

06587552

MODEL 700™ M24

Model **SMS**™

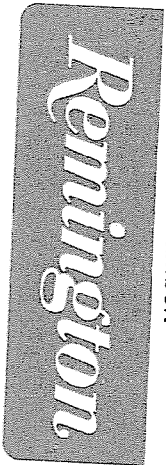
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

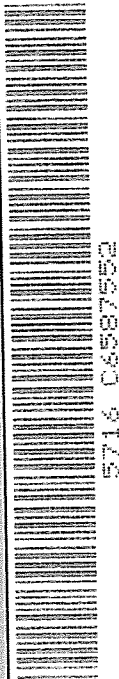
DUPONT
REG. U.S. PAT. & TM. OFF.

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

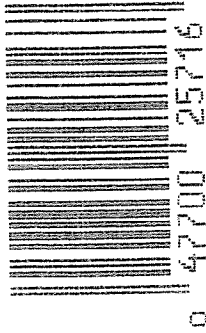
SERIAL NO.
C4587552

ORDER NO.
5716

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



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587552

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		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1	10	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	HA

op. #	BARBER - M24 0022570 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			2/4/91	WB
	G) Safety Off Force	2 ¹ / ₂	2 ³ / ₄	2 ¹ / ₂			2/4/91	WB
	H) Trigger Pull Test & Retainability						1/30/91	JJ
	I) Firing Pin Indent	.0225	.0215	.022			2/4/91	WB
	J) Assemble Stock						2/5/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	RW
	M) Iron Sight Alignment						2/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	RW
	O) Attach Scope to Rifle						2/5/91	RW
	P) Detach & Attach Scope 20 Times						2/5/91	RW
640	Gallery Target & Test						2/5/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						2/5/91	KS
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.49	2.53	2.46	2.39	2.38	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	D/H

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

SERIAL NO. 06587552
DATE 1/30/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.30	2.20	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.37	2.18	2.53	
PULL #3	2.26	2.18	2.16	2.46	
PULL #4	2.35	2.32	2.25	2.39	
PULL #5	2.35	2.32	2.30	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.46		
PULL #2	3.38	3.50		
PULL #3	3.33	3.55		
PULL #4	3.22	3.57		
PULL #5	3.19	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.31		4.41
PULL #2	4.19	4.30		4.31
PULL #3	4.21	4.37		4.31
PULL #4	4.24	4.26		4.36
PULL #5	4.29	4.31		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587552
6 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.330151
1 TO	2	.393315
1 TO	3	.502482
1 TO	4	.517302
1 TO	5	.290264

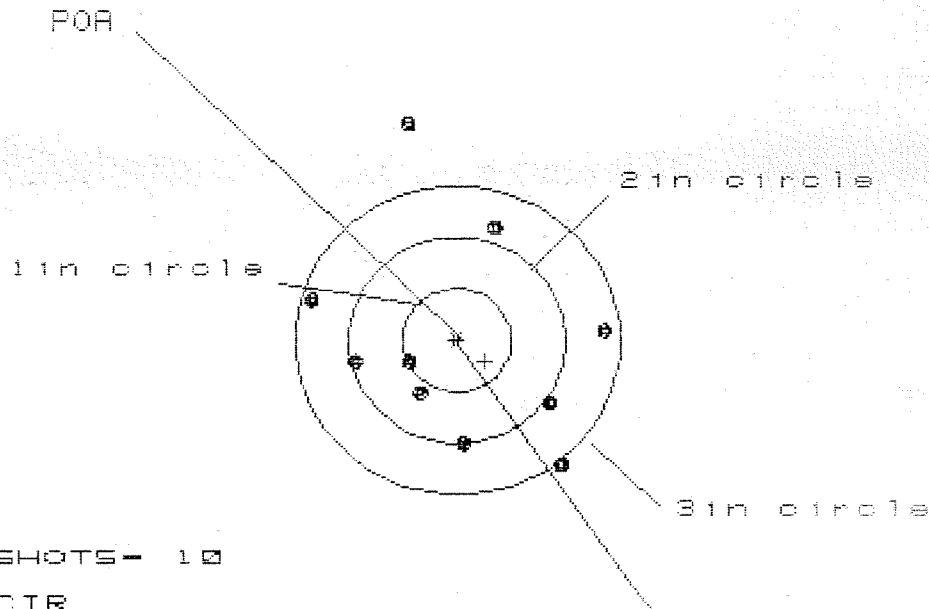
1.0 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.079
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114441
THE AMR FOR THIS RIFLE IS: .9834

6 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587552

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS = 2.715

VS = 3.239

GS = 3.509

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.295	1.405
MINIMUM X	:	-1.373	-1.420	-1.310
MAXIMUM Y	:	2.050	1.368	1.248
MINIMUM Y	:	-1.189	-0.961	-0.900
CENTROID X	:	-0.258	-0.211	-0.321
CENTROID Y	:	0.206	-0.022	0.099
POA TO CENTROID in.	:	0.330	0.212	0.335
MIN RADIUS	:	0.441	0.445	0.347
MEAN RADIUS	:	1.162	1.018	0.973
MAX RADIUS	:	2.093	1.554	1.416
HORIZONTAL SPREAD	:	2.715	2.715	2.715
VERTICAL SPREAD	:	3.239	2.329	2.147
EXTREME SPREAD	:	3.509	2.795	2.735
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

6 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587552

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.475

VS= 2.632

GS= 2.632

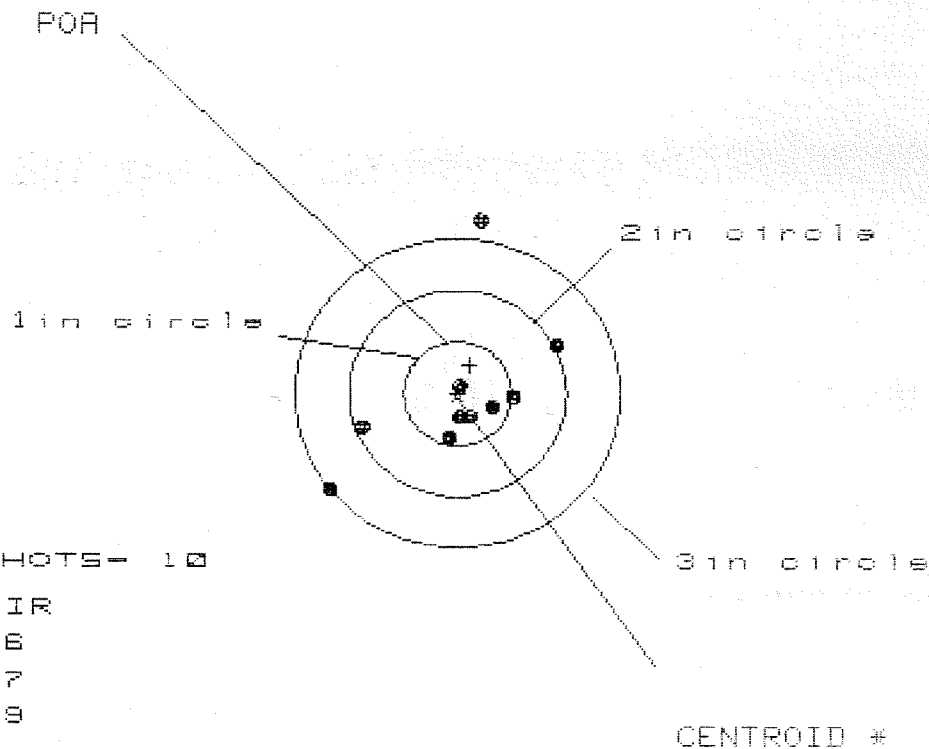
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.858	.818	.763
MINIMUM X	:	-.617	-.657	-.712
MAXIMUM Y	:	.992	.809	.631
MINIMUM Y	:	-1.640	-1.232	-1.131
CENTROID X	:	-.062	-.022	.033
CENTROID Y	:	-.135	.048	-.053
POA TO CENTROID in.	:	.148	.053	.063
MIN RADIUS	:	.247	.140	.239
MEAN RADIUS	:	.813	.682	.664
MAX RADIUS	:	1.679	1.232	1.133
HORIZONTAL SPREAD	:	1.475	1.475	1.475
VERTICAL SPREAD	:	2.632	2.041	1.762
EXTREME SPREAD	:	2.632	2.084	1.788
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08587552

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 6

2in = 7

3in = 9

HS= 2.086

VS= 2.626

GS= 2.942

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.939	.959	.818
MINIMUM X	-1.147	-1.127	-.980
MAXIMUM Y	1.710	.711	.620
MINIMUM Y	-.916	-.726	-.371
CENTROID X	-.116	-.136	.005
CENTROID Y	-.276	-.466	-.375
POA TO CENTROID in.	.299	.485	.375
MIN RADIUS	.062	.015	.153
MEAN RADIUS	.702	.553	.442
MAX RADIUS	1.719	1.341	1.026
HORIZONTAL SPREAD	2.086	2.086	1.798
VERTICAL SPREAD	2.626	1.437	.991
EXTREME SPREAD	2.942	2.533	2.000
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587552

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 3

2in - 7

3in - 10

HS - 2.249

VS - 2.054

GS - 2.354

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.859	.886
MINIMUM X	:	-1.251	-.427	-.315
MAXIMUM Y	:	1.118	1.034	.768
MINIMUM Y	:	-.936	-1.020	-.891
CENTROID X	:	.093	.232	.285
CENTROID Y	:	-.174	-.098	-.219
POA TO CENTROID in.	:	.198	.249	.360
MIN RADIUS	:	.259	.137	.185
MEAN RADIUS	:	.756	.650	.599
MAX RADIUS	:	1.464	1.119	.934
HORIZONTAL SPREAD	:	2.249	1.286	1.121
VERTICAL SPREAD	:	2.054	2.054	1.659
EXTREME SPREAD	:	2.354	2.064	1.659
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587552

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 2

2in - 5

3in - 8

HS- 2.407

VS= 2.422

GS= 3.160

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.112
MINIMUM X	-1.295
MAXIMUM Y	1.252
MINIMUM Y	-1.170
CENTROID X	-.071
CENTROID Y	-.016
POA TO CENTROID in.	.073
MIN RADIUS	.278
MEAN RADIUS	.984
MAX RADIUS	1.637
HORIZONTAL SPREAD	2.407
VERTICAL SPREAD	2.422
EXTREME SPREAD	3.160
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8