

C6594573

MODEL 700™ M24

Model **SMS**

™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24			SERIAL NO. C6594573
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	ORDER NO. 5716



5716 C6594573



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594573

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		"	JS
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	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/31/91	RW

BARBER - M24 0019493

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/31/91	WB
	G) Safety Off Force	3	3	3			4/31/91	WB
	H) Trigger Pull Test & Retainability						1/31/91	RF
	I) Firing Pin Indent	.022	.023	.0225			4/31/91	WB
	J) Assemble Stock						2/8/91	RW
	K) Assemble Swivel Studs						2-21-91	AC
	L) Attach Front and Rear Sight Assemblies						2/8/91	RW
	M) Iron Sight Alignment						2/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/8/91	RW
	O) Attach Scope to Rifle						2/8/91	RW
	P) Detach & Attach Scope 20 Times						2/8/91	RW
640	Gallery Target & Test						2-8-91	AC
	A) Time						2-8-91	AC
	B) Malfunctions						2-8-91	AC
	C) Pierced Primers						2-8-91	AC
	D) Optical Clarity of Scope						2-8-91	AC
645	Inspect for Live Ammo						2-8-91	AC
655	Final Inspection							
	A) Headspace						2-21-91	AC
	B) Trigger Pull	2.27	2.25	2.25	2.30	2.24	2/18/91	WB
	C) Function						2-21-91	AC
660	Pack						3/14/91	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 26594573

DATE 1/31/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.22	2.30	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.33	2.33	2.25	
PULL #3	2.49	2.31	2.28	2.25	
PULL #4	2.36	2.25	2.20	2.30	
PULL #5	2.25	2.21	2.20	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.33		
PULL #2	3.21	3.33		
PULL #3	3.41	3.30		
PULL #4	3.18	3.27		
PULL #5	3.27	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.22		4.24
PULL #2	4.37	4.19		4.24
PULL #3	4.47	4.25		4.20
PULL #4	4.45	4.18		4.31
PULL #5	4.43	4.21		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594573
8 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.246781
1 TO	2	.338895
1 TO	3	.230263
1 TO	4	.0300832
1 TO	5	.425042

$\frac{5}{12}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2348
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .235755

THE AMR FOR THIS RIFLE IS: 1.074

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594573

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.242

VS= 1.962

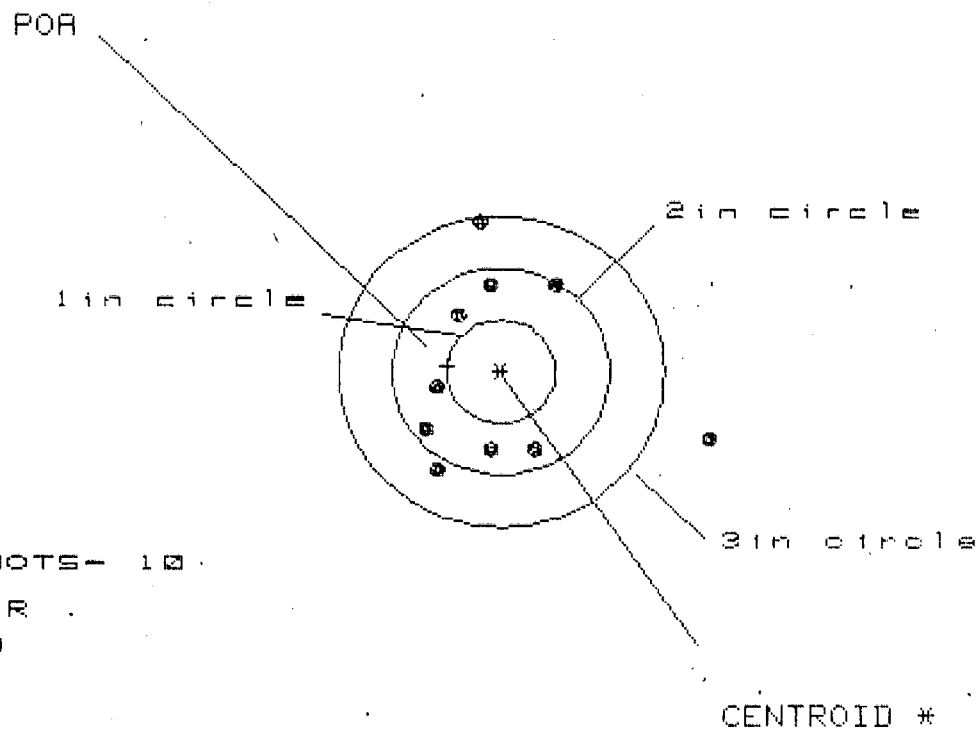
GS= 2.339

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.128	1.189	1.105
MINIMUM X	-1.114	-.989	-1.073
MAXIMUM Y	1.060	.978	.855
MINIMUM Y	-.902	-.984	-.627
CENTROID X	.174	.049	.133
CENTROID Y	-.175	-.093	.030
POA TO CENTROID in.	.247	.105	.136
MIN RADIUS	.538	.409	.349
MEAN RADIUS	.946	.885	.833
MAX RADIUS	1.345	1.244	1.131
HORIZONTAL SPREAD	2.242	2.178	2.178
VERTICAL SPREAD	1.962	1.962	1.482
EXTREME SPREAD	2.339	2.299	2.238
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6594573

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 2.542

VS= 2.392

GS= 2.959

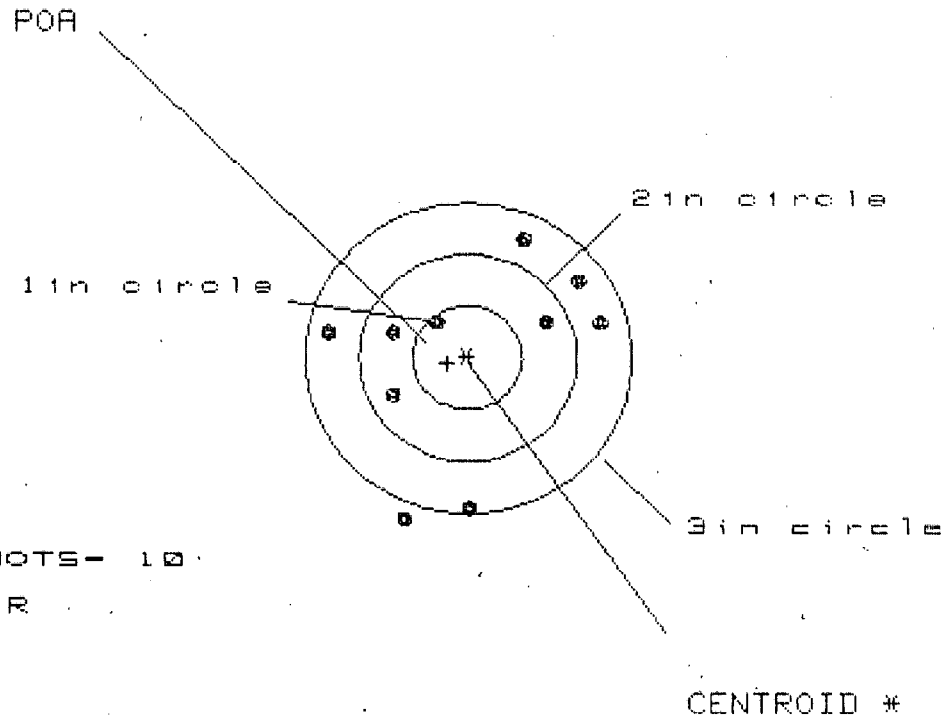
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.868	.675	.673
MINIMUM X	-.674	-.466	-.468
MAXIMUM Y	1.475	1.406	1.002
MINIMUM Y	-.917	-.986	-.811
CENTROID X	.489	.281	.283
CENTROID Y	-.050	.019	-.156
POA TO CENTROID in.	.492	.282	.323
MIN RADIUS	.632	.459	.423
MEAN RADIUS	1.022	.879	.792
MAX RADIUS	1.969	1.406	1.200
HORIZONTAL SPREAD	2.542	1.141	1.141
VERTICAL SPREAD	2.392	2.392	1.813
EXTREME SPREAD	2.959	2.415	2.071
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.526

VS= 2.714

GS= 2.920

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.189	1.182
MINIMUM X	-1.274	-1.337	-1.345
MAXIMUM Y	1.118	.941	.742
MINIMUM Y	-1.596	-1.593	-.773
CENTROID X	.185	.248	.255
CENTROID Y	.055	.232	.431
POA TO CENTROID in.	.193	.339	.501
MIN RADIUS	.462	.377	.321
MEAN RADIUS	1.086	.991	.890
MAX RADIUS	1.692	1.594	1.352
HORIZONTAL SPREAD	2.526	2.526	2.526
VERTICAL SPREAD	2.714	2.534	1.515
EXTREME SPREAD	2.920	2.585	2.529
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6594573

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS = 1.089

VS = 3.541

GS = 3.544

PATTERN #

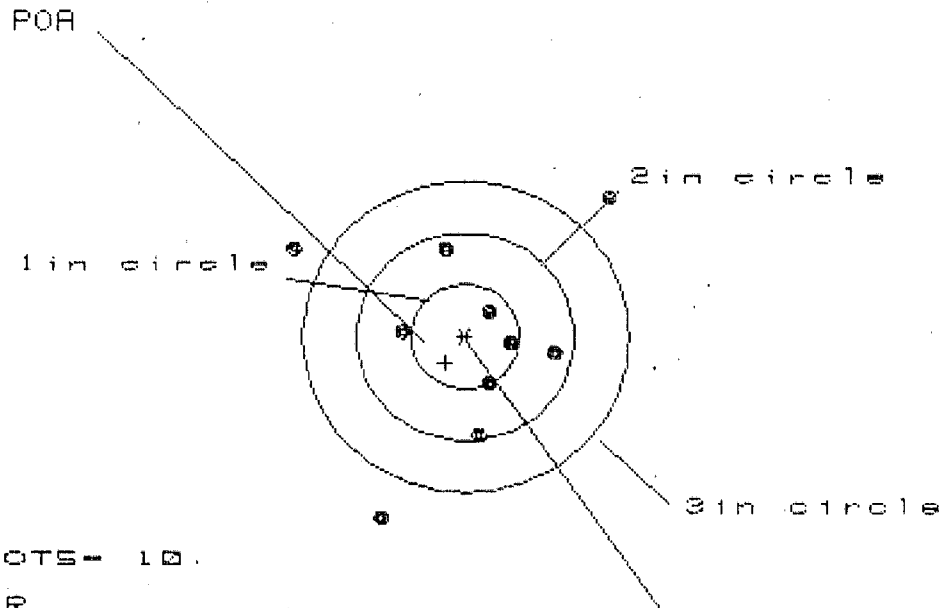
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.619	.598	.589
MINIMUM X	:	-.470	-.491	-.500
MAXIMUM Y	:	1.566	1.347	1.110
MINIMUM Y	:	-1.975	-1.892	-2.051
CENTROID X	:	.146	.167	.176
CENTROID Y	:	-.186	.033	.270
POA TO CENTROID in.	:	.237	.170	.322
MIN RADIUS	:	.645	.442	.267
MEAN RADIUS	:	1.309	1.172	.993
MAX RADIUS	:	1.984	1.894	2.098
HORIZONTAL SPREAD	:	1.089	1.089	1.089
VERTICAL SPREAD	:	3.541	3.239	3.161
EXTREME SPREAD	:	3.544	3.239	3.203
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			5	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10.

IN CIR .

1 in = 3

2 in = 7

3 in = 7

HS= 2.942

VS= 3.072

GS= 3.717

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.323
MINIMUM X	-1.619
MAXIMUM Y	1.333
MINIMUM Y	-1.739
CENTROID X	.180
CENTROID Y	.250
POA TO CENTROID in.	.308
MIN RADIUS	.325
MEAN RADIUS	1.009
MAX RADIUS	1.902
HORIZONTAL SPREAD	2.942
VERTICAL SPREAD	3.072
EXTREME SPREAD	3.717
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	7