

06587514

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

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

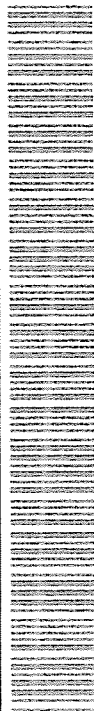
DUPONT

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

MODEL 700TM M24

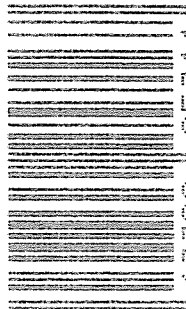
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. 06587514	ORDER NO. 5716
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5716 06587514

UPC



0 47700 25716

2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587514

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel AB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	W

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4	4	4	1-14-91	WB
	G) Safety Off Force	2	2	2	2	2	1-14-91	WB
	H) Trigger Pull Test & Retainability						1-3-91	JH
	I) Firing Pin Indent	.0225	.022	.022	.022	.022	1-3-91	WB
	J) Assemble Stock						1/14/91	RW
	K) Assemble Swivel Studs						1-17-91	JH
	L) Attach Front and Rear Sight Assemblies						1/14/91	RW
	M) Iron Sight Alignment						1/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/14/91	RW
	O) Attach Scope to Rifle						1/14/91	RW
	P) Detach & Attach Scope 20 Times						1/14/91	RW
640	Gallery Target & Test						1-15-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						1-16-91	RF
655	Final Inspection							
	A) Headspace						1-17-91	JH
	B) Trigger Pull	2.24	2.22	2.29	2.20	2.15	1-17-91	JH
	C) Function						1-17-91	JH
660	Pack						3-19-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587514DATE 1-3-98TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.35	2.36	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.34	2.30	2.22	
PULL #3	2.11	2.38	2.40	2.29	
PULL #4	2.30	2.25	2.25	2.20	
PULL #5	2.22	2.36	2.38	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.29		
PULL #2	3.46	3.28		
PULL #3	3.45	3.24		
PULL #4	3.38	3.25		
PULL #5	3.31	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	4.31	4.29		4.43
PULL #2	4.31	4.21		4.24
PULL #3	4.34	4.32		4.31
PULL #4	4.40	4.20		4.36
PULL #5	4.36	4.25		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587514
17 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.319006
1 TO 2	.316092
1 TO 3	.223143
1 TO 4	.280573
1 TO 5	.162929

3
4

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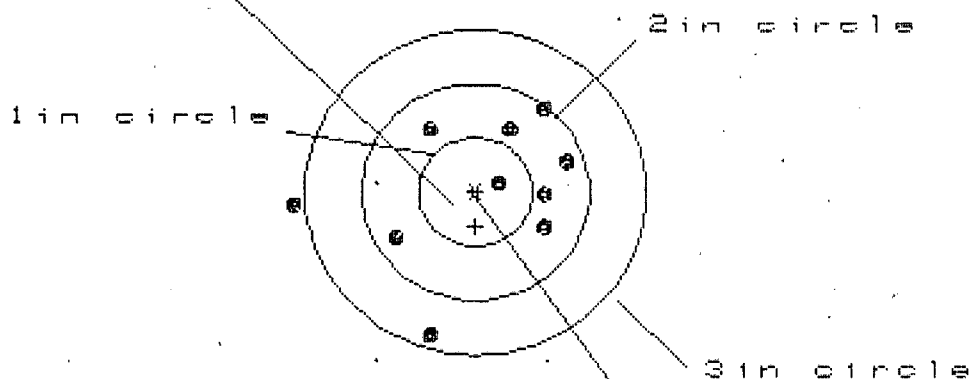
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.029
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .208427
THE AMR FOR THIS RIFLE IS: 1.015

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587514

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.319

VS= 2.104

GS= 2.373

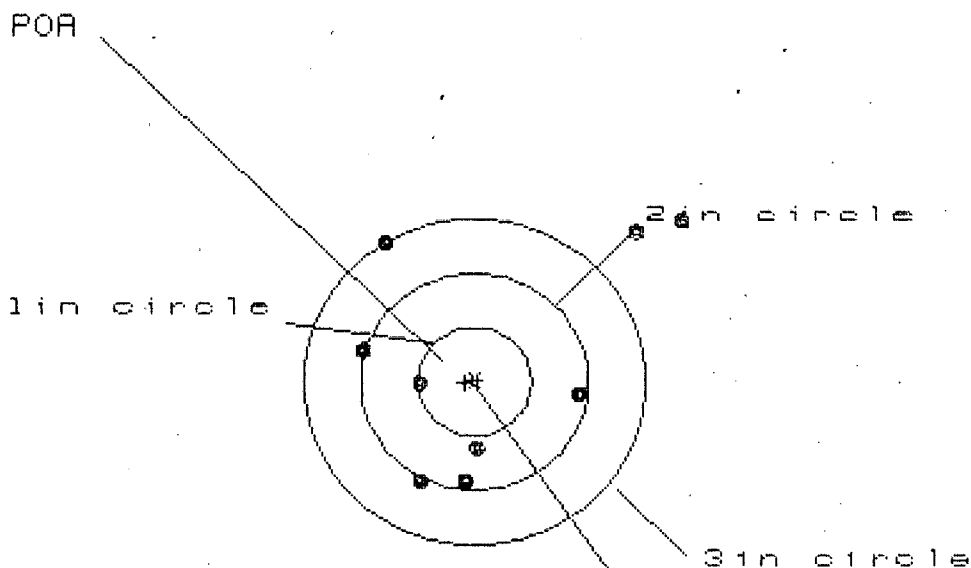
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.593	.521
MINIMUM X	:	-1.553	-.894	-.966
MAXIMUM Y	:	.778	.762	.594
MINIMUM Y	:	-1.326	-1.342	-.628
CENTROID X	:	-.002	.171	.243
CENTROID Y	:	.319	.335	.503
POA TO CENTROID in.	:	.319	.376	.558
MIN RADIUS	:	.202	.085	.108
MEAN RADIUS	:	.841	.712	.582
MAX RADIUS	:	1.560	1.460	1.152
HORIZONTAL SPREAD	:	2.319	1.487	1.487
VERTICAL SPREAD	:	2.104	2.104	1.222
EXTREME SPREAD	:	2.373	2.345	1.825
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587514

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.178

VS= 3.433

GS= 4.678

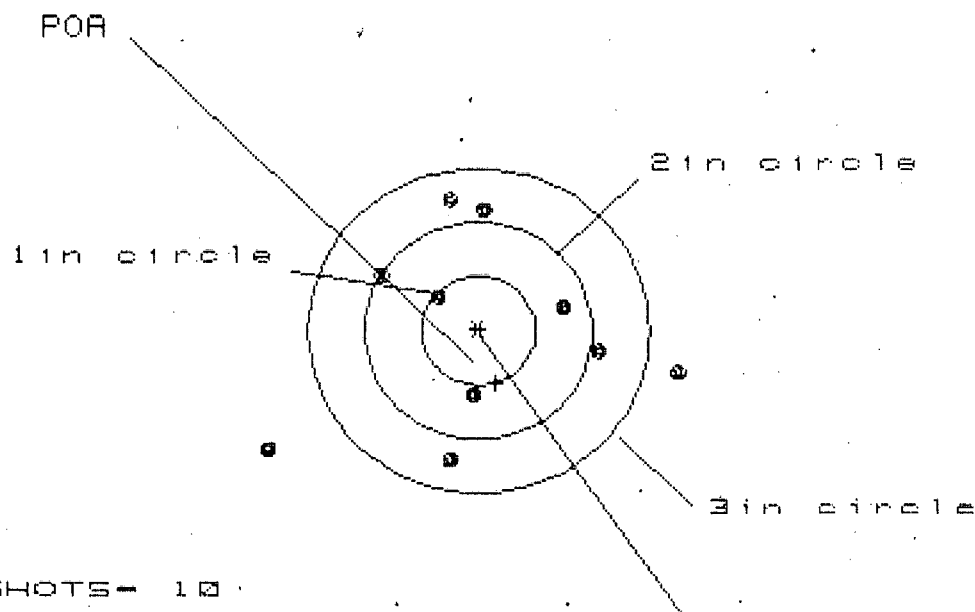
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.790	1.635	1.449
MINIMUM X	-1.388	-1.093	-.888
MAXIMUM Y	1.499	1.285	1.354
MINIMUM Y	-1.934	-1.128	-.968
CENTROID X	.081	.236	.031
CENTROID Y	.014	.228	.068
POA TO CENTROID in.	.082	.328	.075
MIN RADIUS	.460	.660	.417
MEAN RADIUS	1.301	1.220	1.038
MAX RADIUS	2.380	2.080	1.983
HORIZONTAL SPREAD	3.178	2.728	2.337
VERTICAL SPREAD	3.433	2.413	2.322
EXTREME SPREAD	4.678	3.277	2.952
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 3.610

VS = 2.398

GS = 3.687

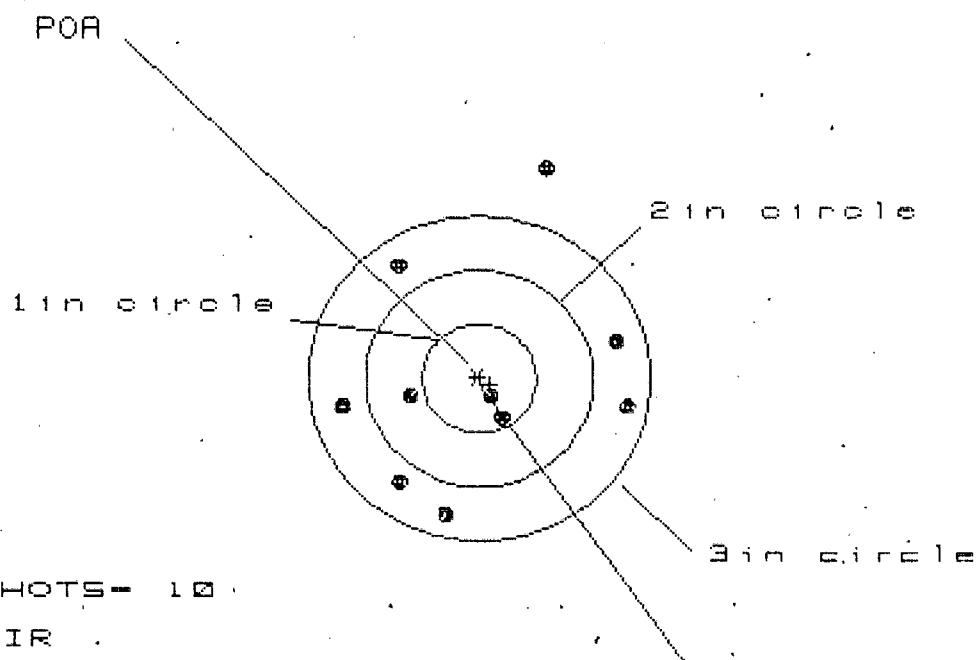
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.746	1.539	1.046
MINIMUM X	-1.864	-1.105	-.912
MAXIMUM Y	1.242	1.121	1.063
MINIMUM Y	-1.156	-1.277	-1.335
CENTROID X	-.150	.057	-.136
CENTROID Y	.486	.607	.665
POA TO CENTROID in.	.509	.610	.678
MIN RADIUS	.461	.591	.390
MEAN RADIUS	1.151	1.025	.931
MAX RADIUS	2.158	1.607	1.366
HORIZONTAL SPREAD	3.610	2.644	1.958
VERTICAL SPREAD	2.398	2.398	2.398
EXTREME SPREAD	3.687	2.766	2.398
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6587514

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 9

HS= 2.576

VS= 3.181

GS= 3.308

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.326	1.395	1.489
MINIMUM X	:	-1.250	-1.181	-1.007
MAXIMUM Y	:	1.964	1.226	1.217
MINIMUM Y	:	-1.217	-.999	-1.008
CENTROID X	:	-.097	-.166	-.340
CENTROID Y	:	.055	-.163	-.154
POA TO CENTROID in.	:	.112	.233	.374
MIN RADIUS	:	.182	.241	.402
MEAN RADIUS	:	1.091	.945	.882
MAX RADIUS	:	2.059	1.446	1.603
HORIZONTAL SPREAD	:	2.576	2.576	2.496
VERTICAL SPREAD	:	3.181	2.225	2.225
EXTREME SPREAD	:	3.308	2.577	2.568
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.732

VS= 1.572

GS= 1.772

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.793	.824	.700
MINIMUM X	-.939	-.908	-.805
MAXIMUM Y	.972	.808	.752
MINIMUM Y	-.600	-.492	-.548
CENTROID X	.023	-.008	-.111
CENTROID Y	.158	.050	.106
POA TO CENTROID in.	.160	.051	.154
MIN RADIUS	.162	.200	.105
MEAN RADIUS	.692	.652	.604
MAX RADIUS	1.012	.939	.815
HORIZONTAL SPREAD	1.732	1.732	1.505
VERTICAL SPREAD	1.572	1.300	1.300
EXTREME SPREAD	1.772	1.772	1.512
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	