

05594496

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]
MODEL 700[™] M24

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

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

SERIAL NO.
C6594496

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 2

5716 C6594496

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594496

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/28/91	RM

BARBER - M24 0018147		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			1/28/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			1/28/91	WB
	H) Trigger Pull Test & Retainability						1/28/91	88P
	I) Firing Pin Indent	.020	.0205	.0205			1/28/91	WB
	J) Assemble Stock						1/31/91	RW
	K) Assemble Swivel Studs						2-6-91	DH
	L) Attach Front and Rear Sight Assemblies						1/31/91	RW
	M) Iron Sight Alignment						1/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/31/91	RW
	O) Attach Scope to Rifle						1/31/91	RW
	P) Detach & Attach Scope 20 Times						1/31/91	RW
640	Gallery Target & Test						1-31-91	AC
	A) Time						1-31-91	AC
	B) Malfunctions						1-31-91	AC
	C) Pierced Primers						1-31-91	AC
	D) Optical Clarity of Scope						1-31-91	AC
645	Inspect for Live Ammo						1-31-91	AC
655	Final Inspection							
	A) Headspace						2-5-91	DH
	B) Trigger Pull	2.30	2.28	2.27	2.23	2.27	2-4-91	88P
	C) Function						2-5-91	DH
660	Pack						3/15/91	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6594496

DATE 1/28/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.55	2.23	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.46	2.41	2.28	
PULL #3	2.21	2.46	2.35	2.27	
PULL #4	2.29	2.54	2.50	2.23	
PULL #5	2.21	2.44	2.34	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.12		
PULL #2	3.16	3.35		
PULL #3	3.26	3.32		
PULL #4	3.19	3.17		
PULL #5	3.38	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.31		4.19
PULL #2	4.35	4.19		4.34
PULL #3	4.25	4.36		4.15
PULL #4	4.26	4.20		4.31
PULL #5	4.24	4.25		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594496
31 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.408094
1 TO 2	.186003
1 TO 3	.276848
1 TO 4	.452598
1 TO 5	.2114

13 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2488
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0644
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .257

THE DPR FOR THIS RIFLE IS: .8484

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594496

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.595

VS= 1.887

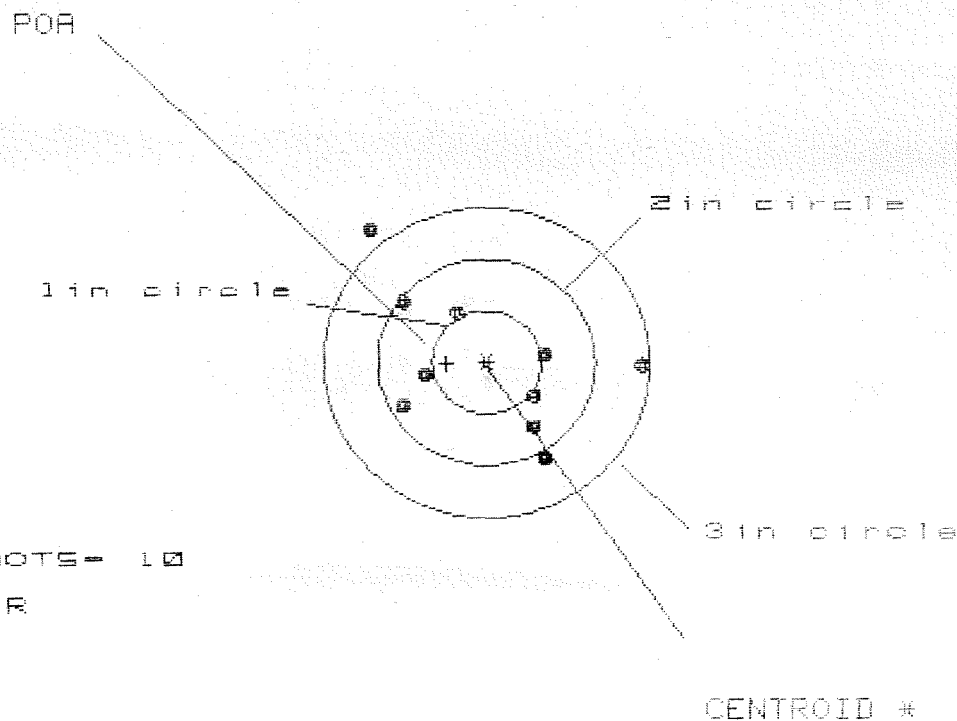
GS= 3.091

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	1.038	.777
MINIMUM X	-1.401	-1.082	-.952
MAXIMUM Y	1.076	1.172	1.083
MINIMUM Y	-.811	-.715	-.765
CENTROID X	.371	.527	.397
CENTROID Y	-.170	-.266	-.177
POA TO CENTROID in.	.408	.590	.434
MIN RADIUS	.042	.154	.021
MEAN RADIUS	.926	.838	.768
MAX RADIUS	1.648	1.275	1.221
HORIZONTAL SPREAD	2.595	2.120	1.729
VERTICAL SPREAD	1.887	1.887	1.848
EXTREME SPREAD	3.091	2.151	2.151
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594498

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 9

HS= 2.453

VS= 2.264

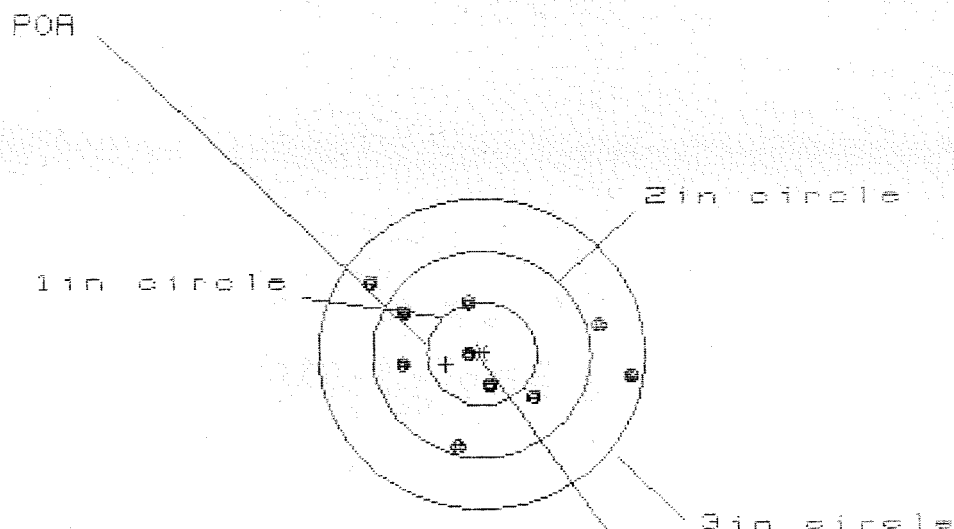
GS= 2.790

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.425	1.311	.597
MINIMUM X	-1.028	-.925	-.761
MAXIMUM Y	1.305	.750	.765
MINIMUM Y	-.959	-.814	-.799
CENTROID X	.370	.484	.320
CENTROID Y	.016	-.129	-.144
POA TO CENTROID in.	.370	.501	.351
MIN RADIUS	.511	.385	.501
MEAN RADIUS	.899	.790	.723
MAX RADIUS	1.661	1.317	1.019
HORIZONTAL SPREAD	2.453	2.236	1.358
VERTICAL SPREAD	2.264	1.564	1.564
EXTREME SPREAD	2.790	2.268	2.015
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594496

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 2.378

VS = 1.567

GS = 2.560

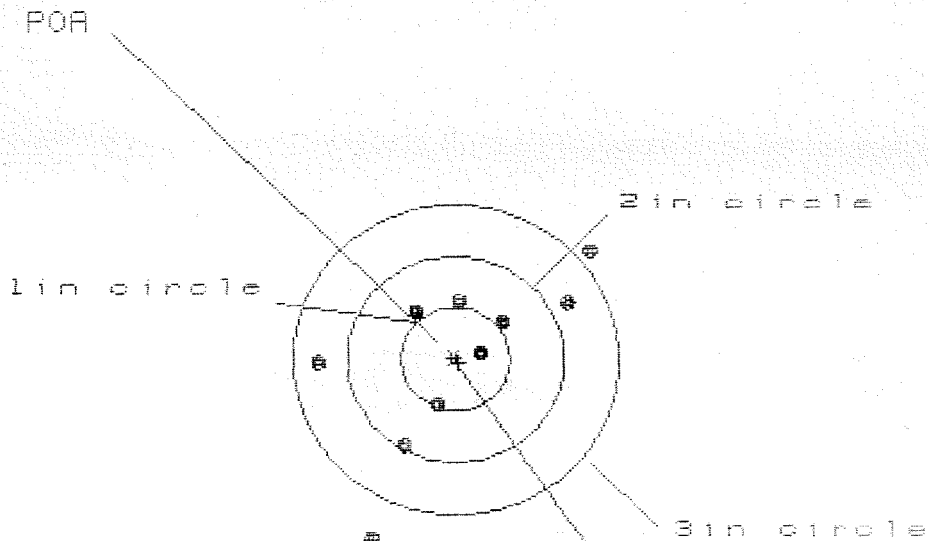
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.394	1.202	1.099
MINIMUM X	-.984	-.830	-.709
MAXIMUM Y	.699	.671	.522
MINIMUM Y	-.868	-.896	-.812
CENTROID X	.325	.171	.274
CENTROID Y	.103	.131	.047
POA TO CENTROID in.	.341	.215	.278
MIN RADIUS	.165	.018	.148
MEAN RADIUS	.780	.680	.638
MAX RADIUS	1.416	1.233	1.156
HORIZONTAL SPREAD	2.378	2.032	1.808
VERTICAL SPREAD	1.567	1.567	1.334
EXTREME SPREAD	2.560	2.070	1.820
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

31 Jan 1993

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 8

HS - 2.482

VS - 2.826

GS - 3.494

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.247	1.158	1.081
MINIMUM X	-1.235	-1.324	-1.180
MAXIMUM Y	1.092	.899	.452
MINIMUM Y	-1.734	-.997	-.885
CENTROID X	-.032	.057	-.087
CENTROID Y	.036	.229	.117
POA TO CENTROID in.	.049	.236	.146
MIN RADIUS	.231	.196	.282
MEAN RADIUS	.932	.791	.714
MAX RADIUS	1.913	1.466	1.190
HORIZONTAL SPREAD	2.482	2.482	2.261
VERTICAL SPREAD	2.826	1.896	1.337
EXTREME SPREAD	3.494	2.743	2.338
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534496

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.086

VS = 2.566

GS = 2.570

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.399	.391	.399
MINIMUM X	-.686	-.695	-.687
MAXIMUM Y	1.381	.991	.862
MINIMUM Y	-1.185	-1.031	-.967
CENTROID X	.210	.219	.211
CENTROID Y	-.367	-.461	-.332
POA TO CENTROID in.	.372	.510	.393
MIN RADIUS	.879	.894	.859
MEAN RADIUS	.785	.614	.556
MAX RADIUS	1.384	1.033	.991
HORIZONTAL SPREAD	1.086	1.086	1.086
VERTICAL SPREAD	2.566	2.022	1.769
EXTREME SPREAD	2.570	2.029	1.838
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		