

C6587665

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



Remington®

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

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

MODEL 700™ M24

SERIAL NO.
C6587665

ORDER NO.
5716

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



5716 C6587665

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *CG587665*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	<i>10 9 90</i>	<i>90</i>	<i>RW</i>
600	Proof	<i>10 9 90</i>	<i>90</i>	<i>RW</i>
607	Check Headspace	<i>10 9 90</i>	<i>90</i>	<i>RW</i>
610	Dis-assemble Gun	<i>10 9 90</i>	<i>90</i>	<i>RW</i>
612	Magnaflux Barrel Action		<i>10/11/90</i>	<i>KR</i>
	Magnaflux Bolt		<i>10/11/90</i>	<i>KR</i>
615	Rollmark Caliber		<i>10/11/90</i>	<i>LS</i>
617	Drill and Tap Sight Holes		<i>10/11/90</i>	<i>LB</i>
618	Polish Barrel <i>RIB</i>		<i>10/12/90</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>10-12-90</i>	<i>TA</i>
	Apply Coating (Bolt)		<i>10-12-90</i>	<i>TA</i>
625	Final Assembly			
	A) Clean inside of Bolt Assembly		<i>10/22/90</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>10/22/90</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>10/22/90</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>10/22/90</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>11/9/90</i>	<i>WB</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/9/90	WB
	G) Safety Off Force	3	3	3			11/9/90	WB
	H) Trigger Pull Test & Retainability						11/9/90	GB
	I) Firing Pin Indent	.020	.020	.020			11/9/90	WB
	J) Assemble Stock						11/10/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/10/90	RW
	M) Iron Sight Alignment						11/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/10/90	RW
	O) Attach Scope to Rifle						11/10/90	RW
	P) Detach & Attach Scope 20 Times						11/10/90	RW
640	Gallery Target & Test						11-12-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						11-12-90	A
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	243	248	249	248	248	11-20-90	DH
	C) Function						11-20-90	DH
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. C6587665

DATE 9 NOV 90

TESTER QIS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	256	232	221	243	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	250	223	212	248	
PULL #3	252	227	220	249	
PULL #4	255	229	227	248	
PULL #5	244	221	225	248	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	291	283		
PULL #2	282	283		
PULL #3	291	281		
PULL #4	294	281		
PULL #5	282	286		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	401	390		440
PULL #2	393	391		431
PULL #3	391	388		429
PULL #4	386	390		428
PULL #5	387	388		427
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587665
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.239107
1 TO	2	.545015
1 TO	3	.29805
1 TO	4	.275427
1 TO	5	.627405

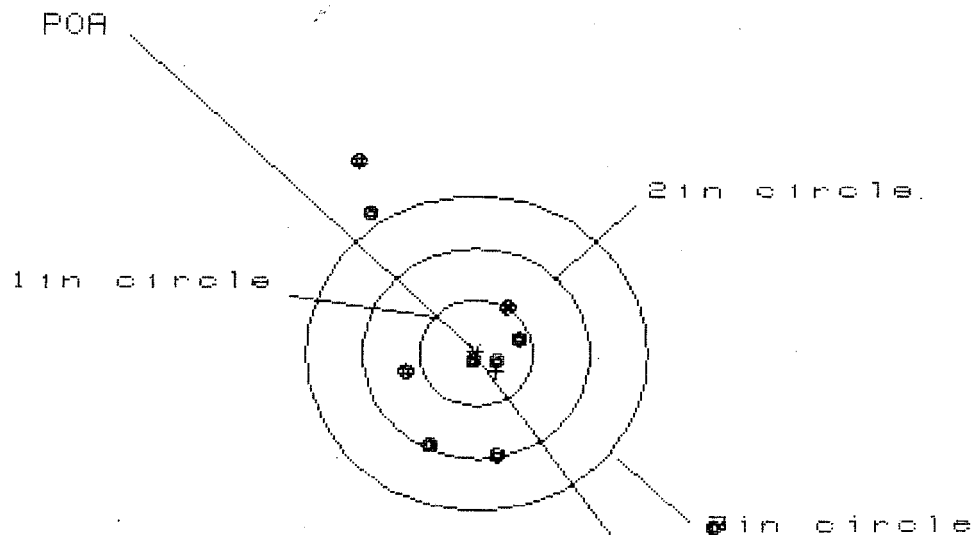
5 1.2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .170162
THE AMR FOR THIS RIFLE IS: 1.072

12 Nov 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 3.122

VS= 3.498

GS= 4.689

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.094	.556	.457
MINIMUM X	-1.028	-.796	-.786
MAXIMUM Y	1.858	1.676	1.354
MINIMUM Y	-1.640	-1.189	-.980
CENTROID X	-.174	-.406	-.307
CENTROID Y	.164	.346	.137
POA TO CENTROID in.	.239	.534	.336
MIN RADIUS	.073	.284	.075
MEAN RADIUS	1.011	.875	.677
MAX RADIUS	2.660	1.855	1.566
HORIZONTAL SPREAD	3.122	1.352	1.243
VERTICAL SPREAD	3.498	2.865	2.334
EXTREME SPREAD	4.689	3.108	2.579
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 1

2in - 2

3in = 8

HS= 2.583

VS= 3.078

GS= 3.104

CENTROID #

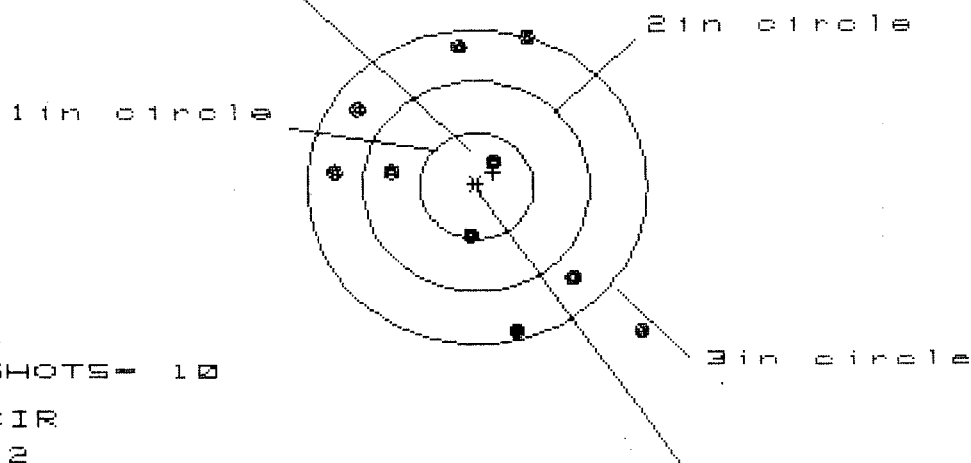
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.373	1.375	1.265
MINIMUM X	:	-1.210	-1.208	-1.036
MAXIMUM Y	:	1.358	1.167	1.057
MINIMUM Y	:	-1.720	-1.440	-1.550
CENTROID X	:	.371	.369	.197
CENTROID Y	:	.168	.359	.469
POA TO CENTROID in.	:	.407	.515	.509
MIN RADIUS	:	.470	.508	.427
MEAN RADIUS	:	1.238	1.161	1.066
MAX RADIUS	:	1.720	1.631	1.550
HORIZONTAL SPREAD	:	2.583	2.583	2.301
VERTICAL SPREAD	:	3.078	2.607	2.607
EXTREME SPREAD	:	3.104	2.867	2.618
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.715

VS= 2.859

GS= 3.246

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.428	1.017	1.093
MINIMUM X	:	-1.287	-1.128	-1.051
MAXIMUM Y	:	1.458	1.303	1.303
MINIMUM Y	:	-1.401	-1.477	-1.315
CENTROID X	:	-.149	-.308	-.385
CENTROID Y	:	-.133	.022	-.140
POA TO CENTROID in.	:	.200	.309	.409
MIN RADIUS	:	.298	.335	.456
MEAN RADIUS	:	1.143	1.026	.964
MAX RADIUS	:	2.000	1.562	1.438
HORIZONTAL SPREAD	:	2.715	2.145	2.145
VERTICAL SPREAD	:	2.859	2.780	2.618
EXTREME SPREAD	:	3.246	2.782	2.664
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

CENTROID *

HS= 2.488

VS= 2.956

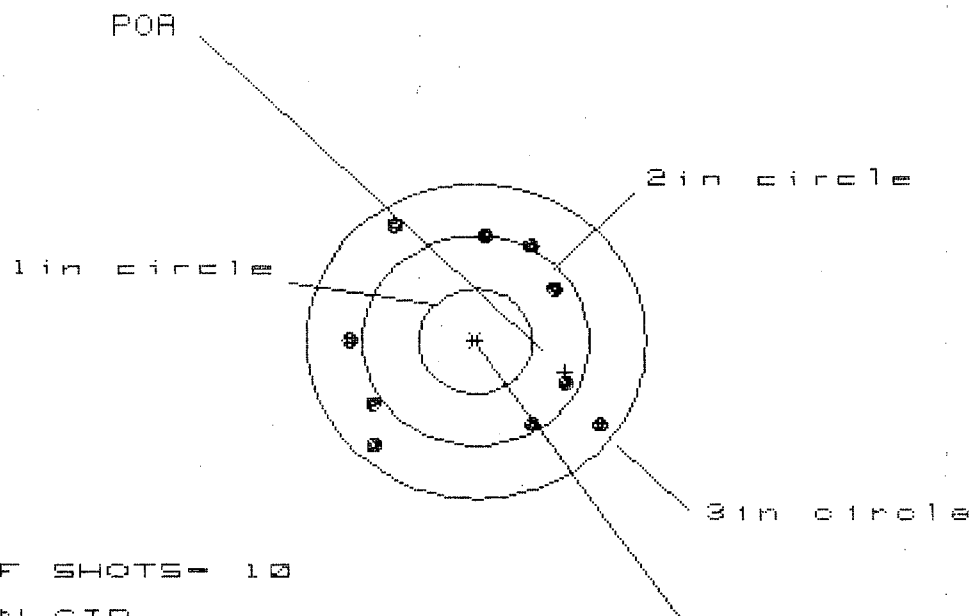
GS= 2.986

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.476	.534
MINIMUM X	:	-1.035	-1.012	-.827
MAXIMUM Y	:	1.811	1.261	1.241
MINIMUM Y	:	-1.145	-.944	-.964
CENTROID X	:	.062	.039	-.146
CENTROID Y	:	.022	-.179	-.159
POA TO CENTROID in.	:	.066	.183	.216
MIN RADIUS	:	.123	.320	.147
MEAN RADIUS	:	.877	.763	.653
MAX RADIUS	:	1.824	1.486	1.262
HORIZONTAL SPREAD	:	2.488	2.488	1.361
VERTICAL SPREAD	:	2.956	2.205	2.205
EXTREME SPREAD	:	2.986	2.496	2.217
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 10

HS = 2.258

VS = 2.080

GS = 2.635

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.133	.940	.848
MINIMUM X	:	-1.125	-.999	-1.091
MAXIMUM Y	:	1.073	.982	.845
MINIMUM Y	:	-1.007	-1.098	-1.045
CENTROID X	:	-.788	-.914	-.822
CENTROID Y	:	.293	.384	.521
POA TO CENTROID in.	:	.841	.992	.973
MIN RADIUS	:	.861	.912	.767
MEAN RADIUS	:	1.092	1.051	.994
MAX RADIUS	:	1.395	1.322	1.178
HORIZONTAL SPREAD	:	2.258	1.939	1.939
VERTICAL SPREAD	:	2.080	2.080	1.890
EXTREME SPREAD	:	2.635	2.346	2.213
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	