

06348885

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington®

Remington
MODEL 700™ M24

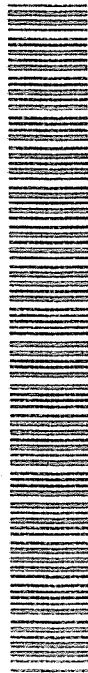
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6348885

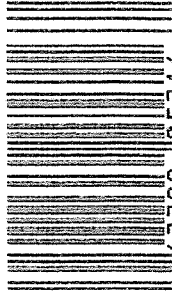
ORDER NO.
5716

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



5716 C6348885

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348885

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	GS
7	Drill and Tap Sight Holes	9 15	89	40
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		30-1-89	JS

op. #	BARBER - M24 0040671 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	5	5			10/3/89	GU
	G) Safety Off Force	3	4	4			10/3/89	GU
	H) Trigger Pull Test & Retainability						300/89	JS
	I) Firing Pin Indent	.022	.0215	.021			10/3/89	GU
	J) Assemble Stock						10/10/89	RW
	K) Assemble Swivel Studs						12/6/89	JS
	L) Attach Front and Rear Sight Assemblies						10/10/89	RW
	M) Iron Sight Alignment						10/10/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/10/89	RW
	O) Attach Scope to Rifle						10/11/89	GU
	P) Detach & Attach Scope 20 Times						10/11/89	GU
640	Gallery Target & Test						10-11-89	DAH
	A) Time						10-11-89	DAH
	B) Malfunctions						10-11-89	DAH
	C) Pierced Primers						10-11-89	DAH
	D) Optical Clarity of Scope						10-11-89	DAH
645	Inspect for Live Ammo						10-11-89	DAH
655	Final Inspection A) Headspace						12/6/89	JS
	B) Trigger Pull	275	269	277	278	247	12/6/89	JS
	C) Function						12/6/89	JS
660	Pack						18 Dec 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348825DATE 4-10-90TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.36	2.30	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.37	2.58	
PULL #3	2.33	2.34	2.46	
PULL #4	2.42	2.35	2.27	
PULL #5	2.44	2.41	2.24	
TOTAL	11.91	11.77	12.08	
AVG.	2.382	2.354	2.416	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.40	3.43	
PULL #2	3.41	3.46	
PULL #3	3.39	3.44	
PULL #4	3.41	3.43	
PULL #5	3.43	3.42	
TOTAL	17.04	17.18	
AVG.	3.408	3.436	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.43		
PULL #2	4.50	4.45		
PULL #3	4.49	4.48		
PULL #4	4.43	4.46		
PULL #5	4.48	4.45		
TOTAL	22.39	22.27		
AVG.	4.478	4.454		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348885
11 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.0184391
1 TO	2	.312444
1 TO	3	.573017
1 TO	4	.340037
1 TO	5	.41758

2.9
+
4

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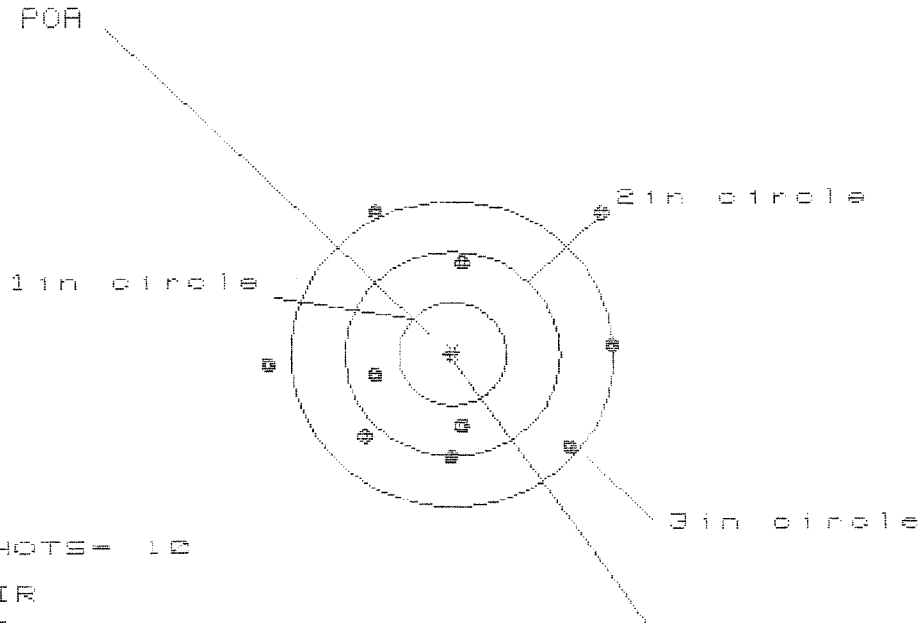
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1892
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214189
THE AMR FOR THIS RIFLE IS: 1.022

01 JUL 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C89488B5

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 3.171

VS= 2.370

GS= 3.434

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.475	1.629	1.437
MINIMUM X	-1.696	-1.542	-1.889
MAXIMUM Y	1.393	1.543	1.543
MINIMUM Y	-1.977	-1.827	-1.827
CENTROID X	.018	-.136	.056
CENTROID Y	.004	-.146	-.146
POA TO CENTROID in.	.019	.200	.156
MIN RADIUS	.746	.602	.595
MEAN RADIUS	1.267	1.152	1.104
MAX RADIUS	1.938	1.646	1.723
HORIZONTAL SPREAD	3.171	3.171	2.326
VERTICAL SPREAD	2.370	2.370	2.370
EXTREME SPREAD	3.434	3.178	2.919
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

01 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346885

CENTERFIRE PATTERNS # 2

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= 2.420

VS= 2.739

GS= 2.964

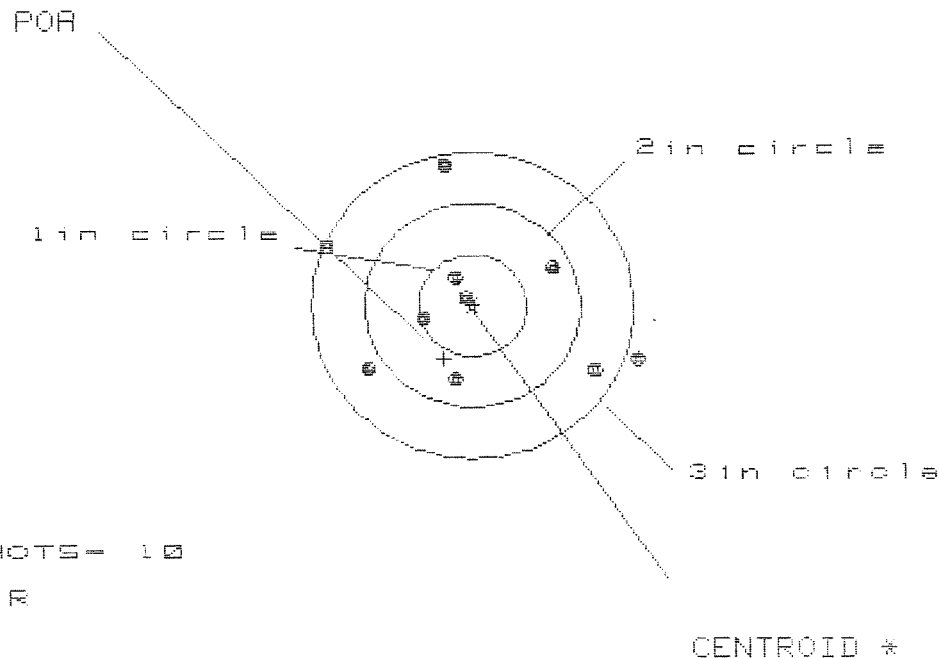
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.950	.787	.743
MINIMUM X	-1.470	-1.189	-1.233
MAXIMUM Y	1.600	1.516	.857
MINIMUM Y	-1.139	-1.223	-1.033
CENTROID X	.048	.211	.255
CENTROID Y	.315	.399	.209
POA TO CENTROID in.	.318	.451	.330
MIN RADIUS	.254	.074	.245
MEAN RADIUS	1.040	.923	.858
MAX RADIUS	1.653	1.555	1.431
HORIZONTAL SPREAD	2.420	1.976	1.976
VERTICAL SPREAD	2.739	2.739	1.890
EXTREME SPREAD	2.964	2.964	2.645
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

11 Oct 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in = 8

HS= 2.922

VS= 2.119

GS= 3.115

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.527	1.341	1.188
MINIMUM X	:	-1.395	-1.225	-.962
MAXIMUM Y	:	1.367	1.313	1.382
MINIMUM Y	:	-.752	-.886	-.737
CENTROID X	:	.263	.093	.246
CENTROID Y	:	.522	.576	.507
POA TO CENTROID in.	:	.585	.583	.564
MIN RADIUS	:	.114	.083	.113
MEAN RADIUS	:	.954	.853	.801
MAX RADIUS	:	1.600	1.522	1.398
HORIZONTAL SPREAD	:	2.922	2.566	2.150
VERTICAL SPREAD	:	2.119	2.119	2.119
EXTREME SPREAD	:	3.115	2.862	2.466
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

01 Oct 1989

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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 = 2

2 in = 7

3 in = 10

HS = 2.481

VS = 1.521

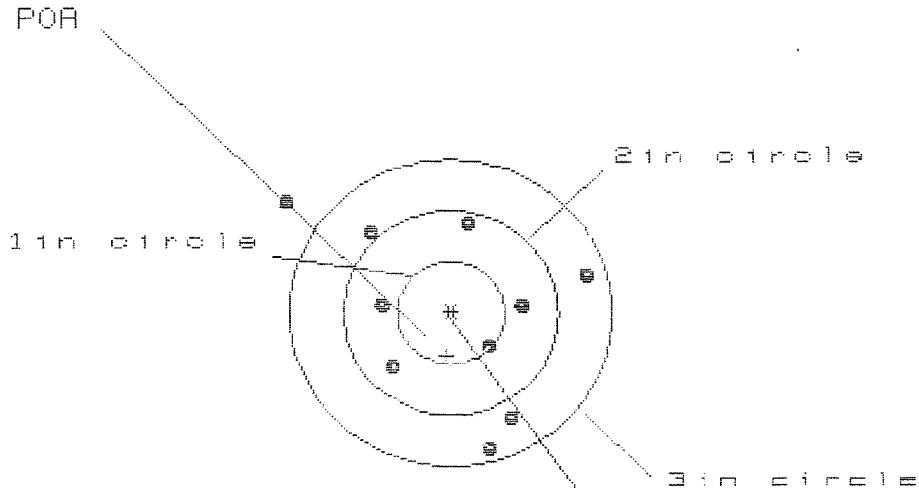
GS = 2.644

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	.874	.731
MINIMUM X	-1.278	-1.145	-1.086
MAXIMUM Y	.786	.705	.712
MINIMUM Y	-.735	-.672	-.665
CENTROID X	.133	-.000	.143
CENTROID Y	-.316	-.235	-.242
POA TO CENTROID in.	.343	.235	.281
MIN RADIUS	.225	.100	.235
MEAN RADIUS	.832	.766	.705
MAX RADIUS	1.409	1.146	1.209
HORIZONTAL SPREAD	2.481	2.019	1.817
VERTICAL SPREAD	1.521	1.377	1.377
EXTREME SPREAD	2.644	2.111	2.111
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

01 Oct 1985

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.767

VS= 2.464

GS= 3.054

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.111	1.130
MINIMUM X	:	-1.490	-.886	-.867
MAXIMUM Y	:	1.119	.985	.833
MINIMUM Y	:	-1.345	-1.221	-1.076
CENTROID X	:	.040	.206	.187
CENTROID Y	:	.421	.297	.449
POA TO CENTROID in.	:	.423	.361	.487
MIN RADIUS	:	.471	.266	.402
MEAN RADIUS	:	1.017	.896	.854
MAX RADIUS	:	1.864	1.236	1.169
HORIZONTAL SPREAD	:	2.767	1.997	1.997
VERTICAL SPREAD	:	2.464	2.206	1.909
EXTREME SPREAD	:	3.054	2.326	2.203
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	