

C6523379

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
 MODEL 700™ M24

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

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

SERIAL NO.
 C6523379

ORDER NO.
 5716

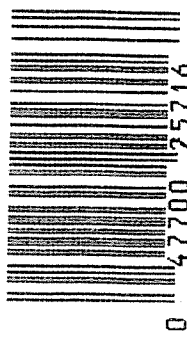
MADE IN ILLINOI, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6523379

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523379

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR.
615	Rollmark Caliber		9-25-90 G.S.	
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TSA
	Apply Coating (Bolt)		10-2-90	TSA
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/19/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/24/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			10/24/90	WB
	H) Trigger Pull Test & Retainability						10/24/90	RM
	I) Firing Pin Indent	.0215	.021	.021			10/24/90	WB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/18/90	SS
	L) Attach Front and Rear Sight Assemblies						10/29/90	RW
	M) Iron Sight Alignment						10/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/90	RW
	O) Attach Scope to Rifle						10/29/90	RW
	P) Detach & Attach Scope 20 Times						10/29/90	RW
640	Gallery Target & Test						10/30/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10/30/90	NF
655	Final Inspection							
	A) Headspace						3/18/90	SS
	B) Trigger Pull	252	285	288	258	257	3/18/90	SS
	C) Function						3/18/90	SS
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO 06523379

DATE 10/19/98

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.34	2.19	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.34	2.33	2.85	
PULL #3	2.50	2.27	2.33	2.88	
PULL #4	2.33	2.23	2.47	2.58	
PULL #5	2.33	2.32	2.30	2.57	
TOTAL	11.84	11.50	11.62		
AVG.	2.368	2.3	2.324		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.42		
PULL #2	3.27	3.25		
PULL #3	3.17	3.24		
PULL #4	3.22	3.28		
PULL #5	3.37	3.33		
TOTAL	16.32	16.52		
AVG.	3.264	3.304		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.31		4.24
PULL #2	4.41	4.35		4.22
PULL #3	4.35	4.40		4.43
PULL #4	4.33	4.38		4.28
PULL #5	4.35	4.40		4.42
TOTAL	21.81	21.84		21.59
AVG.	4.362	4.368		4.318

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523379
31 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.511423
1 TO	2	.671465
1 TO	3	.346344
1 TO	4	.49105
1 TO	5	.246789

192 <----POA

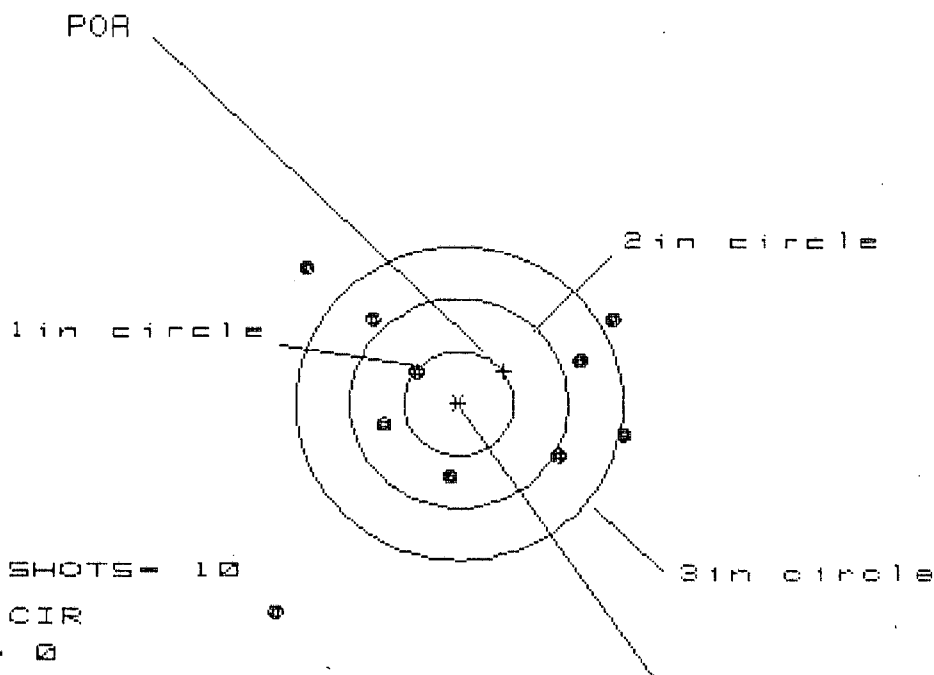
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0956
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.157
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .183816
THE AMR FOR THIS RIFLE IS: .9806

31 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523379

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.197

VS= 3.258

GS= 4.203

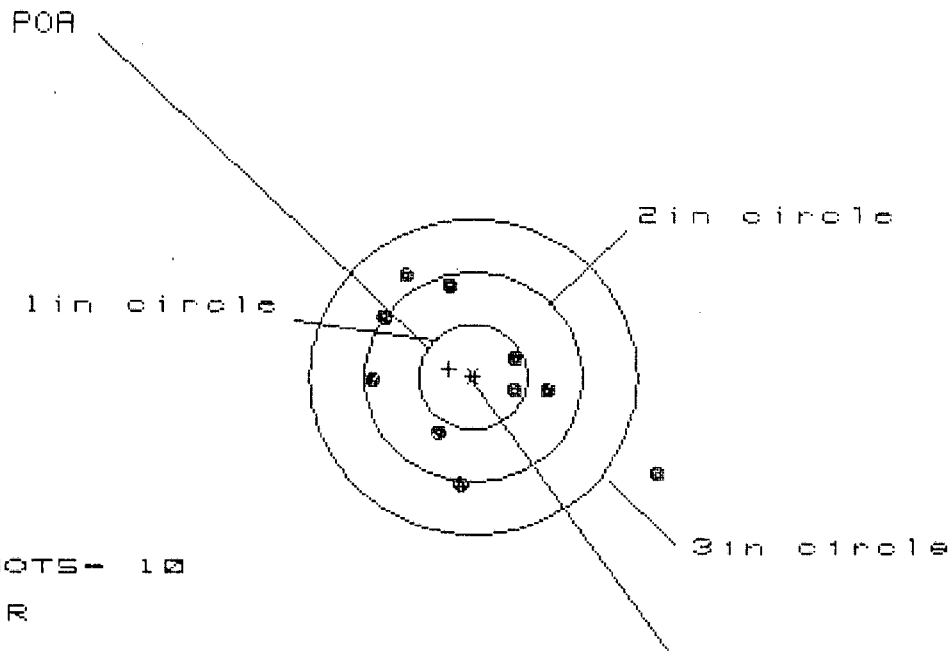
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.491	1.302	1.105
MINIMUM X	:	-1.705	-1.580	-1.142
MAXIMUM Y	:	1.300	1.083	.748
MINIMUM Y	:	-1.958	-.895	-.760
CENTROID X	:	-.412	-.223	-.026
CENTROID Y	:	-.303	-.086	-.221
POR TO CENTROID in.	:	.512	.239	.223
MIN RADIUS	:	.502	.598	.771
MEAN RADIUS	:	1.287	1.138	1.019
MAX RADIUS	:	2.596	1.916	1.360
HORIZONTAL SPREAD	:	3.197	2.882	2.247
VERTICAL SPREAD	:	3.258	1.978	1.508
EXTREME SPREAD	:	4.203	3.286	2.501
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.579

VS = 2.051

GS = 2.998

CENTROID *

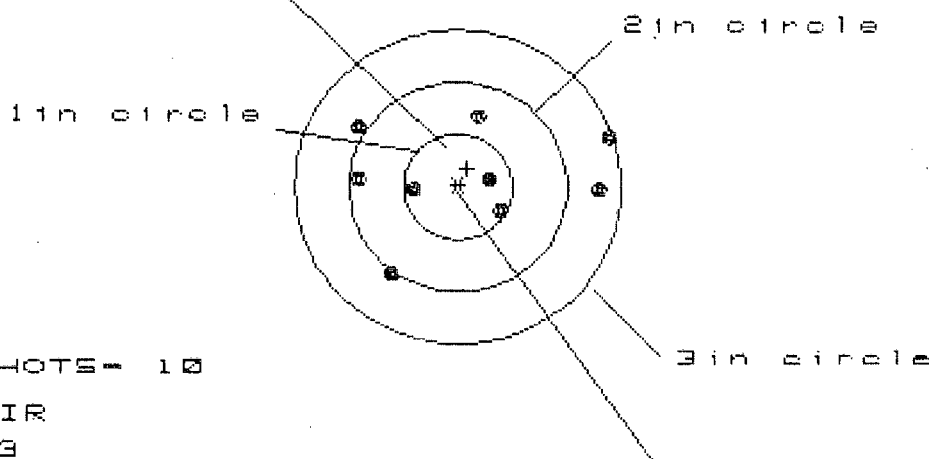
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.646	.815	.758
MINIMUM X	:	-.933	-.751	-.808
MAXIMUM Y	:	1.014	.912	.939
MINIMUM Y	:	-1.037	-1.139	-1.025
CENTROID X	:	.221	.039	.096
CENTROID Y	:	-.079	.023	-.091
POA TO CENTROID in.	:	.235	.045	.132
MIN RADIUS	:	.385	.590	.505
MEAN RADIUS	:	.916	.809	.767
MAX RADIUS	:	1.887	1.141	1.025
HORIZONTAL SPREAD	:	2.579	1.566	1.566
VERTICAL SPREAD	:	2.051	2.051	1.964
EXTREME SPREAD	:	2.998	2.115	1.967
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.292

VS= 1.572

GS= 2.397

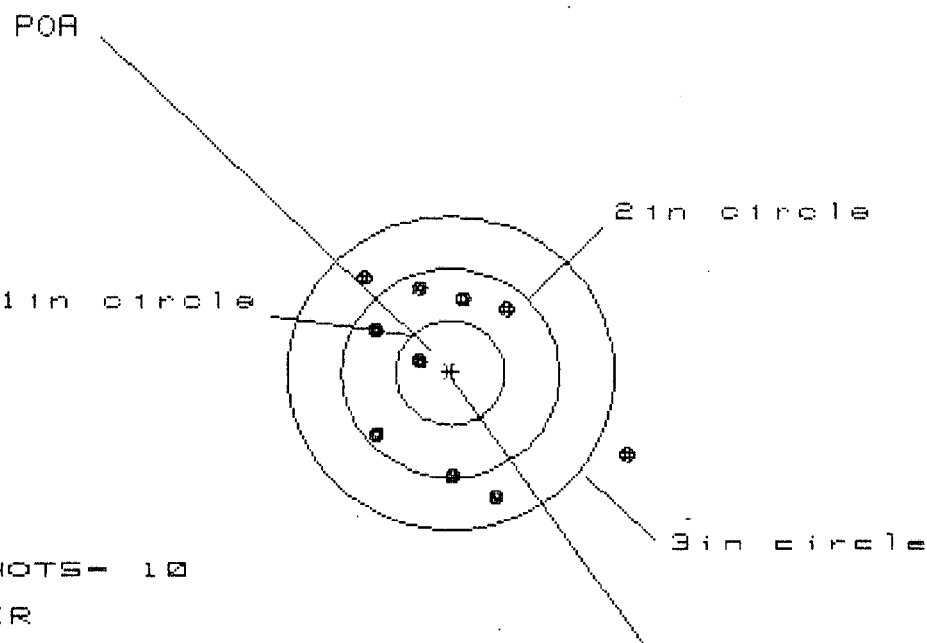
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.473	.697
MINIMUM X	:	-.953	-.804	-.620
MAXIMUM Y	:	.711	.767	.777
MINIMUM Y	:	-.861	-.805	-.795
CENTROID X	:	-.089	-.238	-.422
CENTROID Y	:	-.178	-.234	-.244
POA TO CENTROID in.	:	.199	.334	.487
MIN RADIUS	:	.265	.255	.090
MEAN RADIUS	:	.859	.783	.671
MAX RADIUS	:	1.430	1.475	.914
HORIZONTAL SPREAD	:	2.292	2.277	1.317
VERTICAL SPREAD	:	1.572	1.572	1.572
EXTREME SPREAD	:	2.397	2.334	1.755
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.403

VS= 2.126

GS= 2.931

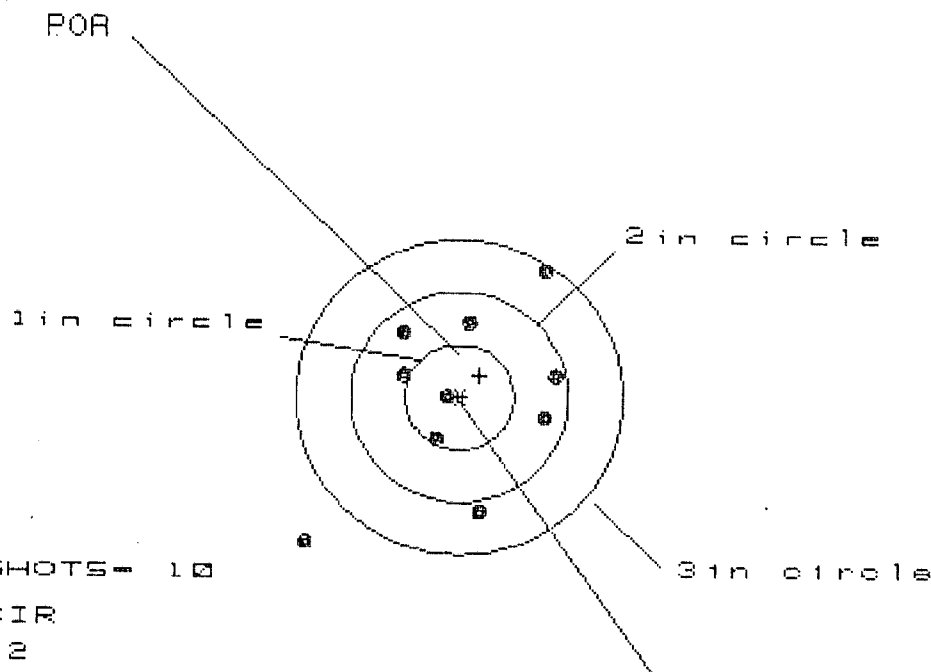
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.596	.668	.743
MINIMUM X	-.807	-.630	-.555
MAXIMUM Y	.891	.804	.639
MINIMUM Y	-1.235	-1.322	-1.193
CENTROID X	-.015	-.192	-.267
CENTROID Y	-.014	.073	.238
POA TO CENTROID in.	.021	.206	.358
MIN RADIUS	.311	.117	.154
MEAN RADIUS	.958	.818	.703
MAX RADIUS	1.779	1.452	1.228
HORIZONTAL SPREAD	2.403	1.298	1.298
VERTICAL SPREAD	2.126	2.126	1.832
EXTREME SPREAD	2.931	2.457	2.018
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.357

VS= 2.556

GS= 3.393

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.928	.770	.850
MINIMUM X	:	-1.429	-.706	-.626
MAXIMUM Y	:	1.201	1.051	.711
MINIMUM Y	:	-1.355	-1.249	-1.118
CENTROID X	:	-.183	-.025	-.105
CENTROID Y	:	-.211	-.061	-.192
POA TO CENTROID in.	:	.280	.066	.219
MIN RADIUS	:	.078	.291	.158
MEAN RADIUS	:	.883	.768	.687
MAX RADIUS	:	1.969	1.250	1.124
HORIZONTAL SPREAD	:	2.357	1.476	1.476
VERTICAL SPREAD	:	2.556	2.300	1.829
EXTREME SPREAD	:	3.393	2.379	1.858
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	