

06594633

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

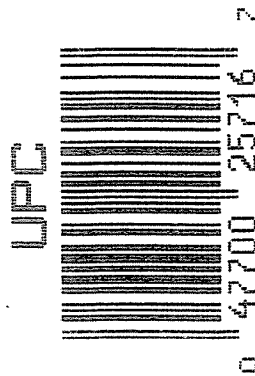
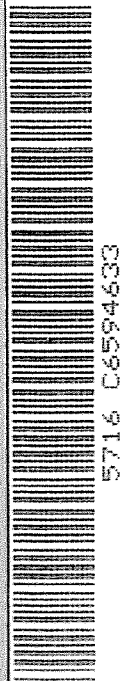
MODEL 700TM M24

SERIAL NO.
C6594633

ORDER NO.
5716

20

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594633

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		Rw
600	Proof	3 25 91		Rw
607	Check Headspace	3 25 91		Rw
610	Dis-assemble Gun	3 25 91		Rw
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		U
615	Rollmark Caliber	3 28 91		GL
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	HL

op. #	BARBER M24 0020734	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-8-91	DH
	G) Safety Off Force	3	3	3			5-8-91	DH
	H) Trigger Pull Test & Retainability						5/7/91	JH
	I) Firing Pin Indent	.020	.022	.020			5-8-91	DH
	J) Assemble Stock						5/8/91	Rw
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/8/91	Rw
	M) Iron Sight Alignment						5/8/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/8/91	Rw
	O) Attach Scope to Rifle						5/8/91	Rw
	P) Detach & Attach Scope 20 Times						5/8/91	Rw
640	Gallery Target & Test						5-8-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-8-91	AF
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.14	2.10	2.54	2.65	2.55	5/20/91	JH
	C) Function						5-21-91	DH
660	Pack						6-8-91	DH

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

SERIAL NO. C6594633DATE 5/7/91TESTER JA.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.20	2.22	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.18	2.26	2.60	
PULL #3	2.22	2.18	2.30	2.59	
PULL #4	2.22	2.18	2.19	2.55	
PULL #5	2.19	2.17	2.19	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.34		
PULL #2	3.36	3.29		
PULL #3	3.34	3.26		
PULL #4	3.37	3.29		
PULL #5	3.36	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.41		4.46
PULL #2	4.36	4.35		4.41
PULL #3	4.39	4.41		4.47
PULL #4	4.41	4.36		4.46
PULL #5	4.43	4.44		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594633
8 May 1991

CENTROIDAL DISTANCES

0 TO 1	.0777817
1 TO 2	.187115
1 TO 3	.287924
1 TO 4	.110635
1 TO 5	.146751

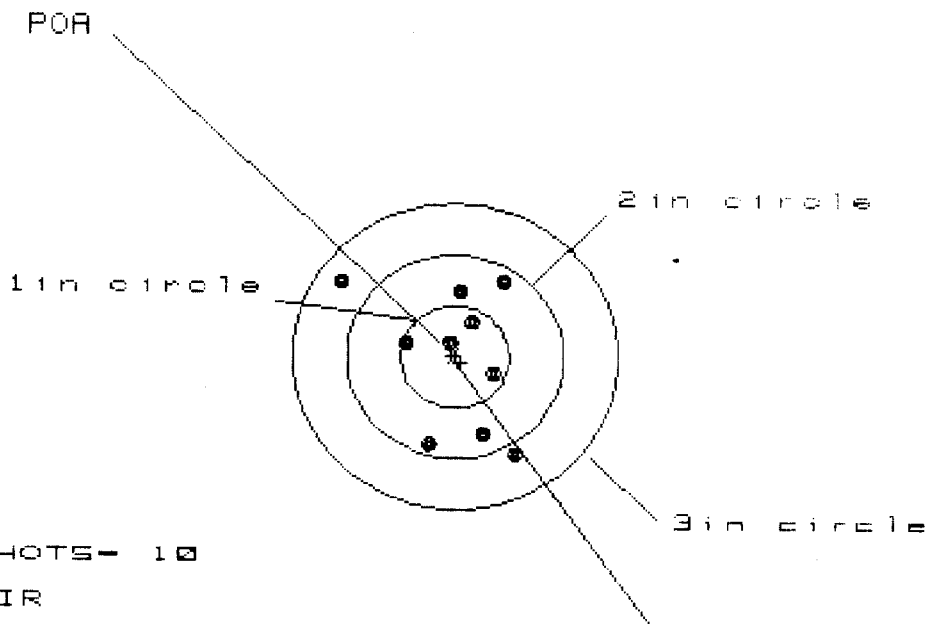
240 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0350404
THE AMR FOR THIS RIFLE IS: 1.028

May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594633

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.667

VS= 1.652

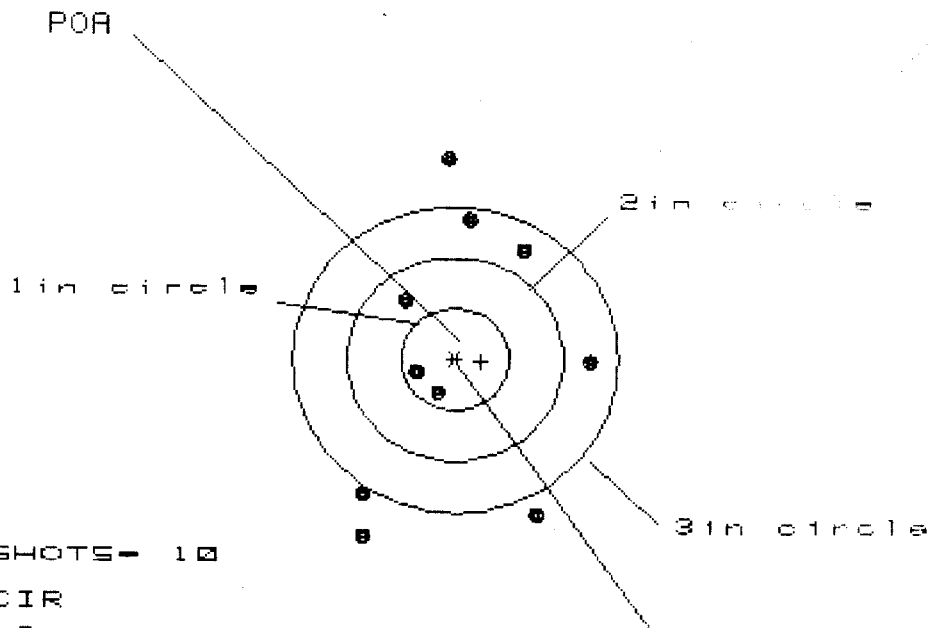
GS= 2.347

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.592	.472	.387
MINIMUM X	-1.075	-.528	-.469
MAXIMUM Y	.720	.778	.672
MINIMUM Y	-.932	-.852	-.856
CENTROID X	-.055	.065	.006
CENTROID Y	.055	-.025	.081
POA TO CENTROID in.	.077	.070	.081
MIN RADIUS	.175	.231	.171
MEAN RADIUS	.692	.626	.559
MAX RADIUS	1.294	.974	.920
HORIZONTAL SPREAD	1.667	1.000	.856
VERTICAL SPREAD	1.652	1.630	1.528
EXTREME SPREAD	2.347	1.690	1.690
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534633

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 2.120

VS= 3.683

GS= 3.782

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	1.224	1.115
MINIMUM X	:	-.895	-.896	-1.005
MAXIMUM Y	:	1.978	1.587	1.401
MINIMUM Y	:	-1.705	-1.485	-1.476
CENTROID X	:	-.239	-.238	-.129
CENTROID Y	:	.021	-.199	-.013
POA TO CENTROID in.	:	.240	.310	.130
MIN RADIUS	:	.334	.183	.377
MEAN RADIUS	:	1.243	1.146	1.078
MAX RADIUS	:	1.978	1.722	1.608
HORIZONTAL SPREAD	:	2.120	2.120	2.120
VERTICAL SPREAD	:	3.683	3.072	2.877
EXTREME SPREAD	:	3.782	3.223	2.948
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594633

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 6

HS = 2.203

VS = 4.473

GS = 4.594

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.142	1.240	1.268
MINIMUM X	-1.061	-.934	-.906
MAXIMUM Y	1.792	1.494	.975
MINIMUM Y	-2.681	-1.319	-1.133
CENTROID X	.221	.094	.066
CENTROID Y	-.027	.271	.085
POA TO CENTROID in.	.222	.287	.107
MIN RADIUS	.141	.137	.184
MEAN RADIUS	1.163	.914	.835
MAX RADIUS	2.915	1.811	1.700
HORIZONTAL SPREAD	2.203	2.174	2.174
VERTICAL SPREAD	4.473	2.813	2.108
EXTREME SPREAD	4.594	3.028	3.028
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

6 May 1991

FILE PATTERNING/CENTERFIRE_PATT/C6594633

CENTERFIRE PATTERNS

4

POA

1 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.749

VS = 4.000

GS = 4.610

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.710	1.157	.926
MINIMUM X	:	-2.039	-1.849	-.658
MAXIMUM Y	:	1.897	1.664	1.555
MINIMUM Y	:	-2.103	-1.236	-1.345
CENTROID X	:	.053	-.137	.094
CENTROID Y	:	.031	.265	.374
POA TO CENTROID in.	:	.061	.299	.385
MIN RADIUS	:	.397	.378	.126
MEAN RADIUS	:	1.313	1.132	.984
MAX RADIUS	:	2.710	2.043	1.675
HORIZONTAL SPREAD	:	3.749	3.006	1.584
VERTICAL SPREAD	:	4.000	2.900	2.900
EXTREME SPREAD	:	4.610	3.270	2.922
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594633

CENTERFIRE PATTERNS # 5

POA

1in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.500

VS = 1.233

GS = 2.531

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.841	.920
MINIMUM X	-1.493	-.787	-.682
MAXIMUM Y	.487	.516	.554
MINIMUM Y	-.747	-.717	-.679
CENTROID X	-.011	.155	.050
CENTROID Y	.195	.165	.127
POA TO CENTROID in.	.195	.227	.137
MIN RADIUS	.250	.243	.288
MEAN RADIUS	.727	.626	.594
MAX RADIUS	1.516	1.065	.962
HORIZONTAL SPREAD	2.500	1.628	1.602
VERTICAL SPREAD	1.233	1.233	1.233
EXTREME SPREAD	2.531	1.923	1.671
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594633
14 May 1991

CENTROIDAL DISTANCES

0 TO 1	.554034
1 TO 2	.318159
1 TO 3	.619242
1 TO 4	.363373
1 TO 5	.296022

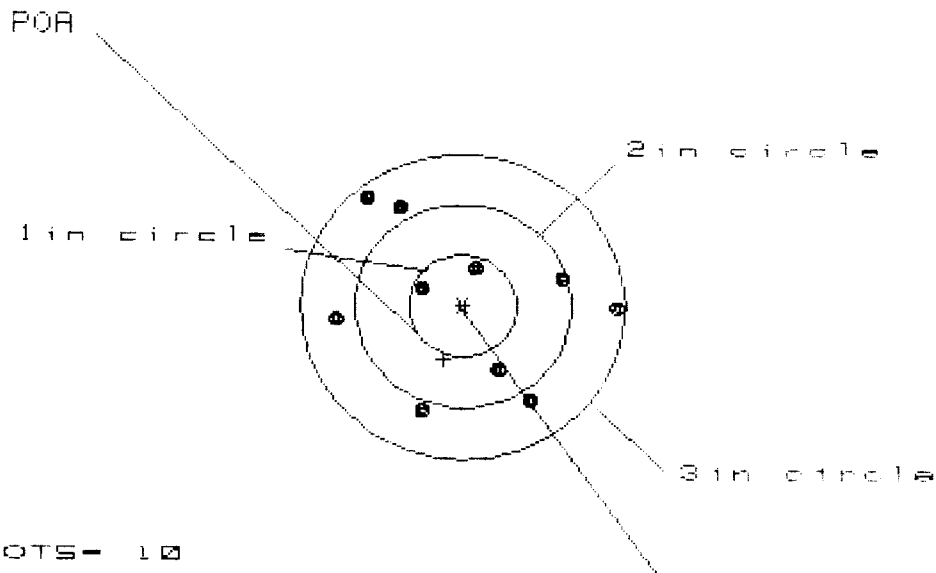
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2494
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .288329
THE AMR FOR THIS RIFLE IS: .8822

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594633.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 4

3 in = 10

HS - 2.569

VS = 2.147

GS = 2.572

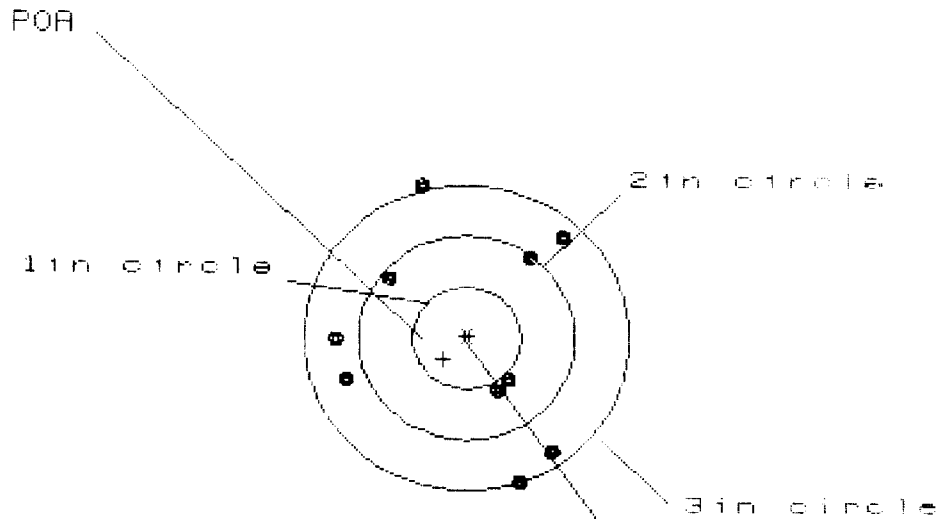
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.404	1.077	.987
MINIMUM X	-1.165	-1.009	-1.099
MAXIMUM Y	1.098	1.094	1.063
MINIMUM Y	-1.049	-1.053	-.916
CENTROID X	.177	.021	.111
CENTROID Y	.525	.529	.392
POA TO CENTROID in.	.554	.530	.408
MIN RADIUS	.403	.263	.420
MEAN RADIUS	.983	.923	.875
MAX RADIUS	1.405	1.309	1.179
HORIZONTAL SPREAD	2.569	2.086	2.086
VERTICAL SPREAD	2.147	2.147	1.980
EXTREME SPREAD	2.572	2.565	2.255
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594633.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 2.055

VS = 2.923

GS = 3.055

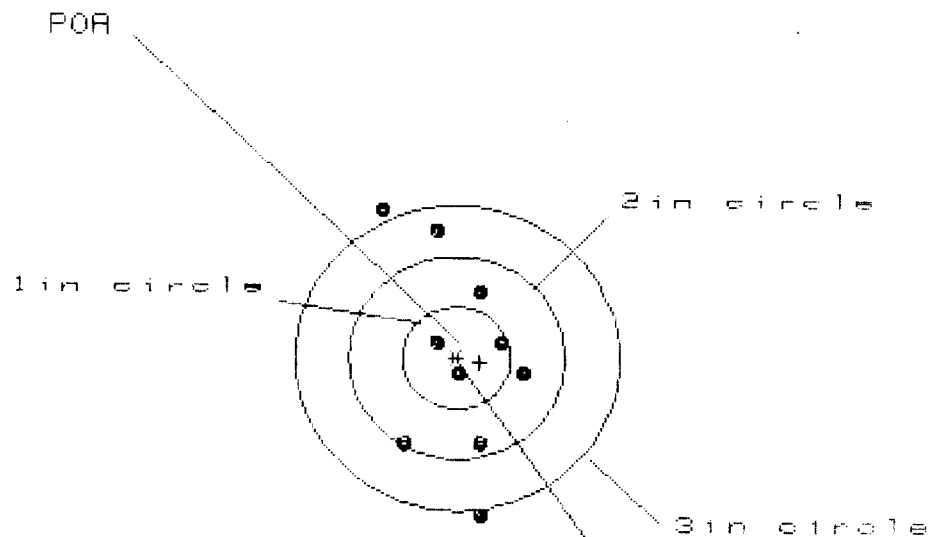
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.886	.937	.890
MINIMUM X	:	-1.169	-1.118	-1.165
MAXIMUM Y	:	1.465	1.303	1.095
MINIMUM Y	:	-1.458	-1.290	-1.127
CENTROID X	:	.214	.163	.210
CENTROID Y	:	.209	.371	.208
POA TO CENTROID in.	:	.299	.405	.295
MIN RADIUS	:	.557	.706	.559
MEAN RADIUS	:	1.108	1.058	1.003
MAX RADIUS	:	1.528	1.517	1.354
HORIZONTAL SPREAD	:	2.055	2.055	2.055
VERTICAL SPREAD	:	2.923	2.593	2.132
EXTREME SPREAD	:	3.055	2.848	2.398
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594633.1

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 3

2in - 7

3in - 8

HS= 1.329

VS= 3.024

GS= 3.153

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.639	.661	.578
MINIMUM X	:	-.690	-.668	-.595
MAXIMUM Y	:	1.438	1.262	1.208
MINIMUM Y	:	-1.586	-1.015	-.857
CENTROID X	:	-.213	-.235	-.152
CENTROID Y	:	.044	.220	.062
POA TO CENTROID in.	:	.217	.322	.164
MIN RADIUS	:	.113	.175	.149
MEAN RADIUS	:	.839	.758	.648
MAX RADIUS	:	1.599	1.428	1.240
HORIZONTAL SPREAD	:	1.329	1.329	1.173
VERTICAL SPREAD	:	3.024	2.277	2.065
EXTREME SPREAD	:	3.153	2.444	2.105
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594633.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 6

3 in - 10

HS - 1.788

VS - 1.988

GS - 2.338

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.958	.866	.780
MINIMUM X	:	-.830	-.823	-.715
MAXIMUM Y	:	.932	.815	.754
MINIMUM Y	:	-1.056	-1.056	-1.117
CENTROID X	:	.095	.187	.079
CENTROID Y	:	.171	.288	.349
POA TO CENTROID in.	:	.195	.343	.358
MIN RADIUS	:	.325	.196	.169
MEAN RADIUS	:	.797	.714	.653
MAX RADIUS	:	1.343	1.101	1.194
HORIZONTAL SPREAD	:	1.788	1.689	1.495
VERTICAL SPREAD	:	1.988	1.871	1.871
EXTREME SPREAD	:	2.338	1.960	1.960
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

14 May 1991

FILE: PATTERNING/CENTERFIRE_PATT-06534633.1

CENTERFIRE PATTERNS # 5

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 5

2 in - 7

3 in - 10

HS - 1.9000

VS = 1.686

GS = 2.344

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.714	.582	.631
MINIMUM X	-1.186	-1.134	-1.035
MAXIMUM Y	.731	.803	.692
MINIMUM Y	-.955	-.883	-.360
CENTROID X	.367	.499	.449
CENTROID Y	.298	.226	.337
FOR TO CENTROID in.	.473	.548	.562
MIN RADIUS	.101	.049	.087
MEAN RADIUS	.684	.580	.542
MAX RADIUS	1.349	1.134	1.091
HORIZONTAL SPREAD	1.900	1.716	1.716
VERTICAL SPREAD	1.686	1.686	1.052
EXTREME SPREAD	2.344	1.819	1.819
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		