

C6523478

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

C-1111
250 0177 011

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

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

MODEL 700TM H24

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

SERIAL NO. 06523478

ORDER NO. 5716

01

5716 06523478

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523478

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/90	KJ
600	Proof		10/1/90	KJ
607	Check Headspace		10/1/90	KJ
610	Dis-assemble Gun		10/1/90	KJ
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	LL
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KS
	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		10-24-90	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5			10/25/90	WB
	G) Safety Off Force	2	2	2			10/25/90	WB
	H) Trigger Pull Test & Retainability						10-24-90	DH
	I) Firing Pin Indent	.0235	.023	.023			10/25/90	WB
	J) Assemble Stock						10/26/90	Kd
	K) Assemble Swivel Studs						3/10/90	JS
	L) Attach Front and Rear Sight Assemblies						10/26/90	Kd
	M) Iron Sight Alignment						10/26/90	Kd
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	Kd
	O) Attach Scope to Rifle						10/26/90	Kd
	P) Detach & Attach Scope 20 Times						10/26/90	Kd
640	Gallery Target & Test						10/27/90	DH
	A) Time						"	DH
	B) Malfunctions						"	DH
	C) Pierced Primers						"	DH
	D) Optical Clarity of Scope						"	DH
645	Inspect for Live Ammo						10/27/90	DH
655	Final Inspection							
	A) Headspace						3/10/90	JS
	B) Trigger Pull	217	226	224	224	221	3/10/90	JS
	C) Function						3/10/90	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. C6523478

DATE 10-24-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.55	2.60	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.61	2.58	2.26	
PULL #3	2.60	2.57	2.61	2.24	
PULL #4	2.55	2.67	2.53	2.24	
PULL #5	2.56	2.60	2.58	2.21	
TOTAL	2.80	13.00	12.90		
AVG.	2.56	2.60	2.58		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.10		
PULL #2	3.18	2.99		
PULL #3	3.11	3.18		
PULL #4	3.16	3.01		
PULL #5	3.09	3.23		
TOTAL	15.80	15.51		
AVG.	3.16	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.34		4.00
PULL #2	4.16	4.39		4.18
PULL #3	4.23	4.21		4.20
PULL #4	4.20	4.40		4.22
PULL #5	4.29	4.34		4.12
TOTAL	21.11	21.68		20.72
AVG.	4.22	4.33		4.14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523478
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.224009
1 TO	2	.243528
1 TO	3	.222948
1 TO	4	.454437
1 TO	5	.234649

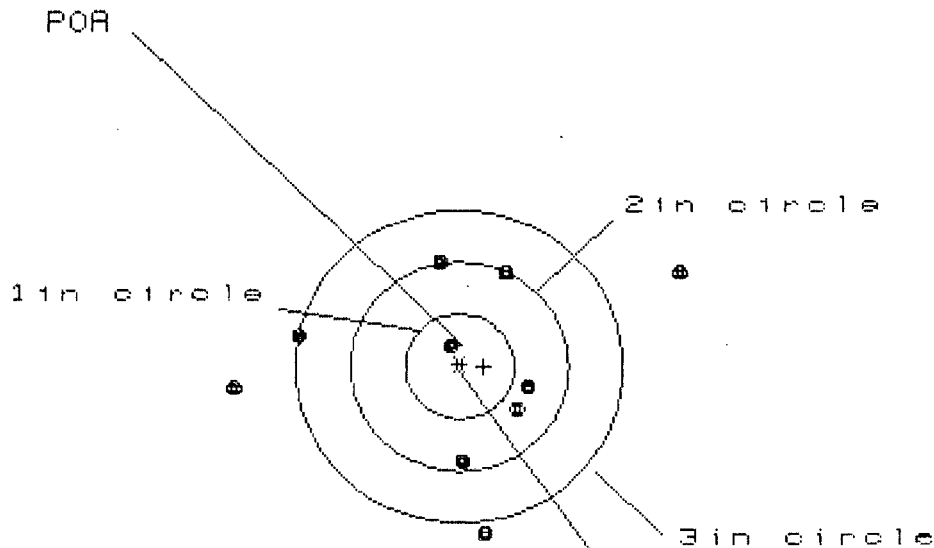
$\frac{3}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .017
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .060824
THE AMR FOR THIS RIFLE IS: .9812

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523478

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS = 4.152

VS = 2.564

GS = 4.316

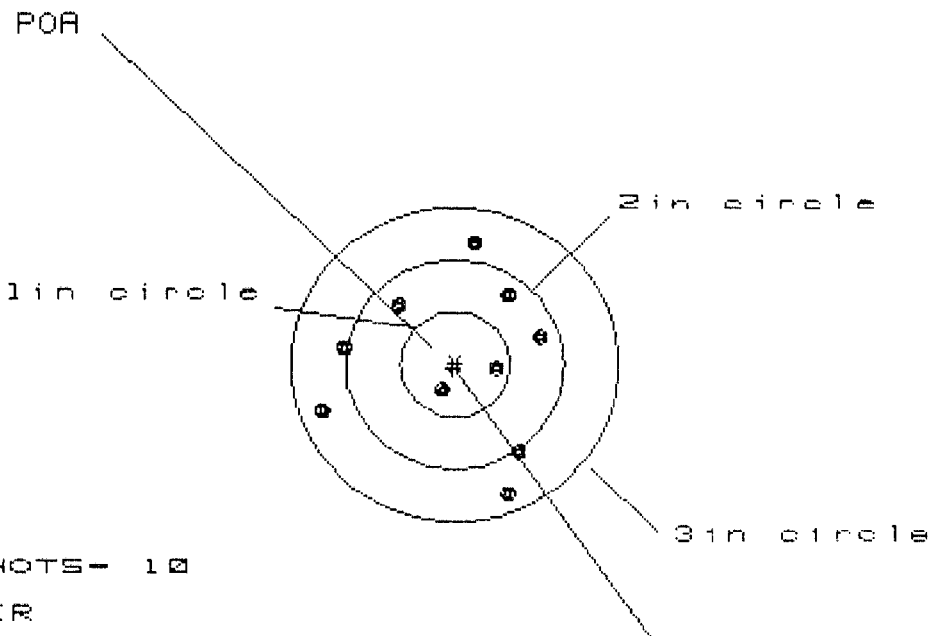
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.036	.804	.568
MINIMUM X	-2.116	-1.890	-1.501
MAXIMUM Y	.952	1.055	1.036
MINIMUM Y	-1.613	-1.509	-1.528
CENTROID X	-.224	-.450	-.214
CENTROID Y	.002	-.101	-.082
POA TO CENTROID in.	.224	.461	.229
MIN RADIUS	.196	.301	.276
MEAN RADIUS	1.182	1.089	.933
MAX RADIUS	2.238	1.896	1.552
HORIZONTAL SPREAD	4.152	2.694	2.069
VERTICAL SPREAD	2.564	2.564	2.564
EXTREME SPREAD	4.316	2.799	2.602
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.033

VS= 2.356

GS= 2.376

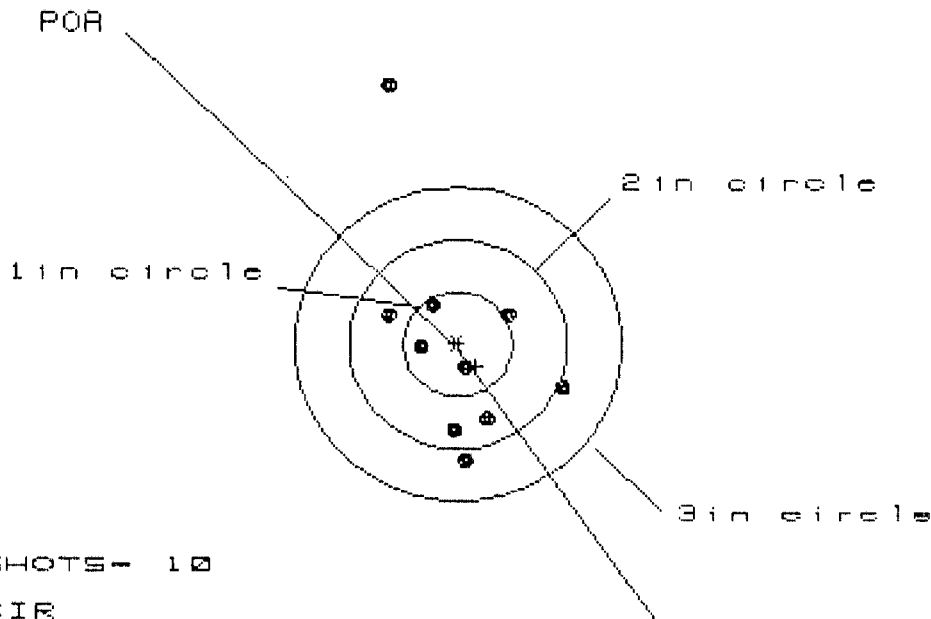
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.683	.721
MINIMUM X	:	-1.215	-1.106	-1.068
MAXIMUM Y	:	1.159	1.106	.950
MINIMUM Y	:	-1.197	-1.250	-1.063
CENTROID X	:	.017	.152	.114
CENTROID Y	:	.037	.090	.246
POA TO CENTROID in.	:	.040	.177	.271
MIN RADIUS	:	.262	.289	.401
MEAN RADIUS	:	.897	.837	.777
MAX RADIUS	:	1.306	1.286	1.172
HORIZONTAL SPREAD	:	2.033	1.789	1.789
VERTICAL SPREAD	:	2.356	2.356	2.013
EXTREME SPREAD	:	2.376	2.376	2.064
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.565

VS = 3.599

GS = 3.659

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.945	.878	.877
MINIMUM X	:	-.620	-.687	-.688
MAXIMUM Y	:	2.446	.694	.584
MINIMUM Y	:	-1.153	-.881	-.685
CENTROID X	:	-.165	-.098	-.097
CENTROID Y	:	.217	-.055	.055
POA TO CENTROID in.	:	.272	.113	.111
MIN RADIUS	:	.220	.072	.045
MEAN RADIUS	:	.856	.629	.587
MAX RADIUS	:	2.519	.896	.922
HORIZONTAL SPREAD	:	1.565	1.565	1.565
VERTICAL SPREAD	:	3.599	1.575	1.269
EXTREME SPREAD	:	3.659	1.708	1.708
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.103

VS= 3.744

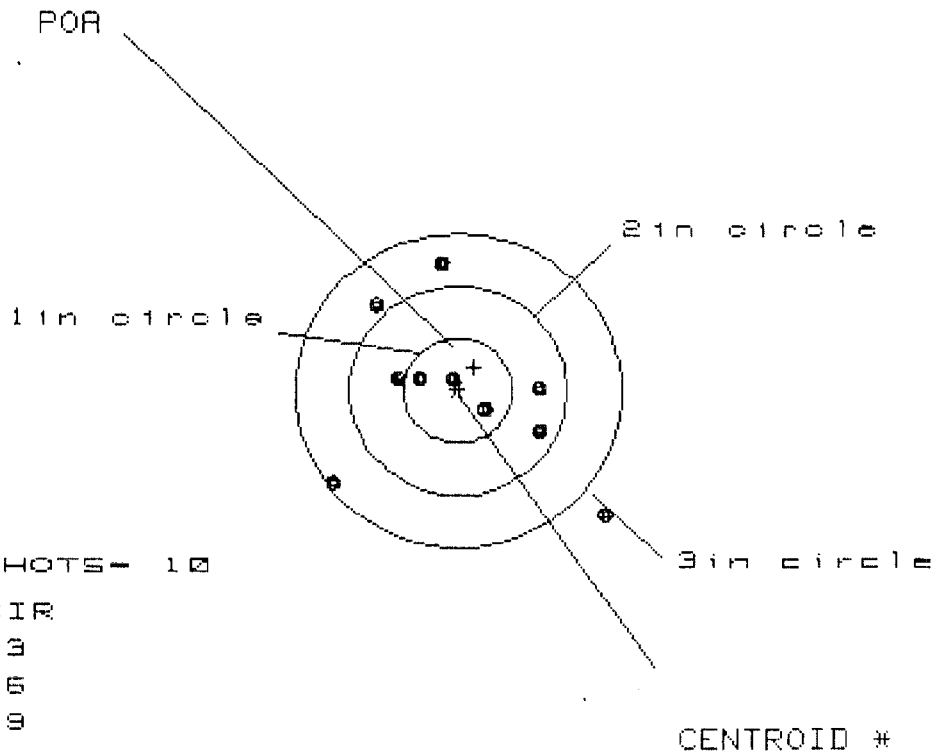
GS= 3.952

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.313	1.396	.545
MINIMUM X	:	-.790	-.707	-.532
MAXIMUM Y	:	1.304	1.033	.804
MINIMUM Y	:	-2.440	-1.829	-1.123
CENTROID X	:	.228	.145	-.030
CENTROID Y	:	.049	.320	.549
POA TO CENTROID in.	:	.233	.351	.550
MIN RADIUS	:	.144	.180	.467
MEAN RADIUS	:	1.108	.890	.685
MAX RADIUS	:	2.552	2.301	1.130
HORIZONTAL SPREAD	:	2.103	2.103	1.077
VERTICAL SPREAD	:	3.744	2.862	1.927
EXTREME SPREAD	:	3.952	3.398	1.965
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



HS= 2.539

VS= 2.396

GS= 2.892

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.342	.932	.980
MINIMUM X	-1.198	-1.048	-.765
MAXIMUM Y	1.261	1.135	1.014
MINIMUM Y	-1.135	-.971	-.578
CENTROID X	-.148	-.298	-.166
CENTROID Y	-.220	-.094	.027
POA TO CENTROID in.	.266	.312	.169
MIN RADIUS	.176	.107	.085
MEAN RADIUS	.863	.740	.658
MAX RADIUS	1.757	1.429	1.022
HORIZONTAL SPREAD	2.539	1.980	1.565
VERTICAL SPREAD	2.396	2.106	1.592
EXTREME SPREAD	2.892	2.354	1.947
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		