

C6587525

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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.
C6587525

ORDER NO.
5716

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

20

5716 C6587525



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587525

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		1-7-91	KR
615	Rollmark Caliber		1-7-91	GL
617	Drill and Tap Sight Holes	1 10	91	WB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	JA

op. #	BARBER - M24 0022009 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/24/91	JK
	G) Safety Off Force	4	3	4			4/24/91	JK
	H) Trigger Pull Test & Retainability						4/24/91	JK
	I) Firing Pin Indent	.023	.023	.023			4/24/91	JK
	J) Assemble Stock						4/25/91	RW
	K) Assemble Swivel Studs						5-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/25/91	RW
	M) Iron Sight Alignment						4/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	RW
	O) Attach Scope to Rifle						4/25/91	RW
	P) Detach & Attach Scope 20 Times						4/25/91	RW
640	Gallery Target & Test						4/26/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						4/26/91	KT
655	Final Inspection							
	A) Headspace						5-11-91	D/H
	B) Trigger Pull	2.44	2.43	2.47	2.46	2.50	5/11/91	JK
	C) Function						5-11-91	D/H
660	Pack						6-18-91	RW

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587525

DATE 4/24/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.37	2.30	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.32	2.38	2.43	
PULL #3	2.45	2.34	2.36	2.47	
PULL #4	2.41	2.32	2.34	2.46	
PULL #5	2.25	2.33	2.36	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.42		
PULL #2	3.53	3.44		
PULL #3	3.56	3.39		
PULL #4	3.40	3.39		
PULL #5	3.41	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.17		4.38
PULL #2	4.29	4.37		4.36
PULL #3	4.28	4.41		4.39
PULL #4	4.20	4.37		4.38
PULL #5	4.17	4.38		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587525
26 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.179513
1 TO	2	.189621
1 TO	3	.509284
1 TO	4	.28486
1 TO	5	.130973

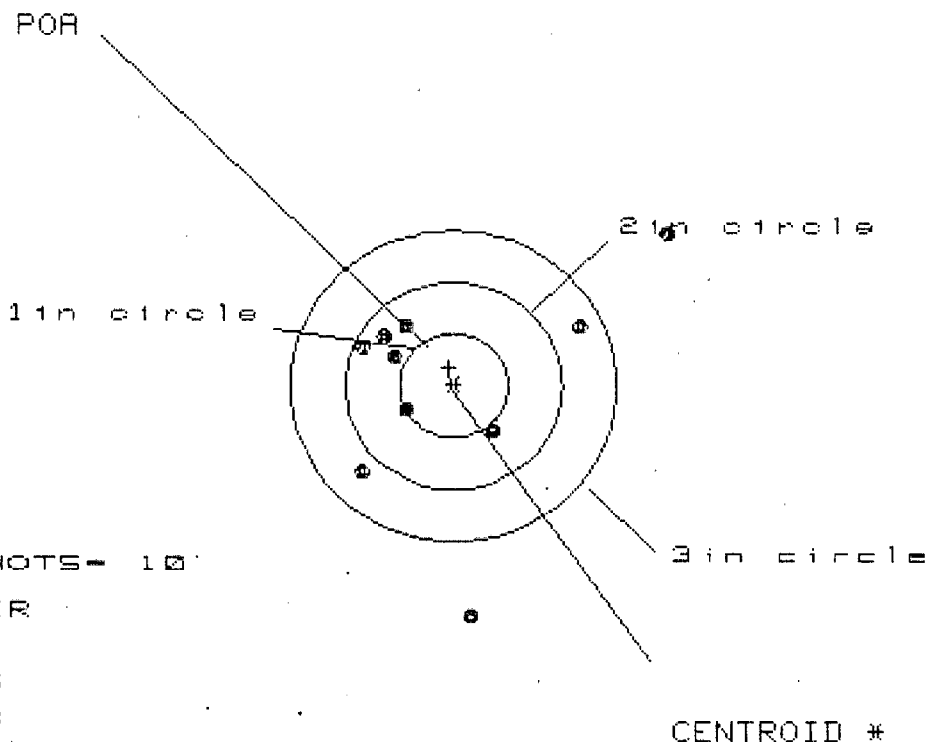
4.3 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0742
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0338
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0815358
THE AMR FOR THIS RIFLE IS: 1.12

26 Apr 1991

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CENTERFIRE PATTERNS # 1

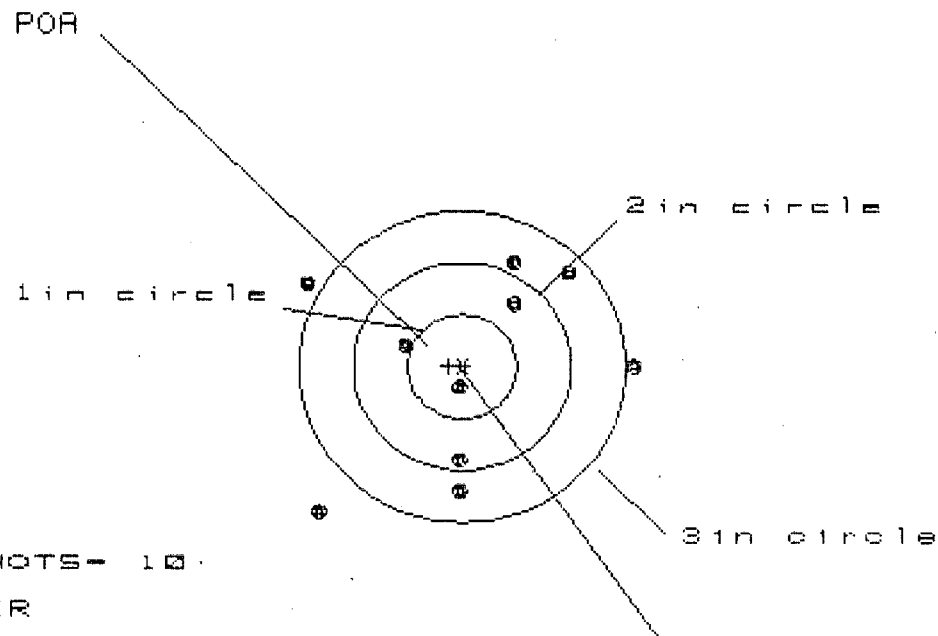


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.916	1.326	1.373
MINIMUM X	-.863	-.650	-.603
MAXIMUM Y	1.456	.749	.487
MINIMUM Y	-2.257	-2.096	-.921
CENTROID X	.040	-.173	-.220
CENTROID Y	-.175	-.336	-.074
POA TO CENTROID in.	.179	.378	.232
MIN RADIUS	.443	.189	.323
MEAN RADIUS	1.108	.916	.704
MAX RADIUS	2.406	2.130	1.457
HORIZONTAL SPREAD	2.779	1.976	1.976
VERTICAL SPREAD	3.713	2.845	1.408
EXTREME SPREAD	4.104	2.998	2.426
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



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.010

VS = 2.350

GS = 3.250

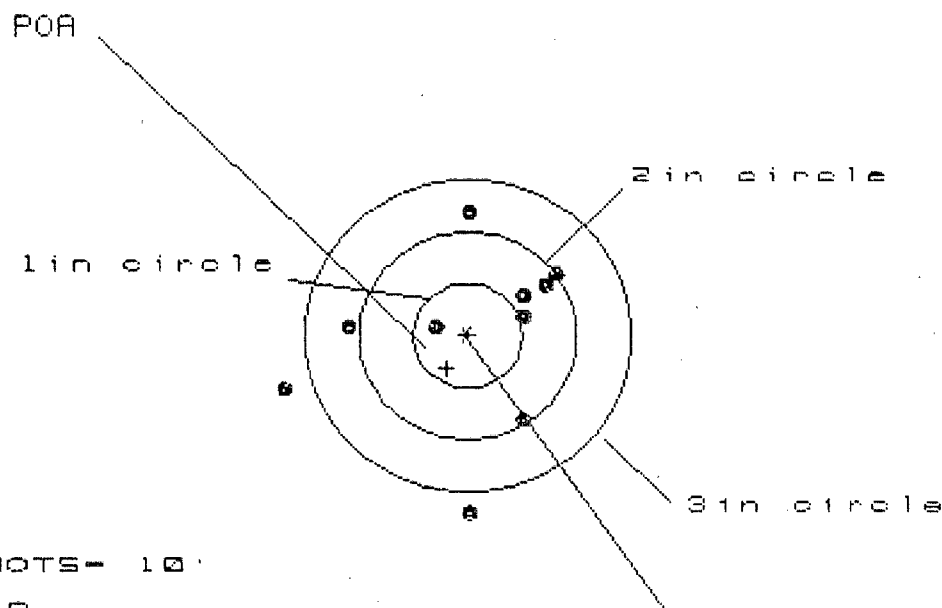
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.541	1.389	1.186
MINIMUM X	:	-1.469	-1.621	-0.865
MAXIMUM Y	:	1.000	.850	.933
MINIMUM Y	:	-1.358	-1.338	-1.255
CENTROID X	:	.124	.276	.479
CENTROID Y	:	-.005	.146	.063
POA TO CENTROID in.	:	.124	.313	.483
MIN RADIUS	:	.236	.435	.511
MEAN RADIUS	:	1.121	1.025	.932
MAX RADIUS	:	1.928	1.754	1.300
HORIZONTAL SPREAD	:	3.010	3.010	2.051
VERTICAL SPREAD	:	2.358	2.188	2.188
EXTREME SPREAD	:	3.250	3.110	2.308
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.566

VS= 2.975

GS= 2.975

CENTROID #

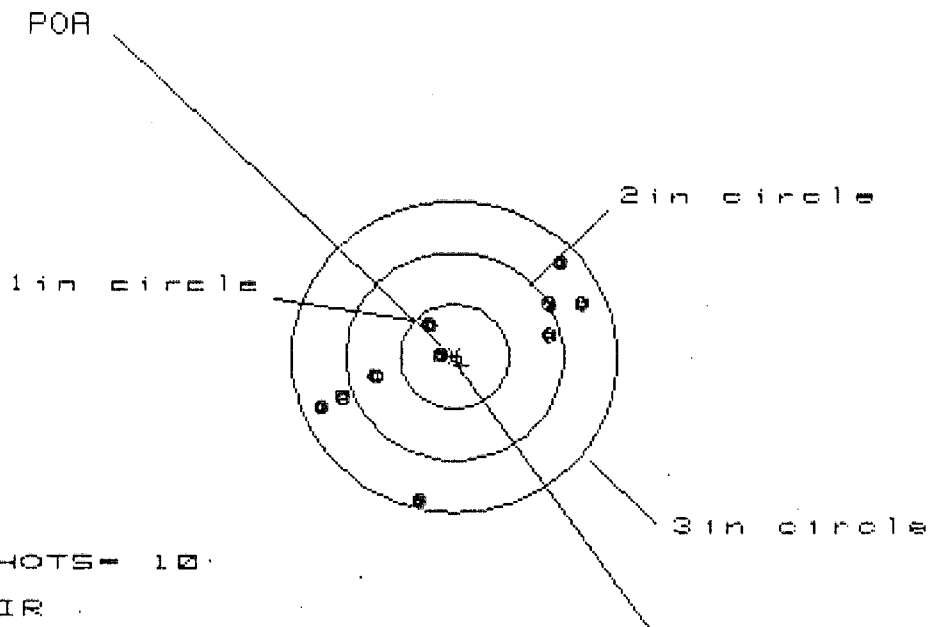
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.839	.647	.624
MINIMUM X	-1.727	-1.280	-1.303
MAXIMUM Y	1.214	1.153	.926
MINIMUM Y	-1.761	-1.822	-1.087
CENTROID X	.189	.381	.404
CENTROID Y	.312	.373	.600
POA TO CENTROID in.	.365	.533	.724
MIN RADIUS	.303	.361	.325
MEAN RADIUS	1.024	.892	.728
MAX RADIUS	1.813	1.831	1.318
HORIZONTAL SPREAD	2.566	1.927	1.927
VERTICAL SPREAD	2.975	2.975	2.013
EXTREME SPREAD	2.975	2.975	2.061
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.370

VS= 2.352

GS= 2.687

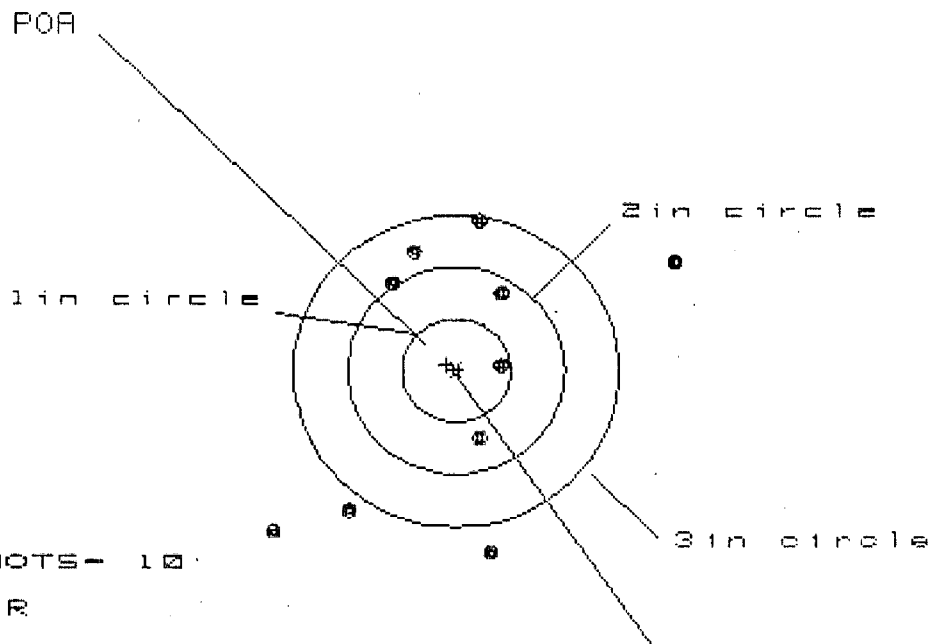
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.117	1.077	.915
MINIMUM X	:	-1.253	-1.293	-1.233
MAXIMUM Y	:	.927	.769	.686
MINIMUM Y	:	-1.425	-.658	-.637
CENTROID X	:	-.067	-.027	.135
CENTROID Y	:	.089	.247	.330
POR TO CENTROID in.	:	.112	.249	.356
MIN RADIUS	:	.112	.207	.385
MEAN RADIUS	:	.958	.892	.821
MAX RADIUS	:	1.471	1.451	1.388
HORIZONTAL SPREAD	:	2.370	2.370	2.148
VERTICAL SPREAD	:	2.352	1.427	1.323
EXTREME SPREAD	:	2.687	2.611	2.368
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.701

VS= 3.250

GS= 4.533

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.057	.676	.499
MINIMUM X	:	-1.644	-1.416	-.950
MAXIMUM Y	:	1.472	1.589	1.407
MINIMUM Y	:	-1.778	-1.661	-1.843
CENTROID X	:	.085	-.143	.034
CENTROID Y	:	-.052	-.169	.013
POA TO CENTROID in.	:	.100	.221	.036
MIN RADIUS	:	.457	.685	.500
MEAN RADIUS	:	1.388	1.304	1.158
MAX RADIUS	:	2.308	2.029	1.882
HORIZONTAL SPREAD	:	3.701	2.092	1.449
VERTICAL SPREAD	:	3.250	3.250	3.250
EXTREME SPREAD	:	4.533	3.587	3.251
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	