

C6587629

MODEL 700™ M24

Model **SMS**™

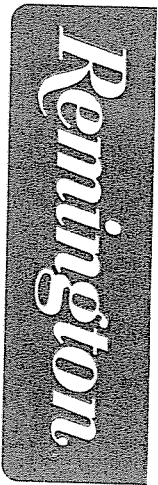
Action

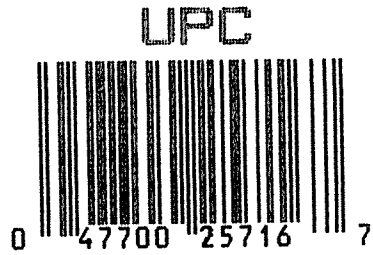
Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6587629	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	
 5716 C6587629			

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587629

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	RW
600	Proof	1019	90	RW
607	Check Headspace	1019	90	RW
610	Dis-assemble Gun	1019	90	RW
612	Magnaflux Barrel Action		10/23/90	KR
	Magnaflux Bolt		10/23/90	KR
615	Rollmark Caliber		10/23/90	B.S.
617	Drill and Tap Sight Holes		10/26/90	FB
618	Polish Barrel RW		10/29/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/29/90	TH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3.75	3.50	3.75	11/29/90	KL
	G) Safety Off Force	2.25 2.50	2.50	2.25	11.29/90	KL
	H) Trigger Pull Test & Retainability				11/29/90	KL
	I) Firing Pin Indent	.023	.022	.022	11/29-90	KL
	J) Assemble Stock				12/4/90	RW
	K) Assemble Swivel Studs				12-4-90	KL
	L) Attach Front and Rear Sight Assemblies				12/4/90	RW
	M) Iron Sight Alignment				12/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container				12/4/90	RW
	O) Attach Scope to Rifle				12/4/90	RW
	P) Detach & Attach Scope 20 Times				12/4/90	RW
640	Gallery Target & Test				12-5-90	DH
	A) Time				12-5-90	DH
	B) Malfunctions				12-5-90	DH
	C) Pierced Primers				12-5-90	DH
	D) Optical Clarity of Scope				12-5-90	DH
645	Inspect for Live Ammo				12-5-90	DH
655	Final Inspection				12-6-90	KL
	A) Headspace				12-6-90	KL
	B) Trigger Pull	294	289	226 229 220	12-6-90	KL
	C) Function				12-6-90	KL
660	Pack				12/19/90	KL

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

SERIAL NO. C6587629DATE 11-29-98TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.31	2.23	2.94	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.42	2.30	2.89	
PULL #3	2.21	2.28	2.13	2.26	
PULL #4	2.20	2.30	2.38	2.29	
PULL #5	2.43	2.37	2.28	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.17		
PULL #2	3.50	3.13		
PULL #3	3.49	3.40		
PULL #4	3.48	3.25		
PULL #5	3.45	3.34		
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	4.35		4.28
PULL #2	4.38	4.33		4.34
PULL #3	4.35	4.32		4.38
PULL #4	4.21	4.12		4.15
PULL #5	4.32	4.29		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587629
5 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.288045
1 TO	2	.234472
1 TO	3	.515909
1 TO	4	.333736
1 TO	5	.435488

←----POA

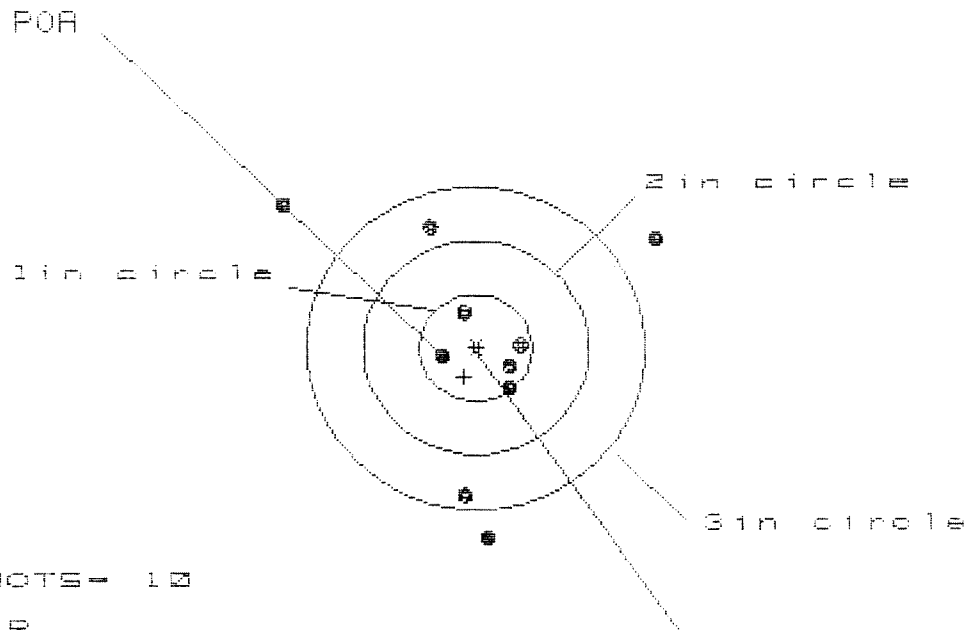
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0626
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0136
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0640603

THE AMR FOR THIS RIFLE IS: .9652

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587629

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 3.314

VS = 3.084

GS = 3.585

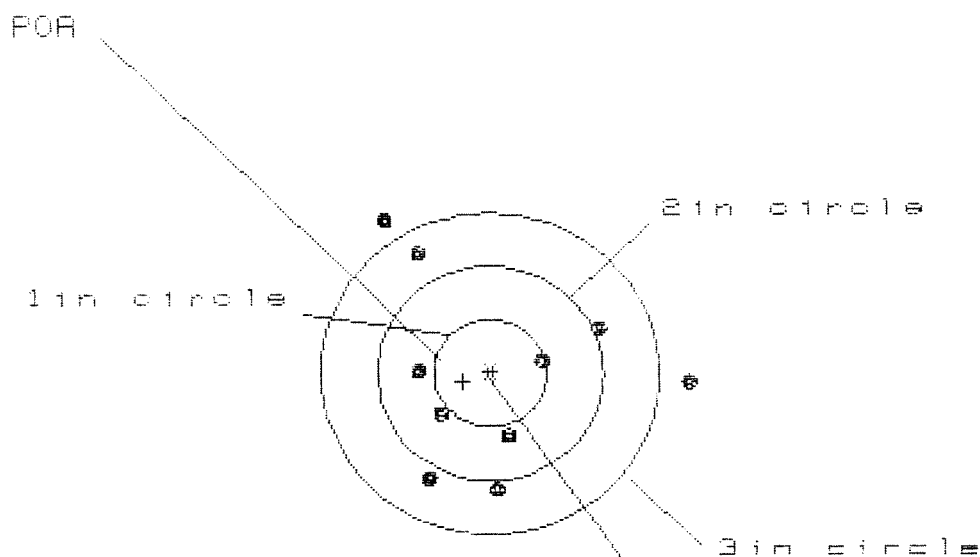
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.563	1.368	.324
MINIMUM X	:	-1.751	-.581	-.410
MAXIMUM Y	:	1.290	1.319	1.466
MINIMUM Y	:	-1.793	-1.650	-1.503
CENTROID X	:	.103	.298	.127
CENTROID Y	:	.269	.125	-.022
POA TO CENTROID in.	:	.288	.323	.128
MIN RADIUS	:	.275	.126	.297
MEAN RADIUS	:	1.037	.875	.777
MAX RADIUS	:	2.175	1.802	1.522
HORIZONTAL SPREAD	:	3.314	1.949	.734
VERTICAL SPREAD	:	3.084	2.969	2.969
EXTREME SPREAD	:	3.585	3.190	3.005
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.703

VS= 2.541

GS= 3.094

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.724	1.115	1.017
MINIMUM X	:	-.979	-.787	-.575
MAXIMUM Y	:	1.419	1.410	1.288
MINIMUM Y	:	-1.122	-1.131	-.955
CENTROID X	:	.239	.047	.145
CENTROID Y	:	.078	.087	-.089
POA TO CENTROID in.	:	.251	.099	.170
MIN RADIUS	:	.481	.418	.432
MEAN RADIUS	:	1.027	.935	.817
MAX RADIUS	:	1.727	1.614	1.411
HORIZONTAL SPREAD	:	2.703	1.902	1.592
VERTICAL SPREAD	:	2.541	2.541	2.243
EXTREME SPREAD	:	3.094	2.729	2.345
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.254

VS = 2.395

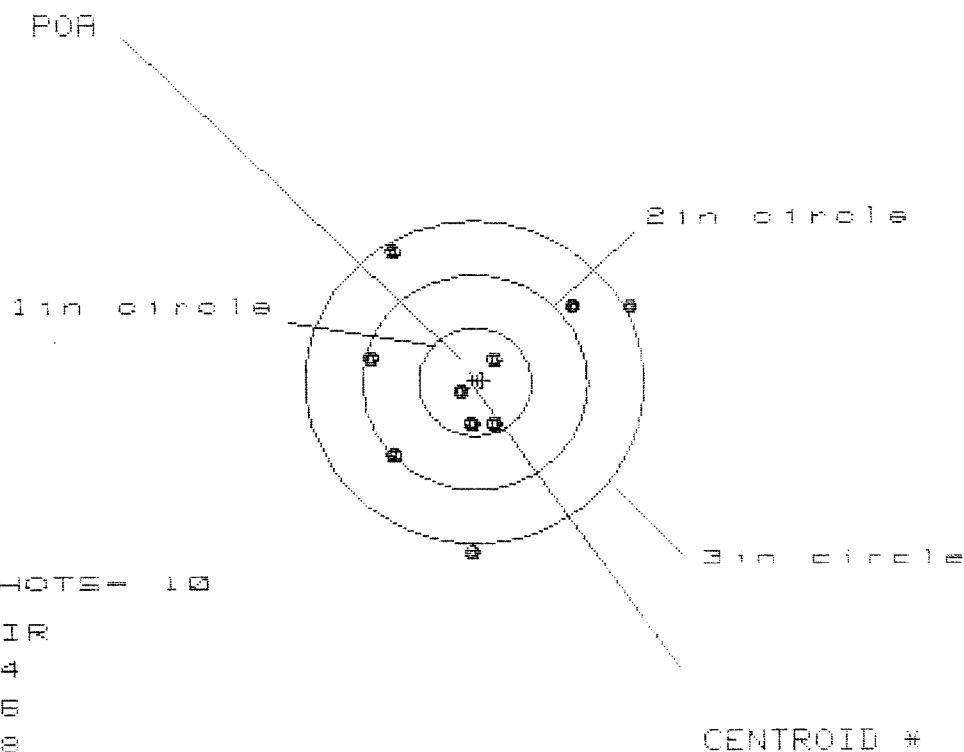
GS = 2.604

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.251	1.310	1.263
MINIMUM X	:	-1.003	-.944	-.780
MAXIMUM Y	:	1.334	.960	1.063
MINIMUM Y	:	-1.061	-.913	-.810
CENTROID X	:	.032	-.027	-.191
CENTROID Y	:	-.242	-.390	-.493
POA TO CENTROID in.	:	.244	.391	.528
MIN RADIUS	:	.433	.346	.376
MEAN RADIUS	:	1.000	.920	.819
MAX RADIUS	:	1.435	1.545	1.319
HORIZONTAL SPREAD	:	2.254	2.254	2.043
VERTICAL SPREAD	:	2.395	1.873	1.873
EXTREME SPREAD	:	2.604	2.459	2.156
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.261

VS= 2.861

GS= 2.964

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.374	1.376	1.021
MINIMUM X	:	-.886	-.885	-.713
MAXIMUM Y	:	1.245	1.065	1.138
MINIMUM Y	:	-1.616	-.823	-.750
CENTROID X	:	-.069	-.071	-.243
CENTROID Y	:	-.017	.163	.090
POA TO CENTROID in.	:	.071	.178	.259
MIN RADIUS	:	.181	.176	.190
MEAN RADIUS	:	.894	.827	.725
MAX RADIUS	:	1.616	1.495	1.280
HORIZONTAL SPREAD	:	2.261	2.261	1.734
VERTICAL SPREAD	:	2.861	1.888	1.888
EXTREME SPREAD	:	2.964	2.536	2.058
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.133

VS= 2.748

GS= 2.830

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	1.025	.886
MINIMUM X	:	-1.134	-1.108	-.540
MAXIMUM Y	:	1.653	.814	.734
MINIMUM Y	:	-1.095	-.912	-.992
CENTROID X	:	.008	-.018	.121
CENTROID Y	:	-.156	-.339	-.259
POR TO CENTROID in.	:	.156	.340	.286
MIN RADIUS	:	.179	.165	.279
MEAN RADIUS	:	.868	.770	.703
MAX RADIUS	:	1.669	1.281	1.129
HORIZONTAL SPREAD	:	2.133	2.133	1.426
VERTICAL SPREAD	:	2.748	1.726	1.726
EXTREME SPREAD	:	2.830	2.278	1.842
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	