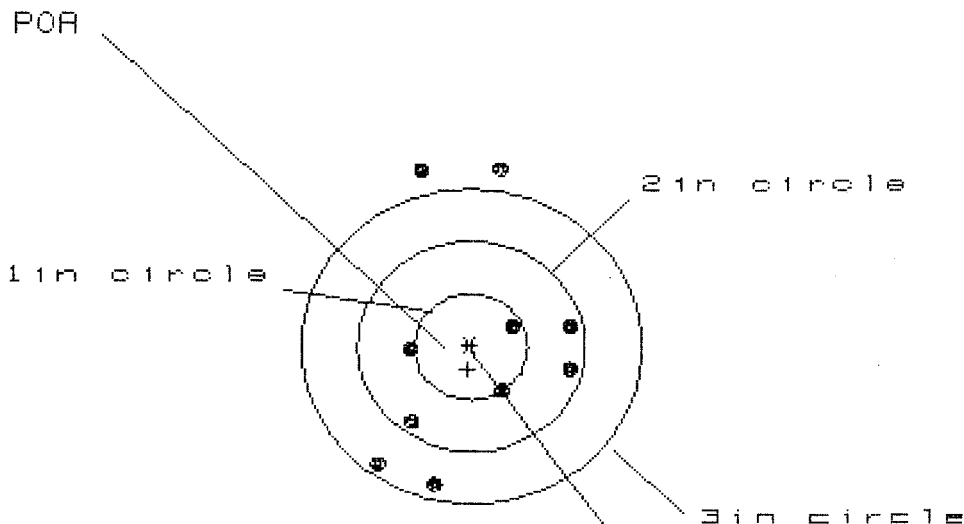
GS= 3.528

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.239	1.022
MINIMUM X	:	-1.891	-1.738	-1.820
MAXIMUM Y	:	1.358	1.152	1.030
MINIMUM Y	:	-1.852	-1.619	-1.741
CENTROID X	:	.153	-.000	.217
CENTROID Y	:	-.185	.021	.143
POA TO CENTROID in.	:	.240	.021	.260
MIN RADIUS	:	.532	.397	.504
MEAN RADIUS	:	1.384	1.251	1.106
MAX RADIUS	:	2.308	1.994	1.917
HORIZONTAL SPREAD	:	3.268	2.977	2.842
VERTICAL SPREAD	:	3.210	2.771	2.771
EXTREME SPREAD	:	3.528	3.528	3.136
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG523436

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.710

VS= 3.076

GS= 3.134

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.933	.882
MINIMUM X	:	-.811	-.777	-.828
MAXIMUM Y	:	1.717	1.847	.638
MINIMUM Y	:	-1.359	-1.168	-.937
CENTROID X	:	.032	-.002	.049
CENTROID Y	:	.214	.023	-.208
POA TO CENTROID in.	:	.216	.023	.214
MIN RADIUS	:	.420	.323	.221
MEAN RADIUS	:	1.032	.926	.781
MAX RADIUS	:	1.744	1.891	1.088
HORIZONTAL SPREAD	:	1.710	1.710	1.710
VERTICAL SPREAD	:	3.076	3.015	1.575
EXTREME SPREAD	:	3.134	3.019	2.164
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

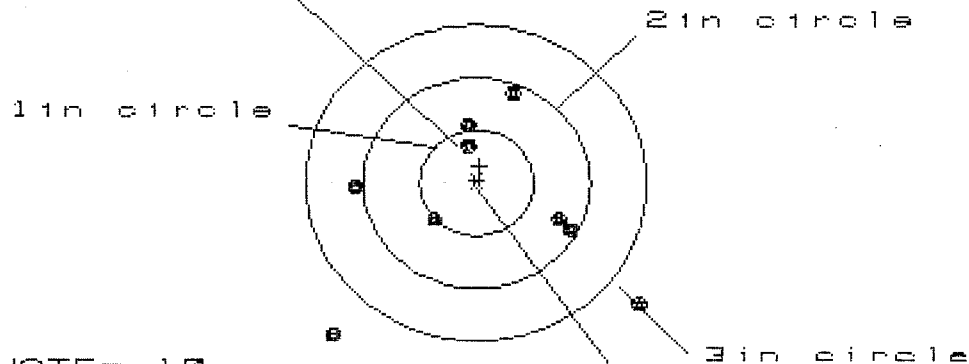
9 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523436

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 2.664

VS= 3.426

GS= 3.731

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.368	1.205
MINIMUM X	:	-1.233	-1.296	-1.296
MAXIMUM Y	:	1.965	1.072	.917
MINIMUM Y	:	-1.461	-1.243	-1.122
CENTROID X	:	-.027	.036	.199
CENTROID Y	:	-.155	-.373	-.218
POA TO CENTROID in.	:	.157	.375	.295
MIN RADIUS	:	.358	.406	.530
MEAN RADIUS	:	1.096	1.003	.875
MAX RADIUS	:	2.046	1.796	1.647
HORIZONTAL SPREAD	:	2.664	2.664	2.502
VERTICAL SPREAD	:	3.426	2.315	2.039
EXTREME SPREAD	:	3.731	2.780	2.767
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523436

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 2.302

VS= 6.399

GS= 6.400

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.894	.978	1.100
MINIMUM X	:	-1.408	-1.324	-1.202
MAXIMUM Y	:	1.922	1.424	1.359
MINIMUM Y	:	-4.477	-1.690	-1.512
CENTROID X	:	.215	.131	.009
CENTROID Y	:	-.265	.233	.054
POA TO CENTROID in.	:	.341	.267	.055
MIN RADIUS	:	.894	.778	.875
MEAN RADIUS	:	1.682	1.282	1.226
MAX RADIUS	:	4.541	1.725	1.513
HORIZONTAL SPREAD	:	2.302	2.302	2.302
VERTICAL SPREAD	:	6.399	3.114	2.871
EXTREME SPREAD	:	6.400	3.282	2.962
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	