

06523468

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

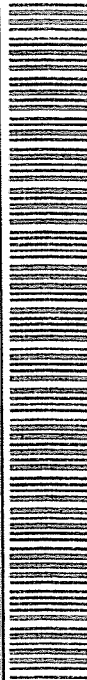
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
D6520468

ORDER NO.
5716

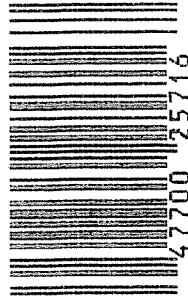
Q1

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



5716 D6520468

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523468

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/21/90	DB
600	Proof		8/31/90	DB
607	Check Headspace		8/21/90	DB
610	Dis-assemble Gun		8/21/90	DB
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-20-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/3/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/3/90	RW
	C) Inspect Ejector Hole for Chamfer		10/3/90	RW
	D) Oil Firing Pin Ass'y		10/3/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/3/90	RW

op. #	OP. NAME	READINGS			DATE	INIT		
655 nt.	F) Safety On Force	4.5	4.5	4.5	10/4/90	RW		
	G) Safety Off Force	3	3	3	10/4/90	RW		
	H) Trigger Pull Test & Retainability				10/3/90	RW		
	I) Firing Pin Indent	.021	.021	.022	10/4/90	RW		
	J) Assemble Stock				10/4/90	RW		
	K) Assemble Swivel Studs				10/30/90	QD		
	L) Attach Front and Rear Sight Assemblies				10/4/90	RW		
	M) Iron Sight Alignment				10/4/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				10/4/90	RW		
	O) Attach Scope to Rifle				10/4/90	RW		
	P) Detach & Attach Scope 20 Times				10/4/90	RW		
640	Gallery Target & Test				10-8-90	L		
	A) Time				"	L		
	B) Malfunctions				"	L		
	C) Pierced Primers				"	L		
	D) Optical Clarity of Scope				"	L		
645	Inspect for Live Ammo				10-8-90	L		
655	Final Inspection							
	A) Headspace				10/30/90	QD		
	B) Trigger Pull	2.38	2.32	2.28	2.28	2.32	10-9-90	QD
	C) Function				10/30/90	QD		
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. C6523468DATE 10/3/90TESTER PRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.26	2.21	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.09	2.40	2.32	
PULL #3	2.37	2.29	2.33	2.27	
PULL #4	2.40	2.03	2.21	2.28	
PULL #5	2.41	2.25	2.16	2.32	
TOTAL	11.94	10.92	11.31	11.57	
AVG.	2.39	2.18	2.26	2.314	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.31		
PULL #2	3.35	3.26		
PULL #3	3.28	3.03		
PULL #4	3.30	3.29		
PULL #5	3.26	3.30		
TOTAL	16.45	16.19		
AVG.	3.29	3.24		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.11		4.13
PULL #2	4.08	4.07		4.06
PULL #3	4.06	4.07		4.13
PULL #4	4.10	4.00		4.11
PULL #5	4.05	4.06		4.04
TOTAL	20.42	20.31		20.47
AVG.	4.08	4.06		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523468
8 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.128798
1 TO	2	.164551
1 TO	3	.349201
1 TO	4	.140929
1 TO	5	.561445

34 5 <----POA

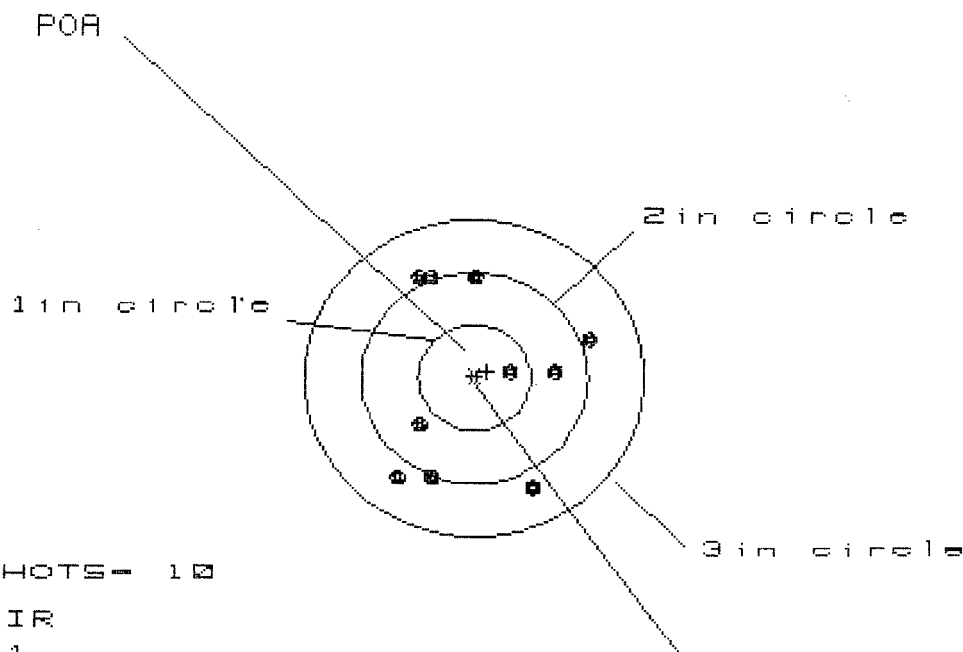
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0984
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107305
THE AMR FOR THIS RIFLE IS: .8998

8 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523468

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 10

HS= 1.703

VS= 2.026

GS= 2.225

CENTROID #

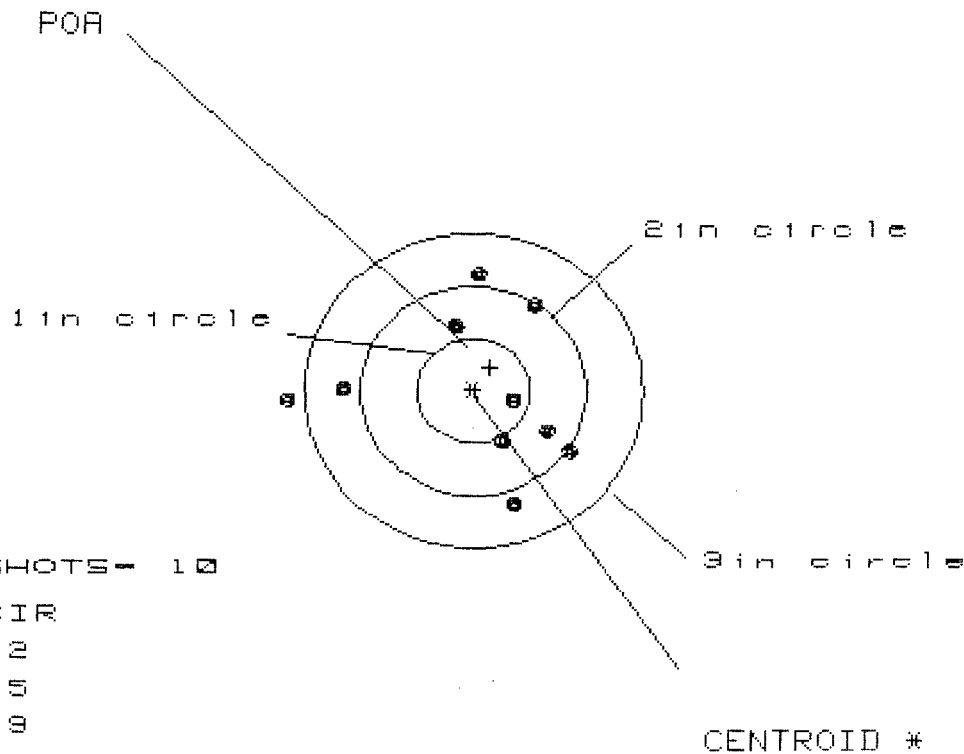
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.997	.919	.975
MINIMUM X	-.706	-.599	-.543
MAXIMUM Y	1.002	.895	.754
MINIMUM Y	-1.024	-1.131	-1.224
CENTROID X	-.115	-.037	-.092
CENTROID Y	-.058	.049	.190
POA TO CENTROID in.	.129	.061	.211
MIN RADIUS	.307	.222	.326
MEAN RADIUS	.920	.872	.824
MAX RADIUS	1.189	1.215	1.288
HORIZONTAL SPREAD	1.703	1.518	1.518
VERTICAL SPREAD	2.026	2.026	1.978
EXTREME SPREAD	2.225	2.225	2.016
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

8 Oct 1998

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.492

VS= 2.204

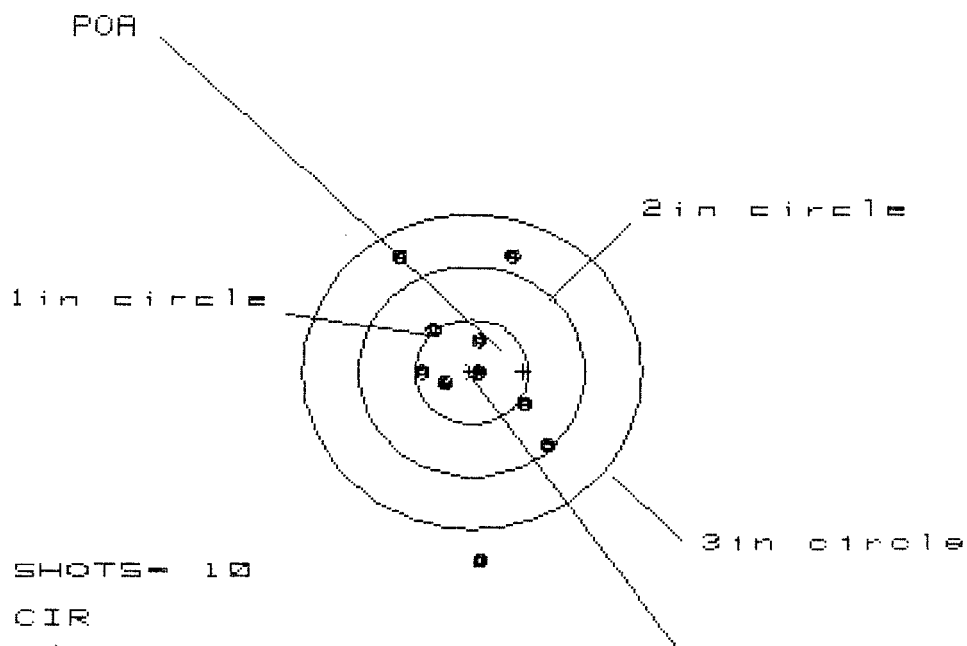
GS= 2.548

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.837	.653	.482
MINIMUM X	:	-1.655	-1.366	-.488
MAXIMUM Y	:	1.119	1.113	1.120
MINIMUM Y	:	-1.085	-1.091	-1.084
CENTROID X	:	-.149	.035	.205
CENTROID Y	:	-.219	-.213	-.220
POA TO CENTROID in.	:	.265	.216	.301
MIN RADIUS	:	.357	.187	.084
MEAN RADIUS	:	.936	.814	.712
MAX RADIUS	:	1.656	1.367	1.156
HORIZONTAL SPREAD	:	2.492	2.019	.971
VERTICAL SPREAD	:	2.204	2.204	2.204
EXTREME SPREAD	:	2.548	2.220	2.220
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Oct 1938

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 1.272

VS = 2.929

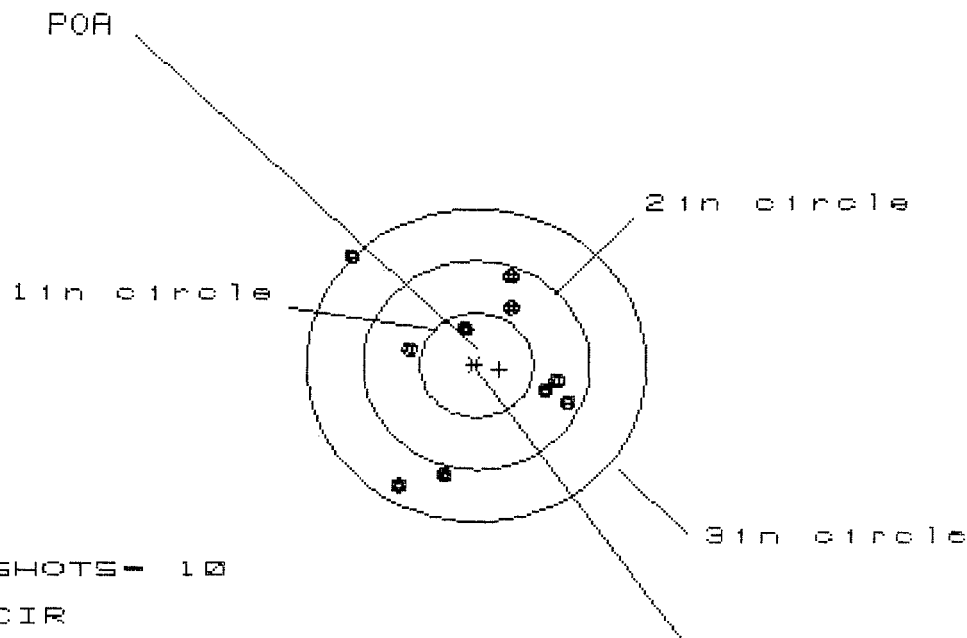
GS = 2.997

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.672	.676	.602
MINIMUM X	:	-.600	-.596	-.498
MAXIMUM Y	:	1.128	.928	1.012
MINIMUM Y	:	-1.801	-.912	-.796
CENTROID X	:	-.460	-.464	-.390
CENTROID Y	:	-.004	.196	.081
POA TO CENTROID in.	:	.460	.504	.398
MIN RADIUS	:	.063	.100	.131
MEAN RADIUS	:	.726	.600	.532
MAX RADIUS	:	1.802	1.136	1.042
HORIZONTAL SPREAD	:	1.272	1.272	1.100
VERTICAL SPREAD	:	2.929	1.840	1.808
EXTREME SPREAD	:	2.997	2.237	1.842
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in - 1

2in - 7

3in - 9

HS - 1.929

VS - 2.267

GS - 2.407

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.690	.593
MINIMUM X	:	-1.115	-.771	-.783
MAXIMUM Y	:	1.074	.940	.806
MINIMUM Y	:	-1.193	-1.074	-1.044
CENTROID X	:	-.209	-.085	.012
CENTROID Y	:	.047	-.072	.062
POA TO CENTROID in.	:	.214	.111	.063
MIN RADIUS	:	.355	.492	.444
MEAN RADIUS	:	.871	.786	.684
MAX RADIUS	:	1.548	1.322	1.184
HORIZONTAL SPREAD	:	1.929	1.461	1.376
VERTICAL SPREAD	:	2.267	2.014	1.850
EXTREME SPREAD	:	2.407	2.211	1.946
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.617

VS= 2.390

GS= 2.778

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.404	1.450	1.318
MINIMUM X	:	-1.213	-1.057	-.813
MAXIMUM Y	:	1.224	1.350	1.435
MINIMUM Y	:	-1.166	-1.040	-.871
CENTROID X	:	.441	.285	.417
CENTROID Y	:	.020	-.106	-.275
POA TO CENTROID in.	:	.442	.304	.500
MIN RADIUS	:	.099	.241	.168
MEAN RADIUS	:	1.046	.939	.796
MAX RADIUS	:	1.803	1.715	1.540
HORIZONTAL SPREAD	:	2.617	2.507	2.130
VERTICAL SPREAD	:	2.390	2.390	2.306
EXTREME SPREAD	:	2.778	2.755	2.422
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	