

C6587735

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

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

DUPONT

SERIAL NO. C6587735	ORDER NO. 5716
-------------------------------	--------------------------

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

Ø1



5716 C6587735

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587735

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	10/22/90	KL
600	Proof		10/22/90	KL
607	Check Headspace		10/22/90	KL
610	Dis-assemble Gun		10/24/90	KL
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
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	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/8/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/8/90	KS
	D) Oil Firing Pin Ass'y		11/8/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-15-90	KL

op. #	BARBER M24 0026094	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/15/90	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/15/90	WLB
	H) Trigger Pull Test & Retainability						11-15-90	JH
	I) Firing Pin Indent	.0215	.022	.022			11/15/90	WLB
	J) Assemble Stock						11/15/90	KS
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/15/90	KS
	M) Iron Sight Alignment						11/15/90	KZ
	N) Detach Front & Rear Sights & place in numbered container						11/15/90	KS
	O) Attach Scope to Rifle						11/15/90	KS
	P) Detach & Attach Scope 20 Times						11/15/90	KS
640	Gallery Target & Test						11-16-90	KT
	A) Time						11-16-90	KT
	B) Malfunctions						11-16-90	KT
	C) Pierced Primers						11-16-90	KT
	D) Optical Clarity of Scope						11-16-90	KT
645	Inspect for Live Ammo						11-16-90	KT
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	251	234	248	251	248	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/14/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CL587735

DATE 11-15-80

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.44	2.42	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.44	2.36	2.34	
PULL #3	2.43	2.47	2.40	2.48	
PULL #4	2.33	2.46	2.45	2.51	
PULL #5	2.42	2.46	2.43	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.38		
PULL #2	3.17	3.39		
PULL #3	3.45	3.43		
PULL #4	3.27	3.44		
PULL #5	3.44	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.35		4.10
PULL #2	4.48	4.32		4.24
PULL #3	4.32	4.41		4.20
PULL #4	4.37	4.30		4.20
PULL #5	4.41	4.25		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587735
17 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.167836
1 TO	2	.35316
1 TO	3	.577187
1 TO	4	.224379
1 TO	5	.235637

54
24
3 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0048
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.073
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0731576
THE AMR FOR THIS RIFLE IS: .8384

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587735

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 8

HS = 1.385

VS = 3.116

GS = 3.306

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.702	.749	.669
MINIMUM X	-.683	-.636	-.521
MAXIMUM Y	2.011	1.135	1.024
MINIMUM Y	-1.105	-.881	-.862
CENTROID X	.040	-.007	.073
CENTROID Y	.163	-.061	.049
POA TO CENTROID in.	.168	.061	.088
MIN RADIUS	.362	.379	.296
MEAN RADIUS	.858	.698	.639
MAX RADIUS	2.055	1.137	1.036
HORIZONTAL SPREAD	1.385	1.385	1.190
VERTICAL SPREAD	3.116	2.016	1.886
EXTREME SPREAD	3.306	2.093	1.889
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CB587735

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.197

VS= 3.351

GS= 3.747

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.787	.631	.645
MINIMUM X	:	-1.410	-.656	-.642
MAXIMUM Y	:	1.817	1.647	1.208
MINIMUM Y	:	-1.534	-.794	-.588
CENTROID X	:	-.059	.097	.083
CENTROID Y	:	-.176	-.006	-.212
POA TO CENTROID in.	:	.186	.097	.228
MIN RADIUS	:	.246	.395	.190
MEAN RADIUS	:	.955	.840	.686
MAX RADIUS	:	2.083	1.651	1.270
HORIZONTAL SPREAD	:	2.197	1.287	1.287
VERTICAL SPREAD	:	3.351	2.441	1.796
EXTREME SPREAD	:	3.747	2.476	1.826
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

17 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587735

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.135

VS= 2.588

GS= 2.741

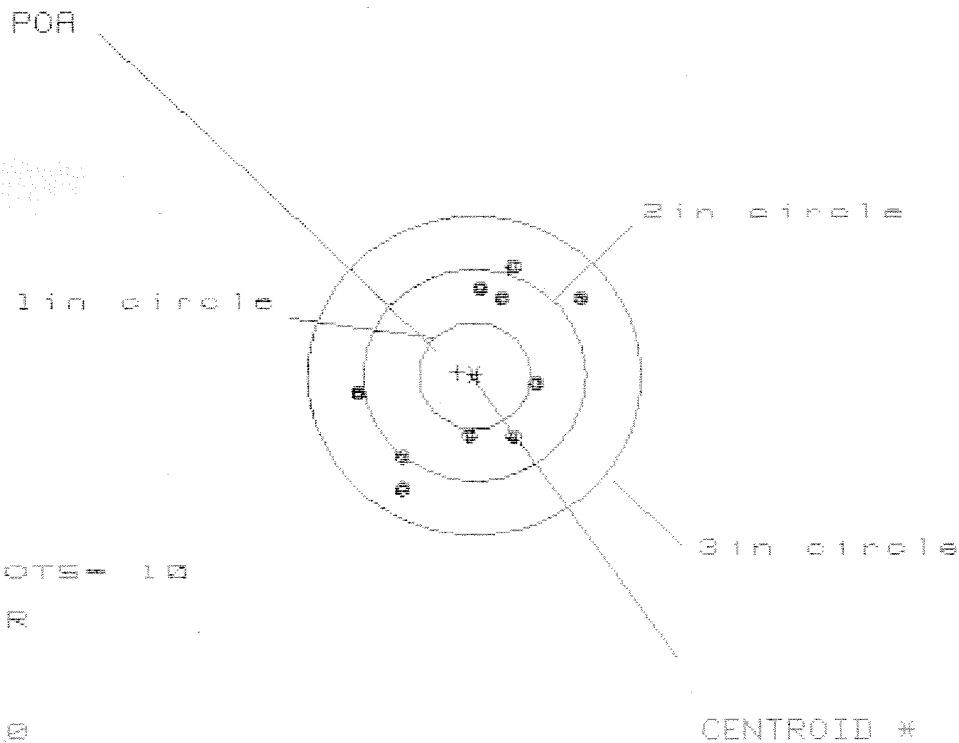
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.456
MINIMUM X	-.679
MAXIMUM Y	1.715
MINIMUM Y	-.873
CENTROID X	.077
CENTROID Y	-.413
POA TO CENTROID (in.)	.420
MIN RADIUS	.197
MEAN RADIUS	.683
MAX RADIUS	1.845
HORIZONTAL SPREAD	1.135
VERTICAL SPREAD	2.588
EXTREME SPREAD	2.741
NUMBER IN ONE INCH CIRCLE	5
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587735

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS = 1.994

VS = 2.104

GS = 2.425

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.959	.882	.566
MINIMUM X	-1.035	-1.112	-1.002
MAXIMUM Y	1.013	.892	.962
MINIMUM Y	-1.091	-.922	-.852
CENTROID X	.151	.228	.118
CENTROID Y	-.032	.089	.019
POA TO CENTROID in.	.154	.245	.120
MIN RADIUS	.536	.488	.576
MEAN RADIUS	.897	.839	.815
MAX RADIUS	1.293	1.183	1.060
HORIZONTAL SPREAD	1.994	1.994	1.568
VERTICAL SPREAD	2.104	1.814	1.814
EXTREME SPREAD	2.425	2.199	2.082
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587735

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.622

VS= 2.155

GS= 2.357

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	: .938	1.004	.972
MINIMUM X	: -.684	-.618	-.492
MAXIMUM Y	: .689	.526	.456
MINIMUM Y	: -1.466	-.904	-.974
CENTROID X	: -.185	-.251	-.377
CENTROID Y	: .093	.256	.326
POA TO CENTROID in.	: .207	.359	.498
MIN RADIUS	: .198	.170	.185
MEAN RADIUS	: .799	.668	.566
MAX RADIUS	: 1.583	1.149	1.008
HORIZONTAL SPREAD	: 1.622	1.622	1.464
VERTICAL SPREAD	: 2.155	1.430	1.430
EXTREME SPREAD	: 2.357	1.790	1.647
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CL6 587735

DATE 11-10-94

TESTER BMM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.44	2.54	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.58	2.59	
PULL #3	2.44	2.43	2.84	
PULL #4	2.43	2.60	2.74	
PULL #5	2.48	2.60	2.74	
TOTAL	12.07	12.75	13.59	
AVG.	2.41	2.55	2.71	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.13	3.28	
PULL #2	3.08	3.16	
PULL #3	3.25	3.03	
PULL #4	3.24	3.08	
PULL #5	3.17	3.14	
TOTAL	15.87	15.69	
AVG.	3.17	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.02		4.25
PULL #2	4.16	4.16		4.15
PULL #3	4.14	4.16		4.13
PULL #4	4.22	4.25		4.24
PULL #5	4.23	4.23		4.21
TOTAL	20.86	20.82		20.98
AVG.	4.17	4.16		4.19

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	BARBER - M24 0026104 F) Safety On Force	5	5	5 1/4			11/22	WB
	G) Safety Off Force	3	3 1/2	3			11/22	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.71	2.65	2.76	2.71	2.72	11/22/95	WB
	C) Function							
660	Pack							

GUN SERIAL # C6587735

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			