

C6594563

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

Remington®

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

DU PONT

MODEL 700™ M24

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

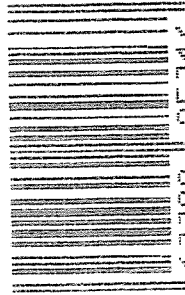
SERIAL NO.
C6594563

ORDER NO.
5716



5716 C6594563

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594563

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	CS
617	Drill and Tap Sight Holes		11/6/90	FB
618	Polish Barrel <i>RB</i>		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	<i>[Signature]</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-7-91	D/H

op. #	BARBER - M24 0019325 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3.75	3.75	3.50			1/2/91	KF
	G) Safety Off Force	2.25	2.25	2.25			1/2/91	KT
	H) Trigger Pull Test & Retainability						1-7-91	DH
	I) Firing Pin Indent	.022	.022	.021			1/2/91	KT
	J) Assemble Stock						1/15/91	KF
	K) Assemble Swivel Studs						1-17-91	JK
	L) Attach Front and Rear Sight Assemblies						1/15/91	KF
	M) Iron Sight Alignment						1/15/91	KF
	N) Detach Front & Rear Sights & place in numbered container						1/15/91	KF
	O) Attach Scope to Rifle						1/15/91	KF
	P) Detach & Attach Scope 20 Times						1/15/91	KF
640	Gallery Target & Test						1-16-91	DH
	A) Time						1-16-91	DH
	B) Malfunctions						1-16-91	DH
	C) Pierced Primers						1-16-91	DH
	D) Optical Clarity of Scope						1-16-91	DH
645	Inspect for Live Ammo						1-16-91	DH
655	Final Inspection							
	A) Headspace						1-17-91	JK
	B) Trigger Pull	2.36	2.36	2.34	2.30	2.33	1-17-91	JK
	C) Function						1-17-91	JK
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. CG594563DATE 1-4-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.47	2.33	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.24	2.33	2.36	
PULL #3	2.59	2.20	2.06	2.34	
PULL #4	2.59	2.28	2.05	2.30	
PULL #5	2.47	2.69	2.25	2.33	
TOTAL	12.74	11.88	11.02		
AVG.	2.54	2.37	2.20		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.76	3.78		
PULL #2	3.39	3.35		
PULL #3	3.10	3.14		
PULL #4	3.00	3.15		
PULL #5	3.36	3.31		
TOTAL	16.01	16.13		
AVG.	3.20	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.42		4.39
PULL #2	4.61	4.43		4.23
PULL #3	4.49	4.45		4.09
PULL #4	4.41	4.44		4.38
PULL #5	4.33	4.46		4.22
TOTAL	22.30	22.20		21.31
AVG.	4.46	4.44		4.26

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594563
17 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.446992
1 TO	2	.331879
1 TO	3	.327674
1 TO	4	.645914
1 TO	5	.571347

Sub 2 <----POA

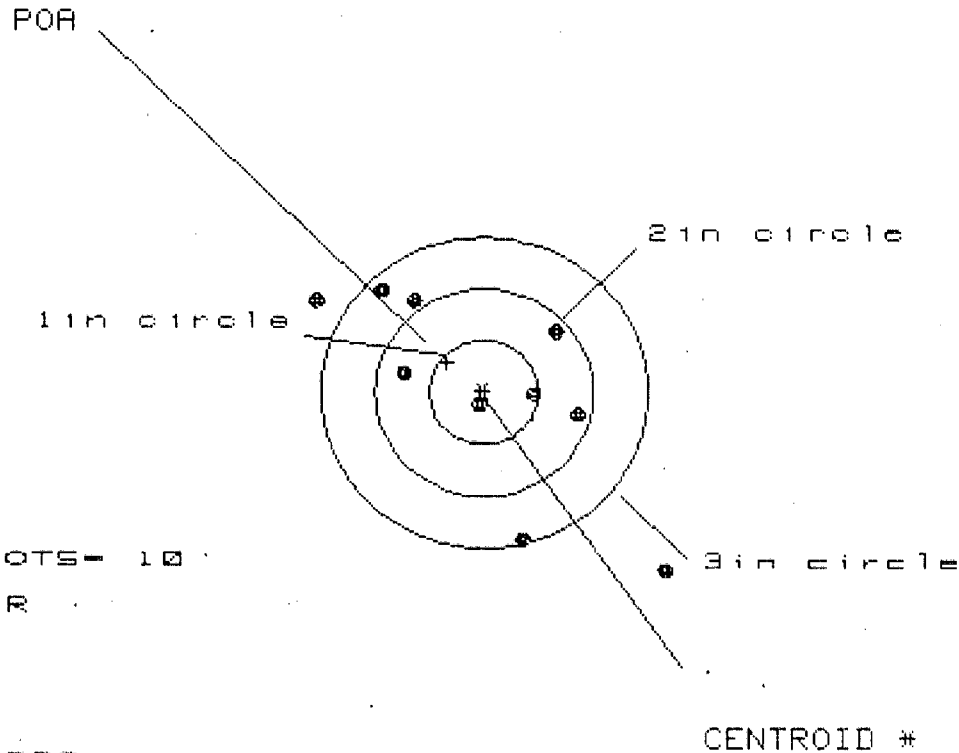
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .207
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .017
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .207697

THE AMR FOR THIS RIFLE IS: .9784

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594563

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.228

VS= 2.688

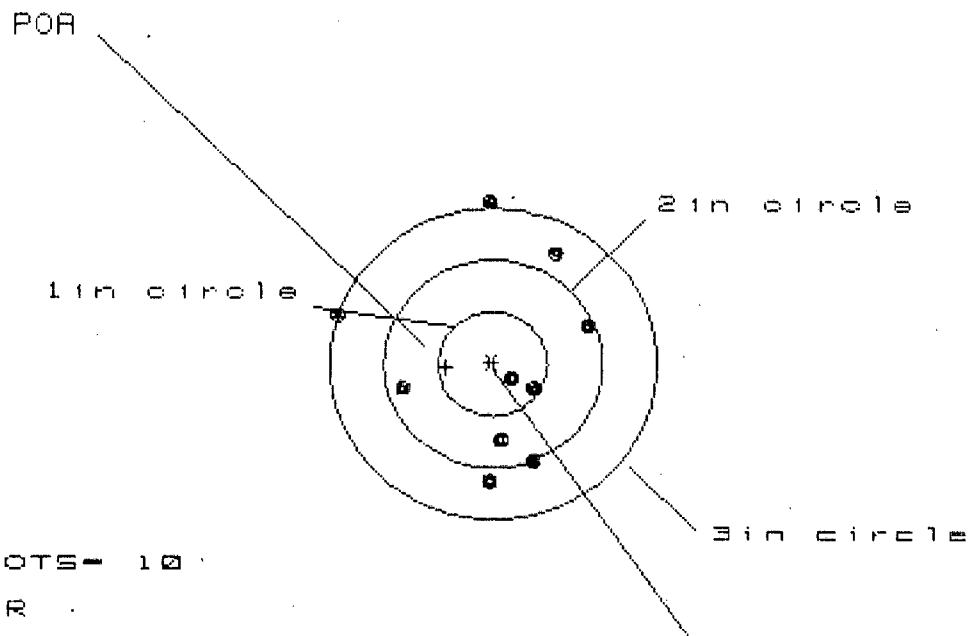
GS= 4.146

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.648	1.024	.849
MINIMUM X	-1.580	-1.396	-.925
MAXIMUM Y	.941	.747	.830
MINIMUM Y	-1.747	-1.595	-1.512
CENTROID X	.341	.157	.332
CENTROID Y	-.289	-.095	-.178
POA TO CENTROID in.	.447	.184	.377
MIN RADIUS	.095	.309	.198
MEAN RADIUS	1.111	.962	.865
MAX RADIUS	2.402	1.690	1.560
HORIZONTAL SPREAD	3.228	2.420	1.774
VERTICAL SPREAD	2.688	2.342	2.342
EXTREME SPREAD	4.146	2.985	2.683
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 5

3 in - 9

HS - 2.273

VS - 2.662

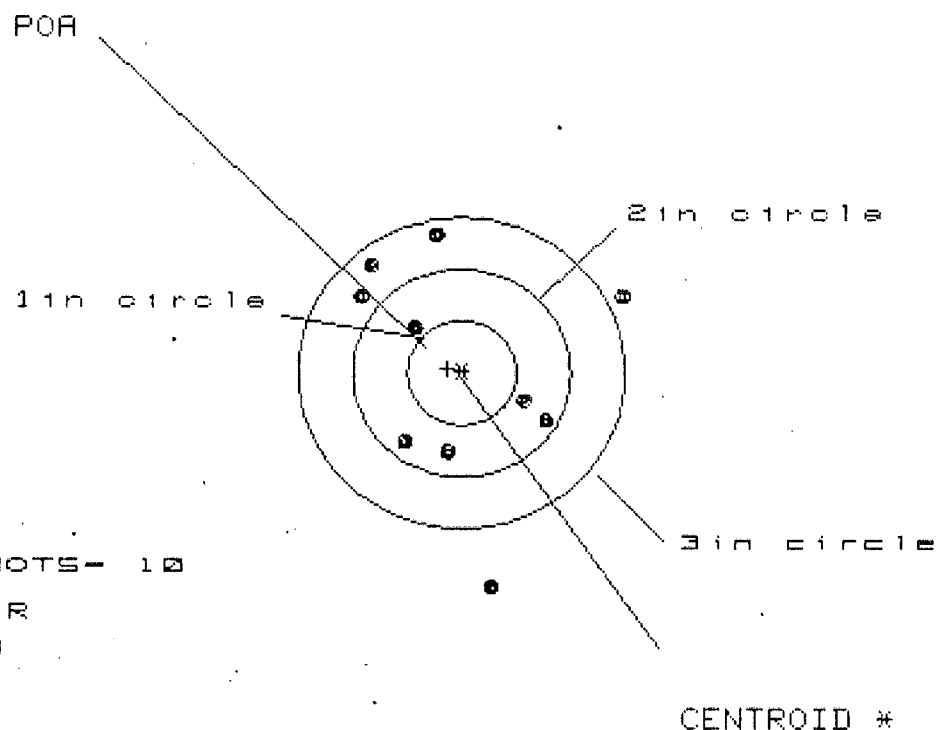
GS - 2.662

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.848	.844	.665
MINIMUM X	-1.425	-1.429	-1.010
MAXIMUM Y	1.578	1.218	1.298
MINIMUM Y	-1.084	-.909	-.829
CENTROID X	.429	.433	.612
CENTROID Y	.031	-.144	-.224
POA TO CENTROID in.	.430	.457	.652
MIN RADIUS	.192	.159	.141
MEAN RADIUS	.951	.841	.705
MAX RADIUS	1.579	1.564	1.350
HORIZONTAL SPREAD	2.273	2.273	1.675
VERTICAL SPREAD	2.662	2.127	2.127
EXTREME SPREAD	2.662	2.276	2.200
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

17 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.421

VS= 3.416

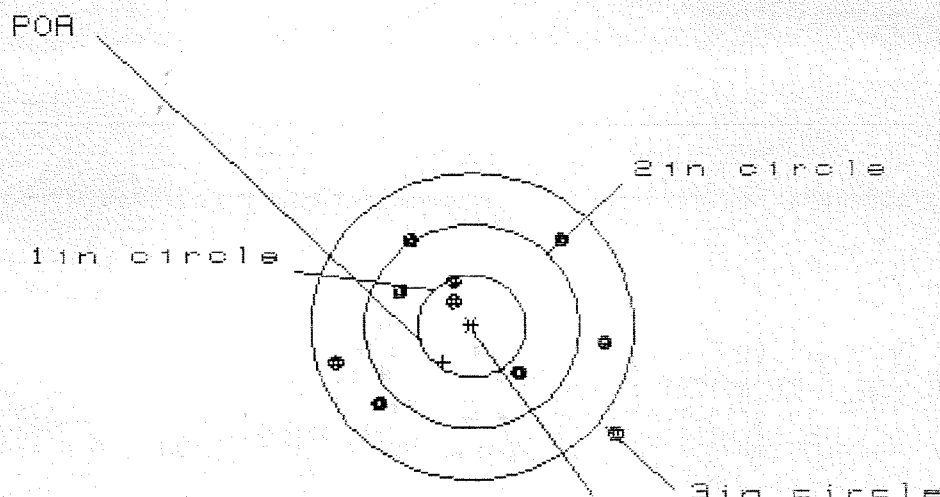
GS= 3.453

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.456
MINIMUM X	-.965
MAXIMUM Y	1.313
MINIMUM Y	-2.103
CENTROID X	.128
CENTROID Y	-.040
POA TO CENTROID in.	.134
MIN RADIUS	.585
MEAN RADIUS	1.151
MAX RADIUS	2.127
HORIZONTAL SPREAD	2.421
VERTICAL SPREAD	3.416
EXTREME SPREAD	3.453
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.662

VS = 1.845

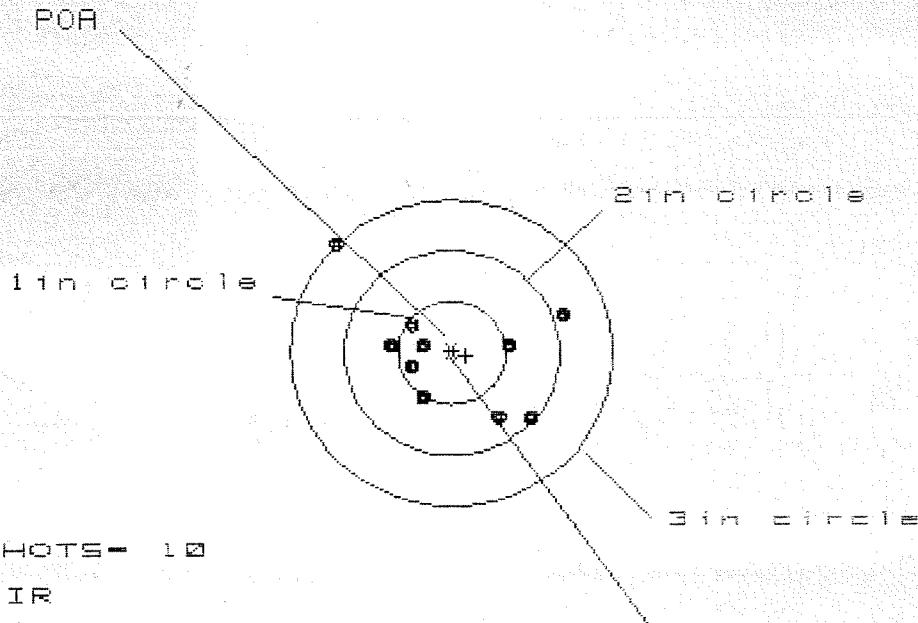
GS = 2.745

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.362	1.407	1.264
MINIMUM X	-1.300	-1.149	-0.869
MAXIMUM Y	.832	.719	.662
MINIMUM Y	-1.013	-.832	-.889
CENTROID X	.270	.119	.262
CENTROID Y	.353	.466	.523
POA TO CENTROID in.	.445	.481	.585
MIN RADIUS	.321	.142	.219
MEAN RADIUS	.984	.856	.815
MAX RADIUS	1.697	1.430	1.301
HORIZONTAL SPREAD	2.662	2.556	2.133
VERTICAL SPREAD	1.845	1.551	1.551
EXTREME SPREAD	2.745	2.564	2.314
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 2.060

VS = 1.731

GS = 2.438

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.034	.920	.692
MINIMUM X	-1.026	-.655	-.540
MAXIMUM Y	1.068	.444	.439
MINIMUM Y	-.663	-.545	-.489
CENTROID X	-.133	-.019	-.134
CENTROID Y	.030	-.088	-.144
POA TO CENTROID in.	.136	.090	.197
MIN RADIUS	.253	.411	.330
MEAN RADIUS	.695	.612	.535
MAX RADIUS	1.481	1.022	.847
HORIZONTAL SPREAD	2.060	1.575	1.232
VERTICAL SPREAD	1.731	.989	.928
EXTREME SPREAD	2.438	1.603	1.419
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	