

C6349206

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

DU PONT
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24	SERIAL NO. C6349206
	ORDER NO. 5716

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

01



5716 C6349206

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349206

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 90	5/8/90	RW
600	Proof	5 2 90	5/8/90	RW
607	Check Headspace	5 2 90	5/8/90	RW
610	Dis-assemble Gun	5 2 90	5/8/90	RW
612	Magnaflux Barrel Action	5-8-90	5/8/90	KCR
	Magnaflux Bolt	5-8-90	5/8/90	KCR
615	Rollmark Caliber		5/8/90	CS
617	Drill and Tap Sight Holes		5/8/90	FB
618	Polish Barrel RB		5/10/90	WB
620	Apply Coatings (Barrel Action)		5-16-90	TJH
	Apply Coating (Bolt)		5-16-90	TJH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/90	RM

BARBER - M24 0110164

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			5/23/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5/23/90	WB
	H) Trigger Pull Test & Retainability						5/23/90	JH
	I) Firing Pin Indent	.024	.0235	.0235			5/23/90	WB
	J) Assemble Stock						5/23/90	RW
	K) Assemble Swivel Studs						29 May 90	JH
	L) Attach Front and Rear Sight Assemblies						5/23/90	RW
	M) Iron Sight Alignment						5/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/23/90	RW
	O) Attach Scope to Rifle						5/23/90	WB
	P) Detach & Attach Scope 20 Times						5/23/90	WB
640	Gallery Target & Test						5-24-90	DH
	A) Time						5-24-90	DH
	B) Malfunctions						5-24-90	DH
	C) Pierced Primers						5-24-90	DH
	D) Optical Clarity of Scope						5-24-90	DH
645	Inspect for Live Ammo						5-24-90	DH
655	Final Inspection							
	A) Headspace						29 May 90	JH
	B) Trigger Pull	265	247	246	239	245	29 May 90	JH
	C) Function						29 May 90	JH
660	Pack						6-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06349206

DATE 5/23/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.25	2.20	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.30	2.21	2.47	
PULL #3	2.28	2.09	2.15	2.46	
PULL #4	2.19	2.19	2.20	2.39	
PULL #5	2.16	2.28	2.09	2.45	
TOTAL	11.58	11.11	10.85		
AVG.	2.316	2.222	2.17		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.24		
PULL #2	3.19	3.31		
PULL #3	3.33	3.28		
PULL #4	3.31	3.24		
PULL #5	3.31	3.25		
TOTAL	16.35	16.32		
AVG.	3.27	3.264		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.26		4.20
PULL #2	4.10	4.27		4.17
PULL #3	4.34	4.29		4.22
PULL #4	4.31	4.24		4.18
PULL #5	4.11	4.27		4.16
TOTAL	21.29	21.33		20.93
AVG.	4.258	4.266		4.186

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349206
25 May 1990

CENTROIDAL DISTANCES

0 TO	1	.376563
1 TO	2	.222697
1 TO	3	.864506
1 TO	4	.542163
1 TO	5	.810492

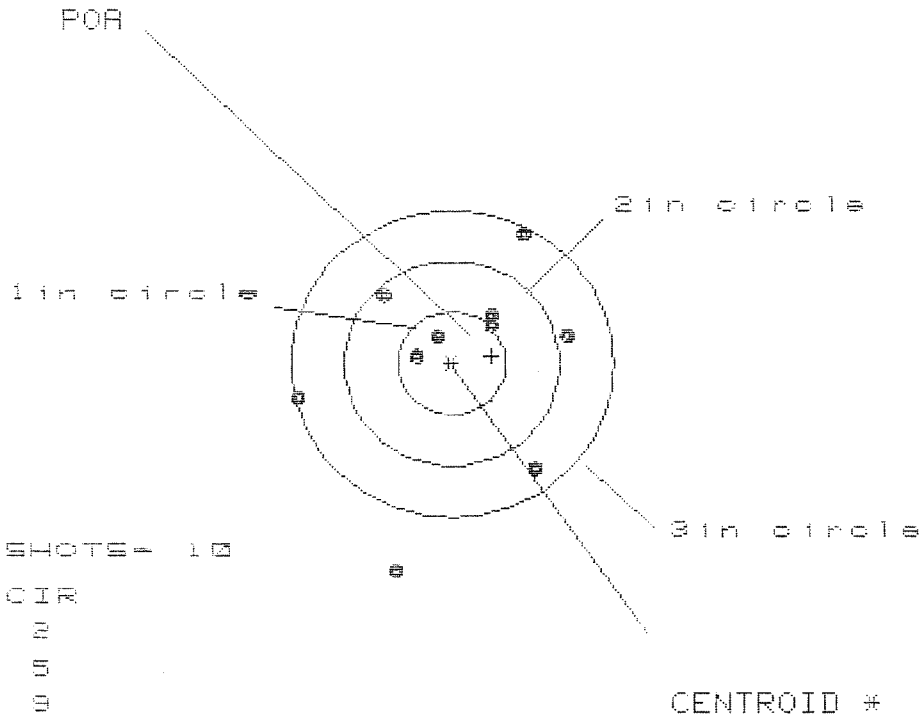
12¹⁵ 3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1064
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0584
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .121373
THE AMR FOR THIS RIFLE IS: .9864

24 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349286

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HOR = 0.8000

VER = 0.8225

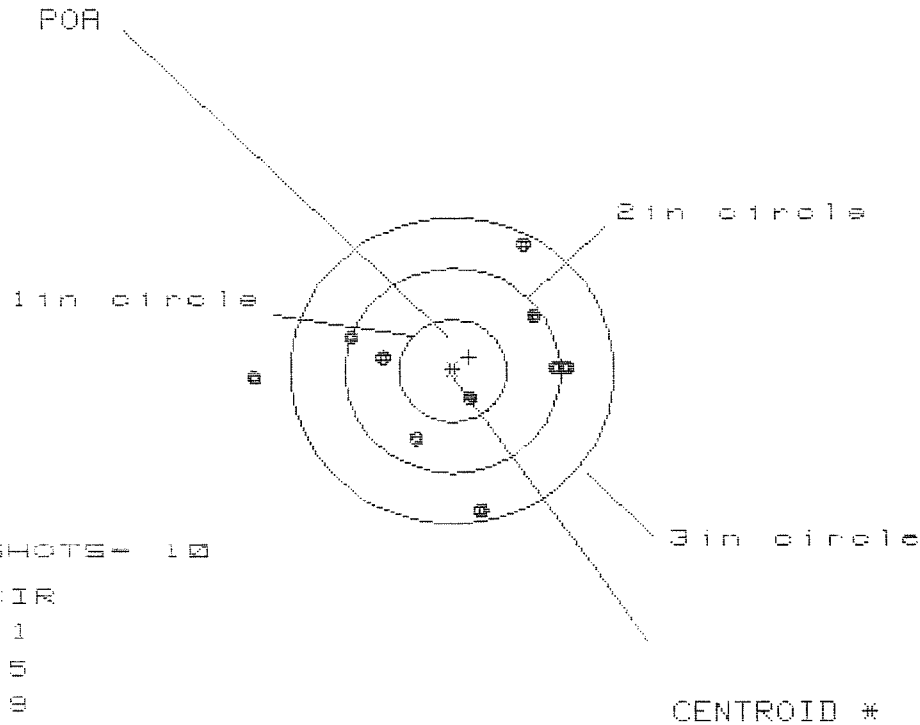
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PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	1.000	.812
MINIMUM X	-1.440	-1.503	-.912
MAXIMUM Y	1.243	1.023	.953
MINIMUM Y	-1.982	-1.237	-1.387
CENTROID X	-.370	-.307	-.119
CENTROID Y	-.070	.150	.220
POR TO CENTROID in.	.376	.342	.250
MIN RADIUS	.290	.235	.157
MEAN RADIUS	1.002	.828	.707
MAX RADIUS	2.062	1.603	1.407
HORIZONTAL SPREAD	2.503	2.503	1.724
VERTICAL SPREAD	3.225	2.260	2.260
EXTREME SPREAD	3.454	2.635	2.262
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

24 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349206

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 2.904

VS= 2.571

CS= 2.866

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.018	.808	.868
MINIMUM X	-1.886	-1.195	-1.135
MAXIMUM Y	1.253	1.247	.664
MINIMUM Y	-1.318	-1.324	-1.168
CENTROID X	-.157	.053	-.007
CENTROID Y	-.135	-.129	-.285
POA TO CENTROID in.	.207	.139	.285
MIN RADIUS	.345	.315	.156
MEAN RADIUS	1.045	.929	.856
MAX RADIUS	1.887	1.336	1.225
HORIZONTAL SPREAD	2.904	2.003	2.003
VERTICAL SPREAD	2.571	2.571	1.832
EXTREME SPREAD	2.906	2.602	2.066
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

24 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349286

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 0

HS= 2.985

VS= 1.865

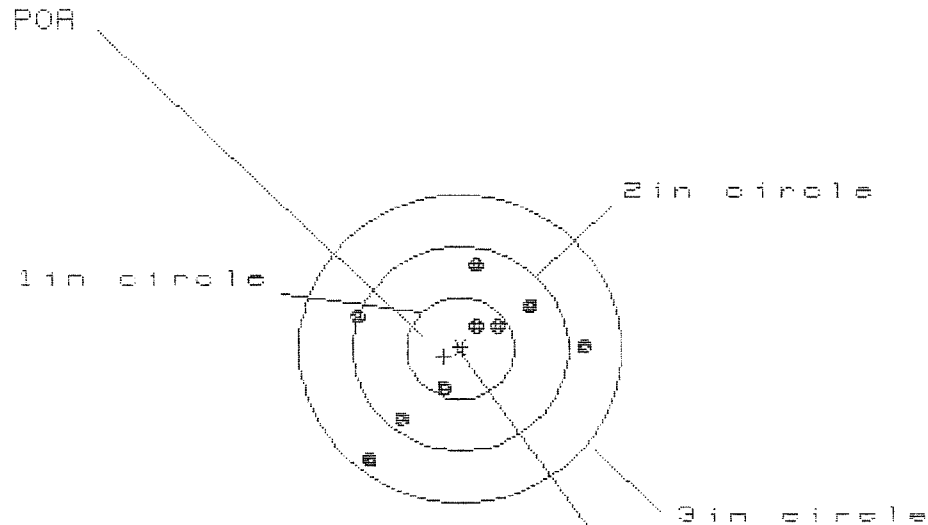
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PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.542	.889	.730
MINIMUM X	:	-1.443	-1.272	-1.340
MAXIMUM Y	:	.995	.987	1.054
MINIMUM Y	:	-.870	-.878	-.811
CENTROID X	:	.479	-.308	.467
CENTROID Y	:	-.233	-.225	-.292
POR TO CENTROID in.	:	.533	.381	.551
MIN RADIUS	:	.686	.558	.715
MEAN RADIUS	:	1.057	.992	.934
MAX RADIUS	:	1.544	1.380	1.340
HORIZONTAL SPREAD	:	2.985	2.161	2.070
VERTICAL SPREAD	:	1.865	1.865	1.865
EXTREME SPREAD	:	3.048	2.435	2.320
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349206

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.125

VS= 1.934

GS= 2.336

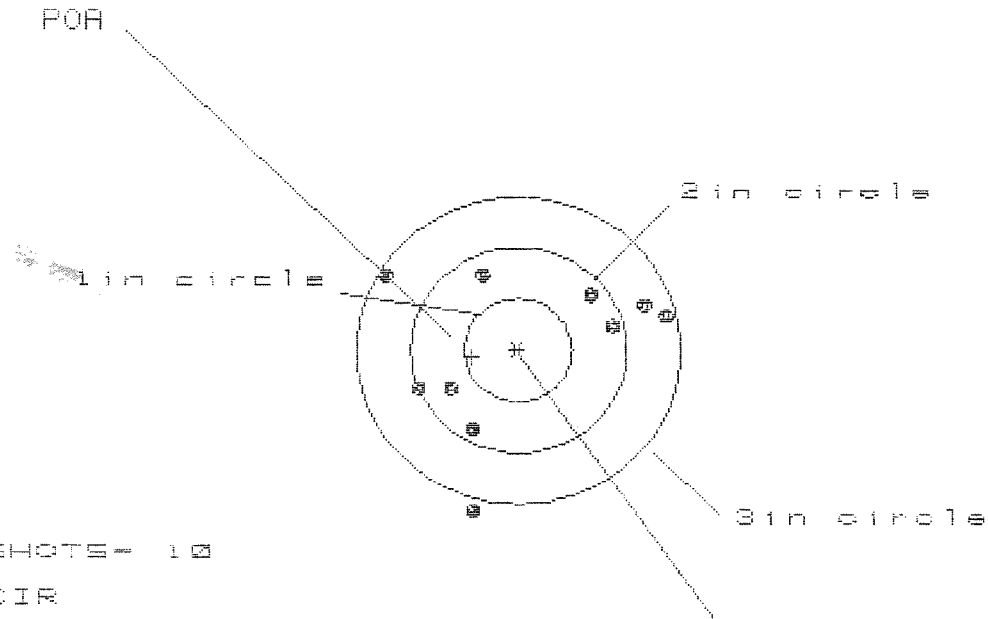
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.044	.631
MINIMUM X	-.983	-1.081	-.951
MAXIMUM Y	.822	.698	.690
MINIMUM Y	-1.113	-.821	-.829
CENTROID X	.151	.249	.119
CENTROID Y	.080	.204	.212
POA TO CENTROID in.	.172	.322	.243
MIN RADIUS	.235	.078	.132
MEAN RADIUS	.737	.611	.584
MAX RADIUS	1.417	1.094	.975
HORIZONTAL SPREAD	2.125	2.125	1.582
VERTICAL SPREAD	1.934	1.519	1.519
EXTREME SPREAD	2.336	2.137	1.655
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

24 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349286

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 0

H0 = 2.640

V0 = 2.372

G0 = 2.687

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.404	1.353	1.192
MINIMUM X	-1.236	-1.287	-1.172
MAXIMUM Y	.781	.605	.615
MINIMUM Y	-1.591	-.972	-.897
CENTROID X	.429	.480	.641
CENTROID Y	.066	.242	.167
POA TO CENTROID in.	.434	.538	.662
MIN RADIUS	.692	.647	.615
MEAN RADIUS	1.091	1.012	.945
MAX RADIUS	1.656	1.422	1.255
HORIZONTAL SPREAD	2.640	2.640	2.364
VERTICAL SPREAD	2.372	1.577	1.512
EXTREME SPREAD	2.687	2.676	2.463
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	