

C6587558

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*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.

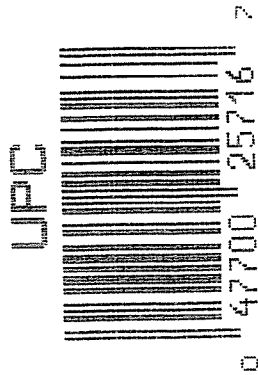
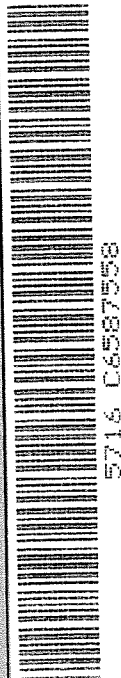
MODEL 700TM H24

SERIAL NO.
C6587558

ORDER NO.
5716

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

20



CONTRACT # DAAA21-87-C-0086

NEW BBLGUN SERIAL # C 6587558

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		11/6/90	WB
618	Polish Barrel <i>RB</i>		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/14/90	KS
	C) Inspect Ejector Hole for Chamfer		12/14/90	KS
	D) Oil Firing Pin Ass'y		12/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1/7/91	JS

op. #	BARBER - M24 0022671 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.50	4.75			1/3/91	KT
	G) Safety Off Force	2.0	2.25	2.0			1/3/91	KT
	H) Trigger Pull Test & Retainability						1/7/91	JH
	I) Firing Pin Indent	.021	.021	.022			1/3/91	KT
	J) Assemble Stock						1-14-91	KS
	K) Assemble Swivel Studs						1-15-91	JH
	L) Attach Front and Rear Sight Assemblies						1-14-91	KS
	M) Iron Sight Alignment						1-14-91	KS
	N) Detach Front & Rear Sights & place in numbered container						1-14-91	KS
	O) Attach Scope to Rifle						1-14-91	KS
	P) Detach & Attach Scope 20 Times						1-14-91	KS
640	Gallery Target & Test						1-14-91	AC
	A) Time						1-14-91	AC
	B) Malfunctions						1-14-91	AC
	C) Pierced Primers						1-14-91	AC
	D) Optical Clarity of Scope						1-14-91	AC
645	Inspect for Live Ammo						1-14-91	AC
655	Final Inspection							
	A) Headspace						1-15-91	JH
	B) Trigger Pull	2.17	2.20	2.10	2.15	2.23	1-15-91	JH
	C) Function						1-15-91	JH
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587558DATE 1-2-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.24	2.29	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.22	2.27	2.20	
PULL #3	2.38	2.29	2.25	2.10	
PULL #4	2.29	2.20	2.23	2.15	
PULL #5	2.33	2.20	2.20	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.50		
PULL #2	3.24	3.41		
PULL #3	3.44	3.45		
PULL #4	3.36	3.45		
PULL #5	3.49	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	4.40	4.41		4.28
PULL #2	4.31	4.43		4.28
PULL #3	4.39	4.34		4.36
PULL #4	4.32	4.33		4.29
PULL #5	4.39	4.34		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587558
15 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.280713
1 TO	2	.264864
1 TO	3	.192634
1 TO	4	.216622
1 TO	5	.317972

392 <----POA

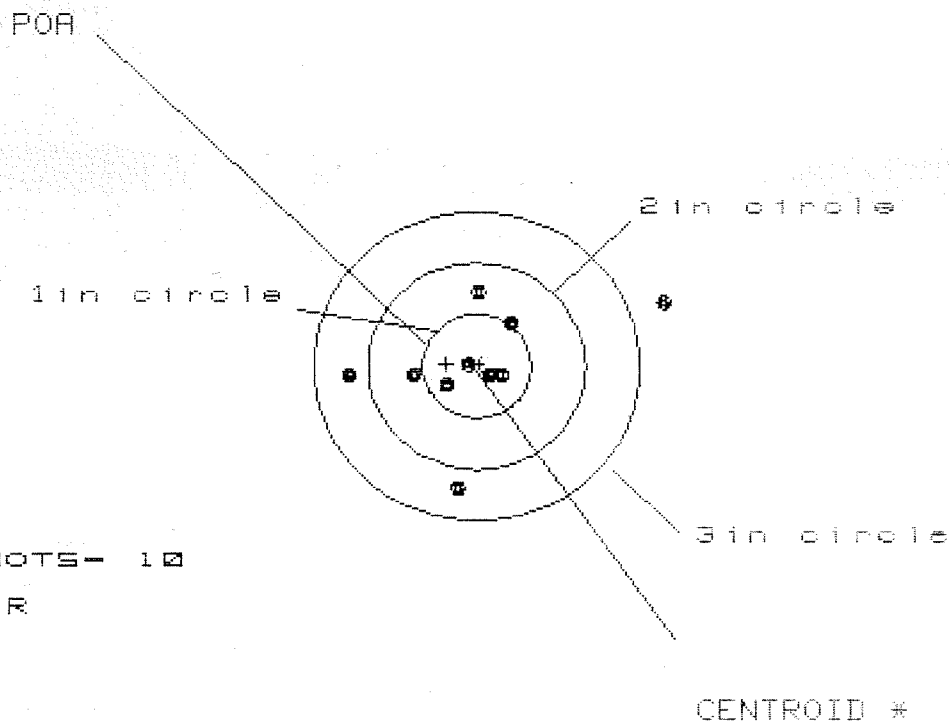
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2676
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .272085

THE AMR FOR THIS RIFLE IS: .8452

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587558

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.909

VS= 1.888

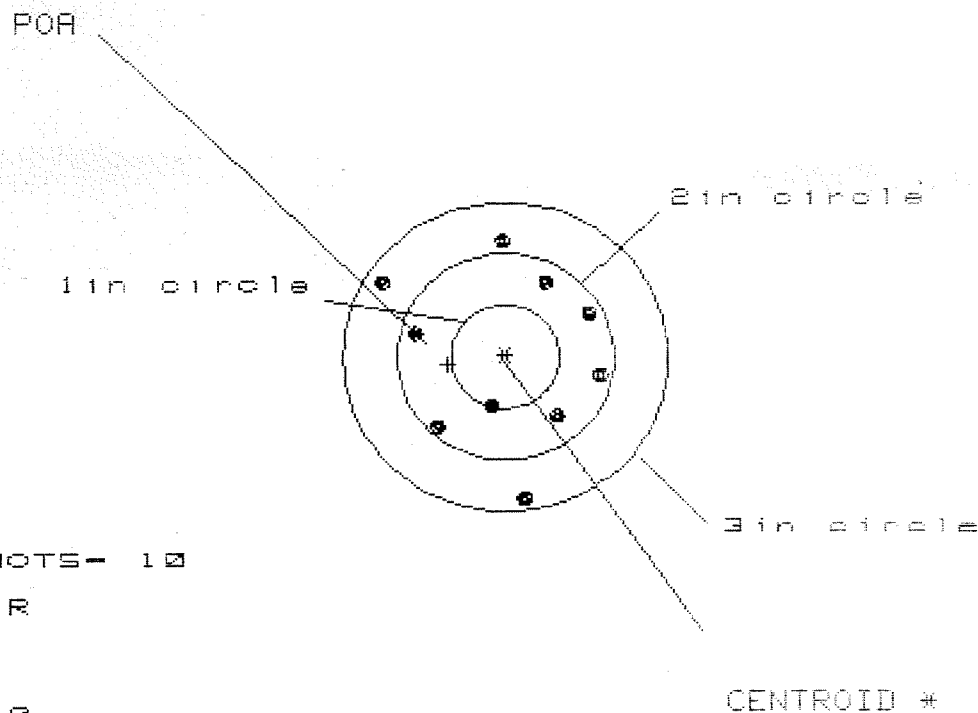
GS= 2.977

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.699	.556	.428
MINIMUM X	-1.210	-1.021	-.524
MAXIMUM Y	.704	.768	.768
MINIMUM Y	-1.184	-1.120	-1.120
CENTROID X	.280	.091	.219
CENTROID Y	-.020	-.084	-.084
POA TO CENTROID in.	.281	.124	.235
MIN RADIUS	.062	.141	.063
MEAN RADIUS	.676	.556	.471
MAX RADIUS	1.793	1.121	1.132
HORIZONTAL SPREAD	2.909	1.577	.952
VERTICAL SPREAD	1.888	1.888	1.888
EXTREME SPREAD	2.977	1.898	1.898
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

15 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.046

VS= 2.546

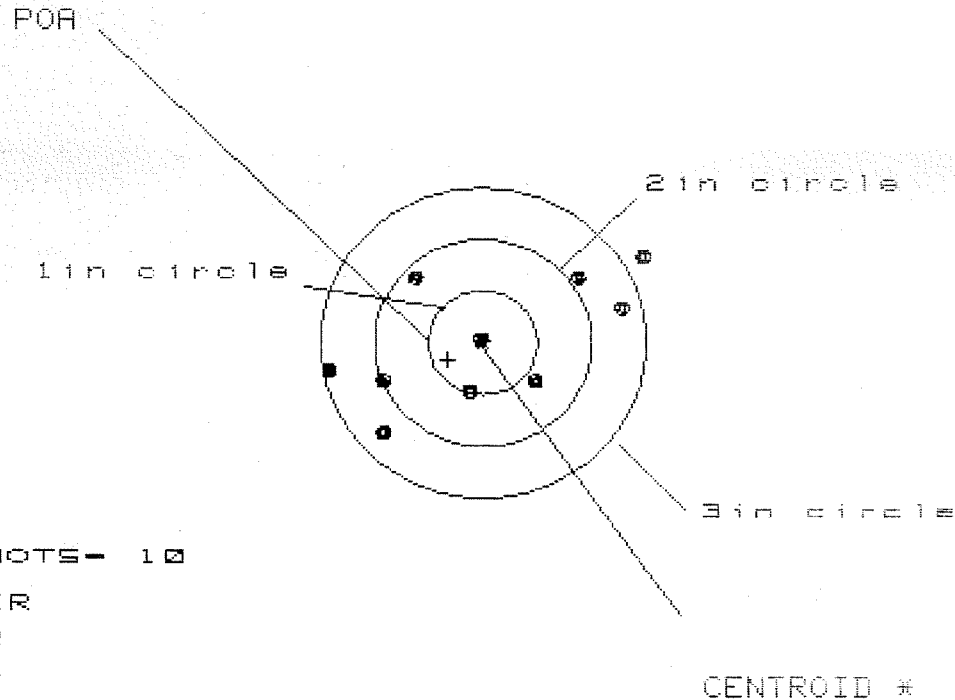
GS= 2.552

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.935	.796
MINIMUM X	:	-1.128	-1.111	-.911
MAXIMUM Y	:	1.139	.982	1.049
MINIMUM Y	:	-1.407	-.805	-.738
CENTROID X	:	.528	.511	.650
CENTROID Y	:	.073	.230	.163
POA TO CENTROID in.	:	.533	.560	.670
MIN RADIUS	:	.448	.600	.570
MEAN RADIUS	:	.946	.892	.831
MAX RADIUS	:	1.415	1.234	1.060
HORIZONTAL SPREAD	:	2.046	2.046	1.787
VERTICAL SPREAD	:	2.546	1.787	1.787
EXTREME SPREAD	:	2.552	2.205	1.883
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.896

VS= 1.660

GS= 3.087

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.468	1.402	1.244
MINIMUM X	:	-1.428	-1.265	-.966
MAXIMUM Y	:	.783	.719	.695
MINIMUM Y	:	-.877	-.790	-.814
CENTROID X	:	.322	.159	.317
CENTROID Y	:	.168	.081	.105
POA TO CENTROID in.	:	.363	.178	.334
MIN RADIUS	:	.020	.194	.054
MEAN RADIUS	:	.971	.891	.821
MAX RADIUS	:	1.664	1.468	1.310
HORIZONTAL SPREAD	:	2.896	2.667	2.210
VERTICAL SPREAD	:	1.660	1.509	1.509
EXTREME SPREAD	:	3.087	2.741	2.490
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Jan 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.123

VS= 2.281

GS= 2.374

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.938	.444	.496
MINIMUM X	:	-1.185	-1.081	-1.035
MAXIMUM Y	:	1.074	.979	.816
MINIMUM Y	:	-1.207	-1.302	-1.103
CENTROID X	:	.213	.109	.063
CENTROID Y	:	.186	.281	.444
POA TO CENTROID in.	:	.283	.302	.449
MIN RADIUS	:	.243	.356	.361
MEAN RADIUS	:	.835	.782	.692
MAX RADIUS	:	1.269	1.354	1.120
HORIZONTAL SPREAD	:	2.123	1.525	1.525
VERTICAL SPREAD	:	2.281	2.281	1.919
EXTREME SPREAD	:	2.374	2.374	1.968
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Jan 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.459

VS= 2.124

GS= 2.152

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.715	.793	.862
MINIMUM X	:	-.744	-.666	-.597
MAXIMUM Y	:	.980	.853	.701
MINIMUM Y	:	-1.144	-1.217	-.431
CENTROID X	:	-.005	-.083	-.152
CENTROID Y	:	-.161	-.034	.118
POA TO CENTROID in.	:	.161	.090	.193
MIN RADIUS	:	.331	.339	.243
MEAN RADIUS	:	.798	.705	.600
MAX RADIUS	:	1.343	1.337	.892
HORIZONTAL SPREAD	:	1.459	1.459	1.459
VERTICAL SPREAD	:	2.124	2.070	1.132
EXTREME SPREAD	:	2.152	2.073	1.552
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	