

C6523316

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6523316	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	
 5716 C6523316			

LPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523316
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.110309
1 TO	2	.122102
1 TO	3	.355376
1 TO	4	.189552
1 TO	5	.157762

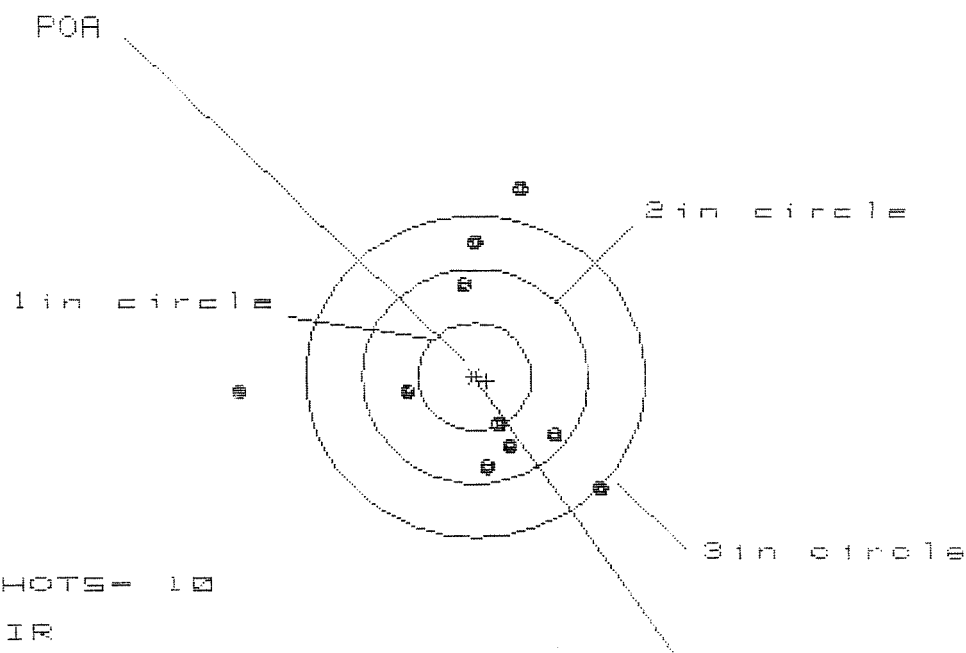
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .04245
THE AMR FOR THIS RIFLE IS: .8692

13 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523316

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.219

VS= 2.849

GS= 3.341

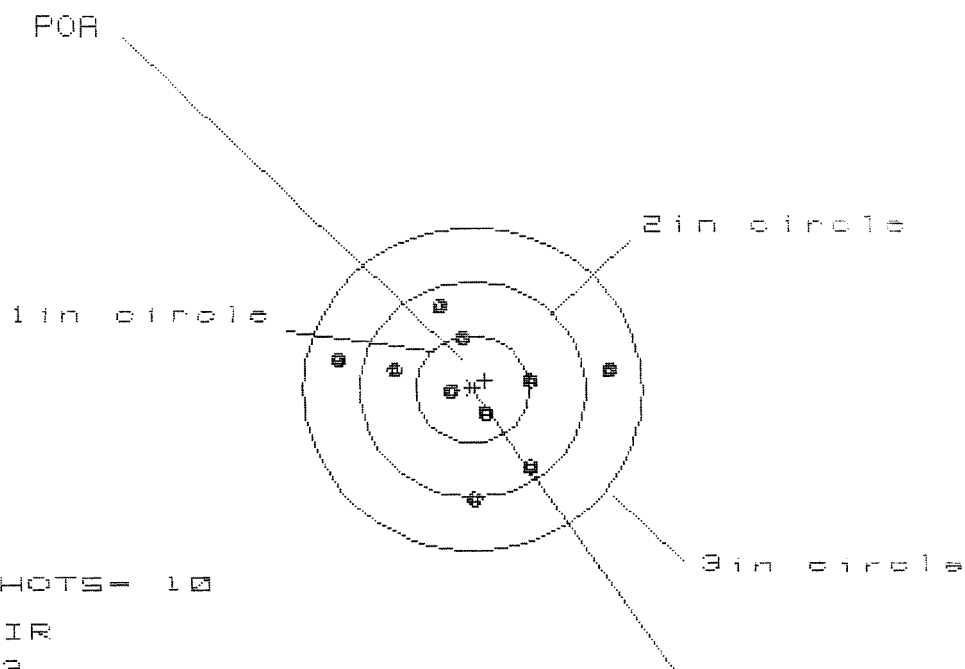
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	.875	.900
MINIMUM X	:	-2.110	-.879	-.853
MAXIMUM Y	:	1.780	1.760	1.459
MINIMUM Y	:	-1.069	-1.089	-.868
CENTROID X	:	-.102	.132	.106
CENTROID Y	:	.042	.062	-.158
POA TO CENTROID in.	:	.111	.146	.191
MIN RADIUS	:	.481	.444	.224
MEAN RADIUS	:	1.118	.991	.822
MAX RADIUS	:	2.117	1.772	1.480
HORIZONTAL SPREAD	:	3.219	1.754	1.754
VERTICAL SPREAD	:	2.849	2.849	2.328
EXTREME SPREAD	:	3.341	2.926	2.595
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.412

VS= 1.821

GS= 2.414

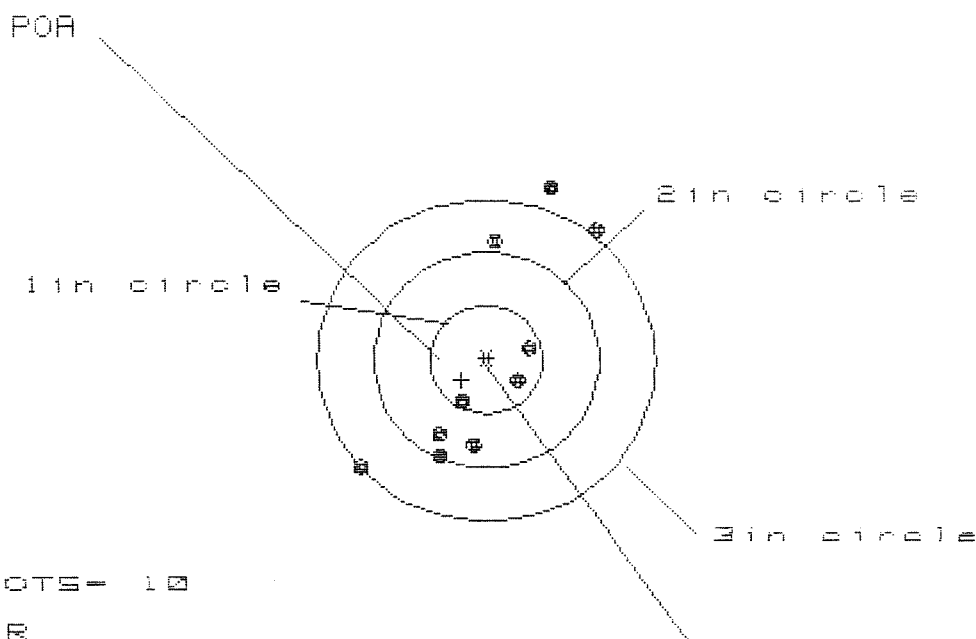
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.228	.667	.536
MINIMUM X	:	-1.184	-1.047	-.693
MAXIMUM Y	:	.782	.799	.833
MINIMUM Y	:	-1.039	-1.022	-.988
CENTROID X	:	-.107	-.244	-.113
CENTROID Y	:	-.080	-.097	-.131
POA TO CENTROID in.	:	.134	.263	.173
MIN RADIUS	:	.158	.050	.170
MEAN RADIUS	:	.733	.668	.611
MAX RADIUS	:	1.238	1.081	.989
HORIZONTAL SPREAD	:	2.412	1.714	1.229
VERTICAL SPREAD	:	1.821	1.821	1.821
EXTREME SPREAD	:	2.414	1.946	1.842
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 2.157

VS= 2.634

GS= 3.144

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	1.079	.600
MINIMUM X	:	-1.142	-1.078	-.944
MAXIMUM Y	:	1.624	1.372	1.442
MINIMUM Y	:	-1.010	-.829	-.658
CENTROID X	:	.222	.158	.024
CENTROID Y	:	.188	.007	-.164
POA TO CENTROID in.	:	.291	.159	.166
MIN RADIUS	:	.321	.262	.064
MEAN RADIUS	:	.967	.836	.665
MAX RADIUS	:	1.723	1.745	1.462
HORIZONTAL SPREAD	:	2.157	2.157	1.544
VERTICAL SPREAD	:	2.634	2.201	2.100
EXTREME SPREAD	:	3.144	3.082	2.410
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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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 = 3

2 in = 5

3 in = 9

HS= 2.556

VS= 2.033

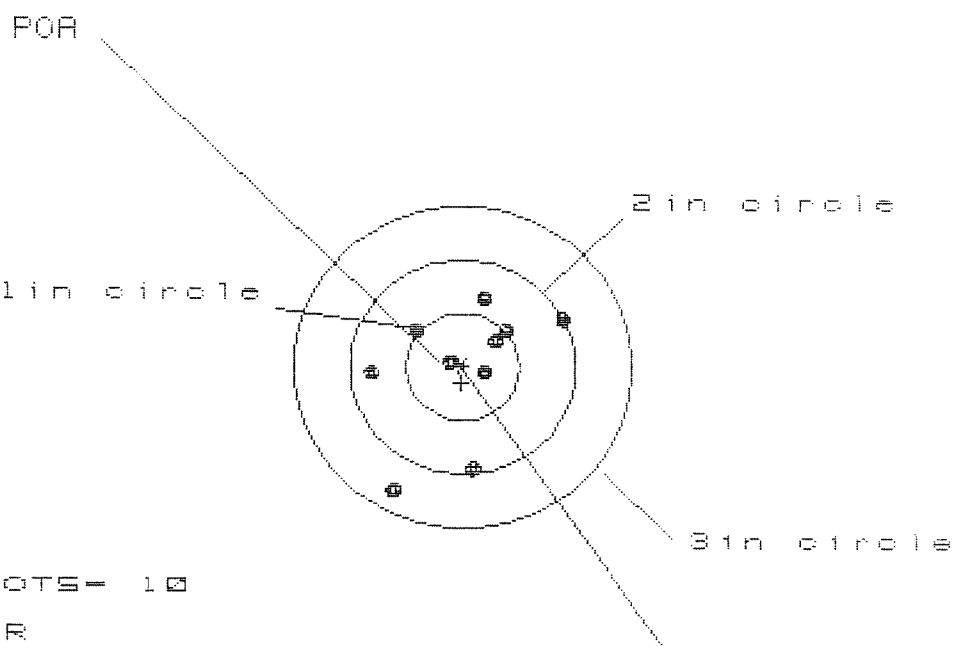
GS= 2.809

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.204	.736
MINIMUM X	:	-1.217	-1.085	-.935
MAXIMUM Y	:	1.103	1.000	.953
MINIMUM Y	:	-.930	-.907	-.954
CENTROID X	:	.029	.164	.014
CENTROID Y	:	-.095	.008	.055
POA TO CENTROID in.	:	.099	.165	.057
MIN RADIUS	:	.292	.172	.161
MEAN RADIUS	:	.870	.768	.685
MAX RADIUS	:	1.532	1.261	1.204
HORIZONTAL SPREAD	:	2.556	2.289	1.671
VERTICAL SPREAD	:	2.033	1.907	1.907
EXTREME SPREAD	:	2.809	2.384	2.322
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.733

VS= 1.865

GS= 2.228

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.930	.865	.447
MINIMUM X	:	-.803	-.868	-.760
MAXIMUM Y	:	.696	.566	.608
MINIMUM Y	:	-1.169	-1.074	-1.032
CENTROID X	:	.013	.078	-.030
CENTROID Y	:	.150	.280	.238
POA TO CENTROID in.	:	.150	.290	.240
MIN RADIUS	:	.154	.202	.113
MEAN RADIUS	:	.658	.562	.516
MAX RADIUS	:	1.306	1.074	1.036
HORIZONTAL SPREAD	:	1.733	1.733	1.207
VERTICAL SPREAD	:	1.865	1.640	1.640
EXTREME SPREAD	:	2.228	1.800	1.645
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523316

DATE 9/11/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.36	2.32	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.57	2.31	2.25	
PULL #3	2.46	2.55	2.25	2.18	
PULL #4	2.47	2.61	2.23	2.21	
PULL #5	2.49	2.57	2.20	2.18	
TOTAL	12.35	12.86	11.31	11.06	
AVG.	2.47	2.57	2.36	2.212	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.29		
PULL #2	3.09	3.16		
PULL #3	3.13	3.20		
PULL #4	3.14	3.28		
PULL #5	3.09	3.24		
TOTAL	15.64	16.17		
AVG.	3.13	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.39		3.95
PULL #2	4.29	4.36		4.05
PULL #3	4.14	4.16		4.01
PULL #4	4.24	4.31		4.03
PULL #5	4.07	4.29		3.95
TOTAL	20.92	21.51		19.99
AVG.	4.18	4.30		4.00

CAD 700
M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523316

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCD
	Magnaflux Bolt		8/22/90	KCD
615	Rollmark Caliber		8/22/90	GS.
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-22-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 Int.	F) Safety On Force	4 1/2	4 1/4	4 1/2			9/11/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/11/90	WB
	H) Trigger Pull Test & Retainability						9/11/90	WB
	I) Firing Pin Indent	.0225	.023	.023			9/11/90	WB
	J) Assemble Stock						9/11/90	RW
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						9/11/90	RW
	M) Iron Sight Alignment						9/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/90	RW
	O) Attach Scope to Rifle						9/11/90	RW
	P) Detach & Attach Scope 20 Times						9/11/90	RW
640	Gallery Target & Test						9-13-90	NF
	A) Time						9-13-90	NF
	B) Malfunctions						9-13-90	NF
	C) Pierced Primers						9-13-90	NF
	D) Optical Clarity of Scope						9-13-90	NF
645	Inspect for Live Ammo						9-13-90	NF
655	Final Inspection						9/15/90	JS
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.24	2.25	2.18	2.21	2.15	9-15-90	JS
	C) Function						9/15/90	JS
660	Pack						9/19/90	NF