

C6225432

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington[®]

MODEL 700TM M24

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

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

REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6225432

ORDER NO.
5716

20

5716 C6225432

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225432

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9	88	RW
600	Proof	12 9	88	RW
607	Check Headspace	12 9	88	RW
610	Dis-assemble Gun	12 9	88	RW
612	Magnaflux Barrel Action		12-22-88	P/C.
	Magnaflux Bolt		1-3-89	P/C.
615	Rollmark Caliber		12/22/88	M/BC.
617	Drill and Tap Sight Holes	1 3	89	FB
618	Polish Barrel	12 2	88	WJT
620	Apply Coatings (Barrel Action)		1-12-89	X/SA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/20/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/20/89	RW
	C) Inspect Ejector Hole for Chamfer		1/20/89	RW
	D) Oil Firing Pin Ass'y		1/20/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		20 Jan 89	918

op. #	BARBER - M24 0060672 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			25 Jan 89	JS
	G) Safety Off Force	3	3	3			25 Jan 89	JS
	H) Trigger Pull Test & Retainability						20 Jan 89	JS
	I) Firing Pin Indent	.0205	.0205	.0205			25 Jan 89	JS
	J) Assemble Stock						1/26/89	RW
	K) Assemble Swivel Studs						3 Feb 89	JS
	L) Attach Front and Rear Sight Assemblies						1/26/89	RW
	M) Iron Sight Alignment						1/26/89	RW
	N) Detach Front & Rear Sights & place in numbered container						1/26/89	RW
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times						30 Jan 89	JS
640	Gallery Target & Test	482	107L				2/2/89	DH
	A) Time						2/2/89	DH
	B) Malfunctions						2/2/89	DH
	C) Pierced Primers						2/2/89	DH
	D) Optical Clarity of Scope						2/2/89	DH
645	Inspect for Live Ammo						2/2/89	DH
655	Final Inspection							
	A) Headspace						3 Feb 89	JS
	B) Trigger Pull	2.56	2.48	2.62	2.63	2.72	3 Feb 89	JS
	C) Function						3 Feb 89	JS
660	Pack						23 Mar 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225432DATE 4-4-80TESTER J4

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.54		2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.50		2.32	
PULL #3	2.56	2.53		2.30	
PULL #4	2.56	2.47		2.33	
PULL #5	2.55	2.40		2.34	
TOTAL	12.82	12.44		11.65	
AVG.	2.564	2.488		2.33	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.26		
PULL #2	3.23	3.30		
PULL #3	3.24	2.25		
PULL #4	3.26	3.24		
PULL #5	3.25	3.25		
TOTAL	16.10	16.30		
AVG.	3.22	3.26		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.32		
PULL #2	4.40	4.30		
PULL #3	4.45	4.33		
PULL #4	4.42	4.35		
PULL #5	4.31	4.39		
TOTAL	21.74	21.69		
AVG.	4.348	4.338		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225432
3 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.587616
1 TO	2	.485979
1 TO	3	.286587
1 TO	4	.732728
1 TO	5	.4064

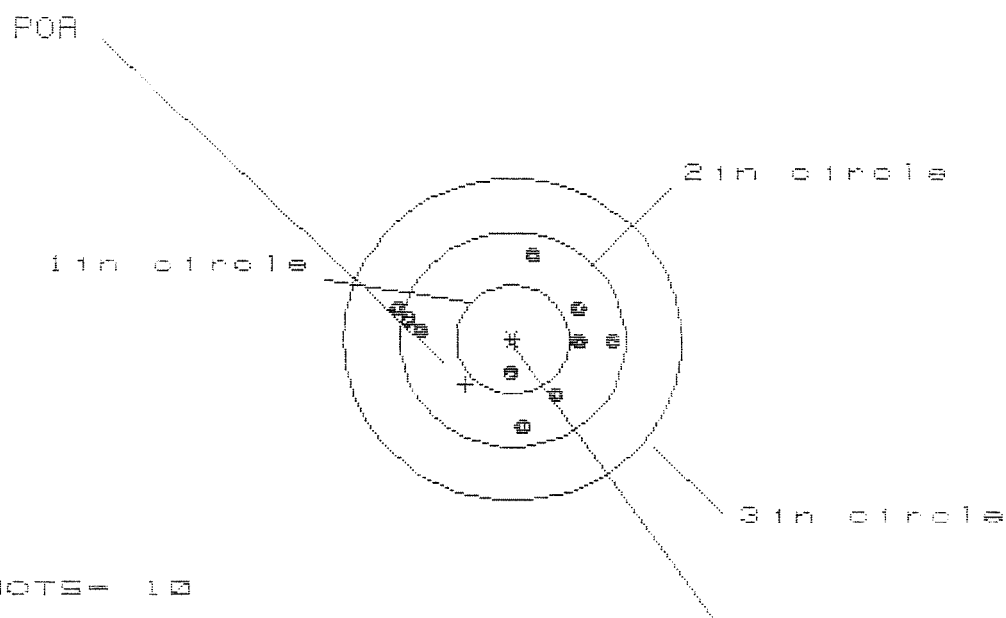
#35 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .348
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .367849
THE AMR FOR THIS RIFLE IS: .9884

3 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225432

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS = 1.964

VS = 1.595

GS = 1.990

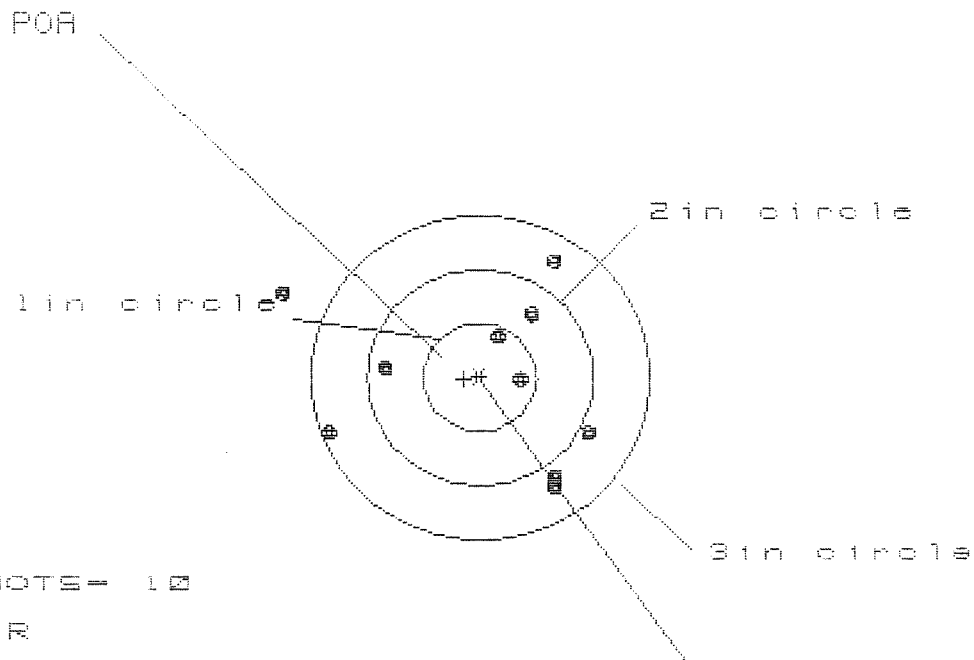
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.902	.784	.653
MINIMUM X	-1.062	-1.051	-1.092
MAXIMUM Y	.786	.818	.842
MINIMUM Y	-.809	-.777	-.753
CENTROID X	.418	.536	.667
CENTROID Y	.413	.381	.357
POA TO CENTROID in.	.587	.658	.757
MIN RADIUS	.310	.308	.365
MEAN RADIUS	.765	.705	.691
MAX RADIUS	1.099	1.068	1.098
HORIZONTAL SPREAD	1.964	1.835	1.745
VERTICAL SPREAD	1.595	1.595	1.595
EXTREME SPREAD	1.990	1.846	1.747
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.784

VS= 2.049

GS= 3.079

CENTROID *

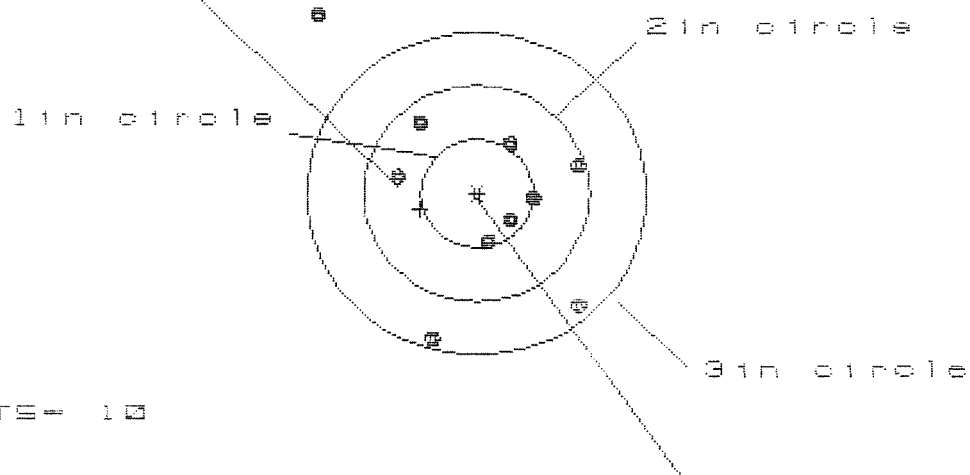
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	.802	.611
MINIMUM X	:	-1.784	-1.527	-1.244
MAXIMUM Y	:	1.046	1.137	1.086
MINIMUM Y	:	-1.003	-.912	-.963
CENTROID X	:	.142	.340	.531
CENTROID Y	:	.013	-.078	-.027
POA TO CENTROID in.	:	.142	.349	.531
MIN RADIUS	:	.384	.184	.020
MEAN RADIUS	:	1.054	.913	.785
MAX RADIUS	:	1.964	1.582	1.250
HORIZONTAL SPREAD	:	2.784	2.329	1.855
VERTICAL SPREAD	:	2.049	2.049	2.049
EXTREME SPREAD	:	3.079	2.538	2.050
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.243

VS= 3.015

GS= 3.506

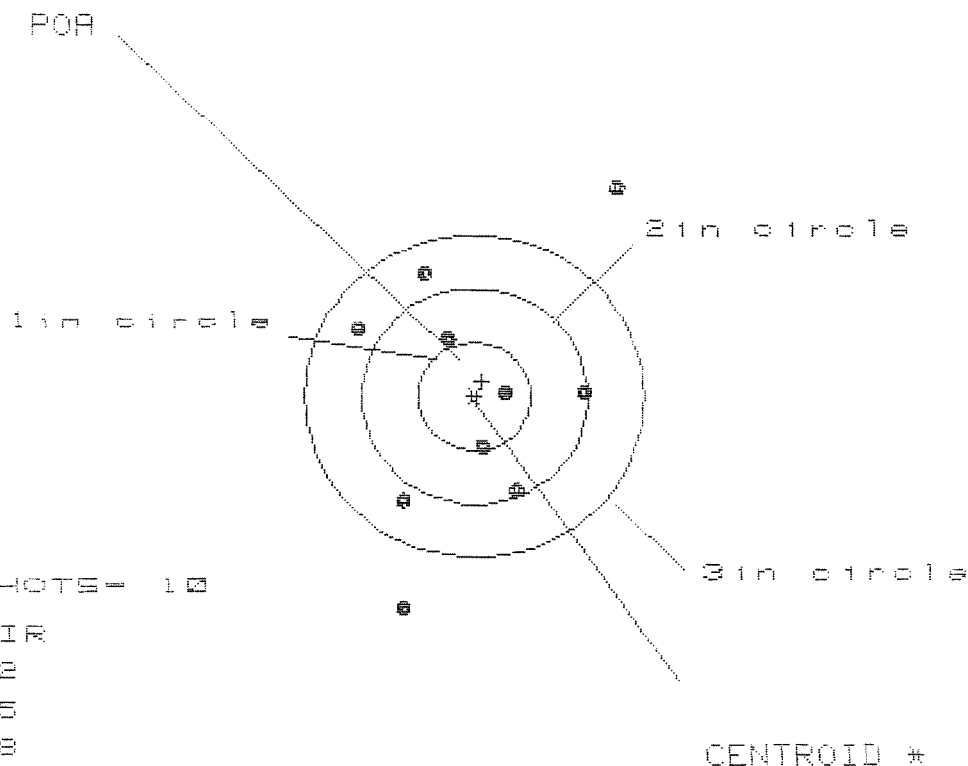
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.880	.729	.663
MINIMUM X	-1.363	-.844	-.910
MAXIMUM Y	1.647	.880	.731
MINIMUM Y	-1.368	-1.185	-1.014
CENTROID X	.502	.653	.719
CENTROID Y	.139	-.044	.105
FOR TO CENTROID in.	.521	.654	.726
MIN RADIUS	.379	.154	.216
MEAN RADIUS	.931	.750	.668
MAX RADIUS	2.137	1.297	1.211
HORIZONTAL SPREAD	2.243	1.573	1.573
VERTICAL SPREAD	3.015	2.065	1.745
EXTREME SPREAD	3.506	2.238	2.238
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



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.343

VS = 3.834

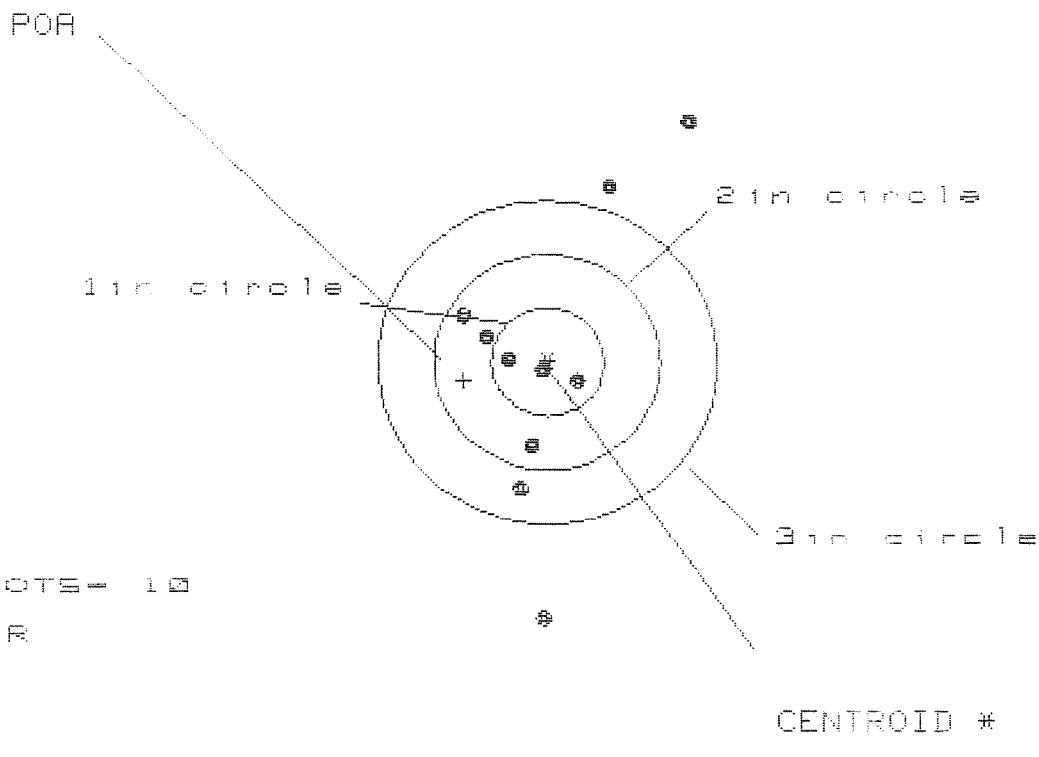
GS = 4.294

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.291	1.083	1.021
MINIMUM X	:	-1.052	-.909	-.971
MAXIMUM Y	:	1.898	1.338	1.123
MINIMUM Y	:	-1.936	-1.725	-.997
CENTROID X	:	-.065	-.208	-.146
CENTROID Y	:	-.138	-.349	-.134
POA TO CENTROID in.	:	.153	.407	.198
MIN RADIUS	:	.237	.326	.317
MEAN RADIUS	:	1.104	.973	.846
MAX RADIUS	:	2.296	1.796	1.186
HORIZONTAL SPREAD	:	2.343	1.992	1.992
VERTICAL SPREAD	:	3.834	3.063	2.120
EXTREME SPREAD	:	4.294	3.068	2.152
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



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 7

HS = 2.036

VS = 4.605

GS = 4.788

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	.718	.733
MINIMUM X	-.749	-.606	-.591
MAXIMUM Y	2.237	1.889	1.624
MINIMUM Y	-2.368	-2.119	-1.225
CENTROID X	.743	.600	.585
CENTROID Y	.169	-.080	.185
POR TO CENTROID in.	.762	.605	.614
MIN RADIUS	.061	.239	.112
MEAN RADIUS	1.088	.907	.714
MAX RADIUS	2.581	2.123	1.781
HORIZONTAL SPREAD	2.036	1.324	1.324
VERTICAL SPREAD	4.605	4.008	2.849
EXTREME SPREAD	4.788	4.053	2.962
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	