

06594522

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

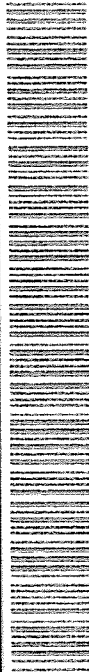
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6594522

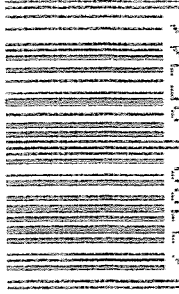
ORDER NO.
5716

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



5716 C6594522

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594522

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)		1-18-91	TJA
	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		1-22-91	RL

BARBER - M24 0018565

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			1/22/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			1/22/91	WB
	H) Trigger Pull Test & Retainability						1-22-91	JF
	I) Firing Pin Indent	.020	.020	.020			1/22/91	WB
	J) Assemble Stock						1/22/91	RW
	K) Assemble Swivel Studs						2-4-91	A
	L) Attach Front and Rear Sight Assemblies						1/22/91	RW
	M) Iron Sight Alignment						1/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/22/91	RW
	O) Attach Scope to Rifle						1/22/91	RW
	P) Detach & Attach Scope 20 Times						1/22/91	RW
640	Gallery Target & Test						1-22-91	AC
	A) Time						1-22-91	AC
	B) Malfunctions						1-22-91	AC
	C) Pierced Primers						1-22-91	AC
	D) Optical Clarity of Scope						1-22-91	AC
645	Inspect for Live Ammo						1-22-91	AC
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.49	2.51	2.51	2.52	2.49	2-1-91	JF
	C) Function						2-4-91	A
660	Pack						3-18-91	N

36 clicks
LEFT

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06594522

DATE 1-22-81

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.38	2.48	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.51	2.50	2.51	
PULL #3	2.46	2.41	2.50	2.51	
PULL #4	2.47	2.50	2.51	2.52	
PULL #5	2.48	2.47	2.51	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.19		
PULL #2	3.14	3.22		
PULL #3	3.19	3.21		
PULL #4	3.38	3.20		
PULL #5	3.34	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.49		4.47
PULL #2	4.48	4.46		4.51
PULL #3	4.40	4.46		4.51
PULL #4	4.41	4.43		4.45
PULL #5	4.44	4.47		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594522
23 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.197952
1 TO	2	.343023
1 TO	3	.236231
1 TO	4	.288855
1 TO	5	.208926

42° <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1686
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1026
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197364
THE AMR FOR THIS RIFLE IS: .8802

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594522

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.111

VS= 2.178

GS= 2.535

CENTROID *

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.489	.355
MINIMUM X	:	-1.101	-.989	-.708
MAXIMUM Y	:	1.024	.896	.911
MINIMUM Y	:	-1.153	-.974	-.959
CENTROID X	:	.193	.081	.205
CENTROID Y	:	-.044	.084	.069
POA TO CENTROID in.	:	.199	.117	.216
MIN RADIUS	:	.312	.204	.236
MEAN RADIUS	:	.825	.728	.679
MAX RADIUS	:	1.533	1.089	1.137
HORIZONTAL SPREAD	:	2.111	1.478	1.073
VERTICAL SPREAD	:	2.178	1.870	1.870
EXTREME SPREAD	:	2.535	2.083	2.083
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

23 Jan 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 5

3 in - 8

HS = 3.125

VS = 1.003

GS = 3.135

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.525	1.347	1.007
MINIMUM X	-1.600	-1.385	-1.216
MAXIMUM Y	.458	.470	.453
MINIMUM Y	-.545	-.533	-.550
CENTROID X	.402	.580	.411
CENTROID Y	.228	.216	.233
POA TO CENTROID in.	.462	.619	.473
MIN RADIUS	.114	.138	.116
MEAN RADIUS	.802	.717	.611
MAX RADIUS	1.603	1.385	1.216
HORIZONTAL SPREAD	3.125	2.732	2.223
VERTICAL SPREAD	1.003	1.003	1.003
EXTREME SPREAD	3.135	2.737	2.246
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		

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NUMBER IN THREE INCH CIRCLE =

8

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594522

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.515

VS= 2.787

GS= 3.754

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.027	.861	.685
MINIMUM X	-1.488	-1.281	-1.173
MAXIMUM Y	1.588	1.454	1.004
MINIMUM Y	-1.199	-.691	-.509
CENTROID X	.284	.450	.342
CENTROID Y	.174	.308	.126
POA TO CENTROID in.	.333	.545	.364
MIN RADIUS	.121	.202	.102
MEAN RADIUS	.864	.752	.586
MAX RADIUS	1.911	1.690	1.258
HORIZONTAL SPREAD	2.515	2.142	1.778
VERTICAL SPREAD	2.787	2.145	1.513
EXTREME SPREAD	3.754	2.994	2.233
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

23 Jan 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HM = 2.752

VS = 1.778

GS = 3.041

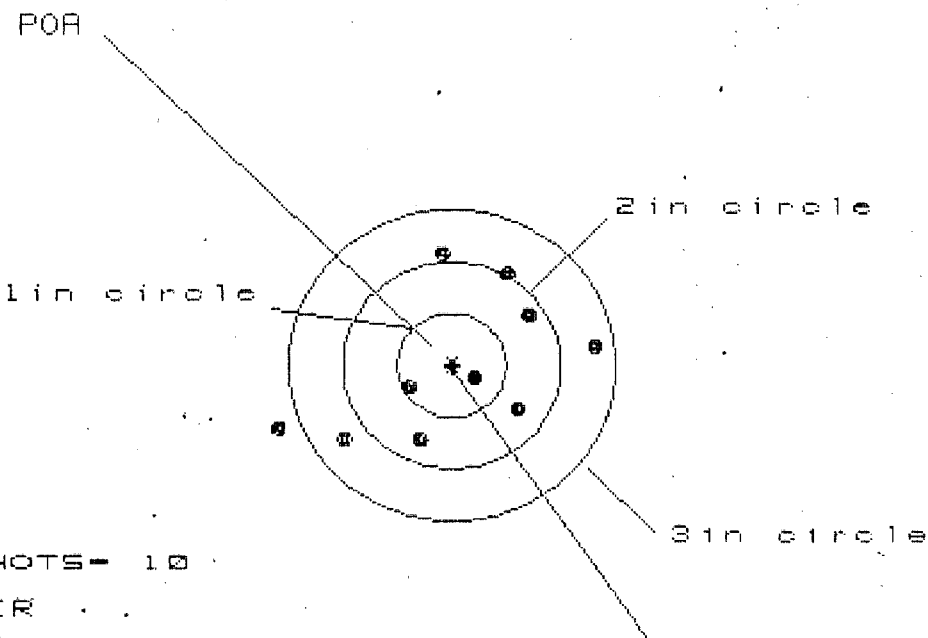
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.453	1.015	.873
MINIMUM X	:	-1.299	-1.138	-.839
MAXIMUM Y	:	.971	1.061	1.012
MINIMUM Y	:	-.807	-.717	-.766
CENTROID X	:	-.028	-.189	-.047
CENTROID Y	:	.142	.052	.101
POA TO CENTROID in.	:	.145	.196	.112
MIN RADIUS	:	.387	.249	.342
MEAN RADIUS	:	.971	.864	.827
MAX RADIUS	:	1.663	1.469	1.336
HORIZONTAL SPREAD	:	2.752	2.153	1.712
VERTICAL SPREAD	:	1.778	1.778	1.778
EXTREME SPREAD	:	3.041	2.599	2.051
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR . . .

1 in = 2

2 in = 5

3 in = 9

HS= 2.920

VS= 1.837

GS= 3.015

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.304	1.124	.639
MINIMUM X	-1.616	-1.156	-1.015
MAXIMUM Y	1.104	1.040	1.052
MINIMUM Y	-.733	-.797	-.784
CENTROID X	-.008	.172	.031
CENTROID Y	.013	.077	.064
POA TO CENTROID in.	.015	.188	.072
MIN RADIUS	.257	.148	.241
MEAN RADIUS	.939	.827	.794
MAX RADIUS	1.717	1.404	1.283
HORIZONTAL SPREAD	2.920	2.280	1.654
VERTICAL SPREAD	1.837	1.837	1.837
EXTREME SPREAD	3.015	2.452	2.208
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	