

C6587619

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

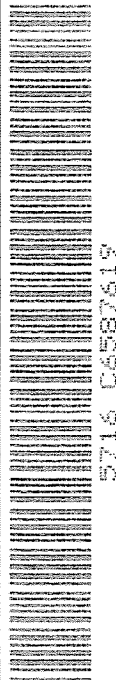
DUPONT

MODEL 700™ M24

SERIAL NO. 06587619

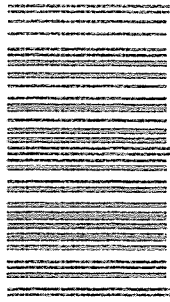
ORDER NO. 5716

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



5716 06587619

UPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587619

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	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes		11/1/90	RB
618	Polish Barrel RB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	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	DH

op. #	BARBER M24 0023887	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4			1/3/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			1/3/91	WB
	H) Trigger Pull Test & Retainability						1-3-91	DH
	I) Firing Pin Indent.	.0225	.023	.023			1/3/91	WB
	J) Assemble Stock						1/16/91	RW
	K) Assemble Swivel Studs						2-1-91	AC
	L) Attach Front and Rear Sight Assemblies						1/16/91	RW
	M) Iron Sight Alignment						1/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/16/91	RW
	O) Attach Scope to Rifle						1/16/91	RW
	P) Detach & Attach Scope 20 Times						1/16/91	RW
640	Gallery Target & Test						1-17-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						1-17-91	AF
655	Final Inspection							
	A) Headspace						2-1-91	R
	B) Trigger Pull	2.36	2.52	2.56	2.54	2.51	1-22-91	JLF
	C) Function						2-1-91	R
660	Pack						3-7-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587619DATE 1-3-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.44	2.37	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.38	2.23	2.52	
PULL #3	2.32	2.47	2.49	2.56	
PULL #4	2.33	2.47	2.48	2.54	
PULL #5	2.20	2.50	2.34	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.30		
PULL #2	3.39	3.34		
PULL #3	3.42	3.07		
PULL #4	3.30	3.26		
PULL #5	3.39	3.35		
TOTAL	16.94	16.32		
AVG.	3.38	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.35		4.38
PULL #2	4.47	4.40		4.34
PULL #3	4.42	4.40		4.05
PULL #4	4.44	4.28		4.39
PULL #5	4.44	4.36		4.11
TOTAL	22.15	21.79		21.27
AVG.	4.43	4.35		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587619
18 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0554617
1 TO	2	.0555428
1 TO	3	.0657647
1 TO	4	.327844
1 TO	5	.516385

4 <----POA
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .082
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.109
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1364

THE AMR FOR THIS RIFLE IS: 1.094

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587619

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 8

HS = 2.241

VS = 2.871

GS = 2.902

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.011	1.077	.931
MINIMUM X	-1.230	-1.164	-1.028
MAXIMUM Y	1.113	.918	.767
MINIMUM Y	-1.758	-1.210	-1.270
CENTROID X	.050	-.016	.130
CENTROID Y	.024	.220	.371
POA TO CENTROID in.	.055	.220	.393
MIN RADIUS	.367	.300	.138
MEAN RADIUS	1.006	.858	.708
MAX RADIUS	1.854	1.679	1.575
HORIZONTAL SPREAD	2.241	2.241	1.959
VERTICAL SPREAD	2.871	2.128	2.037
EXTREME SPREAD	2.902	2.604	2.543
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587619

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 8

3 in = 10

HS = 1.879

VS = 1.685

GS = 2.032

CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.746	.620	.604
MINIMUM X	-1.133	-.695	-.618
MAXIMUM Y	.770	.816	.816
MINIMUM Y	-.925	-.839	-.737
CENTROID X	.063	.189	.112
CENTROID Y	-.030	-.116	-.218
POA TO CENTROID in.	.070	.222	.245
MIN RADIUS	.375	.508	.461
MEAN RADIUS	.768	.696	.642
MAX RADIUS	1.370	1.024	.858
HORIZONTAL SPREAD	1.879	1.315	1.222
VERTICAL SPREAD	1.695	1.655	1.553
EXTREME SPREAD	2.032	1.821	1.588
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587619

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.895

VS = 2.347

GS = 2.773

CENTROID #

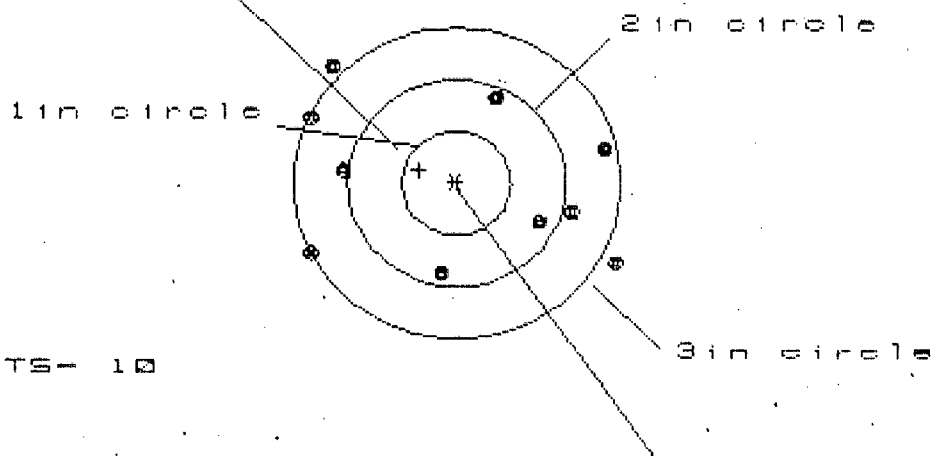
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	1.011	1.053
MINIMUM X	-.955	-.884	-.842
MAXIMUM Y	1.480	1.639	.643
MINIMUM Y	-.867	-.708	-.504
CENTROID X	.004	-.067	-.109
CENTROID Y	.071	-.088	-.293
POA TO CENTROID in.	.071	.111	.312
MIN RADIUS	.339	.229	.278
MEAN RADIUS	.987	.895	.780
MAX RADIUS	1.563	1.671	1.142
HORIZONTAL SPREAD	1.895	1.895	1.895
VERTICAL SPREAD	2.347	2.347	1.147
EXTREME SPREAD	2.773	2.626	2.120
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587619

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.730

VS= 1.965

GS= 3.179

CENTROID *

PATTERN #

4

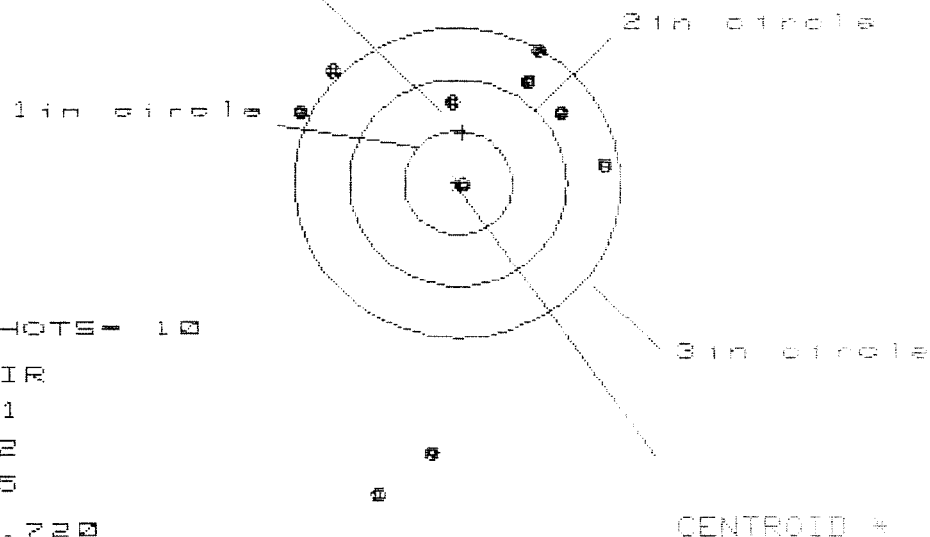
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.425	1.496	1.378
MINIMUM X	-1.305	-1.146	-1.264
MAXIMUM Y	1.141	1.054	.822
MINIMUM Y	-.824	-.911	-.780
CENTROID X	.341	.182	.300
CENTROID Y	-.127	-.040	-.171
POA TO CENTROID in.	.364	.187	.345
MIN RADIUS	.819	.846	.782
MEAN RADIUS	1.222	1.174	1.125
MAX RADIUS	1.630	1.511	1.454
HORIZONTAL SPREAD	2.730	2.642	2.642
VERTICAL SPREAD	1.965	1.965	1.602
EXTREME SPREAD	3.179	2.814	2.814
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587813

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS= 2.720

VS= 4.335

GS= 4.598

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.308	1.221	1.175
MINIMUM X	-1.412	-1.499	-1.545
MAXIMUM Y	1.302	.965	.593
MINIMUM Y	-3.033	-2.974	-1.697
CENTROID X	-.048	.039	.085
CENTROID Y	-.483	-.146	.226
POA TO CENTROID in.	.485	.151	.241
MIN RADIUS	.038	.329	.169
MEAN RADIUS	1.485	1.209	.906
MAX RADIUS	3.132	2.997	1.545
HORIZONTAL SPREAD	2.720	2.720	2.720
VERTICAL SPREAD	4.335	3.939	1.290
EXTREME SPREAD	4.598	4.072	2.777
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		