

C6587713

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

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

SERIAL NO.
C6587713

ORDER NO.
5716

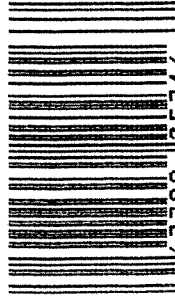
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



5716 C6587713

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587713

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9 90		RW
600	Proof	10 9 90		RW
607	Check Headspace	10 9 90		RW
610	Dis-assemble Gun	10 9 90		RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		11/12/90	KR
615	Rollmark Caliber		10/17/90	LL
617	Drill and Tap Sight Holes		10/18/90	KB
618	Polish Barrel	RB	10/19/90	KB
620	Apply Coatings (Barrel Action)		11-5-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-90	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			11/13/90	WB
	G) Safety Off Force	2	2	2			11/13/90	WB
	H) Trigger Pull Test & Retainability						11/13/90	W
	I) Firing Pin Indent	.0205	.020	.0205			11/13/90	WB
	J) Assemble Stock						11/13/90	RW
	K) Assemble Swivel Studs						11/14/90	JS
	L) Attach Front and Rear Sight Assemblies						11/13/90	RW
	M) Iron Sight Alignment						11/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/13/90	RW
	O) Attach Scope to Rifle						11/13/90	RW
	P) Detach & Attach Scope 20 Times						11/13/90	RW
640	Gallery Target & Test						11-14-90	DH
	A) Time						11-14-90	DH
	B) Malfunctions						11-14-90	DH
	C) Pierced Primers						11-14-90	DH
	D) Optical Clarity of Scope						11-14-90	DH
645	Inspect for Live Ammo						11-14-90	DH
655	Final Inspection							
	A) Headspace						11/19/90	JS
	B) Trigger Pull	245	253	252	233	232	11/19/90	JS
	C) Function	2					11/19/90	JS
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587713

DATE 11-13-90

TESTER 981

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.33	2.30	2.45	MIN. SETTING,
PULL #2	2.35	2.23	2.31	2.53	NO AVG. OF 5
PULL #3	2.34	2.22	2.29	2.52	READINGS ACCEPT-
PULL #4	2.36	2.29	2.28	2.33	ABLE LESS THAN 2#
PULL #5	2.34	2.33	2.26	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.37		
PULL #2	3.29	3.38		
PULL #3	3.11	3.24		
PULL #4	3.37	3.39		
PULL #5	3.29	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.32		4.42
PULL #2	4.37	4.34		4.42
PULL #3	4.43	4.43		4.41
PULL #4	4.40	4.06		4.32
PULL #5	4.42	4.41		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587713
14 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.281044
1 TO	2	.673662
1 TO	3	.201638
1 TO	4	.182497
1 TO	5	.451489

2
435 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .10784
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1056
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131522

THE AMR FOR THIS RIFLE IS: .9708

14 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08582713

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS: 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.074

VS = 1.833

GS = 3.095

CENTROID #

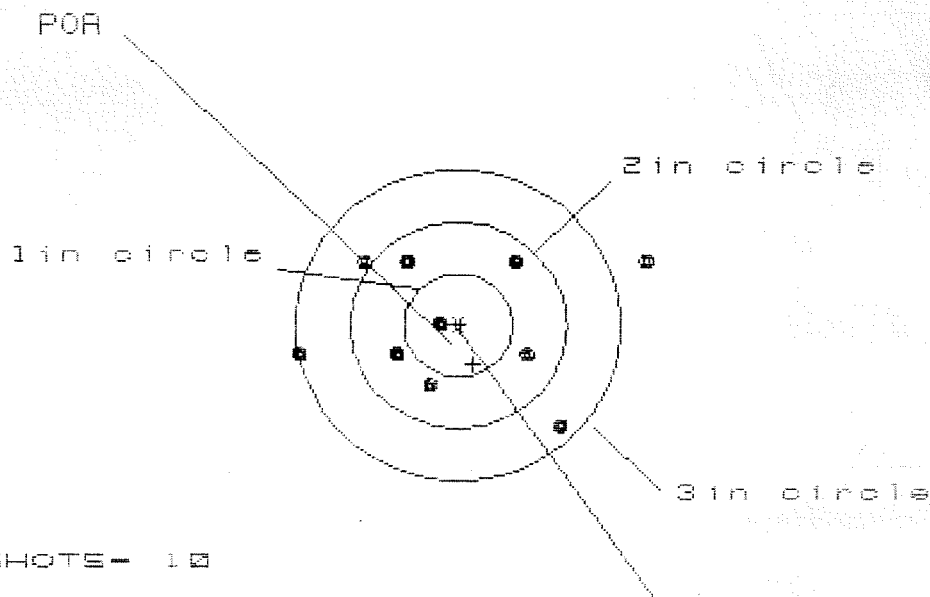
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.630	1.418	1.260
MINIMUM X	-1.444	-1.263	-1.090
MAXIMUM Y	.903	.959	.985
MINIMUM Y	-.930	-.874	-.848
CENTROID X	-.005	-.186	-.028
CENTROID Y	-.281	-.337	-.363
POA TO CENTROID in.	.281	.385	.364
MIN RADIUS	.202	.114	.129
MEAN RADIUS	.919	.802	.742
MAX RADIUS	1.707	1.466	1.322
HORIZONTAL SPREAD	3.074	2.681	2.340
VERTICAL SPREAD	1.833	1.833	1.833
EXTREME SPREAD	3.095	2.686	2.401
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

14 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06507713

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 3.238

VS= 1.634

GS= 3.342

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.727	1.698	.933
MINIMUM X	-1.511	-1.319	-.818
MAXIMUM Y	.621	.685	.660
MINIMUM Y	-1.013	-.949	-.974
CENTROID X	-.135	-.327	-.162
CENTROID Y	.388	.316	.341
POA TO CENTROID in.	.403	.455	.377
MIN RADIUS	.145	.131	.143
MEAN RADIUS	.951	.828	.767
MAX RADIUS	1.819	1.452	1.349
HORIZONTAL SPREAD	3.238	2.417	1.751
VERTICAL SPREAD	1.634	1.634	1.634
EXTREME SPREAD	3.342	2.532	2.395
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587713

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.874

VS= 2.597

GS= 3.020

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	.921	.747
MINIMUM X	:	-1.546	-1.399	-.961
MAXIMUM Y	:	1.285	1.415	1.462
MINIMUM Y	:	-1.312	-1.182	-1.135
CENTROID X	:	.192	.045	.219
CENTROID Y	:	-.238	-.368	-.415
POA TO CENTROID in.	:	.306	.371	.469
MIN RADIUS	:	.237	.056	.175
MEAN RADIUS	:	1.067	.958	.883
MAX RADIUS	:	1.770	1.498	1.462
HORIZONTAL SPREAD	:	2.874	2.320	1.708
VERTICAL SPREAD	:	2.597	2.597	2.597
EXTREME SPREAD	:	3.020	2.792	2.695
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587713

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.664

VS = 2.593

GS = 2.833

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.257	1.081
MINIMUM X	:	-1.389	-1.407	-.590
MAXIMUM Y	:	1.012	.837	.757
MINIMUM Y	:	-1.581	-.724	-.804
CENTROID X	:	-.106	-.088	.088
CENTROID Y	:	-.129	.046	.126
POA TO CENTROID in.	:	.167	.099	.154
MIN RADIUS	:	.370	.251	.058
MEAN RADIUS	:	.876	.772	.647
MAX RADIUS	:	1.589	1.546	1.108
HORIZONTAL SPREAD	:	2.664	2.664	1.671
VERTICAL SPREAD	:	2.593	1.561	1.561
EXTREME SPREAD	:	2.833	2.833	1.774
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

14 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587713

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.025

VS = 2.366

GS = 2.848

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.129
MINIMUM X	-0.896
MAXIMUM Y	1.200
MINIMUM Y	-1.166
CENTROID X	.446
CENTROID Y	-.260
POA TO CENTROID in.	.517
MIN RADIUS	.649
MEAN RADIUS	1.041
MAX RADIUS	1.635
HORIZONTAL SPREAD	2.025
VERTICAL SPREAD	2.366
EXTREME SPREAD	2.848
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9