

06587591

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

BARBER - M24 M2400023346

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587591

DATE 8-28-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.72	2.50	2.65		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.98	2.48	2.62		
PULL #3	2.87	2.27	2.52		
PULL #4	2.95	2.66	2.47		
PULL #5	2.93	2.57	2.52		
TOTAL	14.45	12.48	12.78		
AVG.	2.89	2.49	2.55		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.19		
PULL #2	3.16	3.27		
PULL #3	3.38	3.04		
PULL #4	3.41	3.14		
PULL #5	3.10	3.26		
TOTAL	16.11	15.90		
AVG.	3.22	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	3.83	3.96	
PULL #2	4.04	3.91	3.92	
PULL #3	3.99	3.94	3.92	
PULL #4	3.89	3.91	3.99	
PULL #5	3.96	3.94	4.01	
TOTAL	19.92	19.53	19.80	
AVG.	3.98	3.90	3.96	1195 11/1/95

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587591

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	BARBER M24 0023310 F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.023	.0215	.022	11/31/95	RW
	J) Assemble Stock					
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle					
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test					
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo					
655	Final Inspection A) Headspace					
	B) Trigger Pull	2.726	2.68	2.64	2.70	2.66
	C) Function					
660	Pack					

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6587591

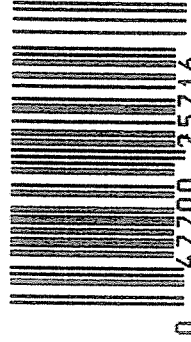
ORDER NO.
5716

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



5716 C6587591

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C 6587591

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		" "	G.L.
617	Drill and Tap Sight Holes		11/6/90	WB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/4/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/4/90	KS
	C) Inspect Ejector Hole for Chamfer		12/4/90	KS
	D) Oil Firing Pin Ass'y		12/4/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/5/90	JS

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	12/5/90	WB
	G) Safety Off Force	2 1/4	2	2 1/4	12/5/90	WB
	H) Trigger Pull Test & Retainability				12/5/90	84
	I) Firing Pin Indent	.0225	.0225	.0225	12/5/90	WB
	J) Assemble Stock				12/5/90	KS
	K) Assemble Swivel Studs				12-6-90	928
	L) Attach Front and Rear Sight Assemblies				12/5/90	KS
	M) Iron Sight Alignment				12/5/90	KS
	N) Detach Front & Rear Sights & place in numbered container				12/5/90	KS
	O) Attach Scope to Rifle				12/5/90	KS
	P) Detach & Attach Scope 20 Times				12/5/90	KS
640	Gallery Target & Test				12/5/90	KJ
	A) Time				"	KJ
	B) Malfunctions				"	KJ
	C) Pierced Primers				"	KJ
	D) Optical Clarity of Scope				"	KJ
645	Inspect for Live Ammo				12/5/90	KJ
655	Final Inspection					
	A) Headspace				12-6-90	928
	B) Trigger Pull	266	273	269	12-6-90	928
	C) Function				12-6-90	928
660	Pack				12/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO

06587591

DATE

12-5-90

TESTER

JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.20	2.31	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.36	2.32	2.73	
PULL #3	2.45	2.31	2.31	2.69	
PULL #4	2.49	2.30	2.50	2.73	
PULL #5	2.40	2.38	2.17	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.33		
PULL #2	3.25	3.43		
PULL #3	3.42	3.41		
PULL #4	3.48	3.32		
PULL #5	3.43	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.34		4.21
PULL #2	4.18	4.20		4.03
PULL #3	4.35	4.29		4.20
PULL #4	4.25	4.29		4.13
PULL #5	4.30	4.28		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587591
6 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.0662118
1 TO	2	.0447772
1 TO	3	.0434626
1 TO	4	.170074
1 TO	5	.207543

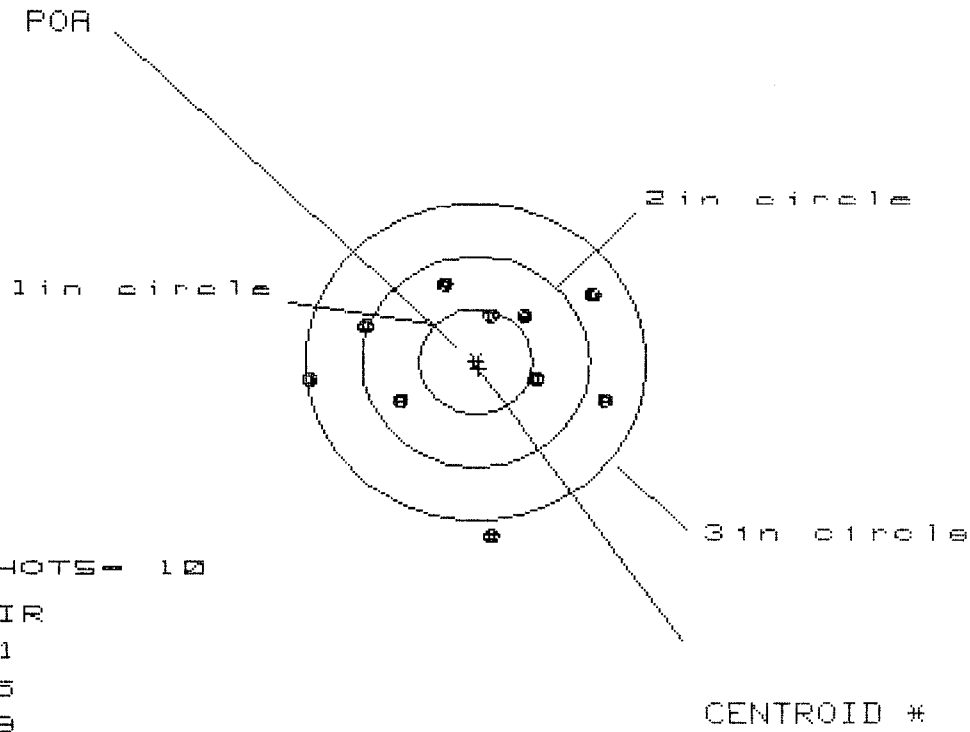
35 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0234
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0295222
THE AMR FOR THIS RIFLE IS: 1.041

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/6567591

CENTERFIRE PATTERNS # 1



HS= 2.587
 VS= 2.471
 GS= 2.634

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.124	1.135	.954
MINIMUM X	-1.463	-1.452	-1.182
MAXIMUM Y	.775	.586	.547
MINIMUM Y	-1.696	-.553	-.592
CENTROID X	-.028	-.039	.142
CENTROID Y	.060	.249	.288
POA TO CENTROID in.	.067	.252	.321
MIN RADIUS	.445	.284	.187
MEAN RADIUS	.983	.870	.753
MAX RADIUS	1.699	1.486	1.191
HORIZONTAL SPREAD	2.587	2.587	2.136
VERTICAL SPREAD	2.471	1.139	1.139
EXTREME SPREAD	2.634	2.634	2.252
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/65B7531

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.392

VS= 3.551

GS= 3.750

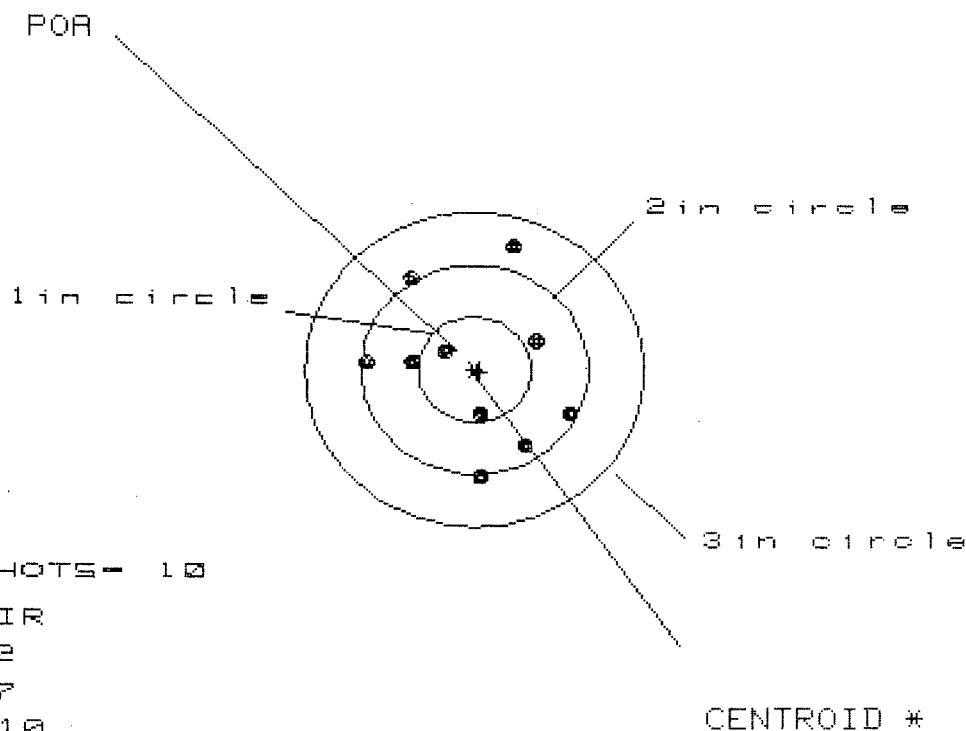
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.025	1.021
MINIMUM X	:	-1.244	-1.367	-1.371
MAXIMUM Y	:	1.843	1.653	.870
MINIMUM Y	:	-1.708	-1.340	-1.134
CENTROID X	:	-.067	.057	.061
CENTROID Y	:	.038	.228	.022
POA TO CENTROID in.	:	.077	.235	.065
MIN RADIUS	:	.201	.266	.327
MEAN RADIUS	:	1.069	.912	.859
MAX RADIUS	:	2.039	1.914	1.779
HORIZONTAL SPREAD	:	2.392	2.392	2.392
VERTICAL SPREAD	:	3.551	2.993	2.004
EXTREME SPREAD	:	3.750	3.277	2.518
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/6587591

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.754

VS= 2.291

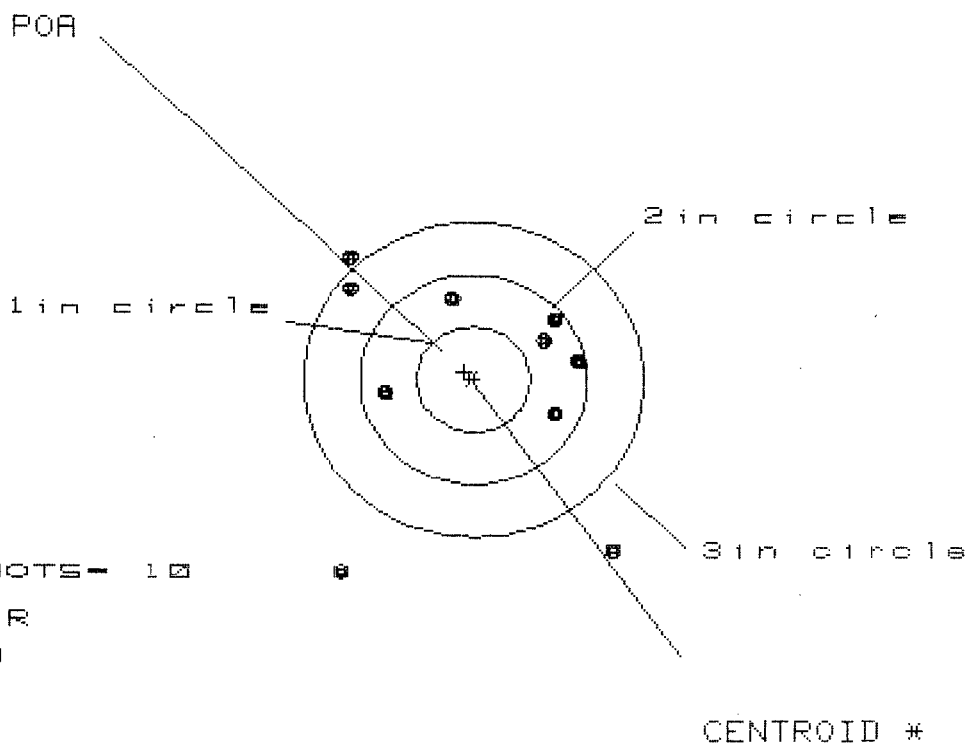
GS= 2.301

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.835	.869	.885
MINIMUM X	-.929	-.895	-.879
MAXIMUM Y	1.227	.973	.857
MINIMUM Y	-1.064	-.928	-.722
CENTROID X	-.045	-.079	-.095
CENTROID Y	.020	-.116	-.000
POA TO CENTROID in.	.050	.141	.095
MIN RADIUS	.328	.325	.298
MEAN RADIUS	.794	.730	.696
MAX RADIUS	1.264	1.113	1.004
HORIZONTAL SPREAD	1.764	1.764	1.764
VERTICAL SPREAD	2.291	1.901	1.579
EXTREME SPREAD	2.301	2.015	1.900
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.263	1.136	.935
MINIMUM X	:	-1.140	-1.237	-1.095
MAXIMUM Y	:	1.206	1.002	.768
MINIMUM Y	:	-1.834	-1.873	-.735
CENTROID X	:	.078	.205	.063
CENTROID Y	:	-.073	.131	.365
POA TO CENTROID in.	:	.107	.243	.370
MIN RADIUS	:	.751	.562	.349
MEAN RADIUS	:	1.217	1.058	.895
MAX RADIUS	:	2.159	2.190	1.316
HORIZONTAL SPREAD	:	2.403	2.373	2.030
VERTICAL SPREAD	:	3.040	2.875	1.503
EXTREME SPREAD	:	3.711	3.711	2.342
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/6567591

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 2.621

VS= 1.998

GS= 3.163

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.039	.863	.799
MINIMUM X	-1.582	-1.524	-1.416
MAXIMUM Y	.988	.893	.995
MINIMUM Y	-1.010	-1.105	-1.003
CENTROID X	.179	.355	.247
CENTROID Y	.045	.140	.038
POA TO CENTROID in.	.185	.382	.250
MIN RADIUS	.678	.508	.610
MEAN RADIUS	1.143	1.043	1.023
MAX RADIUS	1.800	1.535	1.444
HORIZONTAL SPREAD	2.621	2.397	2.215
VERTICAL SPREAD	1.998	1.998	1.998
EXTREME SPREAD	3.163	2.470	2.388
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	