

06523452

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523452

DATE _____

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.81	2.65	2.55		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.85	2.66	2.80		
PULL #3	2.86	2.65	2.70		
PULL #4	2.77	2.71	2.77		
PULL #5	2.78	2.71	2.30		
TOTAL	14.07	13.38	13.12		
AVG.	2.81	2.68	2.62		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.25		
PULL #2	3.16	3.28		
PULL #3	3.24	3.11		
PULL #4	3.21	3.01		
PULL #5	3.21	3.26		
TOTAL	16.09	15.91		
AVG.	3.22	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.09		4.12
PULL #2	4.05	4.08		4.13
PULL #3	4.03	4.01		4.24
PULL #4	4.13	4.05		4.10
PULL #5	4.01	4.11		4.19
TOTAL	20.30	20.34		20.78
AVG.	4.06	4.07		4.16

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523452

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

BARBER - M24 0028377

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/4	5 1/2			11/29	WB
	G) Safety Off Force	3	3	3			11/29	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.78	2.76	2.79	2.74	2.76	11/29	WB
	C) Function							
660	Pack							

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

Remington®

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

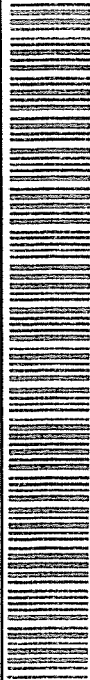
MODEL 700™ M24

SERIAL NO.
06523452

ORDER NO.
5716

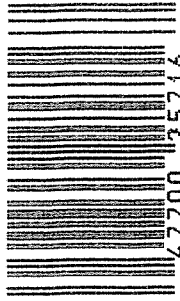
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M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 652 3452

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	LS
600	Proof		10/2/90	LS
607	Check Headspace		10/2/90	LS
610	Dis-assemble Gun		10/2/90	LS
612	Magnaflux Barrel Action	15 1	10/5/90	KR
	Magnaflux Bolt	15 1	10/5/90	KR
615	Rollmark Caliber		10/5/90	LS
617	Drill and Tap Sight Holes		10/8/90	FB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	LS
	Apply Coating (Bolt)		10-20-90	LS
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10/29/90	LS

op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	5	5	5	10/30/90	WB	
	G) Safety Off Force	2	2	2	10/30/90	WB	
	H) Trigger Pull Test & Retainability				10/29/90	SM	
	I) Firing Pin Indent	.021	.0205	.0205	10/30/90	WB	
	J) Assemble Stock				10/31/90	KA	
	K) Assemble Swivel Studs				11/19/90	GB	
	L) Attach Front and Rear Sight Assemblies				10/31/90	KA	
	M) Iron Sight Alignment				10/31/90	KA	
	N) Detach Front & Rear Sights & place in numbered container				10/31/90	KA	
	O) Attach Scope to Rifle				10/31/90	KA	
	P) Detach & Attach Scope 20 Times				10/31/90	KA	
640	Gallery Target & Test				11-1-90	KT	
	A) Time				11-1-90	KT	
	B) Malfunctions				11-1-90	KT	
	C) Pierced Primers				11-1-90	KT	
	D) Optical Clarity of Scope				11-1-90	KT	
645	Inspect for Live Ammo				11-1-90	KT	
655	Final Inspection				11/19/90	GB	
	A) Headspace				11/19/90	GB	
	B) Trigger Pull	278	284	281	281	285	11/19/90
	C) Function				11/19/90	GB	
660	Pack				12-17-90	DH	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523452
2 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0777946
1 TO	2	.373016
1 TO	3	.34192
1 TO	4	.200691
1 TO	5	.0898888

25
11

<----POA

1001

1010 10 1

1011

10

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0448
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0449609
THE AMR FOR THIS RIFLE IS: .911

2 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08523452

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.780

VS = 2.527

GS = 2.846

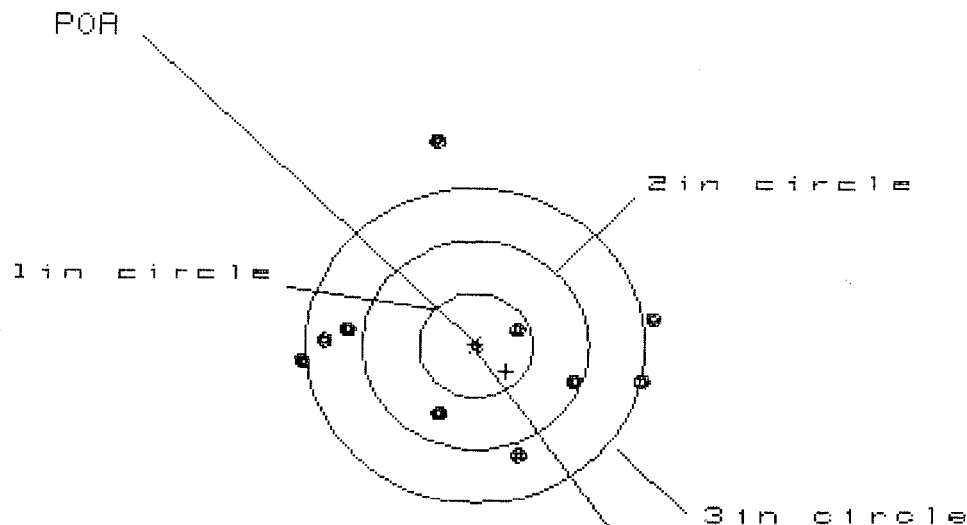
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.689	1.200	1.198
MINIMUM X	:	-1.091	-.904	-.906
MAXIMUM Y	:	1.420	1.391	.848
MINIMUM Y	:	-1.107	-1.136	-.962
CENTROID X	:	.054	-.133	-.131
CENTROID Y	:	.056	.085	-.089
POA TO CENTROID in.	:	.078	.158	.158
MIN RADIUS	:	.235	.209	.372
MEAN RADIUS	:	.970	.874	.817
MAX RADIUS	:	1.709	1.391	1.203
HORIZONTAL SPREAD	:	2.780	2.104	2.104
VERTICAL SPREAD	:	2.527	2.527	1.810
EXTREME SPREAD	:	2.846	2.532	2.138
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG523452

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 3

3 in - 7

HS= 3.037

VS= 2.971

GS= 3.070

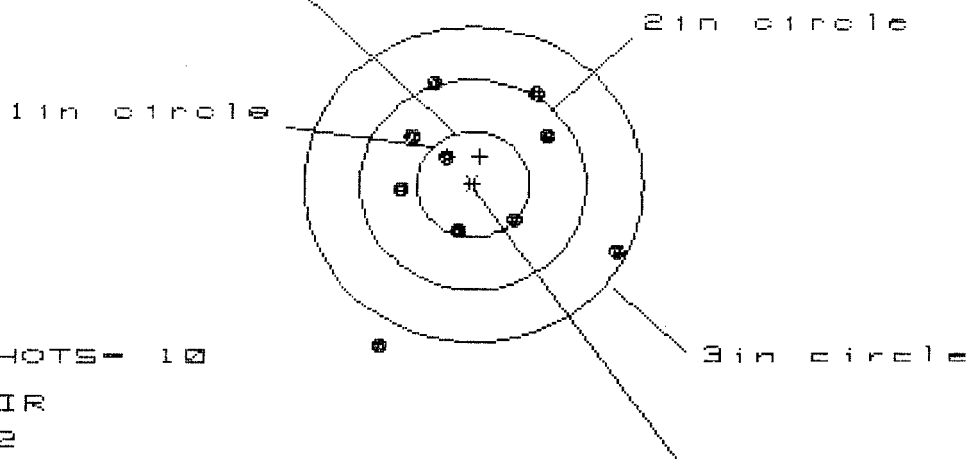
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	1.501	1.574
MINIMUM X	:	-1.502	-1.536	-1.349
MAXIMUM Y	:	1.911	.489	.468
MINIMUM Y	:	-1.060	-.847	-.786
CENTROID X	:	-.267	-.233	-.420
CENTROID Y	:	.246	.033	-.028
POA TO CENTROID in.	:	.363	.235	.421
MIN RADIUS	:	.396	.496	.381
MEAN RADIUS	:	1.209	1.101	1.030
MAX RADIUS	:	1.937	1.578	1.577
HORIZONTAL SPREAD	:	3.037	3.037	2.923
VERTICAL SPREAD	:	2.971	1.336	1.254
EXTREME SPREAD	:	3.070	3.070	2.930
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523452

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.165

VS = 2.536

GS = 2.789

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.295	1.198	.707
MINIMUM X	:	-.870	-.710	-.560
MAXIMUM Y	:	1.000	.829	.726
MINIMUM Y	:	-1.536	-.827	-.677
CENTROID X	:	-.061	.036	-.114
CENTROID Y	:	-.266	-.095	.008
POA TO CENTROID in.	:	.273	.102	.114
MIN RADIUS	:	.384	.387	.226
MEAN RADIUS	:	.875	.769	.652
MAX RADIUS	:	1.765	1.456	.833
HORIZONTAL SPREAD	:	2.165	1.908	1.267
VERTICAL SPREAD	:	2.536	1.656	1.403
EXTREME SPREAD	:	2.789	2.312	1.531
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523452

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 1.917

VS = 2.472

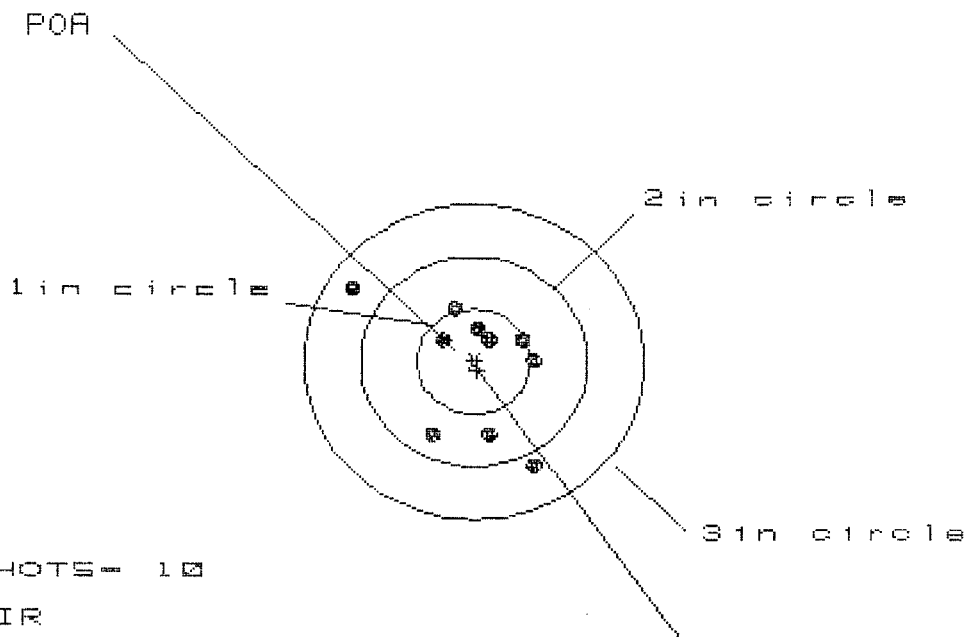
GS = 2.567

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.105	1.103	1.013
MINIMUM X	:	-.812	-.814	-.904
MAXIMUM Y	:	1.069	.913	.712
MINIMUM Y	:	-1.403	-.777	-.663
CENTROID X	:	.080	.082	.172
CENTROID Y	:	-.143	.013	-.101
POA TO CENTROID in.	:	.163	.083	.199
MIN RADIUS	:	.429	.505	.452
MEAN RADIUS	:	.862	.795	.739
MAX RADIUS	:	1.403	1.161	1.021
HORIZONTAL SPREAD	:	1.917	1.917	1.917
VERTICAL SPREAD	:	2.472	1.690	1.375
EXTREME SPREAD	:	2.567	2.030	1.967
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523452

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.626

VS = 1.674

GS = 2.278

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.564	.446	.492
MINIMUM X	-1.062	-.467	-.421
MAXIMUM Y	.723	.611	.502
MINIMUM Y	-.951	-.871	-.706
CENTROID X	-.030	.088	.042
CENTROID Y	.088	.088	.117
POA TO CENTROID in.	.093	.088	.124
MIN RADIUS	.303	.334	.243
MEAN RADIUS	.639	.567	.490
MAX RADIUS	1.284	.945	.822
HORIZONTAL SPREAD	1.626	.913	.913
VERTICAL SPREAD	1.674	1.482	1.208
EXTREME SPREAD	2.278	1.606	1.227
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

SWS TRIGGER PULL TEST

BARBER - M24 0028387

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6523452DATE 10/29/90

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.36	2.53	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.33	2.46	2.84	
PULL #3	2.32	2.41	2.51	2.81	
PULL #4	2.35	2.20	2.52	2.81	
PULL #5	2.29	2.42	2.51	2.85	
TOTAL	11.76	11.72	12.53		
AVG.	2.352	2.344	2.506		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.52		
PULL #2	3.47	3.20		
PULL #3	3.42	3.19		
PULL #4	3.00	3.45		
PULL #5	3.50	3.45		
TOTAL	16.79	16.81		
AVG.	3.358	3.362		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.22		4.27
PULL #2	4.33	4.25		4.25
PULL #3	4.32	4.44		4.20
PULL #4	4.30	4.36		4.19
PULL #5	4.00	4.29		4.23
TOTAL	21.3	21.56		21.14
AVG.	4.26	4.312		4.228