

C6594536

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6594536
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6594536

UPC



0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	5 th round loads hard	KS
	2nd	Adjusted MAG Day	KS 2/13/91
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-G-0086

GUN SERIAL # **C6594536**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/26/90	K.S.
600	Proof		12/26/90	K.S.
607	Check Headspace		12/26/90	K.S.
610	Dis-assemble Gun		12/26/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	GL
617	Drill and Tap Sight Holes	1	10 91	LB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	KA
	C) Inspect Ejector Hole for Chamfer		2/11/91	KA
	D) Oil Firing Pin Ass'y		2/11/91	LB
	E) Adjust Trigger Pull to Min Setting and Stake		2/12/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5	5			2/12/91	WB
	G) Safety Off Force	3	3	3			2/12/91	WB
	H) Trigger Pull Test & Retainability						2/12/91	JH
	I) Firing Pin Indent	.021	.0205	.0205			2/12/91	WB
	J) Assemble Stock						2/13/91	KH
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/13/91	KH
	M) Iron Sight Alignment						2/13/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	KH
	O) Attach Scope to Rifle						2/13/91	KH
	P) Detach & Attach Scope 20 Times						2/13/91	KH
640	Gallery Target & Test						2-14-91	DH
	A) Time						2-14-91	DH
	B) Malfunctions						2-14-91	DH
	C) Pierced Primers						2-14-91	DH
	D) Optical Clarity of Scope						2-14-91	DH
645	Inspect for Live Ammo						2-14-91	DH
655	Final Inspection							
	A) Headspace						2-25-91	A
	B) Trigger Pull	2.19	2.24	2.28	2.30	2.27	2/21/91	JH
	C) Function						2-25-91	AC
660	Pack						3-19-91	NF

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

SERIAL NO. C6594536
DATE 2/12/91
TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.19	2.45	2.19	MIN. SETTING,
PULL #2	2.49	2.40	2.33	2.24	NO AVG. OF 5
PULL #3	2.52	2.49	2.40	2.28	READINGS ACCEPT-
PULL #4	2.29	2.38	2.39	2.30	ABLE LESS THAN 2#
PULL #5	2.32	2.31	2.37	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.22		
PULL #2	3.36	3.24		
PULL #3	3.23	3.29		
PULL #4	3.31	3.16		
PULL #5	3.21	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.32		4.19
PULL #2	4.49	4.43		4.23
PULL #3	4.29	4.45		4.42
PULL #4	4.37	4.25		4.36
PULL #5	4.22	4.47		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594536
14 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.065192
1 TO	2	.547289
1 TO	3	.241812
1 TO	4	.204841
1 TO	5	.205183

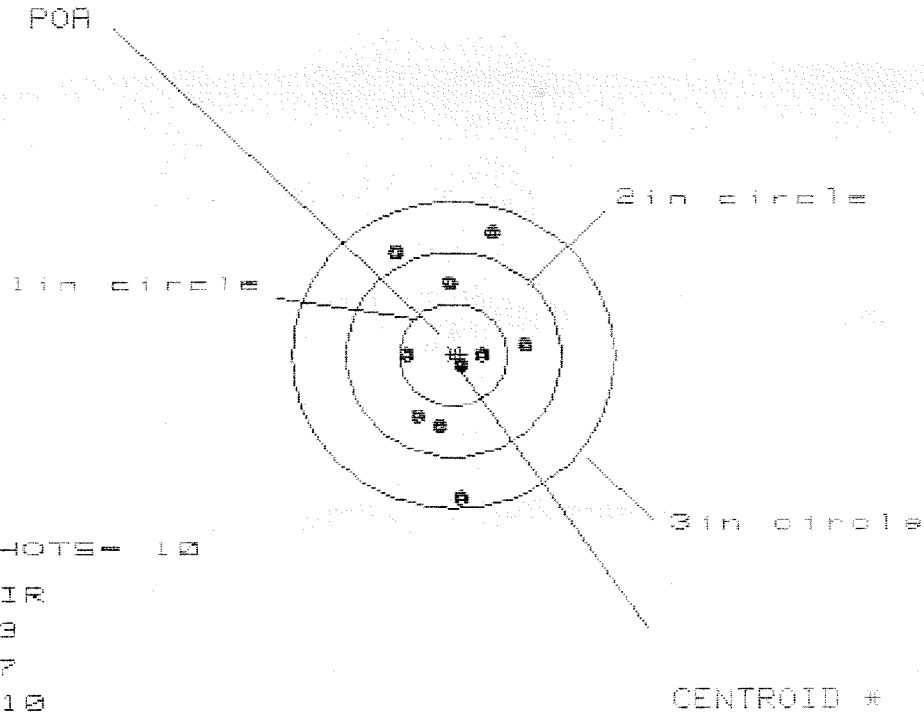
$\frac{a^2}{SM}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .138
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .139118
THE AMR FOR THIS RIFLE IS: .9102

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594596

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.120

VS = 2.604

GS = 2.620

PATTERN #

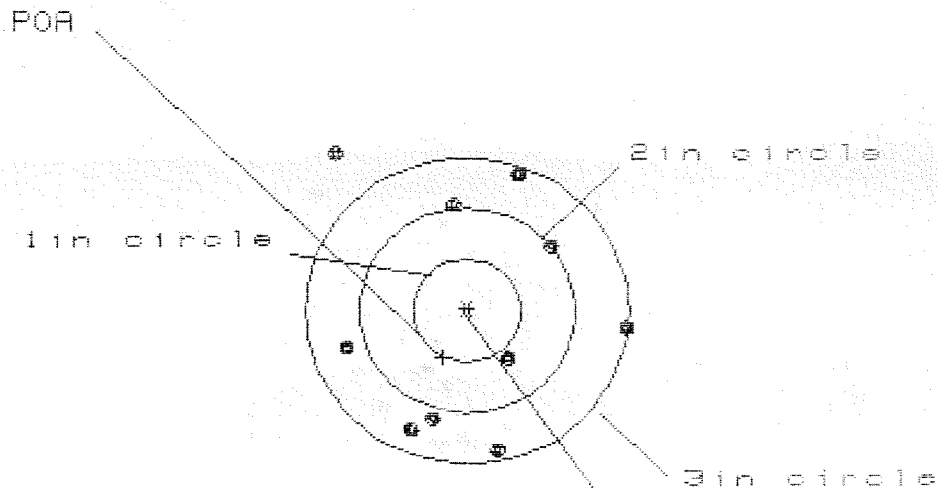
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.633	.639	.683
MINIMUM X	-.487	-.481	-.437
MAXIMUM Y	1.169	1.010	.963
MINIMUM Y	-1.435	-.903	-.777
CENTROID X	-.065	-.071	-.115
CENTROID Y	-.005	.154	.028
POA TO CENTROID in.	.066	.170	.118
MIN RADIUS	.173	.320	.229
MEAN RADIUS	.748	.681	.611
MAX RADIUS	1.436	1.068	1.058
HORIZONTAL SPREAD	1.120	1.120	1.120
VERTICAL SPREAD	2.604	1.913	1.740
EXTREME SPREAD	2.620	1.961	1.784
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 1

3in = 9

HS = 2.637

VS = 2.863

GS = 3.212

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.444

1.311

.832

MINIMUM X

-1.193

-1.277

-1.113

MAXIMUM Y

1.529

1.528

1.528

MINIMUM Y

-1.334

-1.165

-1.165

CENTROID X

.222

.355

.191

CENTROID Y

.461

.292

.292

POA TO CENTROID in.

.512

.459

.349

MIN RADIUS

.609

.393

.507

MEAN RADIUS

1.235

1.123

1.095

MAX RADIUS

1.939

1.563

1.604

HORIZONTAL SPREAD

2.637

2.588

1.945

VERTICAL SPREAD

2.863

2.693

2.693

EXTREME SPREAD

3.212

2.700

2.700

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

1

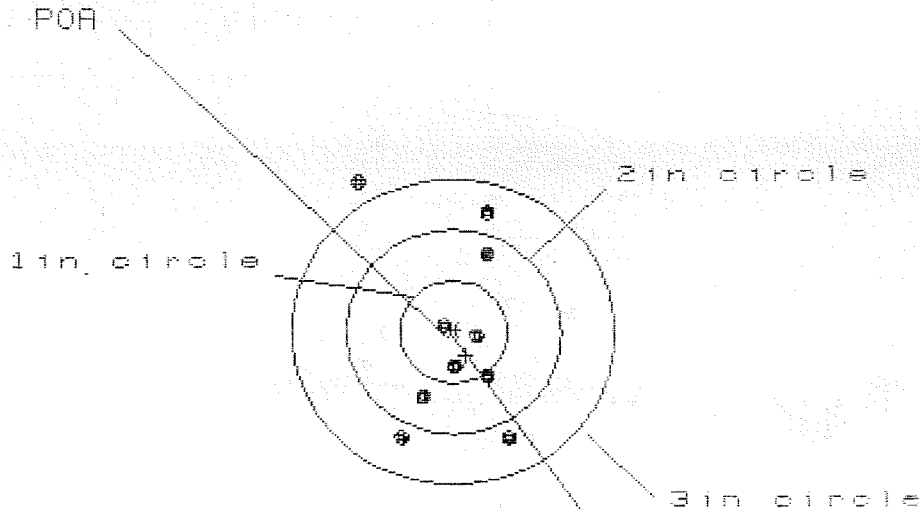
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.393

VS = 2.589

GS = 2.858

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.501	.402	.433
MINIMUM X	-.892	-.541	-.510
MAXIMUM Y	1.512	1.336	1.078
MINIMUM Y	-1.077	-.909	-.742
CENTROID X	-.113	-.014	-.045
CENTROID Y	.232	.064	-.103
POA TO CENTROID in.	.258	.066	.113
MIN RADIUS	.111	.223	.110
MEAN RADIUS	.804	.568	.559
MAX RADIUS	1.755	1.359	1.116
HORIZONTAL SPREAD	1.393	.943	.943
VERTICAL SPREAD	2.589	2.245	1.820
EXTREME SPREAD	2.858	2.380	1.988
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS

4

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 5

3 in - 10

HS = 2.569

VS = 2.141

GS = 2.597

CENTROID *

PATTERN #

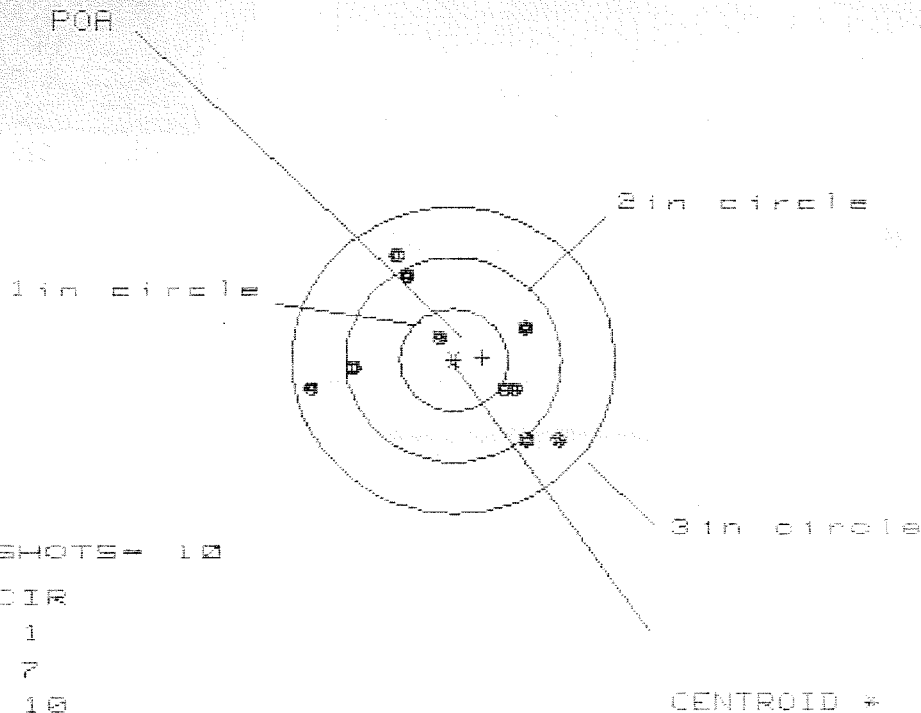
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	1.152	1.210
MINIMUM X	:	-1.276	-1.054	-.911
MAXIMUM Y	:	1.171	1.250	1.304
MINIMUM Y	:	-.970	-.891	-.837
CENTROID X	:	.137	.278	.135
CENTROID Y	:	.029	-.050	-.104
POA TO CENTROID in.	:	.140	.283	.170
MIN RADIUS	:	.170	.103	.160
MEAN RADIUS	:	.898	.832	.753
MAX RADIUS	:	1.459	1.341	1.448
HORIZONTAL SPREAD	:	2.569	2.206	2.121
VERTICAL SPREAD	:	2.141	2.141	2.141
EXTREME SPREAD	:	2.597	2.524	2.524
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.980
MINIMUM X	-1.289
MAXIMUM Y	1.010
MINIMUM Y	-.747
CENTROID X	-.269
CENTROID Y	-.027
POA TO CENTROID in.	.270
MIN RADIUS	.267
MEAN RADIUS	.866
MAX RADIUS	1.320
HORIZONTAL SPREAD	2.269
VERTICAL SPREAD	1.757
EXTREME SPREAD	2.321
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10