

C6522305

MODEL 700™ M24

Model **SMS**™

Action _____

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522305

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	LS.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/6/90	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	M

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/28/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	JH
	I) Firing Pin Indent	.023	.0225	.0225			8/28/90	WB
	J) Assemble Stock						8/29/90	Rw
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						8/29/90	Rw
	M) Iron Sight Alignment						8/29/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	Rw
	O) Attach Scope to Rifle						8/29/90	Rw
	P) Detach & Attach Scope 20 Times						8/29/90	Rw
640	Gallery Target & Test						9-4-90	AC
	A) Time						9-4-90	AC
	B) Malfunctions						9-4-90	AC
	C) Pierced Primers						9-4-90	AC
	D) Optical Clarity of Scope						9-4-90	AC
645	Inspect for Live Ammo						9-4-90	AC
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.13	2.17	2.25	2.21	2.16	9-5-90	JS
	C) Function						9/6/90	JS
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. 06522305

DATE 8/28/90

TESTER 94

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.33	2.41	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.39	2.33	2.17	
PULL #3	2.28	2.33	2.45	2.25	
PULL #4	2.28	2.41	2.31	2.21	
PULL #5	2.40	2.41	2.30	2.16	
TOTAL	11.86	11.87	11.80	10.92	
AVG.	2.372	2.374	2.36	2.184	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.23		
PULL #2	3.24	3.29		
PULL #3	3.08	3.29		
PULL #4	3.27	3.34		
PULL #5	3.27	3.44		
TOTAL	16.14	16.59		
AVG.	3.228	3.318		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.19		4.20
PULL #2	4.10	4.15		4.24
PULL #3	4.10	4.19		4.24
PULL #4	4.12	4.20		4.27
PULL #5	4.20	4.21		4.18
TOTAL	20.79	20.94		21.14
AVG.	4.158	4.188		4.228

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522305
4 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.3528
1 TO	2	.89559
1 TO	3	.375757
1 TO	4	.238002
1 TO	5	.483344

3
2 5 f c----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .36056
THE AMR FOR THIS RIFLE IS: 1.142

4 Sep 1999

FILE:/PATTERNING/CENTERFIRE_PATT/C6522305

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.183

VS= 3.636

GS= 3.721

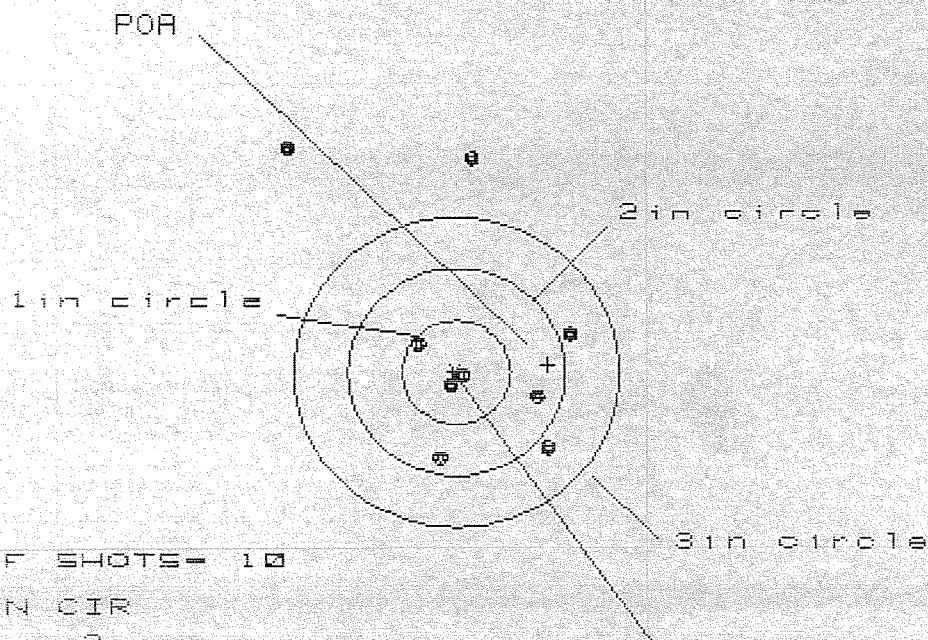
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.625	.651	.584
MINIMUM X	:	-.558	-.532	-.478
MAXIMUM Y	:	2.495	1.317	1.209
MINIMUM Y	:	-1.140	-.863	-.703
CENTROID X	:	-.058	-.084	-.017
CENTROID Y	:	.348	.071	.179
POA TO CENTROID in.	:	.353	.110	.180
MIN RADIUS	:	.383	.139	.261
MEAN RADIUS	:	.916	.671	.641
MAX RADIUS	:	2.506	1.334	1.241
HORIZONTAL SPREAD	:	1.183	1.183	1.062
VERTICAL SPREAD	:	3.636	2.180	1.912
EXTREME SPREAD	:	3.721	2.203	2.005
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/G6522385

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.634

VS= 5.065

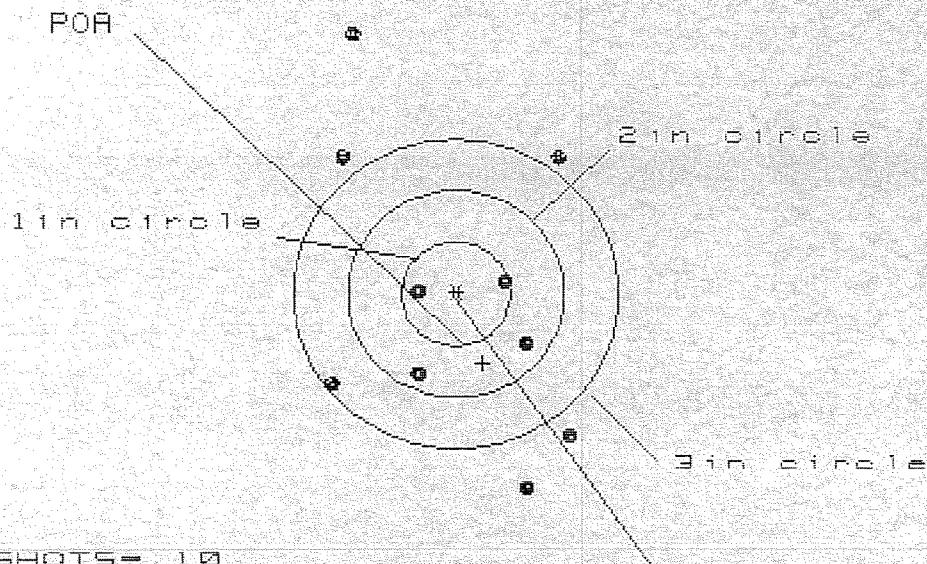
GS= 5.132

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.957	.747
MINIMUM X	:	-1.592	-1.677	-.614
MAXIMUM Y	:	2.151	1.827	1.994
MINIMUM Y	:	-2.914	-1.176	-.947
CENTROID X	:	-.849	-.764	-.554
CENTROID Y	:	-.072	.252	.023
POA TO CENTROID in.	:	.852	.804	.555
MIN RADIUS	:	.075	.402	.323
MEAN RADIUS	:	1.224	1.090	.840
MAX RADIUS	:	3.013	2.480	1.998
HORIZONTAL SPREAD	:	2.634	2.634	1.361
VERTICAL SPREAD	:	5.065	3.003	2.941
EXTREME SPREAD	:	5.132	3.801	2.958
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

4 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/G6522385

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.165

VS = 4.402

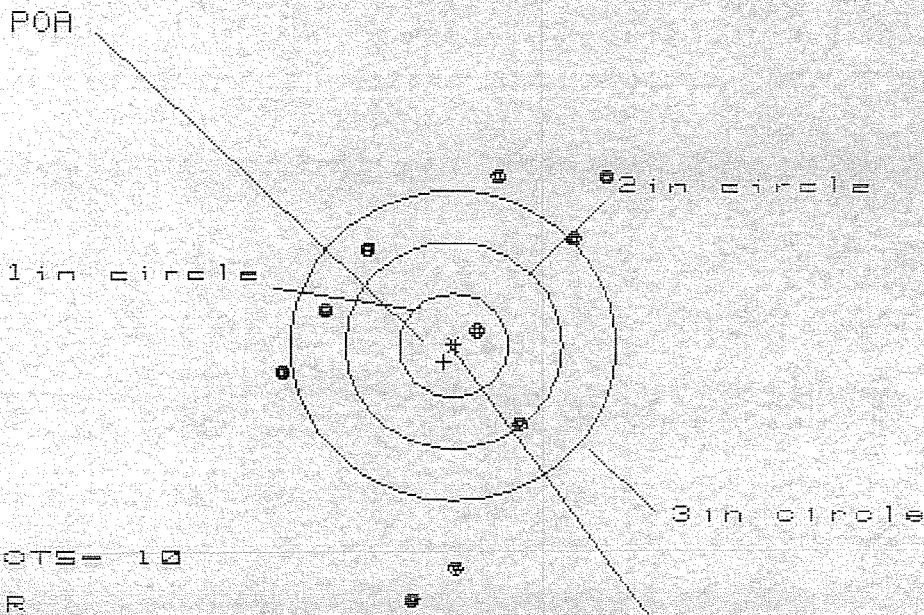
GS = 4.683

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	.896	.964
MINIMUM X	:	-1.164	-1.269	-1.201
MAXIMUM Y	:	2.492	1.641	1.437
MINIMUM Y	:	-1.910	-1.633	-1.269
CENTROID X	:	-.250	-.145	-.213
CENTROID Y	:	.671	.394	.598
POA TO CENTROID in.	:	.716	.420	.635
MIN RADIUS	:	.332	.513	.374
MEAN RADIUS	:	1.366	1.185	1.114
MAX RADIUS	:	2.665	2.002	1.796
HORIZONTAL SPREAD	:	2.165	2.165	2.165
VERTICAL SPREAD	:	4.402	3.274	2.706
EXTREME SPREAD	:	4.683	3.687	3.391
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

4 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/G6522305

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 4

HS = 3.078

VS = 4.048

GS = 4.429

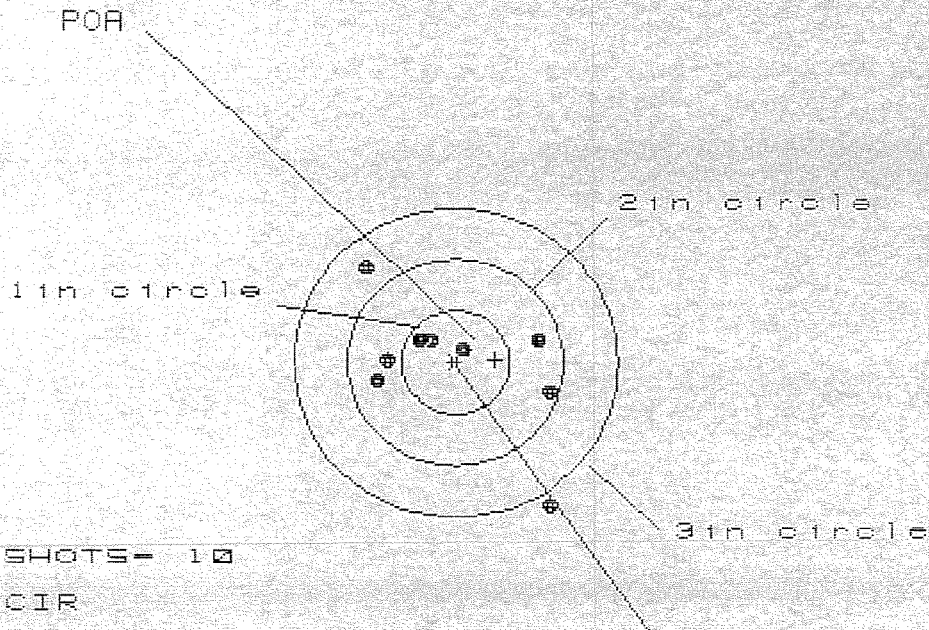
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.457	1.417	1.276
MINIMUM X	:	-1.621	-1.661	-1.483
MAXIMUM Y	:	1.607	1.336	1.502
MINIMUM Y	:	-2.441	-2.409	-2.243
CENTROID X	:	.084	.124	-.053
CENTROID Y	:	.157	.428	.262
POA TO CENTROID in.	:	.178	.446	.267
MIN RADIUS	:	.296	.265	.403
MEAN RADIUS	:	1.534	1.396	1.330
MAX RADIUS	:	2.467	2.409	2.247
HORIZONTAL SPREAD	:	3.078	3.078	2.759
VERTICAL SPREAD	:	4.048	3.745	3.745
EXTREME SPREAD	:	4.429	4.013	3.772
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

4 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522305

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 9

HS = 1.630

VS = 2.260

GS = 2.786

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.843	.913	.827
MINIMUM X	:	-.787	-.693	-.692
MAXIMUM Y	:	.928	.781	.167
MINIMUM Y	:	-1.332	-.431	-.334
CENTROID X	:	-.369	-.463	-.377
CENTROID Y	:	-.022	.125	.028
POA TO CENTROID in.	:	.370	.480	.378
MIN RADIUS	:	.089	.159	.060
MEAN RADIUS	:	.668	.538	.473
MAX RADIUS	:	1.576	1.044	.891
HORIZONTAL SPREAD	:	1.630	1.606	1.518
VERTICAL SPREAD	:	2.260	1.212	.501
EXTREME SPREAD	:	2.786	2.012	1.554
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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

Remington[®]

MODEL 700[™] M24

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

SERIAL NO.
C6522305

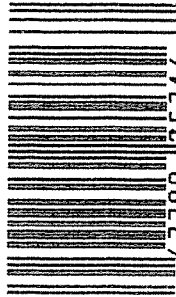
ORDER NO.
5716

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