

C6523449

MODEL 700TM M24

Model **SMS** TM

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.

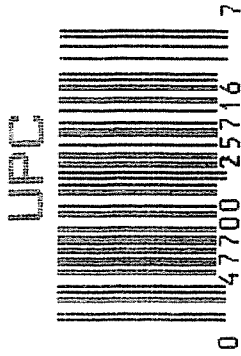
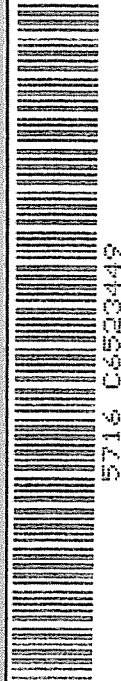
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO. 06523449

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 # C6523449

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	SL
617	Drill and Tap Sight Holes		10/8/90	KG
618	Polish Barrel <i>PB</i>		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	KJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/2/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KJ
	C) Inspect Ejector Hole for Chamfer		10/21/90	KJ
	D) Oil Firing Pin Ass'y		10/21/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		10/29/90	GM

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4	10/30/90	WB		
	G) Safety Off Force	2	2	2	10/30/90	WB		
	H) Trigger Pull Test & Retainability				10/29/90	gll		
	I) Firing Pin Indent	.021	.0215	.0215	10/30/90	WB		
	J) Assemble Stock				10/31/90	KL		
	K) Assemble Swivel Studs				11/19/90	gll		
	L) Attach Front and Rear Sight Assemblies				10/31/90	KL		
	M) Iron Sight Alignment				10/31/90	KL		
	N) Detach Front & Rear Sights & place in numbered container				10/31/90	KL		
	O) Attach Scope to Rifle				10/31/90	KL		
P) Detach & Attach Scope 20 Times				10/31/90	KL			
640	Gallery Target & Test				11-1-90	AC		
	A) Time				11-1-90	AC		
	B) Malfunctions				11-1-90	AC		
	C) Pierced Primers				11-1-90	AC		
	D) Optical Clarity of Scope				11-1-90	AC		
645	Inspect for Live Ammo				11-1-90	AC		
655	Final Inspection							
	A) Headspace				11/19/90	gll		
	B) Trigger Pull	224	216	219	209	224	11/19/90	gll
	C) Function						11/19/90	gll
660	Pack				12-1-90	DH		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523449

DATE 10/29/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.49	2.46	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.42	2.40	2.16	
PULL #3	2.22	2.49	2.38	2.19	
PULL #4	2.47	2.39	2.35	2.09	
PULL #5	2.41	2.35	2.30	2.24	
TOTAL	11.54	12.14	11.89		
AVG.	2.312	2.428	2.378		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.38		
PULL #2	3.32	3.40		
PULL #3	3.33	3.30		
PULL #4	3.40	3.32		
PULL #5	3.28	3.22		
TOTAL	16.61	16.62		
AVG.	3.322	3.324		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.38		4.42
PULL #2	4.40	4.34		4.14
PULL #3	4.50	4.36		4.35
PULL #4	4.47	4.37		4.33
PULL #5	4.37	4.46		4.32
TOTAL	22.04	21.91		21.56
AVG.	4.408	4.382		4.312

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523449
1 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.391065
1 TO	2	.718672
1 TO	3	.341884
1 TO	4	.546883
1 TO	5	.498531

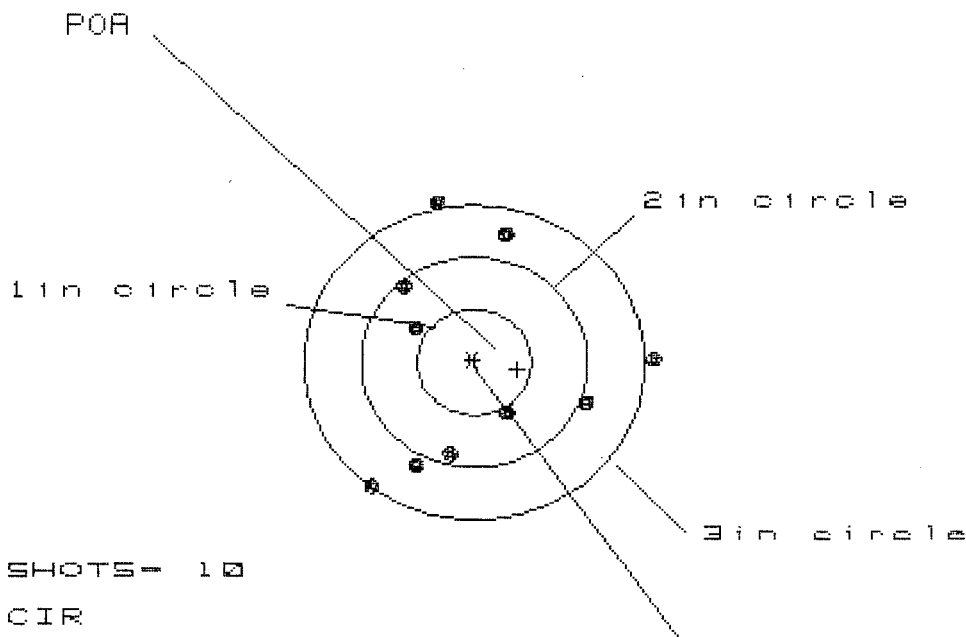
1.52 < ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.058
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0581519
THE AMR FOR THIS RIFLE IS: .8294

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523449

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.528

VS= 2.733

GS= 2.824

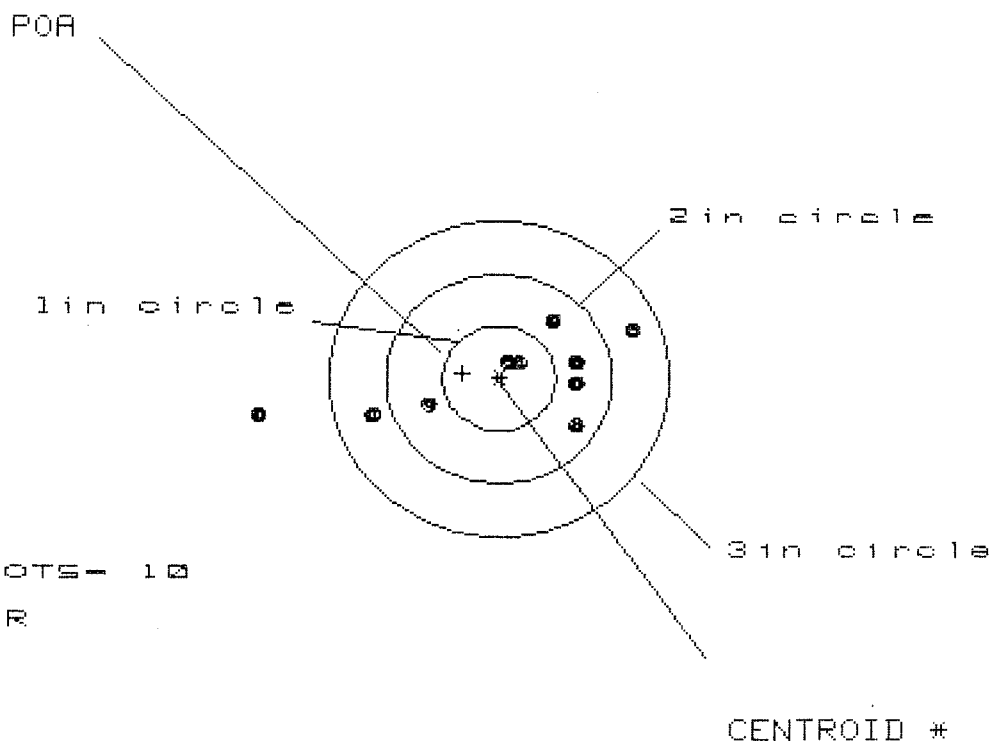
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.571	1.188	1.168
MINIMUM X	-0.957	-0.782	-0.802
MAXIMUM Y	1.517	1.522	1.462
MINIMUM Y	-1.216	-1.211	-1.021
CENTROID X	-0.384	-0.559	-0.539
CENTROID Y	0.074	0.069	-0.121
POA TO CENTROID in.	0.391	0.563	0.552
MIN RADIUS	0.561	0.450	0.535
MEAN RADIUS	1.116	1.048	0.964
MAX RADIUS	1.572	1.530	1.532
HORIZONTAL SPREAD	2.528	1.970	1.970
VERTICAL SPREAD	2.733	2.733	2.483
EXTREME SPREAD	2.824	2.804	2.783
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

1 Nov 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 3.323

VS = 1.061

GS = 3.418

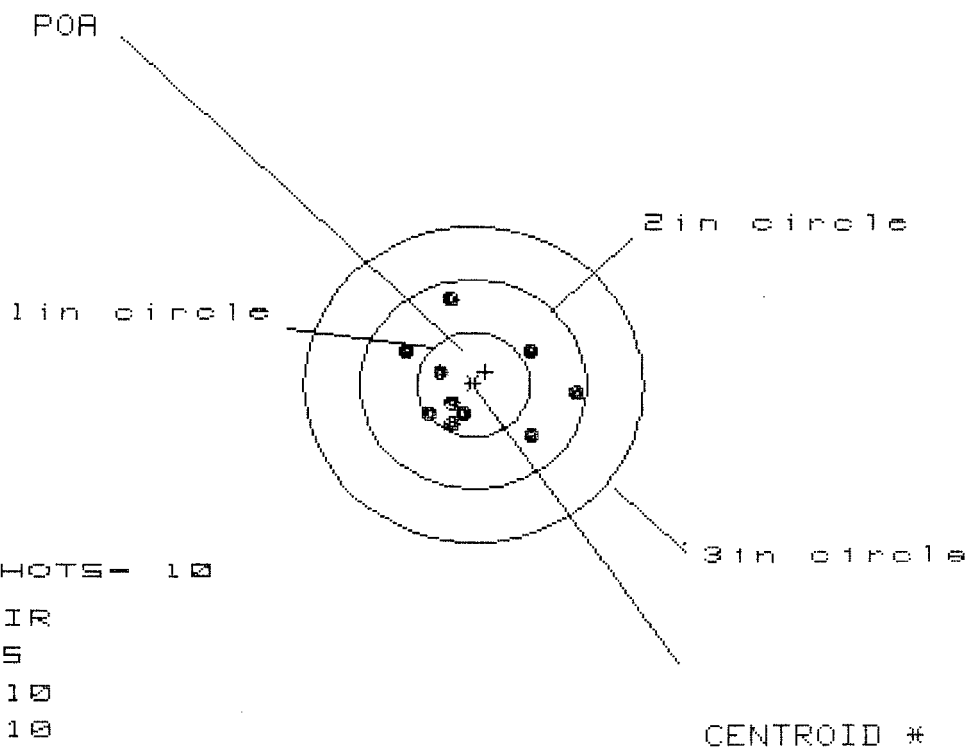
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.179	.940	.584
MINIMUM X	:	-2.144	-1.407	-1.289
MAXIMUM Y	:	.579	.540	.592
MINIMUM Y	:	-.482	-.521	-.469
CENTROID X	:	.323	.562	.444
CENTROID Y	:	-.055	-.016	-.068
POA TO CENTROID in.	:	.328	.562	.449
MIN RADIUS	:	.145	.147	.148
MEAN RADIUS	:	.873	.670	.637
MAX RADIUS	:	2.173	1.471	1.344
HORIZONTAL SPREAD	:	3.323	2.347	1.873
VERTICAL SPREAD	:	1.061	1.061	1.061
EXTREME SPREAD	:	3.418	2.494	1.957
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

1 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.523

VS= 1.280

GS= 1.584

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.919	.621	.616
MINIMUM X	:	-.604	-.502	-.507
MAXIMUM Y	:	.846	.835	.460
MINIMUM Y	:	-.434	-.445	-.341
CENTROID X	:	-.106	-.208	-.203
CENTROID Y	:	-.125	-.114	-.218
POA TO CENTROID in.	:	.164	.237	.298
MIN RADIUS	:	.275	.209	.144
MEAN RADIUS	:	.547	.483	.409
MAX RADIUS	:	.925	.836	.729
HORIZONTAL SPREAD	:	1.523	1.123	1.123
VERTICAL SPREAD	:	1.280	1.280	.801
EXTREME SPREAD	:	1.584	1.443	1.359
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Nov 1998

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 1.748

VS = 2.967

GS = 3.116

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.827	.755	.784
MINIMUM X	:	-.921	-.993	-.964
MAXIMUM Y	:	1.537	1.379	.729
MINIMUM Y	:	-1.430	-.726	-.554
CENTROID X	:	.032	.104	.074
CENTROID Y	:	-.281	-.123	-.295
POA TO CENTROID in.	:	.283	.161	.304
MIN RADIUS	:	.236	.315	.203
MEAN RADIUS	:	.824	.757	.637
MAX RADIUS	:	1.568	1.398	1.007
HORIZONTAL SPREAD	:	1.748	1.748	1.748
VERTICAL SPREAD	:	2.967	2.105	1.283
EXTREME SPREAD	:	3.116	2.109	1.865
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1998

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.236

VS= 1.896

GS= 2.383

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	.947	.858
MINIMUM X	:	-1.160	-.863	-.745
MAXIMUM Y	:	1.054	.960	.947
MINIMUM Y	:	-.842	-.794	-.807
CENTROID X	:	.114	.243	.125
CENTROID Y	:	.097	.191	.205
POA TO CENTROID in.	:	.150	.309	.240
MIN RADIUS	:	.156	.287	.265
MEAN RADIUS	:	.787	.720	.672
MAX RADIUS	:	1.434	1.025	.954
HORIZONTAL SPREAD	:	2.236	1.810	1.603
VERTICAL SPREAD	:	1.896	1.754	1.754
EXTREME SPREAD	:	2.383	1.928	1.860
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	