

C6587711

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

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

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

SERIAL NO.
C6587711

ORDER NO.
5716

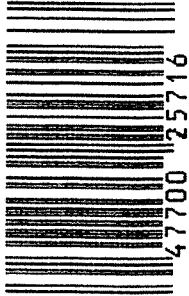
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



5716 C6587711

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587711

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KA
600	Proof		10/18/90	KA
607	Check Headspace		10/18/90	KA
610	Dis-assemble Gun		10/18/90	KA
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	JB
617	Drill and Tap Sight Holes		10/23/90	FB
618	Polish Barrel <i>RB</i>		10/24/90	WB
620	Apply Coatings (Barrel Action)		11/6/90	JA
	Apply Coating (Bolt)		11/6/90	JA
625	Final Assembly A) Clean inside of Bolt Assembly		11-6-90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	K.S.
	C) Inspect Ejector Hole for Chamfer		11-6-90	K.S.
	D) Oil Firing Pin Ass'y		11-6-90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		11/12/90	G.S.

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4. 1/2	4.0	4.0	11-7-90	KJ
	G) Safety Off Force	2. 1/4	2. 1/4	2. 1/4	11-7-90	KJ
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.020	.021	.020	11-7-90	KJ
	J) Assemble Stock				11/12/90	KJ
	K) Assemble Swivel Studs				11/19/90	QJ8
	L) Attach Front and Rear Sight Assemblies				11/12/90	KJ
	M) Iron Sight Alignment				11/12/90	KJ
	N) Detach Front & Rear Sights & place in numbered container				11/12/90	KJ
	O) Attach Scope to Rifle				11/12/90	KJ
	P) Detach & Attach Scope 20 Times				11/12/90	KJ
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					
	A) Headspace				11/19/90	QJ8
	B) Trigger Pull	290	251	242 244 241	11/19/90	QJ8
	C) Function				11/19/90	QJ8
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. C658711
DATE 12/08/90
TESTER gds

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	255	237	210	290	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	286	241	220	251	
PULL #3	241	239	222	242	
PULL #4	234	239	223	244	
PULL #5	217	243	225	241	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	286	305		
PULL #2	303	303		
PULL #3	306	298		
PULL #4	303	299		
PULL #5	303	304		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	383	377		394
PULL #2	378	375		394
PULL #3	378	378		392
PULL #4	386	378		392
PULL #5	379	374		390
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587711
13 Nov 1998

CENTROIDAL DISTANCES

0 TO	1	.250505
1 TO	2	.492
1 TO	3	.284113
1 TO	4	.531361
1 TO	5	.523924

4.5 <----FOR
4

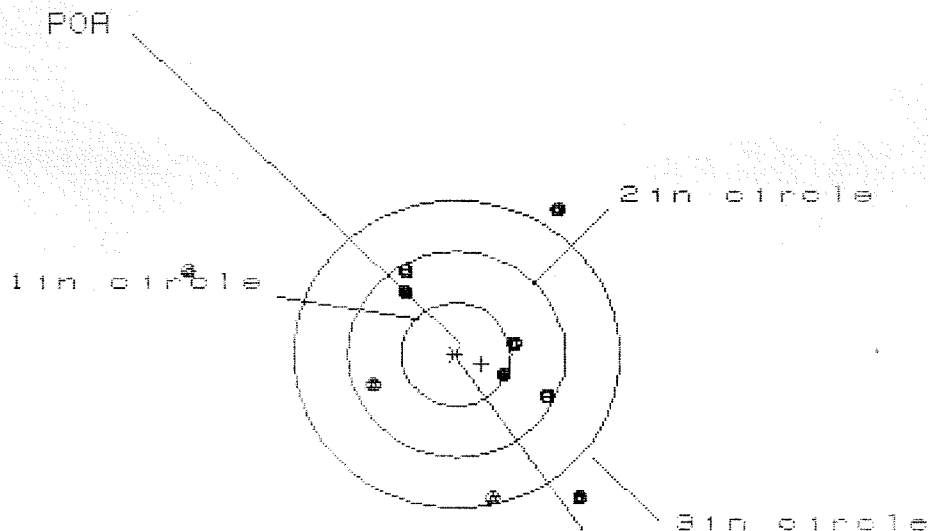
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0978
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0044
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0978989

THE AMR FOR THIS RIFLE IS: .9556

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587711

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.611

VS= 2.829

GS= 4.213

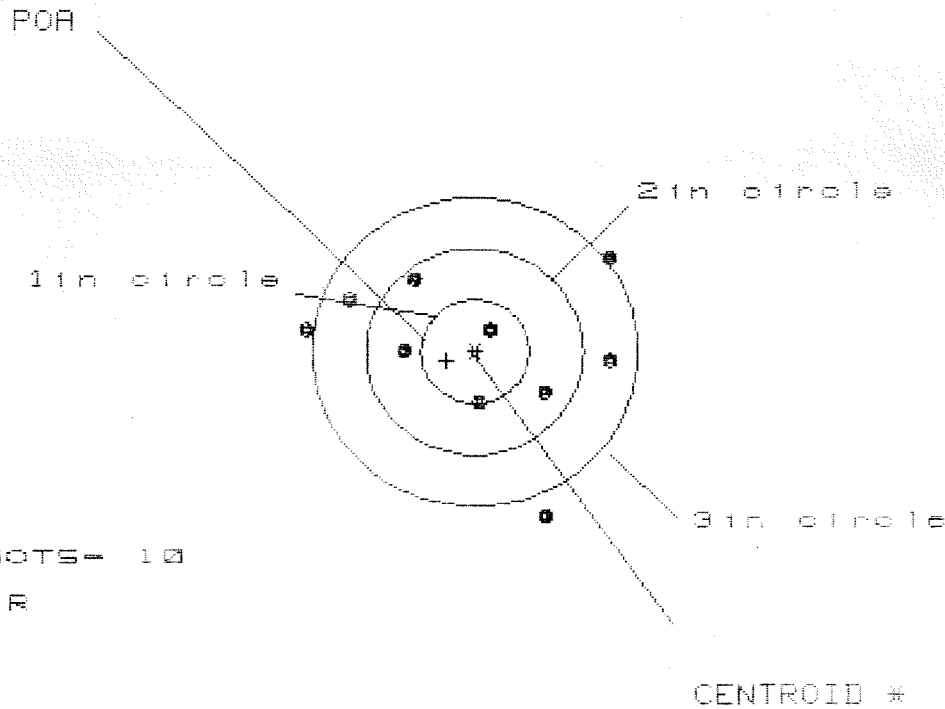
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.141	.866	.793
MINIMUM X	:	-2.470	-1.037	-.928
MAXIMUM Y	:	1.394	1.481	1.319
MINIMUM Y	:	-1.435	-1.348	-1.510
CENTROID X	:	-.233	.042	-.067
CENTROID Y	:	.092	.005	.167
POA TO CENTROID in.	:	.250	.042	.180
MIN RADIUS	:	.487	.211	.352
MEAN RADIUS	:	1.208	1.001	.939
MAX RADIUS	:	2.592	1.632	1.539
HORIZONTAL SPREAD	:	3.611	1.903	1.721
VERTICAL SPREAD	:	2.829	2.829	2.829
EXTREME SPREAD	:	4.213	2.900	2.900
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

13 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587711

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.794

VS= 2.510

GS= 2.836

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	1.337	1.154
MINIMUM X	:	-1.528	-1.457	-1.253
MAXIMUM Y	:	.897	.718	.719
MINIMUM Y	:	-1.613	-.627	-.626
CENTROID X	:	.259	.188	.371
CENTROID Y	:	.092	.271	.270
POA TO CENTROID in.	:	.275	.330	.458
MIN RADIUS	:	.255	.175	.061
MEAN RADIUS	:	1.027	.935	.859
MAX RADIUS	:	1.733	1.475	1.320
HORIZONTAL SPREAD	:	2.794	2.794	2.407
VERTICAL SPREAD	:	2.510	1.345	1.345
EXTREME SPREAD	:	2.836	2.836	2.482
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Nov 1998

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.492

VS= 2.150

GS= 2.373

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.820
MINIMUM X	-.672
MAXIMUM Y	1.303
MINIMUM Y	-.847
CENTROID X	-.001
CENTROID Y	-.072
POA TO CENTROID in.	.072
MIN RADIUS	.229
MEAN RADIUS	.739
MAX RADIUS	1.356
HORIZONTAL SPREAD	1.492
VERTICAL SPREAD	2.150
EXTREME SPREAD	2.373
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10

13 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08587711

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.913

VS= 2.172

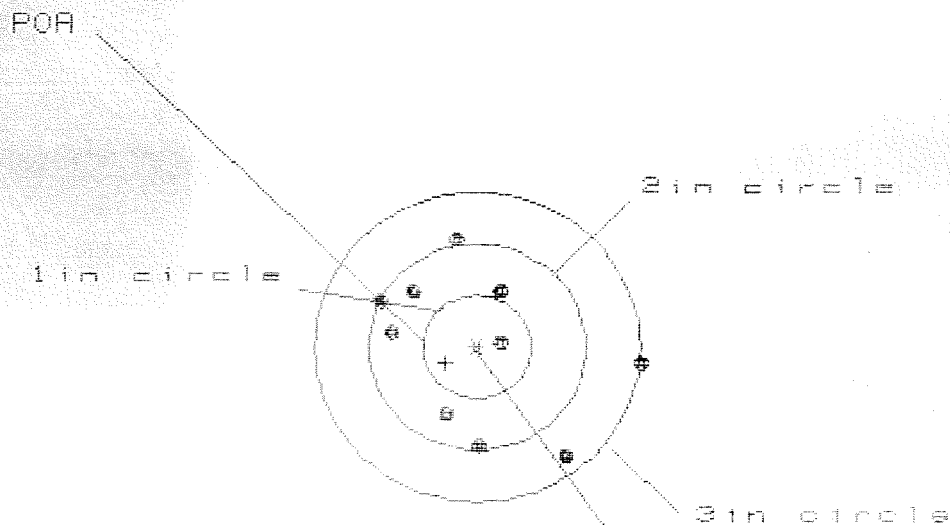
GS= 2.206

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.119	1.117	1.067
MINIMUM X	-.794	-.796	-.846
MAXIMUM Y	1.125	1.045	.929
MINIMUM Y	-1.046	-.921	-1.031
CENTROID X	.177	.179	.229
CENTROID Y	-.246	-.372	-.256
POA TO CENTROID in.	.304	.412	.344
MIN RADIUS	.453	.500	.500
MEAN RADIUS	.903	.869	.850
MAX RADIUS	1.126	1.126	1.067
HORIZONTAL SPREAD	1.913	1.913	1.913
VERTICAL SPREAD	2.172	1.966	1.960
EXTREME SPREAD	2.206	2.086	1.977
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

13 May 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.418

VS = 2.160

GS = 2.500

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.523	.936	.495
MINIMUM X	-.894	-.725	-.600
MAXIMUM Y	1.082	1.064	.927
MINIMUM Y	-1.078	-1.096	-1.091
CENTROID X	.287	.118	.001
CENTROID Y	.156	.174	.311
POA TO CENTROID in.	.327	.211	.311
MIN RADIUS	.202	.369	.460
MEAN RADIUS	.901	.816	.711
MAX RADIUS	1.532	1.441	1.142
HORIZONTAL SPREAD	2.418	1.661	1.103
VERTICAL SPREAD	2.160	2.160	2.018
EXTREME SPREAD	2.500	2.374	2.036
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		