

C6587655

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®

MODEL 700™ H24

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

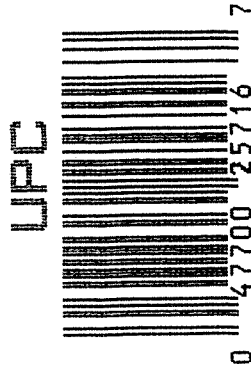
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6587655

ORDER NO.
5716

Ø1



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587655

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KS
600	Proof		10/18/90	KS
607	Check Headspace		10/18/90	KS
610	Dis-assemble Gun		10/18/90	KS
612	Magnaflux Barrel Action		10/22	KR
	Magnaflux Bolt		10/22	KR
615	Rollmark Caliber		10/27	LS
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel <i>RB</i>		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	Apply Coating (Bolt)			
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		11/2/90	GS

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4.50	4.25	4.25	11-9-90	KJ		
	G) Safety Off Force	2.25	2.25	2.0	11-9-90	KJ		
	H) Trigger Pull Test & Retainability				12 Nov 90	JS		
	I) Firing Pin Indent	.023	.022	.022	11-9-90	KJ		
	J) Assemble Stock				11/12/90	KS		
	K) Assemble Swivel Studs				11/19/90	JS		
	L) Attach Front and Rear Sight Assemblies				11/12/90	KS		
	M) Iron Sight Alignment				11/12/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				11/12/90	KS		
	O) Attach Scope to Rifle				11/12/90	KS		
	P) Detach & Attach Scope 20 Times				11/12/90	KS		
640	Gallery Target & Test				11-13-90	AC		
	A) Time				11-13-90	AC		
	B) Malfunctions				11-13-90	AC		
	C) Pierced Primers				11-13-90	AC		
	D) Optical Clarity of Scope				11-13-90	AC		
645	Inspect for Live Ammo				11-13-90	AC		
655	Final Inspection				11/19/90	JS		
	A) Headspace				11/19/90	JS		
	B) Trigger Pull	237	240	242	241	244	11/19/90	JS
	C) Function						11/19/90	JS
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. C6587655

DATE 12 NOV 90

TESTER 928

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	227	265	259	237	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	227	255	267	240	
PULL #3	221	257	266	242	
PULL #4	223	257	269	241	
PULL #5	219	259	265	244	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	348	346		
PULL #2	345	353		
PULL #3	345	349		
PULL #4	345	350		
PULL #5	353	353		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	416	403		419
PULL #2	416	414		419
PULL #3	403	393		421
PULL #4	413	413		411
PULL #5	411	414		417
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587655
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.626125
1 TO	2	.386174
1 TO	3	.741772
1 TO	4	.751779
1 TO	5	.780236

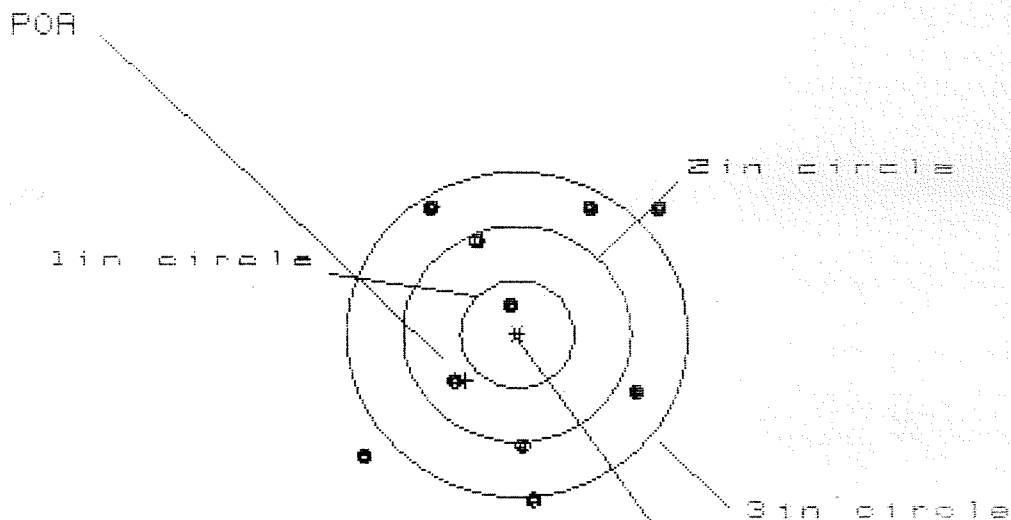
s_y^2 $\leftarrow$ ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0506
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0918
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104822
THE AMR FOR THIS RIFLE IS: 1.016

13 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06587655

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.621

VS= 2.760

GS= 3.488

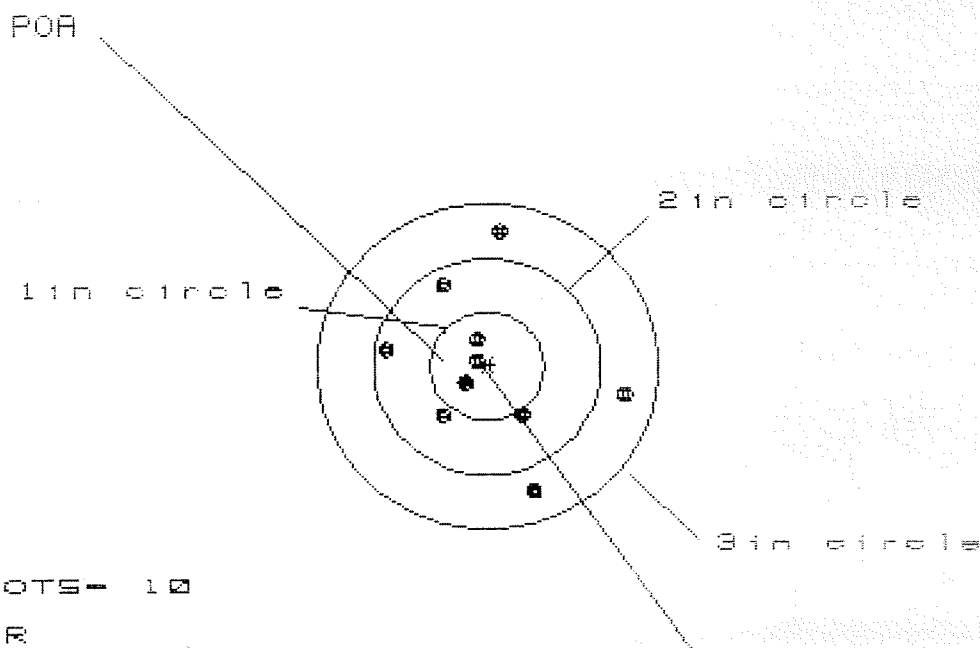
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.254	1.102	1.064
MINIMUM X	-1.367	-0.935	-0.797
MAXIMUM Y	1.216	1.095	1.231
MINIMUM Y	-1.544	-1.665	-1.529
CENTROID X	.457	.609	.471
CENTROID Y	.428	.549	.413
POA TO CENTROID in.	.626	.920	.626
MIN RADIUS	.261	.225	.278
MEAN RADIUS	1.204	1.136	1.070
MAX RADIUS	1.747	1.666	1.531
HORIZONTAL SPREAD	2.621	2.037	1.861
VERTICAL SPREAD	2.760	2.760	2.760
EXTREME SPREAD	3.488	2.991	2.897
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

13 Nov 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.073

VS= 2.447

GS= 2.459

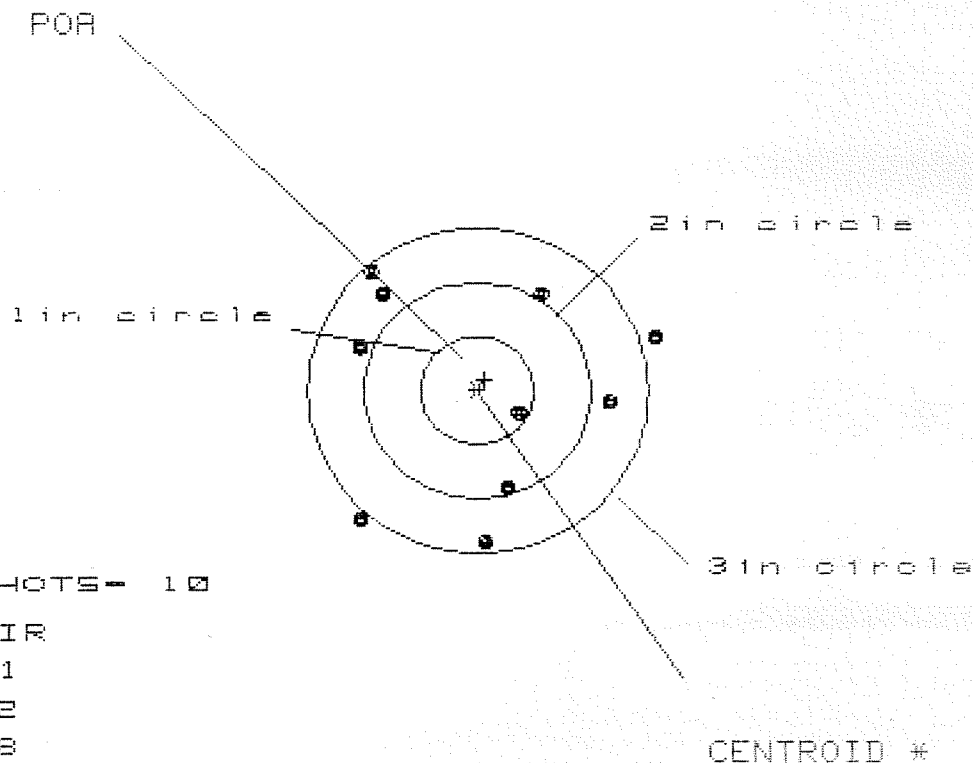
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.179	1.197	1.248
MINIMUM X	:	-.894	-.876	-.825
MAXIMUM Y	:	1.289	.853	.726
MINIMUM Y	:	-1.158	-1.014	-.414
CENTROID X	:	.190	.172	.121
CENTROID Y	:	.149	.005	.132
POA TO CENTROID in.	:	.241	.173	.179
MIN RADIUS	:	.084	.173	.036
MEAN RADIUS	:	.710	.638	.553
MAX RADIUS	:	1.299	1.200	1.267
HORIZONTAL SPREAD	:	2.073	2.073	2.073
VERTICAL SPREAD	:	2.447	1.867	1.140
EXTREME SPREAD	:	2.459	2.114	2.114
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS= 2.598

VS= 2.457

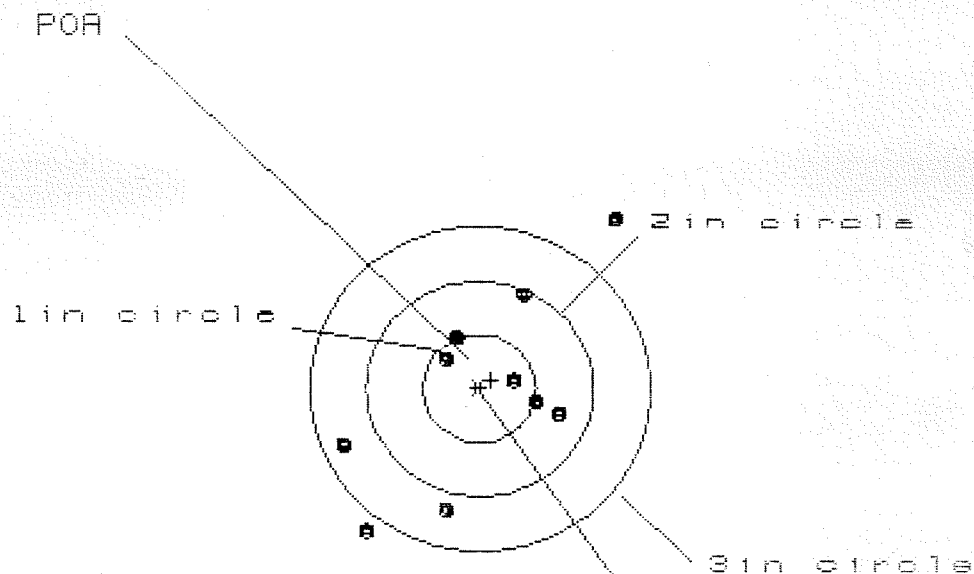
GS= 3.121

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.518	1.398	1.202
MINIMUM X	-1.080	-1.192	-1.018
MAXIMUM Y	1.106	.968	1.011
MINIMUM Y	-1.351	-1.489	-1.446
CENTROID X	-.064	.056	-.118
CENTROID Y	-.100	.038	-.085
POA TO CENTROID in.	.119	.068	.118
MIN RADIUS	.378	.389	.476
MEAN RADIUS	1.198	1.135	1.095
MAX RADIUS	1.649	1.492	1.449
HORIZONTAL SPREAD	2.598	2.590	2.220
VERTICAL SPREAD	2.457	2.457	2.457
EXTREME SPREAD	3.121	2.624	2.624
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.417

VS= 2.946

GS= 3.673

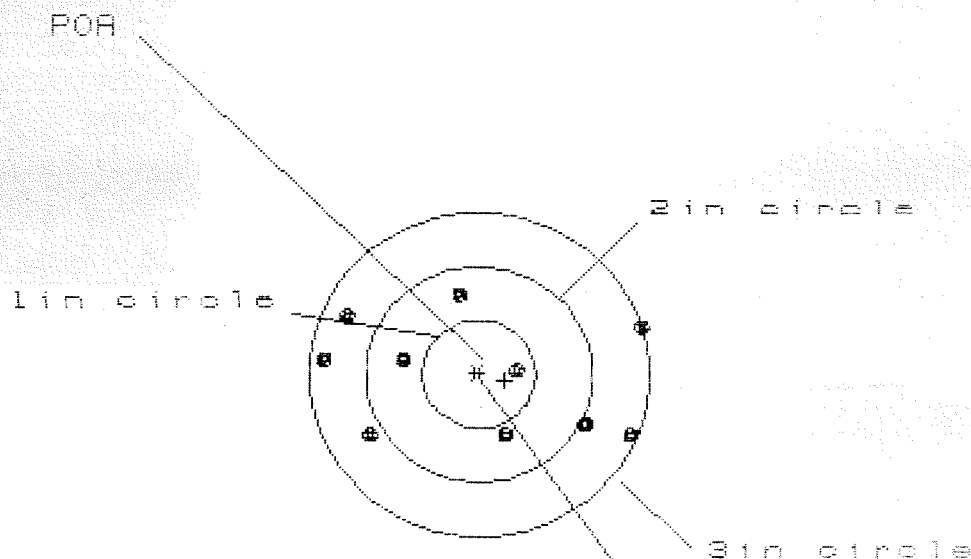
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.179	.853	.742
MINIMUM X	:	-1.238	-1.106	-1.217
MAXIMUM Y	:	1.626	1.012	.870
MINIMUM Y	:	-1.320	-1.140	-1.123
CENTROID X	:	-.099	-.231	-.120
CENTROID Y	:	-.078	-.258	-.116
POA TO CENTROID in.	:	.126	.346	.167
MIN RADIUS	:	.271	.470	.304
MEAN RADIUS	:	.954	.867	.742
MAX RADIUS	:	2.009	1.442	1.297
HORIZONTAL SPREAD	:	2.417	1.959	1.959
VERTICAL SPREAD	:	2.946	2.152	1.993
EXTREME SPREAD	:	3.673	2.565	2.105
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



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.844

VS= 1.302

GS= 2.866

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.504	1.281
MINIMUM X	:	-1.392	-1.231	-1.043
MAXIMUM Y	:	.741	.793	.729
MINIMUM Y	:	-.561	-.509	-.551
CENTROID X	:	-.231	-.392	-.580
CENTROID Y	:	.060	.008	.072
POA TO CENTROID in.	:	.239	.392	.585
MIN RADIUS	:	.362	.525	.333
MEAN RADIUS	:	1.014	.949	.847
MAX RADIUS	:	1.524	1.588	1.350
HORIZONTAL SPREAD	:	2.844	2.735	2.324
VERTICAL SPREAD	:	1.302	1.302	1.280
EXTREME SPREAD	:	2.866	2.815	2.381
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	