

C6587621

MODEL 700™ M24

Model **SMS**™

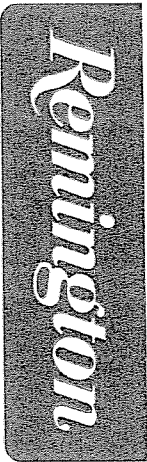
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6587621

ORDER NO.
5716

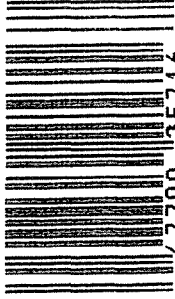
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6587621

UPC



0 47700 25716 7

Model _____

Action _____

Barrel Length _____

Capacity _____

Order No. _____

*Includes 1 in cl



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587621

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KJ
600	Proof		10/22/90	KJ
607	Check Headspace		10/22/90	KJ
610	Dis-assemble Gun		10/22/90	KJ
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes		10/25/90	F.B.
618	Polish Barrel		10/26/90	W.B.
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)		11-7-90	JA
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-27/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/27/90	WLB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			11/27/90	WLB
	H) Trigger Pull Test & Retainability						11/27/90	90/
	I) Firing Pin Indent	.021	.021	.021			11/27/90	WLB
	J) Assemble Stock						11/28/90	KS
	K) Assemble Swivel Studs						11-30-90	928
	L) Attach Front and Rear Sight Assemblies						11/28/90	KS
	M) Iron Sight Alignment						11/28/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/28/90	KS
	O) Attach Scope to Rifle						11/28/90	KS
	P) Detach & Attach Scope 20 Times						11/28/90	KS
640	Gallery Target & Test						11-29-90	✓
	A) Time						11	✓
	B) Malfunctions						11	✓
	C) Pierced Primers						11	✓
	D) Optical Clarity of Scope						11	✓
645	Inspect for Live Ammo						11-29-90	✓
655	Final Inspection							
	A) Headspace						11-30-90	928
	B) Trigger Pull	286	280	282	280	289	11-30-90	928
	C) Function						11-30-90	928
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587621DATE 11-27-90TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.31	2.49	2.86	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.37	2.47	2.90	
PULL #3	2.38	2.42	2.46	2.82	
PULL #4	2.50	2.47	2.47	2.80	
PULL #5	2.48	2.48	2.45	2.89	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.26		
PULL #2	3.42	3.40		
PULL #3	3.50	3.47		
PULL #4	3.27	3.33		
PULL #5	3.38	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	4.20	4.29		4.32
PULL #2	4.28	4.39		4.36
PULL #3	4.26	4.34		4.38
PULL #4	4.35	4.38		4.35
PULL #5	4.30	4.38		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587621
29 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.112414
1 TO	2	.0881192
1 TO	3	.534064
1 TO	4	.269007
1 TO	5	.212941

$\bar{x}_2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1746
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0796
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191889

THE AMR FOR THIS RIFLE IS: 1.087

29 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587621

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.752

VS= 2.061

GS= 3.050

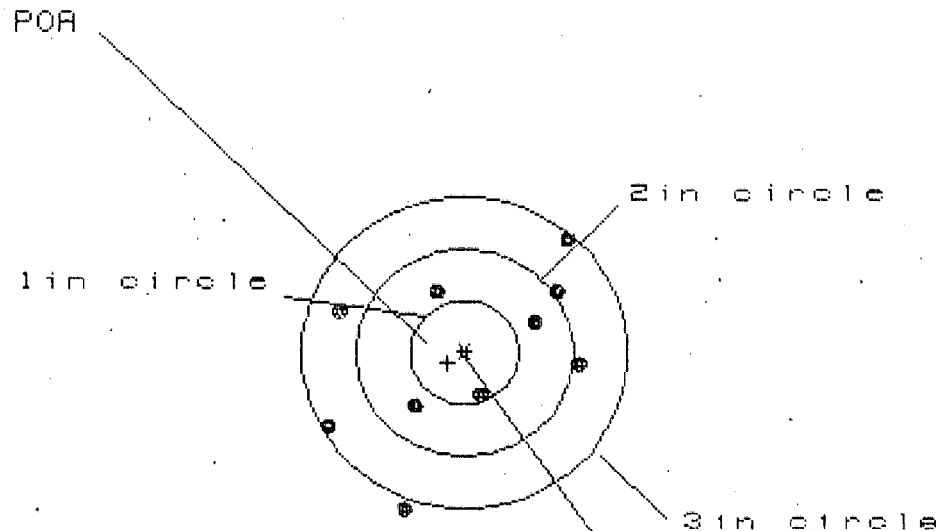
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.358	1.213	1.005
MINIMUM X	-1.394	-1.539	-1.387
MAXIMUM Y	1.018	.902	.838
MINIMUM Y	-1.043	-.899	-.963
CENTROID X	.066	.211	.059
CENTROID Y	.091	.207	.271
POA TO CENTROID in.	.112	.295	.277
MIN RADIUS	.337	.202	.183
MEAN RADIUS	1.076	.983	.938
MAX RADIUS	1.671	1.540	1.387
HORIZONTAL SPREAD	2.752	2.752	2.392
VERTICAL SPREAD	2.061	1.801	1.801
EXTREME SPREAD	3.050	2.810	2.517
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.348

VS= 2.628

GS= 3.015

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.077	1.016	1.124
MINIMUM X	-1.271	-1.332	-1.224
MAXIMUM Y	1.137	.972	.587
MINIMUM Y	-1.491	-.831	-.710
CENTROID X	.153	.214	.106
CENTROID Y	.105	.270	.149
POA TO CENTROID in.	.185	.345	.183
MIN RADIUS	.427	.550	.487
MEAN RADIUS	1.028	.951	.904
MAX RADIUS	1.589	1.570	1.415
HORIZONTAL SPREAD	2.348	2.348	2.348
VERTICAL SPREAD	2.628	1.803	1.297
EXTREME SPREAD	3.015	2.843	2.486
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.813

VS = 3.005

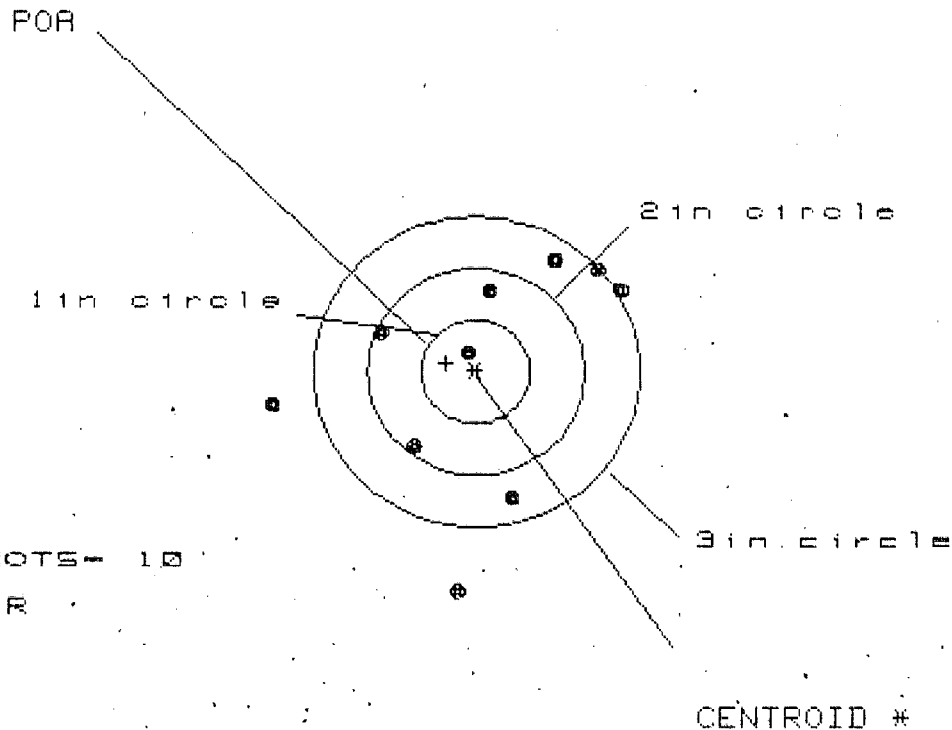
GS = 3.090

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.712
MINIMUM X	-1.101
MAXIMUM Y	1.524
MINIMUM Y	-1.481
CENTROID X	.296
CENTROID Y	-.391
POA TO CENTROID in.	.490
MIN RADIUS	.119
MEAN RADIUS	1.054
MAX RADIUS	1.887
HORIZONTAL SPREAD	2.813
VERTICAL SPREAD	3.005
EXTREME SPREAD	3.090
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 3.161

VS = 3.218

GS = 3.359

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.324	1.304	1.072
MINIMUM X	-1.837	-1.857	-1.084
MAXIMUM Y	1.104	.869	.798
MINIMUM Y	-2.114	-1.472	-1.542
CENTROID X	.272	.292	.524
CENTROID Y	-.082	.153	.223
POR TO CENTROID in.	.284	.330	.570
MIN RADIUS	.246	.131	.372
MEAN RADIUS	1.253	1.111	1.005
MAX RADIUS	2.122	1.941	1.544
HORIZONTAL SPREAD	3.161	3.161	2.156
VERTICAL SPREAD	3.218	2.341	2.341
EXTREME SPREAD	3.359	3.358	2.437
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.906

VS = 2.246

GS = 3.118

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.513

1.358

1.080

MINIMUM X

-1.393

-1.160

-.990

MAXIMUM Y

1.159

1.039

.911

MINIMUM Y

-1.087

-1.023

-.942

CENTROID X

.086

.241

.071

CENTROID Y

-.121

.000

.128

POA TO CENTROID in.

.148

.241

.146

MIN RADIUS

.121

.195

.136

MEAN RADIUS

1.026

.943

.823

MAX RADIUS

1.767

1.701

1.203

HORIZONTAL SPREAD

2.906

2.518

2.070

VERTICAL SPREAD

2.246

2.062

1.853

EXTREME SPREAD

3.118

2.842

2.143

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8