

06523511

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

*S
mend*

Remington[®]

MODEL 700TM N24

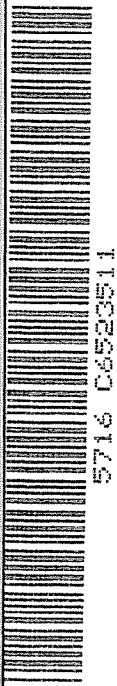
DUPONT
REG. U.S. PAT. & TM. OFF.

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

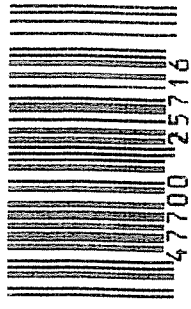
SERIAL NO.
C6523511

ORDER NO.
5716

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



LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523511

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25 90	9/25/90	RW
600	Proof	9 25 90	9/25/90	RW
607	Check Headspace	9 25 90	9/25/90	RW
610	Dis-assemble Gun	9 25 90	9/25/90	RW
612	Magnaflux Barrel Action		9/26/90	KR
	Magnaflux Bolt		9/26/90	KR
615	Rollmark Caliber		9/26/90	LS
617	Drill and Tap Sight Holes		9/28/90	FB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10/5/90	TS
	Apply Coating (Bolt)		10/5/90	TS
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/11/90	WB

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	10/4/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	10/11/90	WB
	H) Trigger Pull Test & Retainability				10/4/90	WB
	I) Firing Pin Indent	0205	0205	0205	10/4/90	WB
	J) Assemble Stock				10/11/90	RW
	K) Assemble Swivel Studs				10/30/90	JS
	L) Attach Front and Rear Sight Assemblies				10/11/90	RW
	M) Iron Sight Alignment				10/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container				10/11/90	RW
	O) Attach Scope to Rifle				10/11/90	RW
	P) Detach & Attach Scope 20 Times				10/11/90	RW
640	Gallery Target & Test				10-15-90	KT
	A) Time				10-15-90	KT
	B) Malfunctions				10-15-90	KT
	C) Pierced Primers				10-15-90	KT
	D) Optical Clarity of Scope				10-15-90	KT
645	Inspect for Live Ammo				10-15-90	KT
655	Final Inspection				10/30/90	JS
	A) Headspace				10/30/90	JS
	B) Trigger Pull	273	264	260	10/30/90	JS
	C) Function				10/30/90	JS
660	Pack				12-18-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523511
DATE 10/11/90
TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.41	2.39	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.29	2.33	2.69	
PULL #3	2.55	2.25	2.52	2.60	
PULL #4	2.33	2.20	2.55	2.57	
PULL #5	2.53	2.24	2.39	2.52	
TOTAL	12.38	11.39	12.18		
AVG.	2.47	2.28	2.43		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.23		
PULL #2	3.28	3.39		
PULL #3	3.23	3.29		
PULL #4	3.35	3.20		
PULL #5	3.34	3.28		
TOTAL	16.39	16.39		
AVG.	3.28	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.03		4.24
PULL #2	4.31	4.12		4.22
PULL #3	4.19	4.16		4.30
PULL #4	4.23	4.23		4.28
PULL #5	4.29	4.12		4.39
TOTAL	21.23	20.66		21.43
AVG.	4.24	4.13		4.28

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523511
16 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.352433
1 TO	2	.455303
1 TO	3	.472883
1 TO	4	.459322
1 TO	5	.376197

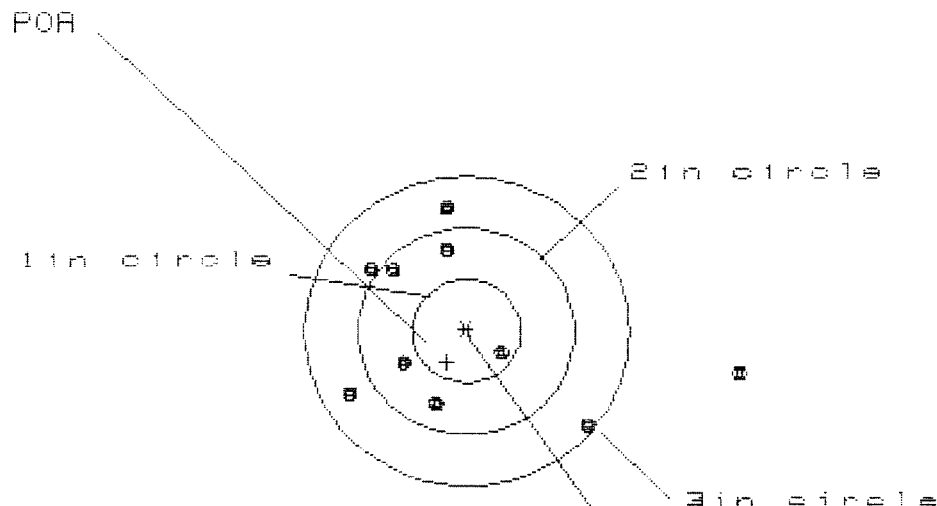
$\frac{1}{25}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0272
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0468840
THE ABR FOR THIS RIFLE IS: .788

18 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523511

CENTERFIRE PATTERNS # 1



OF SHOTS= 10
 # IN CIR
 1in = 1
 2in = 5
 3in = 4
 HS= 3.599
 VS= 2.166
 GS= 3.604

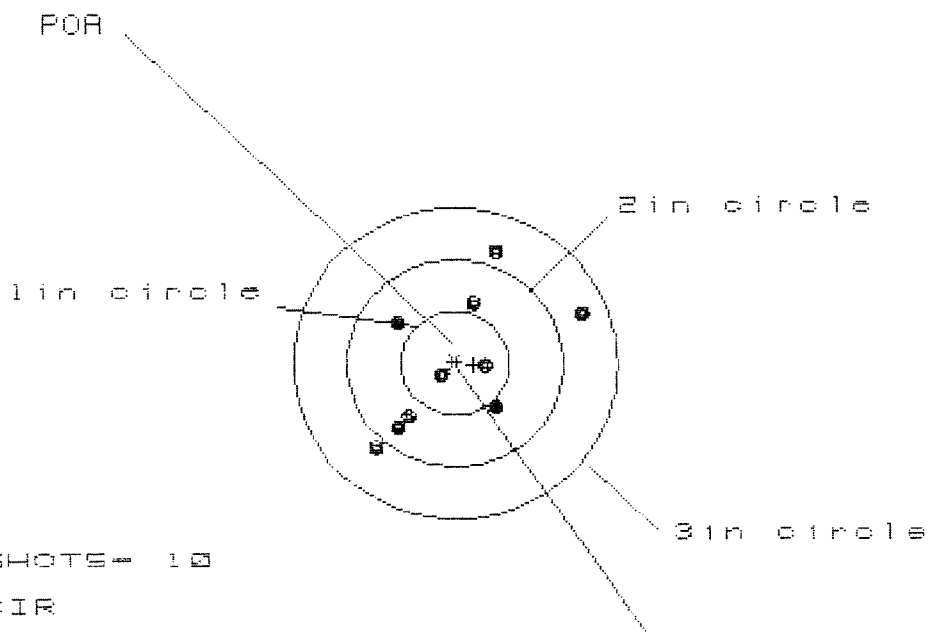
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.507	1.350	.775
MINIMUM X	:	-1.092	-.814	-.645
MAXIMUM Y	:	1.214	1.165	1.040
MINIMUM Y	:	-.952	-1.001	-.858
CENTROID X	:	.180	-.098	-.267
CENTROID Y	:	.303	.352	.477
POA TO CENTROID in.	:	.353	.366	.547
MIN RADIUS	:	.387	.442	.490
MEAN RADIUS	:	1.105	.894	.789
MAX RADIUS	:	2.545	1.681	1.066
HORIZONTAL SPREAD	:	3.599	2.164	1.428
VERTICAL SPREAD	:	2.166	2.166	1.898
EXTREME SPREAD	:	3.604	2.537	2.037
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523511

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.883

VS = 1.869

GS = 2.313

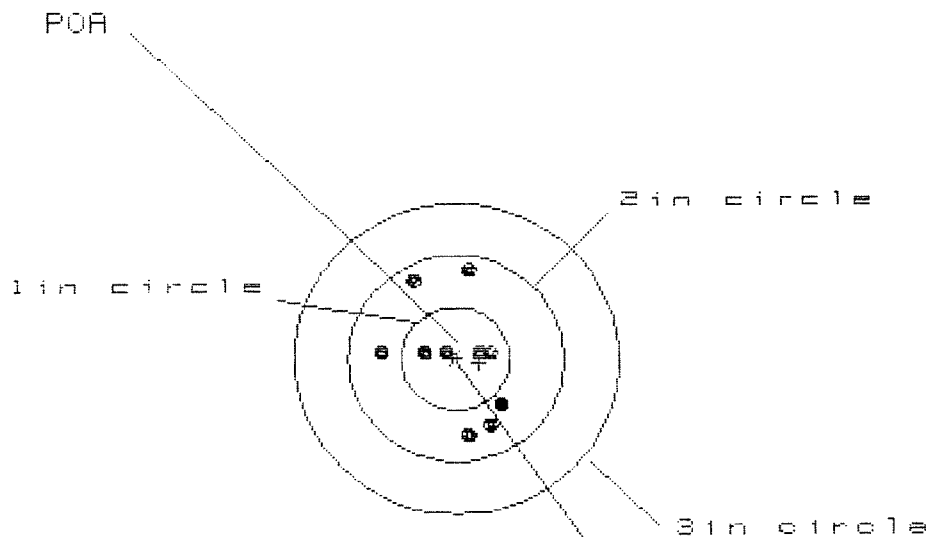
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	.535	.456
MINIMUM X	:	-.755	-.629	-.469
MAXIMUM Y	:	1.037	1.094	.997
MINIMUM Y	:	-.832	-.775	-.626
CENTROID X	:	-.171	-.297	-.218
CENTROID Y	:	.013	-.044	.053
POA TO CENTROID in.	:	.172	.300	.224
MIN RADIUS	:	.223	.096	.220
MEAN RADIUS	:	.732	.658	.621
MAX RADIUS	:	1.239	1.203	1.083
HORIZONTAL SPREAD	:	1.883	1.164	.925
VERTICAL SPREAD	:	1.869	1.869	1.623
EXTREME SPREAD	:	2.313	2.185	1.944
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523511

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 10

3 in = 10

HS= 1.160

VS= 1.647

GS= 1.647

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.434	.446	.398
MINIMUM X	:	-.726	-.714	-.762
MAXIMUM Y	:	.889	.813	.302
MINIMUM Y	:	-.758	-.660	-.558
CENTROID X	:	-.213	-.225	-.177
CENTROID Y	:	.040	-.059	-.161
POA TO CENTROID in.	:	.216	.232	.239
MIN RADIUS	:	.072	.161	.271
MEAN RADIUS	:	.538	.506	.462
MAX RADIUS	:	.895	.897	.806
HORIZONTAL SPREAD	:	1.160	1.160	1.160
VERTICAL SPREAD	:	1.647	1.473	.860
EXTREME SPREAD	:	1.647	1.565	1.279
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Oct 1998

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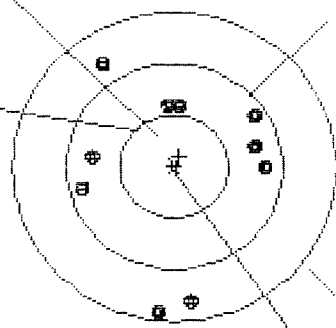
CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS= 1.640

VS= 2.414

GS= 2.474

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.821	.807	.819
MINIMUM X	-.819	-.833	-.821
MAXIMUM Y	.963	.801	.614
MINIMUM Y	-1.451	-1.502	-1.505
CENTROID X	-.044	-.030	-.042
CENTROID Y	-.098	.064	.251
POA TO CENTROID in.	.107	.070	.255
MIN RADIUS	.591	.430	.242
MEAN RADIUS	.924	.826	.694
MAX RADIUS	1.457	1.505	.964
HORIZONTAL SPREAD	1.640	1.640	1.640
VERTICAL SPREAD	2.414	2.303	1.119
EXTREME SPREAD	2.474	2.432	1.798
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

18 Oct 1998

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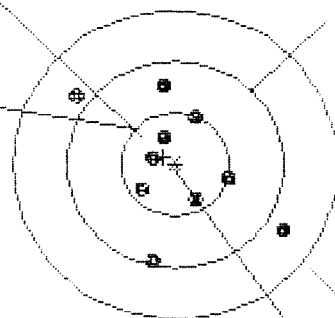
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



+ OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.845

VS= 1.670

ES= 2.370

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.641	.535
MINIMUM X	:	-.958	-.848	-.855
MAXIMUM Y	:	.726	.651	.727
MINIMUM Y	:	-.944	-1.019	-.943
CENTROID X	:	.112	.002	.108
CENTROID Y	:	-.067	.008	-.067
POA TO CENTROID in.	:	.130	.008	.127
MIN RADIUS	:	.233	.093	.220
MEAN RADIUS	:	.641	.560	.585
MAX RADIUS	:	1.196	1.041	.962
HORIZONTAL SPREAD	:	1.945	1.489	.890
VERTICAL SPREAD	:	1.670	1.670	1.670
EXTREME SPREAD	:	2.370	1.793	1.674
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	