

C6587695

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

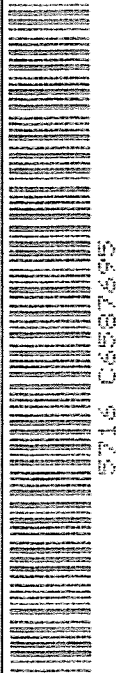
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

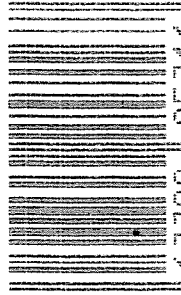
SERIAL NO. C6587695

ORDER NO. 5716

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



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587695

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		11/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		11/5/90	FB
618	Polish Barrel		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-4-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.25	4.50	4.50			1/13/91	KT
	G) Safety Off Force	3.0	3.0	3.0			1/13/91	KT
	H) Trigger Pull Test & Retainability						1-4-91	DH
	I) Firing Pin Indent	.020	.020	.020			1/13/91	KT
	J) Assemble Stock						1/8/91	RW
	K) Assemble Swivel Studs						1-4-91	JH
	L) Attach Front and Rear Sight Assemblies						1/8/91	RW
	M) Iron Sight Alignment						1/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/8/91	RW
	O) Attach Scope to Rifle						1/8/91	RW
	P) Detach & Attach Scope 20 Times						1/8/91	RW
640	Gallery Target & Test						1-11-91	DH
	A) Time						1-11-91	DH
	B) Malfunctions						1-11-91	DH
	C) Pierced Primers						1-11-91	DH
	D) Optical Clarity of Scope						1-11-91	DH
645	Inspect for Live Ammo						1-11-91	DH
655	Final Inspection							
	A) Headspace						1-14-91	JH
	B) Trigger Pull	2.23	2.25	2.28	2.29	2.26	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587695

DATE 1-4-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.33	2.64	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.17	2.69	2.25	
PULL #3	2.26	2.21	2.54	2.28	
PULL #4	2.23	2.21	2.64	2.29	
PULL #5	2.28	2.18	2.60	2.26	
TOTAL	11.39	11.10	13.11		
AVG.	2.27	2.22	2.62		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.79	3.16		
PULL #2	3.01	3.17		
PULL #3	3.11	3.10		
PULL #4	3.15	3.10		
PULL #5	3.19	3.08		
TOTAL	15.65	15.61		
AVG.	3.13	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.34		4.18
PULL #2	4.32	4.05		4.25
PULL #3	4.37	4.30		4.16
PULL #4	4.30	4.34		4.29
PULL #5	4.32	4.12		4.14
TOTAL	21.65	21.15		21.02
AVG.	4.33	4.23		4.20

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06587695
 11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.174837
1 TO	2	.57053
1 TO	3	.270766
1 TO	4	.305367
1 TO	5	.129035

σ_2 <----FOR

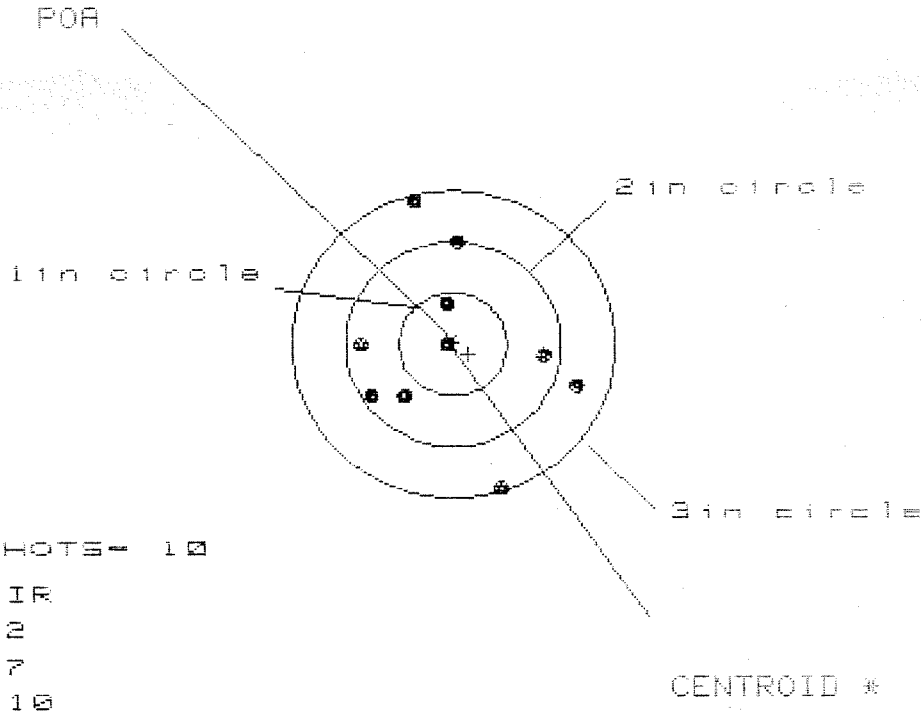
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .069
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0094
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0696373
 THE AMR FOR THIS RIFLE IS: 1.02

11 Jan 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08587695

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.935

VS = 2.822

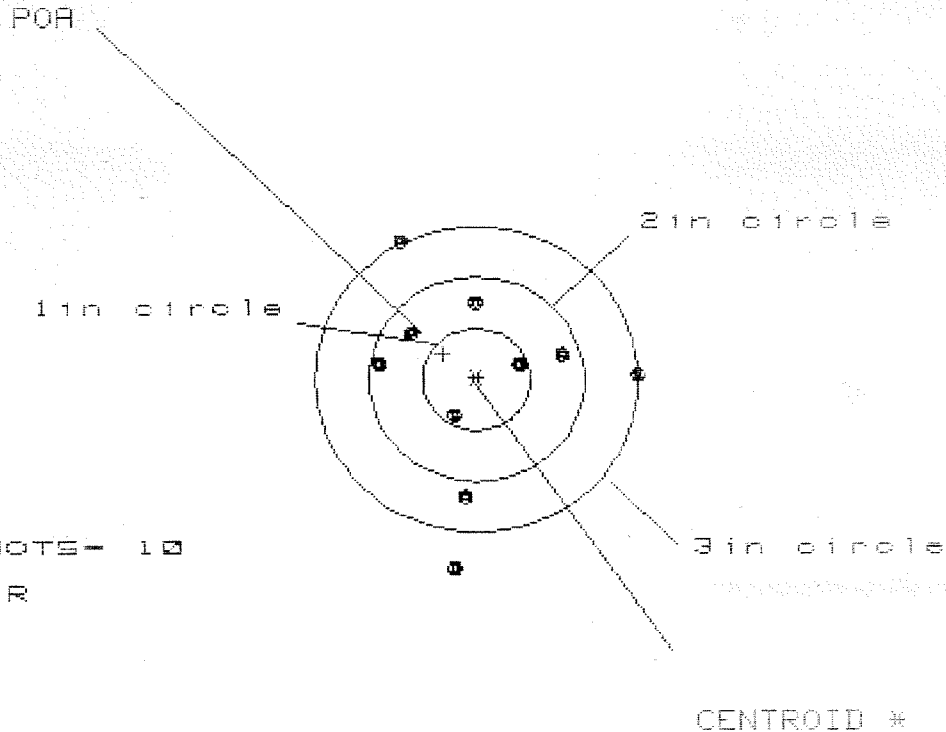
GS = 2.910

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.109	1.074	1.119
MINIMUM X	-.826	-.861	-.816
MAXIMUM Y	1.427	1.107	.953
MINIMUM Y	-1.394	-1.236	-.487
CENTROID X	-.142	-.107	-.152
CENTROID Y	.102	-.057	.097
POA TO CENTROID in.	.174	.121	.180
MIN RADIUS	.032	.142	.024
MEAN RADIUS	.871	.816	.724
MAX RADIUS	1.462	1.287	1.183
HORIZONTAL SPREAD	1.935	1.935	1.935
VERTICAL SPREAD	2.822	2.343	1.440
EXTREME SPREAD	2.910	2.363	1.983
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587695

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 2.441

VS = 3.229

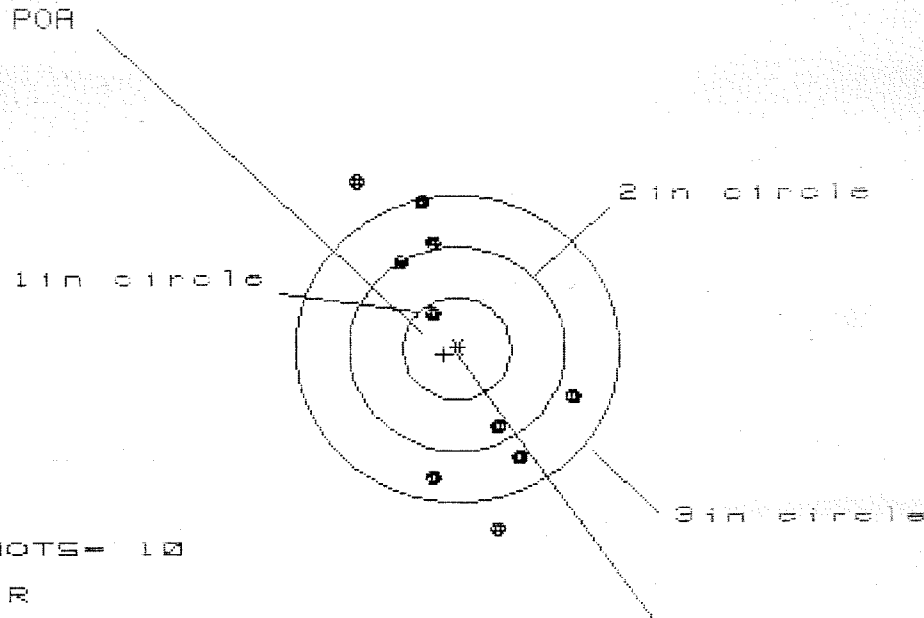
GS = 3.267

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.480	1.394
MINIMUM X	:	-.942	-.961	-1.047
MAXIMUM Y	:	1.386	1.182	.734
MINIMUM Y	:	-1.843	-1.394	-1.247
CENTROID X	:	.307	.326	.412
CENTROID Y	:	-.250	-.046	-.193
POA TO CENTROID in.	:	.396	.329	.455
MIN RADIUS	:	.357	.362	.288
MEAN RADIUS	:	1.022	.909	.845
MAX RADIUS	:	1.850	1.484	1.395
HORIZONTAL SPREAD	:	2.441	2.441	2.441
VERTICAL SPREAD	:	3.229	2.576	1.981
EXTREME SPREAD	:	3.267	2.630	2.442
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587695

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 2.034

VS = 3.372

GS = 3.622

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	.988	1.022
MINIMUM X	:	-.942	-.593	-.559
MAXIMUM Y	:	1.635	1.647	1.453
MINIMUM Y	:	-1.737	-1.555	-1.290
CENTROID X	:	.125	.229	.195
CENTROID Y	:	.057	-.125	.069
POA TO CENTROID in.	:	.137	.261	.207
MIN RADIUS	:	.446	.583	.473
MEAN RADIUS	:	1.213	1.125	1.057
MAX RADIUS	:	1.887	1.702	1.505
HORIZONTAL SPREAD	:	2.034	1.581	1.581
VERTICAL SPREAD	:	3.372	3.202	2.743
EXTREME SPREAD	:	3.622	3.279	2.745
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			7	

11 Jan 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8587695

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 7

3in = 10

HS = 2.642

VS = 1.831

GS = 2.815

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.149	.983	.994
MINIMUM X	-1.493	-1.031	-.908
MAXIMUM Y	.947	.939	1.050
MINIMUM Y	-.884	-.892	-.781
CENTROID X	.158	.324	.201
CENTROID Y	.159	.167	.056
POA TO CENTROID in.	.224	.364	.268
MIN RADIUS	.645	.573	.537
MEAN RADIUS	.989	.920	.854
MAX RADIUS	1.495	1.325	1.084
HORIZONTAL SPREAD	2.642	2.014	1.982
VERTICAL SPREAD	1.831	1.831	1.831
EXTREME SPREAD	2.815	2.435	2.063
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587695

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.580

VS = 2.497

GS = 2.603

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.185	1.031	1.042
MINIMUM X	:	-1.395	-.903	-.892
MAXIMUM Y	:	1.226	1.246	1.090
MINIMUM Y	:	-1.271	-1.251	-1.023
CENTROID X	:	-.103	.052	.041
CENTROID Y	:	-.021	-.041	.115
POA TO CENTROID in.	:	.105	.067	.122
MIN RADIUS	:	.366	.372	.358
MEAN RADIUS	:	1.003	.946	.899
MAX RADIUS	:	1.406	1.276	1.358
HORIZONTAL SPREAD	:	2.580	1.934	1.934
VERTICAL SPREAD	:	2.497	2.497	2.113
EXTREME SPREAD	:	2.603	2.523	2.409
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	