

C6587670

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead®

Remington®

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

Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.

C6587670

ORDER NO.

5716

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

01



5716 C6587670

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587670

OP. #	OP. NAME	READINGS	DATE	IN.
575 & 580	Assemble Action and Stock	10 9	90	K
600	Proof	10 9	90	K
607	Check Headspace	10 9	90	K
610	Dis-assemble Gun	10 9	90	K
612	Magnaflux Barrel Action		10/11/90	K
	Magnaflux Bolt		10/11/90	K
615	Rollmark Caliber		10/11/90	L
617	Drill and Tap Sight Holes		10/11/90	K
618	Polish Barrel <i>R/B</i>		10/12/90	u
620	Apply Coatings (Barrel Action)		10-13-90	T
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	K
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	K
	C) Inspect Ejector Hole for Chamfer		10/22/90	K
	D) Oil Firing Pin Ass'y		10/22/90	K
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	K

op. #	OP. NAME	READINGS			DATE	INI		
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2	11/6/90	LC		
	G) Safety Off Force	2 1/4	2 1/2	2 1/4	11/6/90	LC		
	H) Trigger Pull Test & Retainability				11-6-90	X		
	I) Firing Pin Indent	.0205	.021	.021	11/6/90	LC		
	J) Assemble Stock				11/6/90	KC		
	K) Assemble Swivel Studs				11-20-90	92		
	L) Attach Front and Rear Sight Assemblies				11/6/90	KC		
	M) Iron Sight Alignment				11/6/90	KC		
	N) Detach Front & Rear Sights & place in numbered container				11/6/90	KC		
	O) Attach Scope to Rifle				11/6/90	KC		
	P) Detach & Attach Scope 20 Times				11/6/90	KC		
640	Gallery Target & Test				11-8-90	D		
	A) Time				11-8-90	D		
	B) Malfunctions				11-8-90	D		
	C) Pierced Primers				11-8-90	D		
	D) Optical Clarity of Scope				11-8-90	D		
645	Inspect for Live Ammo				11-8-90	D		
655	Final Inspection							
	A) Headspace				11-20-90	925		
	B) Trigger Pull	262	266	264	263	268	11-20-90	925
	C) Function						11-20-90	925
660	Pack						12/18/90	LC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587670DATE 11-6-90TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.27	2.26	262	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN :
PULL #2	2.22	2.28	2.21	266	
PULL #3	2.20	2.28	2.23	264	
PULL #4	2.21	2.27	2.16	273	
PULL #5	2.32	2.28	2.25	268	
TOTAL	11.22	11.38	11.11		
AVG.	2.244	2.276	2.222		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.29		
PULL #2	3.35	3.35		
PULL #3	3.32	3.20		
PULL #4	3.35	3.33		
PULL #5	3.31	3.30		
TOTAL	16.58	16.47		
AVG.	3.316	3.294		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURAC
PULL #1	4.47	4.46		4.40
PULL #2	4.17	4.42		4.41
PULL #3	4.45	4.45		4.41
PULL #4	4.41	4.41		4.32
PULL #5	4.26	4.33		4.41
TOTAL	21.76	22.07		21.95
AVG.	4.352	4.414		4.39

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587670
8 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.358437
1 TO	2	.261205
1 TO	3	.0349857
1 TO	4	.171058
1 TO	5	.369005

$\frac{28}{5}$ <----POA

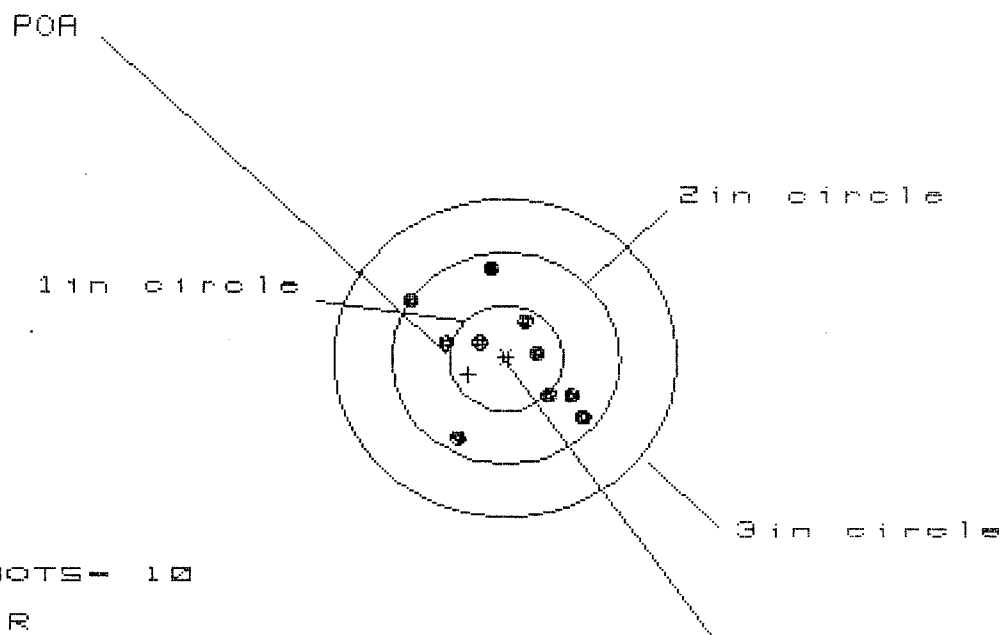
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .268
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .279288
THE AMR FOR THIS RIFLE IS: .7858

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587670

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 10

3 in = 10

HS= 1.531

VS= 1.631

GS= 1.853

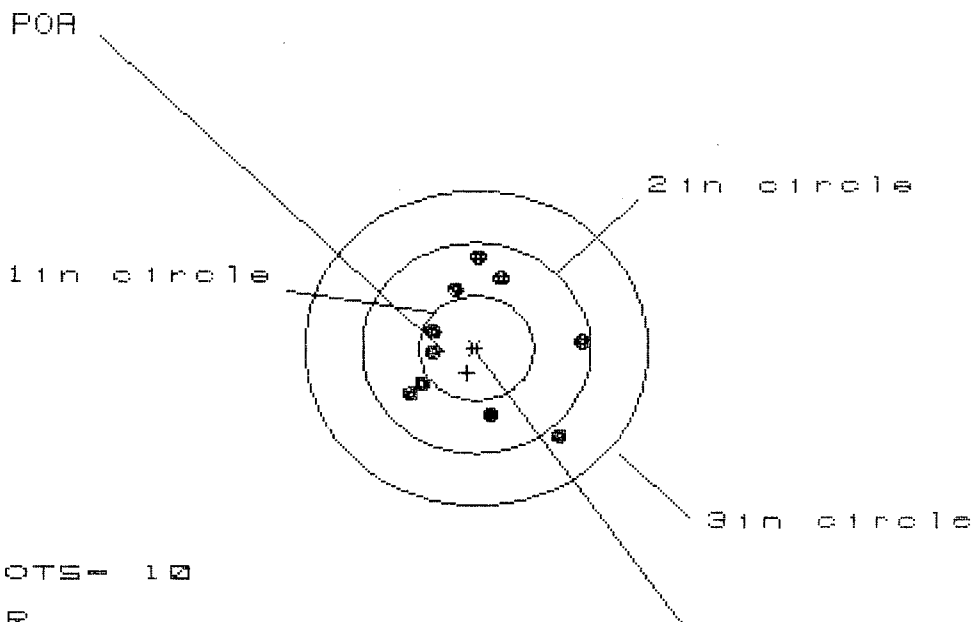
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.708	.616	.592
MINIMUM X	:	-.823	-.587	-.611
MAXIMUM Y	:	.893	.950	.485
MINIMUM Y	:	-.738	-.681	-.562
CENTROID X	:	.326	.418	.442
CENTROID Y	:	.149	.092	-.027
POA TO CENTROID in.	:	.359	.428	.443
MIN RADIUS	:	.224	.238	.271
MEAN RADIUS	:	.613	.564	.512
MAX RADIUS	:	.970	.969	.771
HORIZONTAL SPREAD	:	1.531	1.203	1.203
VERTICAL SPREAD	:	1.631	1.631	1.047
EXTREME SPREAD	:	1.853	1.660	1.369
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	10		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 1.484

VS = 1.683

GS = 1.825

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.923	1.003	.384
MINIMUM X	:	-.560	-.481	-.355
MAXIMUM Y	:	.844	.751	.747
MINIMUM Y	:	-.839	-.754	-.758
CENTROID X	:	.078	-.001	-.127
CENTROID Y	:	.231	.324	.328
POA TO CENTROID in.	:	.244	.324	.352
MIN RADIUS	:	.420	.342	.226
MEAN RADIUS	:	.698	.628	.551
MAX RADIUS	:	1.105	1.004	.841
HORIZONTAL SPREAD	:	1.484	1.484	.739
VERTICAL SPREAD	:	1.683	1.505	1.505
EXTREME SPREAD	:	1.825	1.575	1.512
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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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 = 5

2 in = 7

3 in = 9

HS = 1.796

VS = 2.307

GS = 2.733

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.737	.604
MINIMUM X	:	-.986	-1.059	-.823
MAXIMUM Y	:	1.365	1.118	.431
MINIMUM Y	:	-.942	-.791	-.651
CENTROID X	:	.356	.429	.561
CENTROID Y	:	.167	.016	-.124
POA TO CENTROID in.	:	.394	.429	.575
MIN RADIUS	:	.321	.180	.036
MEAN RADIUS	:	.744	.602	.437
MAX RADIUS	:	1.514	1.540	.929
HORIZONTAL SPREAD	:	1.796	1.796	1.427
VERTICAL SPREAD	:	2.307	1.909	1.082
EXTREME SPREAD	:	2.733	2.621	1.791
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.785

VS= 2.376

GS= 2.581

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	1.016	.970
MINIMUM X	:	-.859	-.769	-.816
MAXIMUM Y	:	1.037	.888	.734
MINIMUM Y	:	-1.339	-1.233	-.866
CENTROID X	:	.436	.346	.393
CENTROID Y	:	.018	.167	.321
POA TO CENTROID in.	:	.436	.384	.507
MIN RADIUS	:	.487	.572	.435
MEAN RADIUS	:	.950	.862	.782
MAX RADIUS	:	1.564	1.288	1.190
HORIZONTAL SPREAD	:	1.785	1.785	1.785
VERTICAL SPREAD	:	2.376	2.121	1.600
EXTREME SPREAD	:	2.581	2.274	2.010
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.295

VS = 2.748

GS = 2.776

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.200	1.185	1.215
MINIMUM X	:	-1.095	-1.110	-1.080
MAXIMUM Y	:	1.470	.790	.650
MINIMUM Y	:	-1.278	-1.114	-.925
CENTROID X	:	.144	.159	.129
CENTROID Y	:	-.172	-.336	-.196
POA TO CENTROID in.	:	.224	.372	.235
MIN RADIUS	:	.336	.279	.353
MEAN RADIUS	:	.924	.854	.808
MAX RADIUS	:	1.477	1.323	1.226
HORIZONTAL SPREAD	:	2.295	2.295	2.295
VERTICAL SPREAD	:	2.748	1.904	1.575
EXTREME SPREAD	:	2.776	2.392	2.392
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	