

C6594601

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6594601
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6594601

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C'6594601

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		"	LL
617	Drill and Tap Sight Holes	1 10 91		LB
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		1/28/91	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	JA

op. #	BARBER - M24 0020054 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			2/4/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/4/91	WB
	H) Trigger Pull Test & Retainability						1/31/91	RI
	I) Firing Pin Indent	023	023	023			2/4/91	WB
	J) Assemble Stock						2/8/91	RW
	K) Assemble Swivel Studs						2-25-91	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	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-8-91	NF
655	Final Inspection							
	A) Headspace						2-25-91	AC
	B) Trigger Pull	2.46	2.47	2.47	2.51	2.60	2/25/91	RI
	C) Function						2-25-91	AC
660	Pack						3-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6594601
DATE 1/31/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.46	2.34	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.49	2.36	2.47	
PULL #3	2.18	2.45	2.25	2.47	
PULL #4	2.49	2.50	2.55	2.51	
PULL #5	2.46	2.50	2.47	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.28		
PULL #2	3.25	3.23		
PULL #3	3.42	3.33		
PULL #4	3.20	3.20		
PULL #5	3.21	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.26		4.40
PULL #2	4.36	4.14		4.29
PULL #3	4.27	4.27		4.44
PULL #4	4.37	4.25		4.47
PULL #5	4.32	4.15		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594601
9 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.175932
1 TO	2	.120337
1 TO	3	.312541
1 TO	4	.323514
1 TO	5	.584377

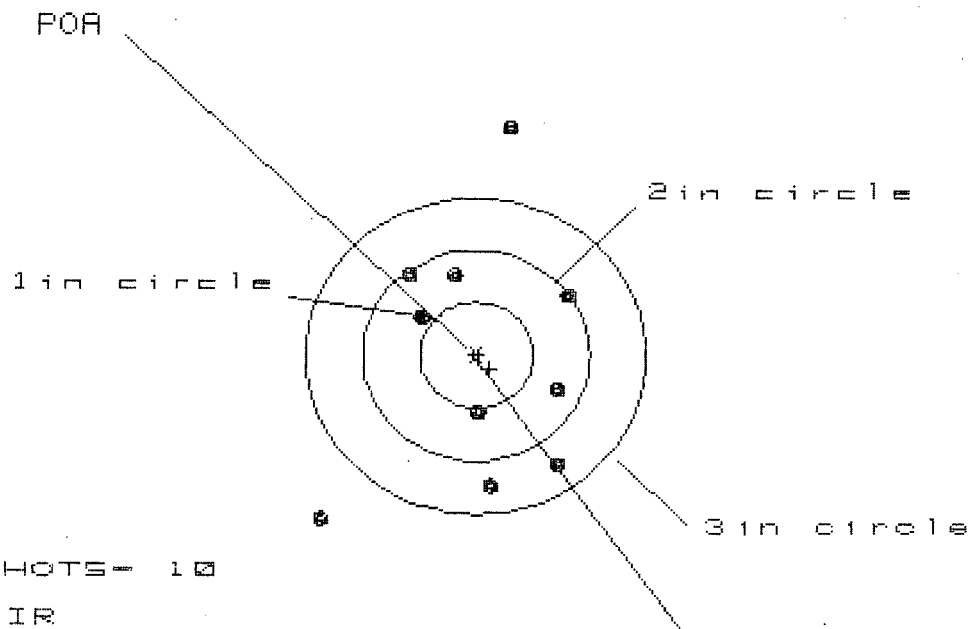
$\frac{14}{95}$ <----POA

THE AVERAGE COORDINATE OF THIS RIFLE IS: .079
THE AVERAGE Y COORDINATE OF THIS RIFLE IS: .0244
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0826823
THE AMR FOR THIS RIFLE IS: 1.059

9 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594601

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 2.162

VS= 3.647

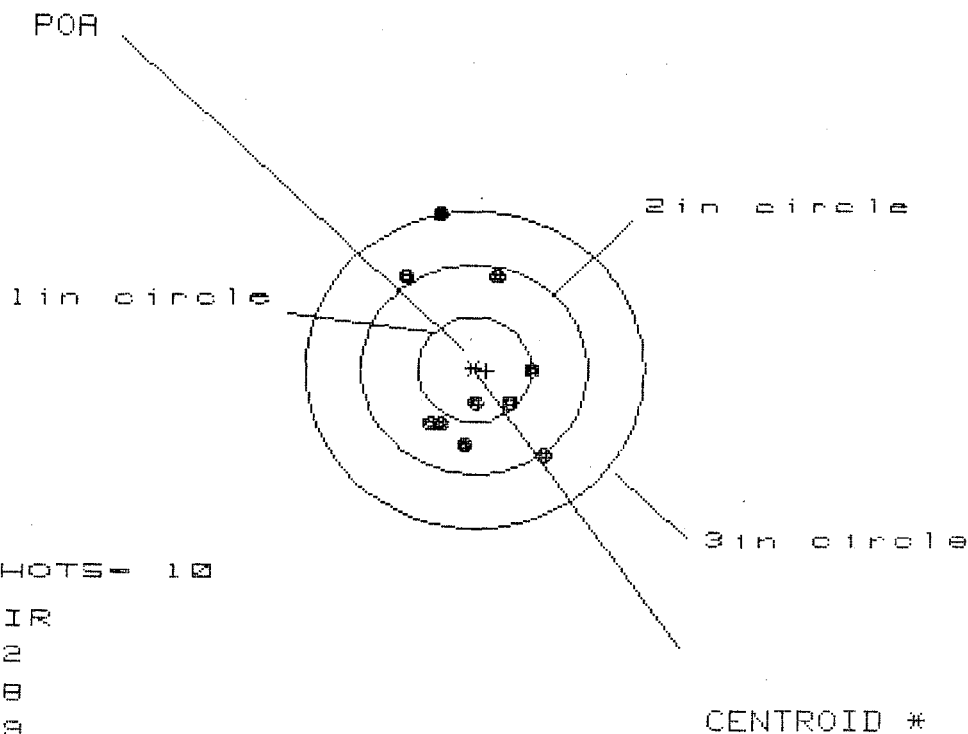
GS= 4.049

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.764	.805	.635
MINIMUM X	-1.398	-1.357	-.714
MAXIMUM Y	2.122	1.030	.869
MINIMUM Y	-1.525	-1.289	-1.161
CENTROID X	-.114	-.155	.015
CENTROID Y	.134	-.102	.059
POA TO CENTROID in.	.176	.185	.061
MIN RADIUS	.537	.306	.476
MEAN RADIUS	1.140	1.015	.888
MAX RADIUS	2.153	1.872	1.161
HORIZONTAL SPREAD	2.162	2.162	1.349
VERTICAL SPREAD	3.647	2.319	2.030
EXTREME SPREAD	4.049	3.027	2.207
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.120

VS= 2.325

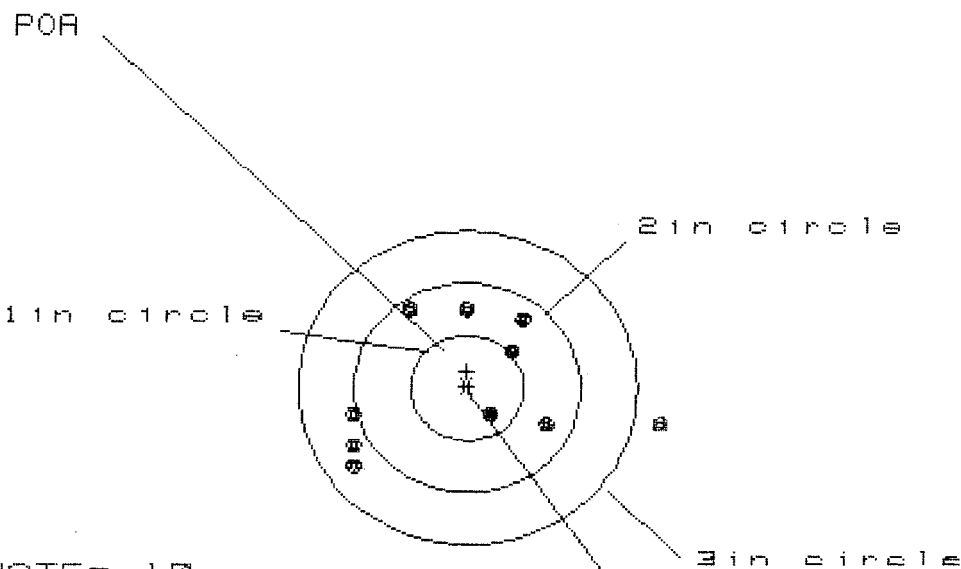
GS= 2.477

PATTERN #	2	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	.555	.522	.447	
MINIMUM X	-.565	-.598	-.536	
MAXIMUM Y	1.501	1.083	1.218	
MINIMUM Y	-.824	-.657	-.522	
CENTROID X	-.105	-.072	.003	
CENTROID Y	.014	-.153	-.288	
POA TO CENTROID in.	.106	.169	.288	
MIN RADIUS	.353	.185	.091	
MEAN RADIUS	.791	.650	.526	
MAX RADIUS	1.531	1.237	1.226	
HORIZONTAL SPREAD	1.120	1.120	.983	
VERTICAL SPREAD	2.325	1.740	1.740	
EXTREME SPREAD	2.477	2.069	1.768	
NUMBER IN ONE INCH CIRCLE =		2		
NUMBER IN TWO INCH CIRCLE =		8		
NUMBER IN THREE INCH CIRCLE =		9		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.732

VS= 1.541

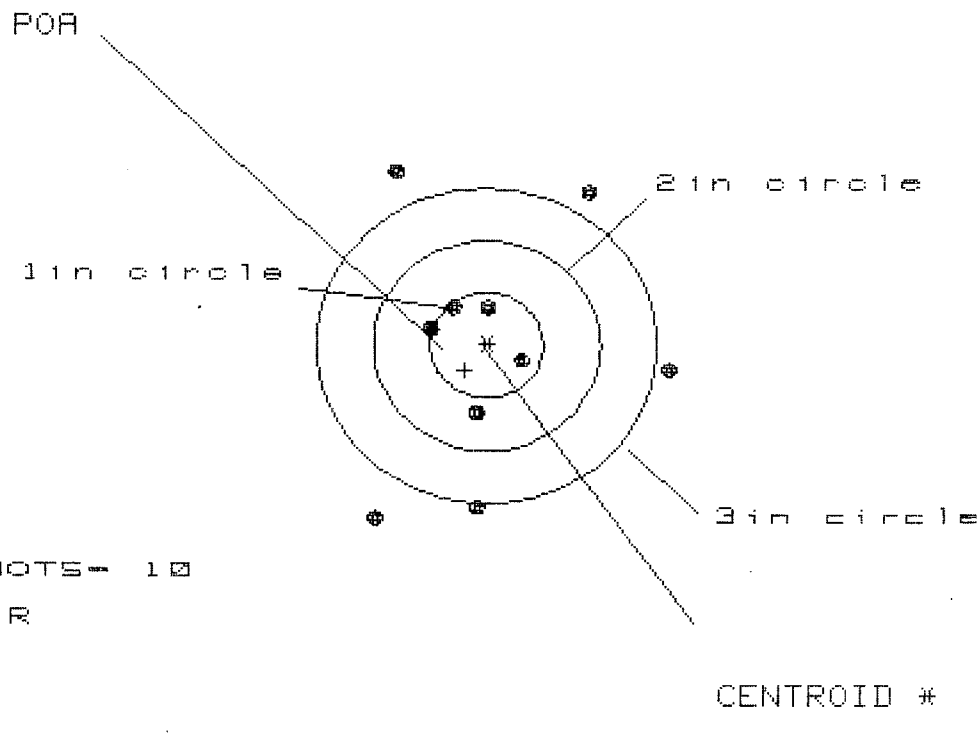
GS= 2.751

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.698	.897	.792
MINIMUM X	-1.034	-.845	-.950
MAXIMUM Y	.790	.750	.651
MINIMUM Y	-.751	-.791	-.638
CENTROID X	.005	-.184	-.079
CENTROID Y	-.155	-.115	-.016
POA TO CENTROID in.	.156	.217	.081
MIN RADIUS	.321	.469	.484
MEAN RADIUS	.937	.850	.787
MAX RADIUS	1.736	1.152	1.144
HORIZONTAL SPREAD	2.732	1.742	1.742
VERTICAL SPREAD	1.541	1.541	1.289
EXTREME SPREAD	2.751	2.117	1.963
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 5

HS = 2.587

VS = 3.292

GS = 3.535

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.636	1.545	1.415
MINIMUM X	-.951	-1.042	-.741
MAXIMUM Y	1.697	1.630	1.454
MINIMUM Y	-1.595	-1.406	-1.506
CENTROID X	.192	.283	.413
CENTROID Y	.239	.050	.226
POA TO CENTROID in.	.306	.287	.471
MIN RADIUS	.330	.244	.125
MEAN RADIUS	1.097	1.017	.906
MAX RADIUS	1.885	1.802	1.588
HORIZONTAL SPREAD	2.587	2.587	2.156
VERTICAL SPREAD	3.292	3.036	2.960
EXTREME SPREAD	3.535	3.535	3.117
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	5		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 1.910

VS= 3.942

GS= 3.971

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.729	.801	.884
MINIMUM X	:	-1.181	-1.109	-1.026
MAXIMUM Y	:	1.782	1.542	1.249
MINIMUM Y	:	-2.160	-2.344	-1.393
CENTROID X	:	.417	.345	.262
CENTROID Y	:	-.110	.130	.423
POA TO CENTROID in.	:	.431	.368	.497
MIN RADIUS	:	.567	.605	.666
MEAN RADIUS	:	1.330	1.197	1.019
MAX RADIUS	:	2.255	2.435	1.395
HORIZONTAL SPREAD	:	1.910	1.910	1.910
VERTICAL SPREAD	:	3.942	3.886	2.642
EXTREME SPREAD	:	3.971	3.909	2.673
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	