

C6587726

MODEL 700™ M24

Model **SMS**™

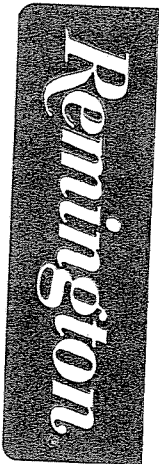
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

SERIAL NO.
C6587726

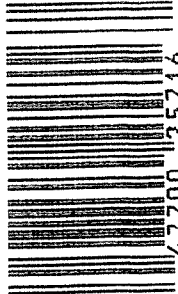
ORDER NO.
5716

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



5716 C6587726

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06587726

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1023	90	RW
600	Proof	1023	90	RW
607	Check Headspace	1023	90	RW
610	Dis-assemble Gun	1023	90	RW
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GB
617	Drill and Tap Sight Holes		10/25/90	FB
618	Polish Barrel RB		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/17/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	5	5			11/16/90	WB
	G) Safety Off Force	2	2	2			11/16/90	WB
	H) Trigger Pull Test & Retainability						11/17/90	WB
	I) Firing Pin Indent	.0225	.023	.023			11/16/90	WB
	J) Assemble Stock						12/4/90	RW
	K) Assemble Swivel Studs						12-5-90	JS
	L) Attach Front and Rear Sight Assemblies						12/4/90	RW
	M) Iron Sight Alignment						12/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/90	RW
	O) Attach Scope to Rifle						12/4/90	RW
	P) Detach & Attach Scope 20 Times						12/4/90	RW
640	Gallery Target & Test						12/4/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12/4/90	NF
655	Final Inspection							
	A) Headspace						12-5-90	JS
	B) Trigger Pull	285	296	296	295	279	12-5-90	JS
	C) Function						12-5-90	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. C6587726DATE 11/17/90TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.50	2.60	2.85	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.48	2.40	2.96	
PULL #3	2.59	2.60	2.30	2.96	
PULL #4	2.57	2.60	2.57	2.85	
PULL #5	2.55	2.55	2.58	2.79	
TOTAL	12.68	12.73	12.45		
AVG.	2.53	2.54	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.20		
PULL #2	3.12	3.19		
PULL #3	3.14	3.11		
PULL #4	3.24	3.12		
PULL #5	3.23	3.13		
TOTAL	15.95	15.75		
AVG.	3.19	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.07		4.08
PULL #2	4.16	4.09		4.09
PULL #3	4.18	4.13		4.20
PULL #4	4.15	4.12		4.20
PULL #5	4.06	4.13		4.21
TOTAL	20.80	20.54		20.78
AVG.	4.16	4.11		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587726
5 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.290408
1 TO	2	.564809
1 TO	3	.247251
1 TO	4	.447967
1 TO	5	.486498

$\frac{1}{5}$ <----POA

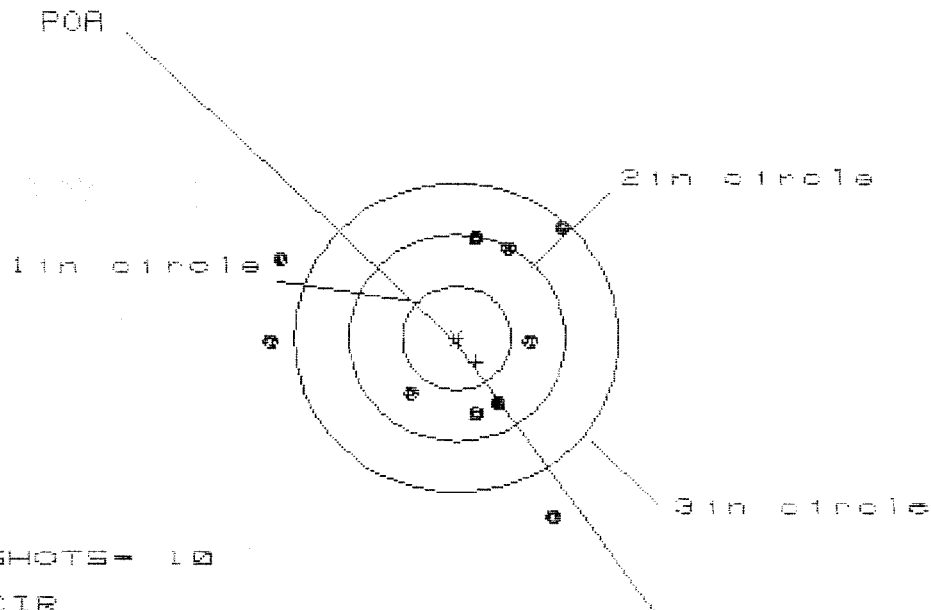
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .057393

THE AMR FOR THIS RIFLE IS: 1.021

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587726

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 2.716

VS= 2.752

GS= 3.498

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.998	1.095	.904
MINIMUM X	-1.718	-1.621	-1.812
MAXIMUM Y	1.069	.882	.955
MINIMUM Y	-1.683	-.954	-.882
CENTROID X	-.176	-.273	-.082
CENTROID Y	.231	.418	.346
POA TO CENTROID in.	.290	.499	.355
MIN RADIUS	.641	.751	.578
MEAN RADIUS	1.163	1.092	.980
MAX RADIUS	1.896	1.640	1.821
HORIZONTAL SPREAD	2.716	2.716	2.716
VERTICAL SPREAD	2.752	1.836	1.836
EXTREME SPREAD	3.498	2.944	2.944
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

5 Dec 1998

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.052

VS= 3.168

CS= 3.582

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.669	1.310	1.280
MINIMUM X	:	-1.393	-1.208	-1.238
MAXIMUM Y	:	1.761	1.651	1.112
MINIMUM Y	:	-1.407	-1.517	-1.310
CENTROID X	:	.096	-.089	-.059
CENTROID Y	:	-.264	-.154	-.361
POA TO CENTROID in.	:	.281	.178	.366
MIN RADIUS	:	.192	.086	.126
MEAN RADIUS	:	1.194	1.084	1.013
MAX RADIUS	:	1.940	1.730	1.596
HORIZONTAL SPREAD	:	3.062	2.518	2.518
VERTICAL SPREAD	:	3.168	3.168	2.422
EXTREME SPREAD	:	3.582	3.209	3.166
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

CENTROID #

HS= 2.195

VS= 2.502

GS= 3.046

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.277	1.245
MINIMUM X	:	-.807	-.653	-.685
MAXIMUM Y	:	1.170	1.039	.857
MINIMUM Y	:	-1.332	-1.463	-1.115
CENTROID X	:	-.109	-.263	-.231
CENTROID Y	:	-.007	.124	.306
POA TO CENTROID in.	:	.109	.291	.384
MIN RADIUS	:	.188	.144	.296
MEAN RADIUS	:	.974	.845	.754
MAX RADIUS	:	1.817	1.484	1.251
HORIZONTAL SPREAD	:	2.195	1.930	1.930
VERTICAL SPREAD	:	2.502	2.502	1.972
EXTREME SPREAD	:	3.046	2.506	2.046
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.593

VS= 2.615

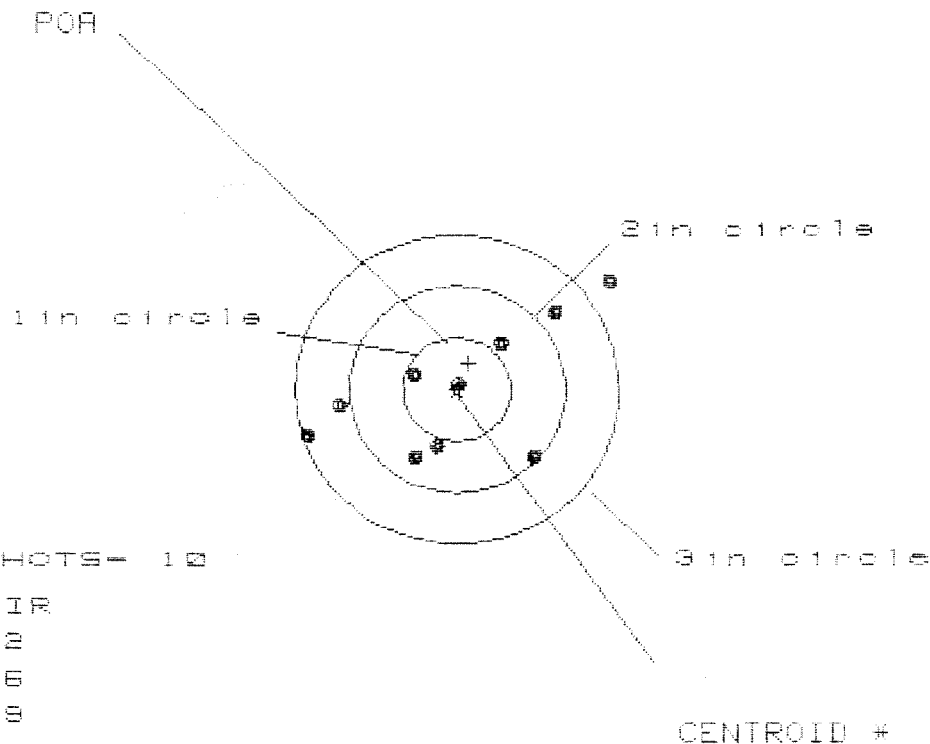
GS= 2.974

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.161	1.277	1.113
MINIMUM X	:	-1.432	-1.316	-0.873
MAXIMUM Y	:	1.072	.900	.772
MINIMUM Y	:	-1.543	-1.028	-0.736
CENTROID X	:	.217	.101	.265
CENTROID Y	:	.016	.188	.316
POA TO CENTROID in.	:	.218	.213	.413
MIN RADIUS	:	.173	.068	.074
MEAN RADIUS	:	.902	.752	.623
MAX RADIUS	:	1.864	1.670	1.153
HORIZONTAL SPREAD	:	2.593	2.593	1.986
VERTICAL SPREAD	:	2.615	1.928	1.508
EXTREME SPREAD	:	2.974	2.974	2.075
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.721

VS= 1.719

GS= 3.113

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.368
MINIMUM X	-1.353
MAXIMUM Y	1.043
MINIMUM Y	-.676
CENTROID X	-.110
CENTROID Y	-.251
POA TO CENTROID in.	.274
MIN RADIUS	.052
MEAN RADIUS	.873
MAX RADIUS	1.721
HORIZONTAL SPREAD	2.721
VERTICAL SPREAD	1.719
EXTREME SPREAD	3.113
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8