

C6594664

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smead®

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.
C6594664

ORDER NO.
5716

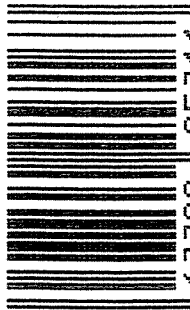
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

46



5716 C6594664

UPC



0 47700 25716 7

GUN SERIAL # C6594664

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 16 91	RW
600	Proof		1 16 91	RW
607	Check Headspace		1 16 91	RW
610	Dis-assemble Gun		1 16 91	RW
612	Magnaflux Barrel Action		1 18 91	KR
	Magnaflux Bolt		1 18 91	KR
615	Rollmark Caliber		1 18 91	LS
617	Drill and Tap Sight Holes		1 24 91	FB
618	Polish Barrel		1 24 91	WB
620	Apply Coatings (Barrel Action)		2-15-91	PH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/6/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/6/91	RW
	C) Inspect Ejector Hole for Chamfer		3/6/91	RW
	D) Oil Firing Pin Ass'y		3/6/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/91	PH

625 cont.	F) Safety On Force	4 1/4	4	4	3-11-91	DH		
	G) Safety Off Force	3	3	3	3-11-91	DH		
	H) Trigger Pull Test & Retainability				3/8/91	JH		
	I) Firing Pin Indent	.020	.020	.021	3-11-91	DH		
	J) Assemble Stock				4/3/91	Rw		
	K) Assemble Swivel Studs				4-10-91	DH		
	L) Attach Front and Rear Sight Assemblies				4/3/91	Rw		
	M) Iron Sight Alignment				4/3/91	Rw		
	N) Detach Front & Rear Sights & place in numbered container				4/3/91	Rw		
	O) Attach Scope to Rifle				4/3/91	Rw		
	P) Detach & Attach Scope 20 Times				4/3/91	Rw		
640	Gallery Target & Test				4-8-91	AC		
	A) Time				4-8-91	AC		
	B) Malfunctions				4-8-91	AC		
	C) Pierced Primers				4-8-91	AC		
	D) Optical Clarity of Scope				4-8-91	AC		
645	Inspect for Live Ammo				4-8-91	AC		
655	Final Inspection				4-10-91	DH		
	A) Headspace							
	B) Trigger Pull	2.41	2.51	2.42	2.52	2.46	4/10/91	JH
	C) Function						4-10-91	DH
660	Pack						6-19-91	W-

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594664

DATE 3-8-91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.36	2.38	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.32	2.36	2.51	
PULL #3	2.37	2.33	2.34	2.42	
PULL #4	2.38	2.35	2.34	2.52	
PULL #5	2.34	2.34	2.35	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.37		
PULL #2	3.47	3.38		
PULL #3	3.43	3.40		
PULL #4	3.41	3.39		
PULL #5	3.37	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	4.22	4.27		4.26
PULL #2	4.27	4.25		4.27
PULL #3	4.26	4.25		4.28
PULL #4	4.24	4.25		4.28
PULL #5	4.25	4.25		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594664
8 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.419634
1 TO 2	.343281
1 TO 3	.274563
1 TO 4	.511682
1 TO 5	.288295

σ^2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214909
THE AMR FOR THIS RIFLE IS: .8844

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594684

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 3.166

VS= 2.786

GS= 3.883

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.772	1.617	.937
MINIMUM X	:	-1.394	-1.076	-.874
MAXIMUM Y	:	1.049	.856	.896
MINIMUM Y	:	-1.737	-.930	-.890
CENTROID X	:	.418	.573	.371
CENTROID Y	:	.037	.230	.190
POA TO CENTROID in.	:	.420	.618	.417
MIN RADIUS	:	.187	.263	.058
MEAN RADIUS	:	1.037	.881	.751
MAX RADIUS	:	2.228	1.648	1.292
HORIZONTAL SPREAD	:	3.166	2.693	1.811
VERTICAL SPREAD	:	2.786	1.786	1.786
EXTREME SPREAD	:	3.883	2.734	2.033
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

2

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 1

2in - 7

3in = 10

HS= 2.050

VS= 2.052

GS= 2.531

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.613	.453	.504
MINIMUM X	:	-1.437	-1.061	-1.004
MAXIMUM Y	:	.870	.903	.759
MINIMUM Y	:	-1.182	-1.149	-.561
CENTROID X	:	.327	.487	.430
CENTROID Y	:	-.294	-.327	-.183
POR TO CENTROID in.	:	.440	.586	.468
MIN RADIUS	:	.269	.237	.368
MEAN RADIUS	:	.816	.698	.656
MAX RADIUS	:	1.468	1.378	1.245
HORIZONTAL SPREAD	:	2.050	1.514	1.508
VERTICAL SPREAD	:	2.052	2.052	1.320
EXTREME SPREAD	:	2.531	2.531	1.880
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 0

2in - 4

3in - 10

HS= 2.491

VS= 2.572

GS= 2.731

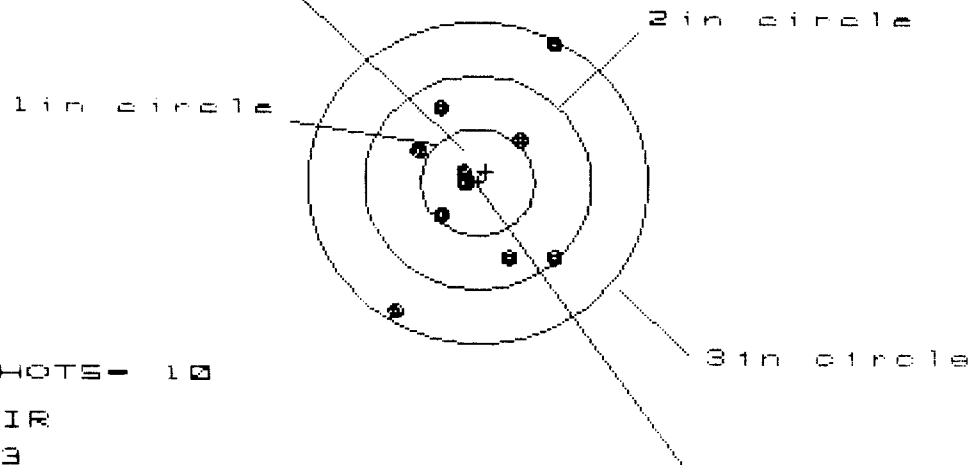
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.323	1.241	1.253
MINIMUM X	:	-1.168	-1.250	-1.238
MAXIMUM Y	:	1.228	1.132	.981
MINIMUM Y	:	-1.344	-1.208	-.642
CENTROID X	:	.166	.247	.235
CENTROID Y	:	.146	.010	.161
POA TO CENTROID in.	:	.221	.247	.284
MIN RADIUS	:	.588	.468	.533
MEAN RADIUS	:	1.074	1.019	.994
MAX RADIUS	:	1.431	1.292	1.254
HORIZONTAL SPREAD	:	2.491	2.491	2.491
VERTICAL SPREAD	:	2.572	2.340	1.623
EXTREME SPREAD	:	2.731	2.491	2.491
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4

POR



OF SHOTS - 10

IN CIR

1in - 3

2in - 8

3in = 10

HS - 1.437

VS = 2.505

GS = 2.888

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.709	.725	.644
MINIMUM X	:	-.728	-.649	-.497
MAXIMUM Y	:	1.322	.804	.674
MINIMUM Y	:	-1.183	-1.036	-.697
CENTROID X	:	-.075	-.154	-.073
CENTROID Y	:	-.100	-.247	-.117
POR TO CENTROID in.	:	.125	.291	.138
MIN RADIUS	:	.098	.186	.108
MEAN RADIUS	:	.724	.642	.547
MAX RADIUS	:	1.500	1.223	.949
HORIZONTAL SPREAD	:	1.437	1.374	1.141
VERTICAL SPREAD	:	2.505	1.840	1.371
EXTREME SPREAD	:	2.888	1.969	1.662
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in = 10

HS= 1.609

VS= 1.971

GS= 2.204

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.904	.887	.901
MINIMUM X	:	-.705	-.605	-.591
MAXIMUM Y	:	1.119	1.226	.698
MINIMUM Y	:	-.852	-.745	-.592
CENTROID X	:	.183	.083	.069
CENTROID Y	:	-.130	-.237	-.390
POA TO CENTROID in.	:	.224	.251	.396
MIN RADIUS	:	.275	.348	.321
MEAN RADIUS	:	.771	.698	.617
MAX RADIUS	:	1.322	1.231	.950
HORIZONTAL SPREAD	:	1.609	1.492	1.492
VERTICAL SPREAD	:	1.971	1.971	1.290
EXTREME SPREAD	:	2.204	2.002	1.540
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	