

06554642

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

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

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

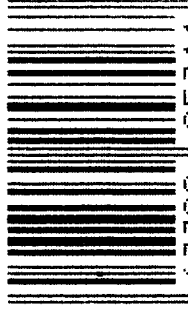
MODEL 700™ H24	SERIAL NO. C6594642
	ORDER NO. 5716

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



5716 C6594642

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594642

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/20/90	K.S.
600	Proof		12/20/90	K.S.
607	Check Headspace		12/20/90	K.S.
610	Dis-assemble Gun		12/20/90	K.S.
612	Magnaflux Barrel Action		1/9/91	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)		1-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KA
	C) Inspect Ejector Hole for Chamfer		2/4/91	KA
	D) Oil Firing Pin Ass'y		2/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/5/91	KA

op. #	BARBER M24 0020910	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			2/5/91	WB
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			2/5/91	WB
	H) Trigger Pull Test & Retainability						2/5/91	JL
	I) Firing Pin Indent	.0205	.0205	.0205			2/5/91	WB
	J) Assemble Stock						2/6/91	KA
	K) Assemble Swivel Studs						2-21-91	K
	L) Attach Front and Rear Sight Assemblies						2/6/91	KA
	M) Iron Sight Alignment						2/6/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/6/91	KA
	O) Attach Scope to Rifle						2/6/91	KA
	P) Detach & Attach Scope 20 Times						2/6/91	KA
640	Gallery Target & Test						2/7/91	KA
	A) Time						"	KA
	B) Malfunctions						"	KA
	C) Pierced Primers						"	KA
	D) Optical Clarity of Scope						"	KA
645	Inspect for Live Ammo						2/7/91	KA
655	Final Inspection							
	A) Headspace						2-21-91	K
	B) Trigger Pull	2.45	2.36	2.45	2.37	2.37	2/18/91	WB
	C) Function						2-21-91	K
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. C6594642DATE 2/5/91TESTER JLI.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.21	2.25		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.24	2.28		
PULL #3	2.42	2.23	2.24		
PULL #4	2.41	2.24	2.24		
PULL #5	2.43	2.21	2.19		
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.37		
PULL #2	3.26	3.26		
PULL #3	3.20	3.24		
PULL #4	3.27	3.23		
PULL #5	3.24	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.33		4.26
PULL #2	4.38	4.24		4.40
PULL #3	4.12	4.24		4.36
PULL #4	4.32	4.26		4.32
PULL #5	4.39	4.44		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594642
8 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.0702638
1 TO 2	.493
1 TO 3	.157813
1 TO 4	.0607289
1 TO 5	.416751

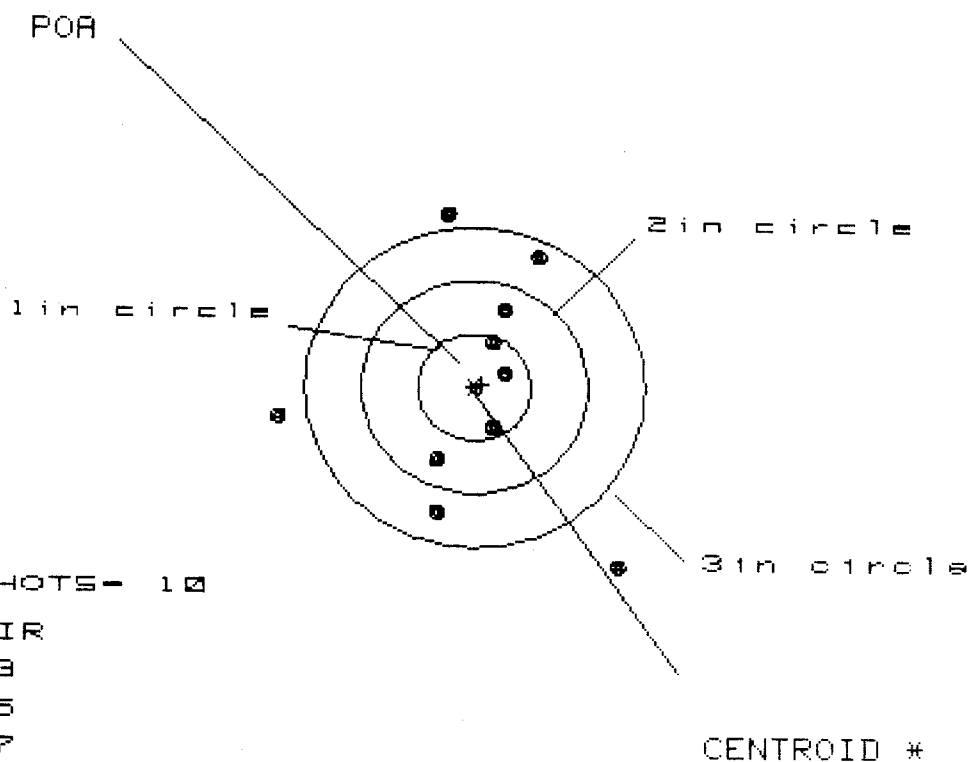
²₄₈₅ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0304
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0588
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0661937
THE AMR FOR THIS RIFLE IS: 1.115

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594642

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 5

3 in - 7

HS- 2.976

VS- 3.285

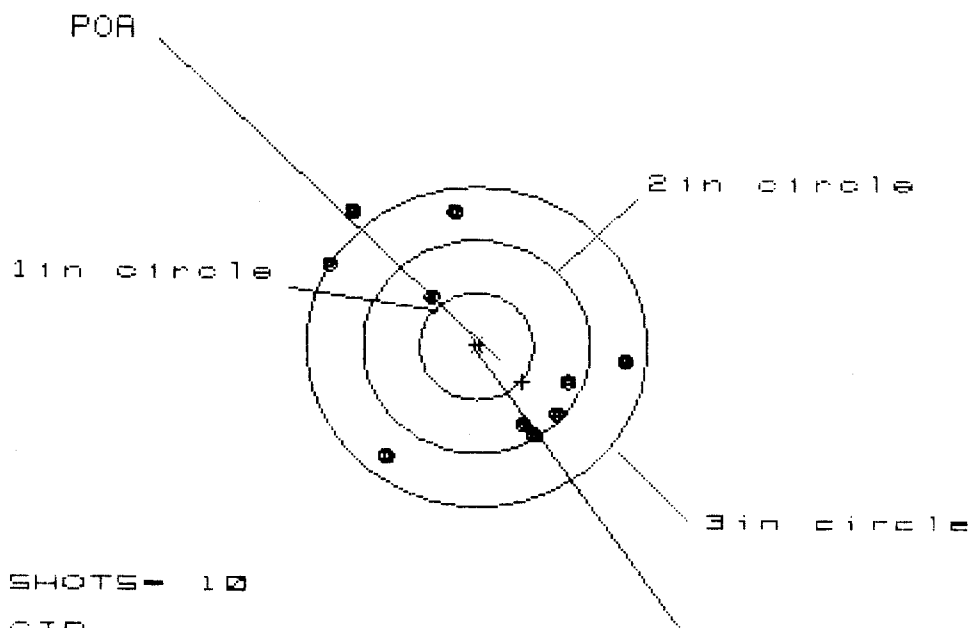
GS- 3.611

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.230	.723	.522
MINIMUM X	:	-1.746	-1.609	-.444
MAXIMUM Y	:	1.622	1.437	1.382
MINIMUM Y	:	-1.663	-1.330	-1.385
CENTROID X	:	-.064	-.201	.001
CENTROID Y	:	-.029	.156	.211
POA TO CENTROID in.	:	.070	.254	.211
MIN RADIUS	:	.333	.388	.241
MEAN RADIUS	:	1.073	.967	.822
MAX RADIUS	:	2.069	1.669	1.455
HORIZONTAL SPREAD	:	2.976	2.332	.965
VERTICAL SPREAD	:	3.285	2.767	2.767
EXTREME SPREAD	:	3.611	2.769	2.769
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 0

2in - 4

3in - 8

HS- 2.635

VS- 2.350

GS- 2.777

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.291	1.171	.988
MINIMUM X	:	-1.344	-1.464	-1.074
MAXIMUM Y	:	1.283	1.419	1.528
MINIMUM Y	:	-1.067	-.931	-.822
CENTROID X	:	-.404	-.284	-.101
CENTROID Y	:	.328	.192	.083
POA TO CENTROID in.	:	.521	.343	.131
MIN RADIUS	:	.621	.637	.461
MEAN RADIUS	:	1.139	1.047	.901
MAX RADIUS	:	1.634	1.703	1.615
HORIZONTAL SPREAD	:	2.635	2.635	2.062
VERTICAL SPREAD	:	2.350	2.350	2.350
EXTREME SPREAD	:	2.777	2.777	2.414
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 1

2in - 3

3in = 7

HS= 3.305

VS= 3.408

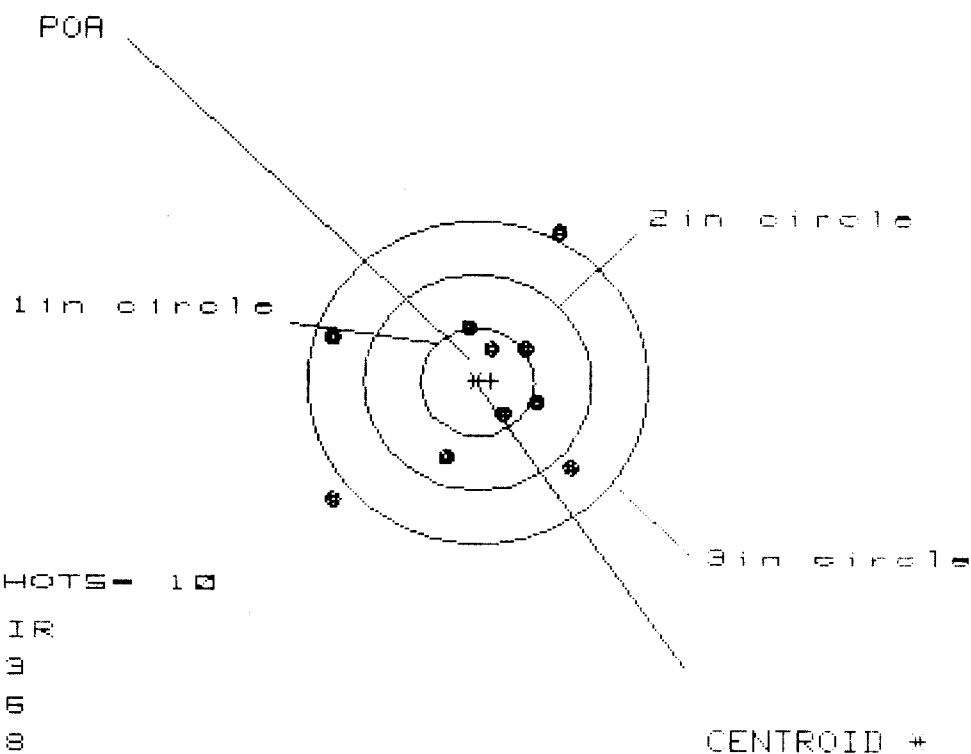
GS= 4.177

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.354	1.878	1.801
MINIMUM X	:	-.951	-.689	-.766
MAXIMUM Y	:	2.014	1.943	1.227
MINIMUM Y	:	-1.394	-1.465	-1.222
CENTROID X	:	.093	-.169	-.092
CENTROID Y	:	-.045	.026	-.217
POA TO CENTROID in.	:	.103	.171	.236
MIN RADIUS	:	.229	.058	.268
MEAN RADIUS	:	1.372	1.190	1.075
MAX RADIUS	:	2.438	2.120	2.179
HORIZONTAL SPREAD	:	3.305	2.567	2.567
VERTICAL SPREAD	:	3.408	3.408	2.449
EXTREME SPREAD	:	4.177	3.598	3.029
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.051

VS= 2.438

GS= 3.144

CENTROID +

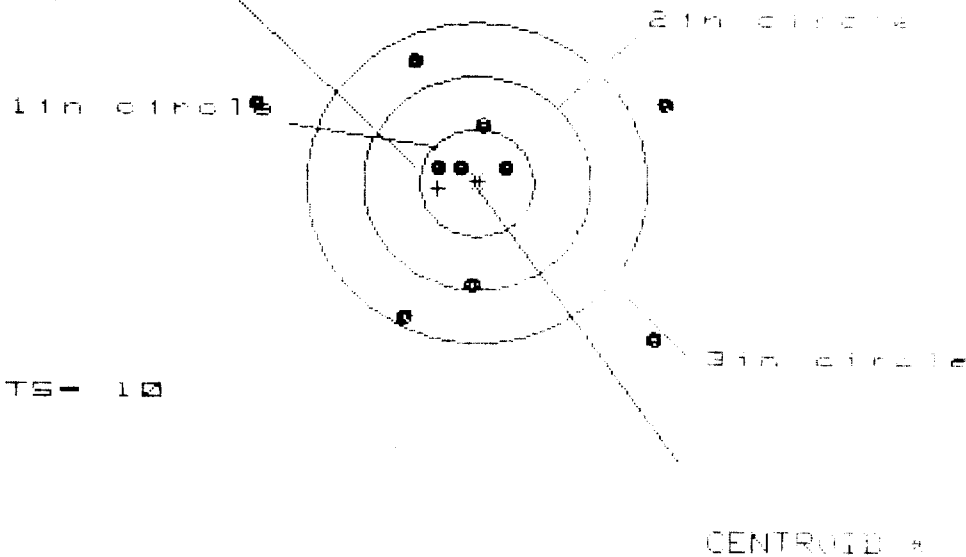
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.789	.652	.730
MINIMUM X	:	-1.262	-1.399	-1.321
MAXIMUM Y	:	1.393	1.277	.522
MINIMUM Y	:	-1.045	-.913	-.754
CENTROID X	:	-.122	.015	-.063
CENTROID Y	:	-.011	.105	-.054
POA TO CENTROID in.	:	.122	.106	.083
MIN RADIUS	:	.372	.243	.362
MEAN RADIUS	:	.871	.756	.678
MAX RADIUS	:	1.613	1.437	1.409
HORIZONTAL SPREAD	:	2.051	2.051	2.051
VERTICAL SPREAD	:	2.438	2.190	1.276
EXTREME SPREAD	:	3.144	2.399	2.399
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 5

3 in - 7

HS- 3.585

VS- 2.632

GS- 4.118

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.683

1.861

1.646

MINIMUM X

:

-1.902

-1.724

-1.667

MAXIMUM Y

:

1.189

1.029

1.099

MINIMUM Y

:

-1.443

-1.442

-1.372

CENTROID X

:

.345

.167

.382

CENTROID Y

:

.051

.211

.141

POA TO CENTROID in.

:

.349

.269

.407

MIN RADIUS

:

.179

.072

.155

MEAN RADIUS

:

1.119

.963

.658

MAX RADIUS

:

2.156

1.965

1.738

HORIZONTAL SPREAD

:

3.585

3.585

2.313

VERTICAL SPREAD

:

2.632

2.471

2.471

EXTREME SPREAD

:

4.118

3.586

2.195

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7

BARBER - M24 M2400020957

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6594642DATE 11-1-95TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.22	2.61	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.44	2.23	
PULL #3	2.35	2.58	2.38	
PULL #4	2.38	2.62	2.43	
PULL #5	2.42	2.61	2.49	
TOTAL	11.60	12.86	11.97	
AVG.	2.32	2.57	2.39	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.08	2.90	
PULL #2	3.00	3.09	
PULL #3	3.05	3.11	
PULL #4	2.90	2.90	
PULL #5	2.92	2.96	
TOTAL	14.95	14.96	
AVG.	2.99	2.99	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	3.90	4.01	
PULL #2	4.00	3.85	4.02	
PULL #3	3.92	3.80	4.00	
PULL #4	4.00	3.85	4.05	
PULL #5	4.02	3.87	4.00	
TOTAL	20.00	19.27	20.08	
AVG.	4.00	3.85	4.01	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594642

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/4			12/14	WB
	G) Safety Off Force	3 1/2	3	3			12/14	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.31	2.24	2.31	2.33	2.33	12/14	WB
	C) Function							
660	Pack							