

06523504

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

SWS TRIGGER PULL TEST

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

SERIAL NO. C65 23504
DATE 10-26-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.48	2.45	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.53	2.52	
PULL #3	2.62	2.70	2.60	
PULL #4	2.54	2.60	2.36	
PULL #5	2.54	2.51	2.39	
TOTAL	12.68	12.79	12.32	
AVG.	2.53	2.55	2.46	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.32	3.14	
PULL #2	3.24	3.18	
PULL #3	3.23	2.98	
PULL #4	3.17	3.10	
PULL #5	3.08	3.05	
TOTAL	16.04	15.45	
AVG.	3.20	3.09	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.23	4.07	
PULL #2	4.25	4.21	4.07	
PULL #3	4.07	4.28	4.00	
PULL #4	4.21	4.21	4.00	
PULL #5	4.20	4.21	3.91	
TOTAL	21.05	21.14	20.05	
AVG.	4.21	4.22	4.01	

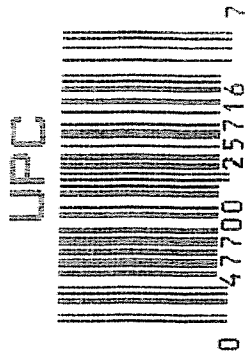
CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523504

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			11/28	WB
	G) Safety Off Force	3	3	3			11/28	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.20	2.26	2.35	2.30	2.34	11/28	WB
	C) Function							
660	Pack							

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6523504
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6523504*

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/30/90	WB
	G) Safety Off Force	2	2	2			10/30/90	WB
	H) Trigger Pull Test & Retainability						10/29/90	JH
	I) Firing Pin Indent	.021	.020	.0205			10/30/90	WB
	J) Assemble Stock						10/31/90	KA
	K) Assemble Swivel Studs						11/19/90	QSS
	L) Attach Front and Rear Sight Assemblies						10/31/90	KA
	M) Iron Sight Alignment						10/31/90	KA
	N) Detach Front & Rear Sights & place in numbered container						10/31/90	KA
	O) Attach Scope to Rifle						10/31/90	KA
	P) Detach & Attach Scope 20 Times						10/31/90	KA
640	Gallery Target & Test						11-1-90	KT
	A) Time						11-1-90	KT
	B) Malfunctions						11-1-90	KT
	C) Pierced Primers						11-1-90	KT
	D) Optical Clarity of Scope						11-1-90	KT
645	Inspect for Live Ammo						11-1-90	KT
655	Final Inspection						11/19/90	QSS
	A) Headspace						11/19/90	QSS
	B) Trigger Pull	243	240	248	248	252	11/19/90	QSS
	C) Function						11/19/90	QSS
660	Pack						12/18/90	VF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523504
2 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.0735935
1 TO 2	.2461
1 TO 3	.314871
1 TO 4	.311718
1 TO 5	.200392

3 ● ←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0606

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.013

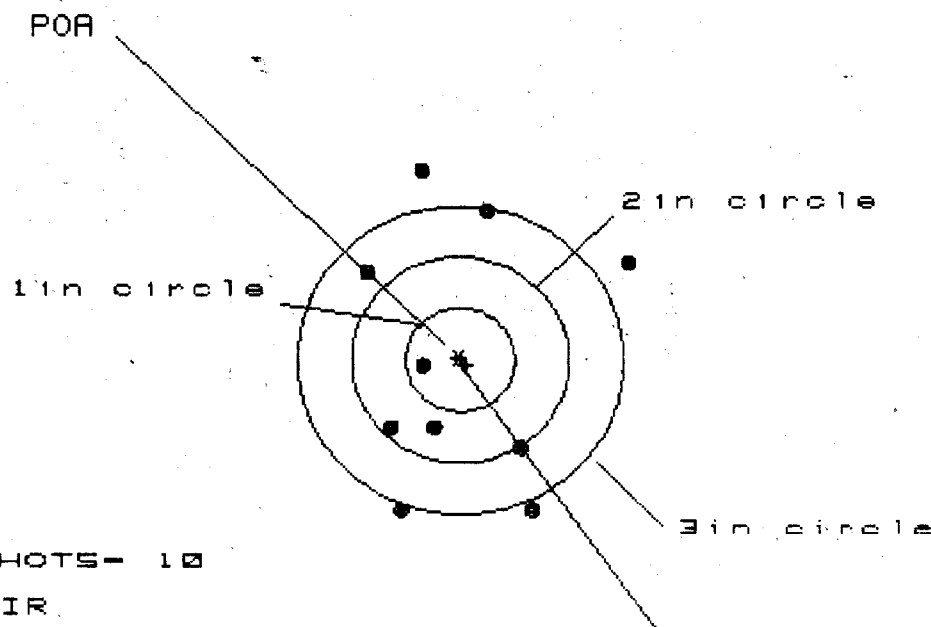
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0619787

THE AMR FOR THIS RIFLE IS: 1.123

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523504

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.337

VS= 3.294

GS= 3.427

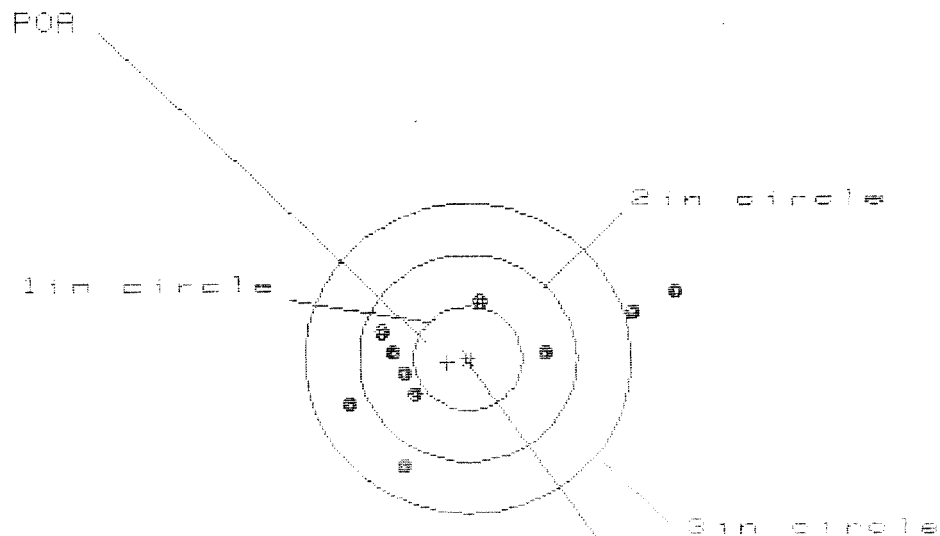
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.531	1.495	.773
MINIMUM X	:	-.806	-.842	-.655
MAXIMUM Y	:	1.839	1.671	1.813
MINIMUM Y	:	-1.455	-1.251	-1.109
CENTROID X	:	-.054	-.018	-.205
CENTROID Y	:	.050	-.154	-.296
POA TO CENTROID in.	:	.074	.155	.360
MIN RADIUS	:	.344	.408	.303
MEAN RADIUS	:	1.234	1.131	.972
MAX RADIUS	:	1.868	1.875	1.851
HORIZONTAL SPREAD	:	2.337	2.337	1.428
VERTICAL SPREAD	:	3.294	2.922	2.922
EXTREME SPREAD	:	3.427	3.164	3.023
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Nov 1980

FILE:/PATTERNING/CENTERFIRE_PATT/08523504

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 2.948

VS= 1.687

GS= 3.132

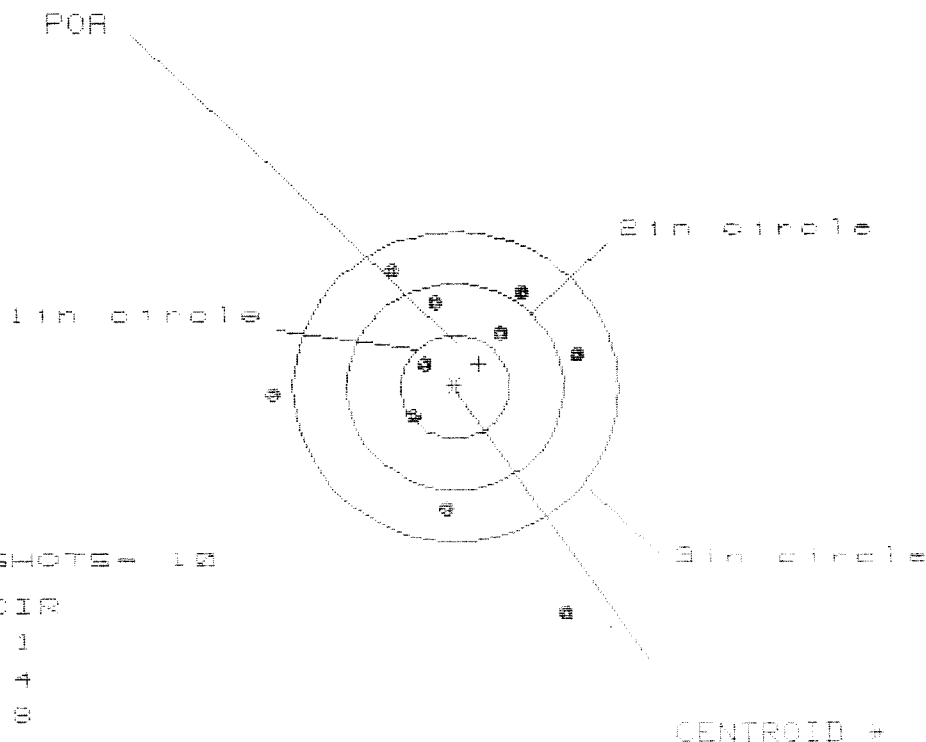
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.861	1.762	1.127
MINIMUM X	:	-1.087	-.880	-.660
MAXIMUM Y	:	.619	.599	.668
MINIMUM Y	:	-1.068	-.999	-.930
CENTROID X	:	.192	-.015	-.235
CENTROID Y	:	.043	-.026	-.095
FOR TO CENTROID in.	:	.196	.030	.254
MIN RADIUS	:	.548	.410	.193
MEAN RADIUS	:	.998	.827	.614
MAX RADIUS	:	1.962	1.846	1.152
HORIZONTAL SPREAD	:	2.948	2.642	1.787
VERTICAL SPREAD	:	1.687	1.598	1.598
EXTREME SPREAD	:	3.132	2.798	1.867
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Nov 1980

FILE:/PATTERNING/CENTERFIRE_PATT/CS523504

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.781

VS = 3.342

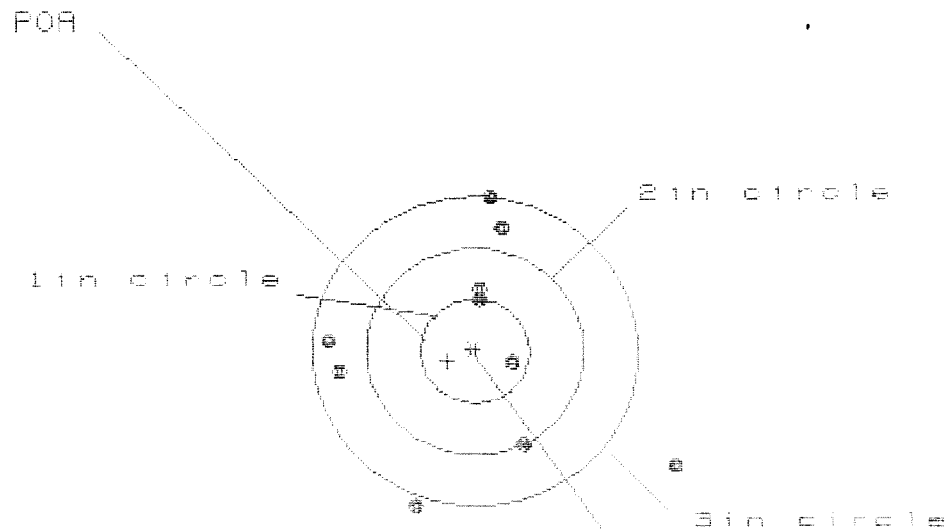
GS = 3.681

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.116	1.226	1.032
MINIMUM X	-1.665	-1.555	-1.639
MAXIMUM Y	1.113	.865	.823
MINIMUM Y	-2.229	-1.466	-1.508
CENTROID X	-.216	-.326	-.132
CENTROID Y	-.220	.028	.070
POR TO CENTROID (in.)	.388	.327	.149
MIN RADIUS	.305	.142	.339
MEAN RADIUS	1.119	.912	.820
MAX RADIUS	2.439	1.591	1.522
HORIZONTAL SPREAD	2.781	2.781	1.670
VERTICAL SPREAD	3.342	2.331	2.331
EXTREME SPREAD	3.681	2.808	2.370
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

2 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523504

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 7

IS = 3.160

VS = 3.050

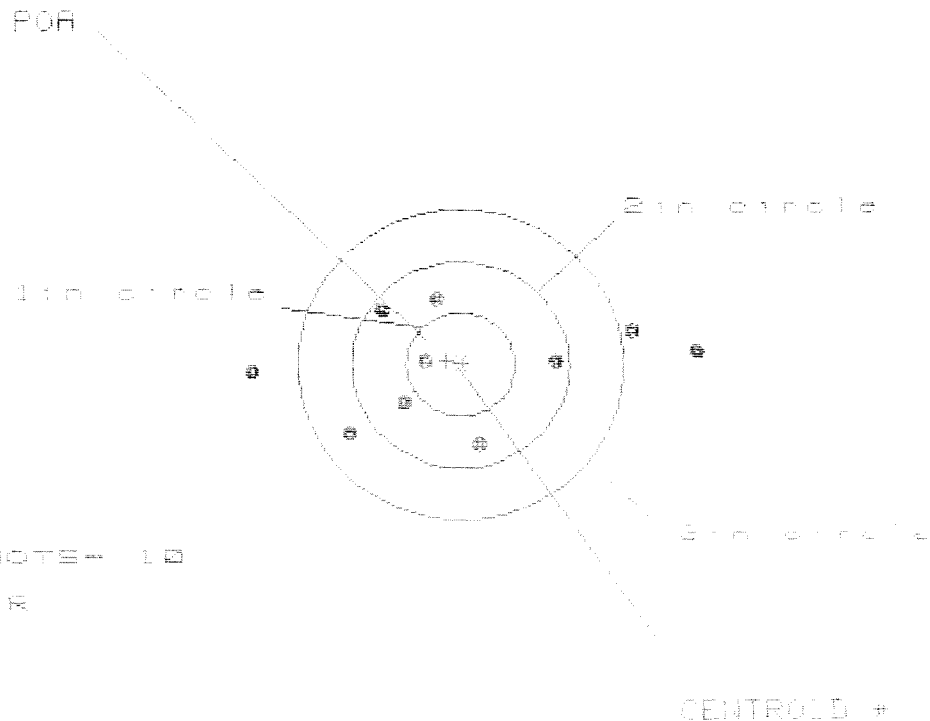
OS = 3.359

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.824	.686	.646
MINIMUM X	:	-1.336	-1.133	-1.173
MAXIMUM Y	:	1.567	1.388	1.180
MINIMUM Y	:	-1.543	-1.662	-1.225
CENTROID X	:	.254	.051	.091
CENTROID Y	:	.093	.217	.425
POA TO CENTROID in.	:	.272	.223	.435
MIN RADIUS	:	.381	.466	.281
MEAN RADIUS	:	1.153	1.032	.961
MAX RADIUS	:	2.117	1.692	1.385
HORIZONTAL SPREAD	:	3.160	1.819	1.819
VERTICAL SPREAD	:	3.050	3.050	2.405
EXTREME SPREAD	:	3.359	3.114	2.434
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523584

CENTERFIRE PATTERNS # 5



OF SHOTS= 10
 # IN CIR
 1in = 1
 2in = 6
 3in = 7
 ME= 4.071
 VE= 1.447
 GE= 4.078

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.149	1.813	1.683
MINIMUM X	:	-1.922	-1.683	-1.020
MAXIMUM Y	:	1.667	1.687	1.681
MINIMUM Y	:	-1.780	-1.760	-1.766
CENTROID X	:	1.127	1.112	1.098
CENTROID Y	:	-1.036	-1.056	-1.050
POA TO CENTROID in.	:	1.132	1.125	1.111
MIN RADIUS	:	1.319	1.090	1.099
MEAN RADIUS	:	1.112	1.040	1.074
MAX RADIUS	:	2.157	1.848	1.641
HORIZONTAL SPREAD	:	4.071	3.496	3.673
VERTICAL SPREAD	:	1.447	1.447	1.447
EXTREME SPREAD	:	4.076	3.519	3.792
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	6	6	6
NUMBER IN THREE INCH CIRCLE	=	7	7	7

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523504

DATE 10/29/90

TESTER JCL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.31	2.48	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.39	2.36	2.40	
PULL #3	2.31	2.44	2.32	2.48	
PULL #4	2.40	2.44	2.33	2.48	
PULL #5	2.32	2.38	2.30	2.52	
TOTAL	11.69	11.96	11.79		
AVG.	2.338	2.392	2.358		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.20		
PULL #2	3.25	3.17		
PULL #3	3.29	3.22		
PULL #4	3.20	3.26		
PULL #5	3.21	3.32		
TOTAL	16.22	16.17		
AVG.	3.244	3.234		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.30		4.34
PULL #2	4.27	4.30		4.41
PULL #3	4.25	4.20		4.38
PULL #4	4.30	4.31		4.43
PULL #5	4.28	4.33		4.50
TOTAL	21.31	21.44		22.06
AVG.	4.262	4.288		4.412