

C6523478

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

C-1111
2000 01/01/01

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

Remington®
REG. U.S. PAT. & TM. OFF.

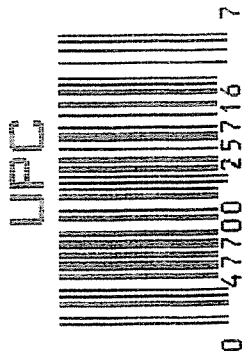
MODEL 700™ H24

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

SERIAL NO.
06523478

ORDER NO.
5716

01



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523478

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/90	KJ
600	Proof		10/1/90	KJ
607	Check Headspace		10/1/90	KJ
610	Dis-assemble Gun		10/1/90	KJ
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	J.L.
617	Drill and Tap Sight Holes		10/4/90	F.B.
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10-24-90	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5			10/25/90	WB
	G) Safety Off Force	2	2	2			10/25/90	WB
	H) Trigger Pull Test & Retainability						10-24-90	DH
	I) Firing Pin Indent	.0235	.023	.023			10/25/90	WB
	J) Assemble Stock						10/26/90	Kel
	K) Assemble Swivel Studs						3/10/90	JS
	L) Attach Front and Rear Sight Assemblies						10/26/90	Kel
	M) Iron Sight Alignment						10/26/90	Kel
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	Kel
	O) Attach Scope to Rifle						10/26/90	Kel
	P) Detach & Attach Scope 20 Times						10/26/90	Kel
640	Gallery Target & Test						10/27/90	DH
	A) Time						"	DH
	B) Malfunctions						"	DH
	C) Pierced Primers						"	DH
	D) Optical Clarity of Scope						"	DH
645	Inspect for Live Ammo						10/27/90	DH
655	Final Inspection							
	A) Headspace						3/10/90	JS
	B) Trigger Pull	217	226	224	224	221	3/10/90	JS
	C) Function						3/10/90	JS
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. C6523478

DATE 10-24-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.55	2.60	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.61	2.58	2.26	
PULL #3	2.60	2.57	2.61	2.24	
PULL #4	2.55	2.67	2.53	2.24	
PULL #5	2.56	2.60	2.58	2.21	
TOTAL	2.80	13.00	12.90		
AVG.	2.56	2.60	2.58		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.10		
PULL #2	3.18	2.99		
PULL #3	3.11	3.18		
PULL #4	3.16	3.01		
PULL #5	3.09	3.23		
TOTAL	15.80	15.51		
AVG.	3.16	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.34		4.00
PULL #2	4.16	4.39		4.18
PULL #3	4.23	4.21		4.20
PULL #4	4.20	4.40		4.22
PULL #5	4.29	4.34		4.12
TOTAL	21.11	21.68		20.72
AVG.	4.22	4.33		4.14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523478
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.224009
1 TO	2	.243528
1 TO	3	.222948
1 TO	4	.454437
1 TO	5	.234649

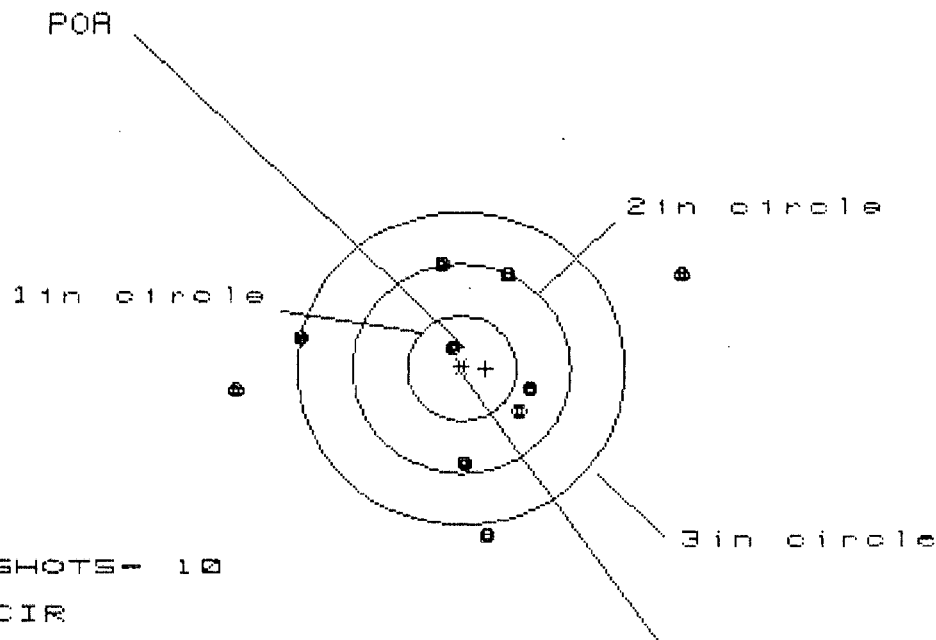
$\frac{3}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .017
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .060824
THE AMR FOR THIS RIFLE IS: .9812

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523478

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS = 4.152

VS = 2.564

GS = 4.316

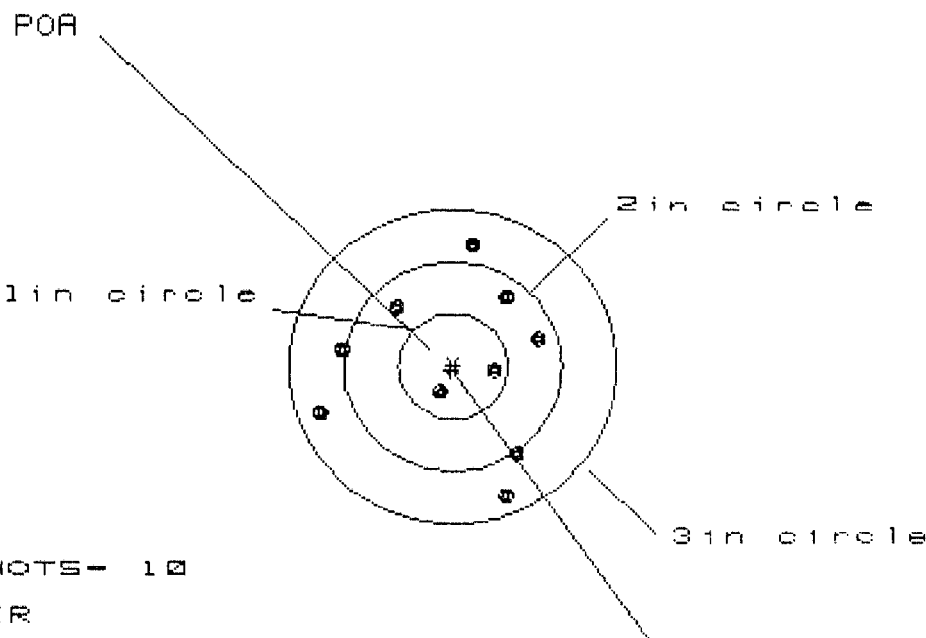
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.036	.804	.568
MINIMUM X	:	-2.116	-1.890	-1.501
MAXIMUM Y	:	.952	1.055	1.036
MINIMUM Y	:	-1.613	-1.509	-1.528
CENTROID X	:	-.224	-.450	-.214
CENTROID Y	:	.002	-.101	-.082
POA TO CENTROID in.	:	.224	.461	.229
MIN RADIUS	:	.196	.301	.276
MEAN RADIUS	:	1.182	1.089	.933
MAX RADIUS	:	2.238	1.896	1.552
HORIZONTAL SPREAD	:	4.152	2.694	2.069
VERTICAL SPREAD	:	2.564	2.564	2.564
EXTREME SPREAD	:	4.316	2.799	2.602
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
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 = 10

HS= 2.033

VS= 2.356

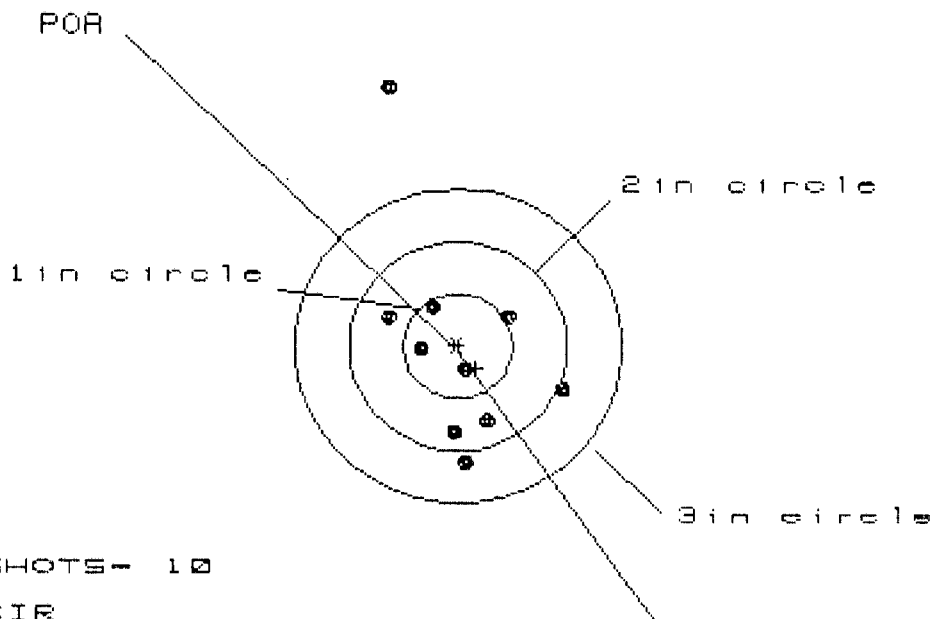
GS= 2.376

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.683	.721
MINIMUM X	:	-1.215	-1.106	-1.068
MAXIMUM Y	:	1.159	1.106	.950
MINIMUM Y	:	-1.197	-1.250	-1.063
CENTROID X	:	.017	.152	.114
CENTROID Y	:	.037	.090	.246
POA TO CENTROID in.	:	.040	.177	.271
MIN RADIUS	:	.262	.289	.401
MEAN RADIUS	:	.897	.837	.777
MAX RADIUS	:	1.306	1.286	1.172
HORIZONTAL SPREAD	:	2.033	1.789	1.789
VERTICAL SPREAD	:	2.356	2.356	2.013
EXTREME SPREAD	:	2.376	2.376	2.064
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.565

VS= 3.599

GS= 3.659

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.945	.878	.877
MINIMUM X	:	-.620	-.687	-.688
MAXIMUM Y	:	2.446	.694	.584
MINIMUM Y	:	-1.153	-.881	-.685
CENTROID X	:	-.165	-.098	-.097
CENTROID Y	:	.217	-.055	.055
POA TO CENTROID in.	:	.272	.113	.111
MIN RADIUS	:	.220	.072	.045
MEAN RADIUS	:	.856	.629	.587
MAX RADIUS	:	2.519	.896	.922
HORIZONTAL SPREAD	:	1.565	1.565	1.565
VERTICAL SPREAD	:	3.599	1.575	1.269
EXTREME SPREAD	:	3.659	1.708	1.708
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

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.103

VS= 3.744

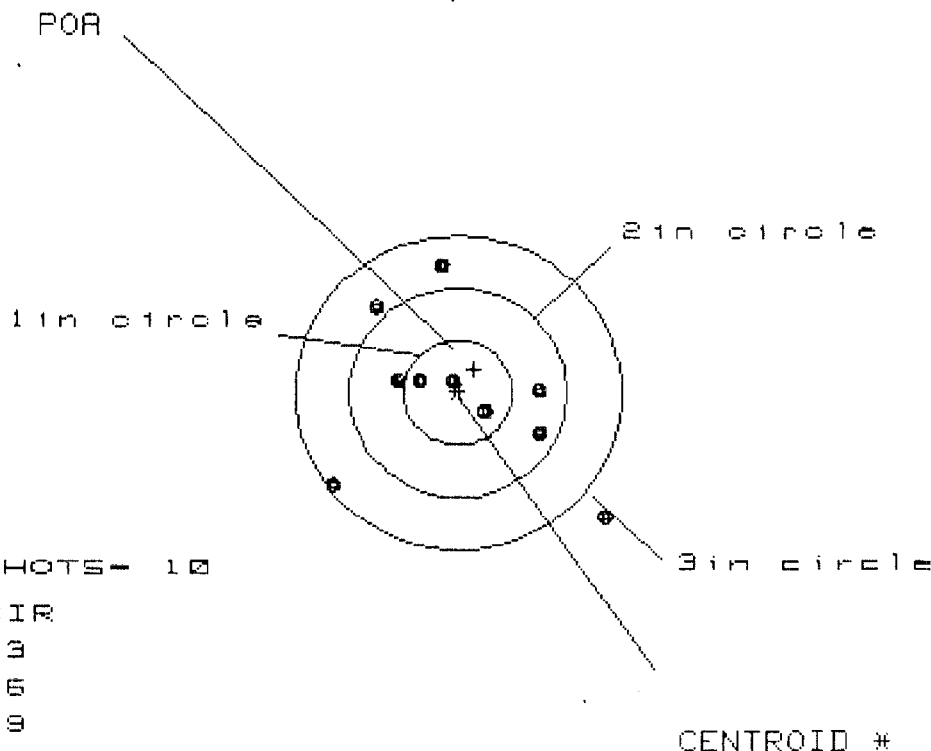
GS= 3.952

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.313	1.396	.545
MINIMUM X	:	-.790	-.707	-.532
MAXIMUM Y	:	1.304	1.033	.804
MINIMUM Y	:	-2.440	-1.829	-1.123
CENTROID X	:	.228	.145	-.030
CENTROID Y	:	.049	.320	.549
POA TO CENTROID in.	:	.233	.351	.550
MIN RADIUS	:	.144	.180	.467
MEAN RADIUS	:	1.108	.890	.685
MAX RADIUS	:	2.552	2.301	1.130
HORIZONTAL SPREAD	:	2.103	2.103	1.077
VERTICAL SPREAD	:	3.744	2.862	1.927
EXTREME SPREAD	:	3.952	3.398	1.965
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 = 9

HS= 2.539

VS= 2.396

GS= 2.892

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	.932	.980
MINIMUM X	:	-1.198	-1.048	-.765
MAXIMUM Y	:	1.261	1.135	1.014
MINIMUM Y	:	-1.135	-.971	-.578
CENTROID X	:	-.148	-.298	-.166
CENTROID Y	:	-.220	-.094	.027
POA TO CENTROID in.	:	.266	.312	.169
MIN RADIUS	:	.176	.107	.085
MEAN RADIUS	:	.863	.740	.658
MAX RADIUS	:	1.757	1.429	1.022
HORIZONTAL SPREAD	:	2.539	1.980	1.565
VERTICAL SPREAD	:	2.396	2.106	1.592
EXTREME SPREAD	:	2.892	2.354	1.947
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	