

06587746

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

SERIAL NO.
C6587746

ORDER NO.
5716

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

01

5716 C6587746

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587746

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	BR
	Magnaflux Bolt		"	BR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel AB		10/19/90	WB
620	Apply Coatings (Barrel Action)		11-5-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 ³ / ₄	3 ³ / ₄	3 ³ / ₄			11/13/90	WB
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			11/13/90	WB
	H) Trigger Pull Test & Retainability						11-13-90	JM
	I) Firing Pin Indent	.0205	.021	.021			11/13/90	WB
	J) Assemble Stock						11/14/90	RW
	K) Assemble Swivel Studs						11-19-90	D/H
	L) Attach Front and Rear Sight Assemblies						11/14/90	RW
	M) Iron Sight Alignment						11/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	RW
	O) Attach Scope to Rifle						11/14/90	RW
	P) Detach & Attach Scope 20 Times						11/14/90	RW
640	Gallery Target & Test						11/14/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11/14/90	AF
655	Final Inspection							
	A) Headspace						11-19-90	D/H
	B) Trigger Pull	2.48	2.41	2.36	2.44	2.38	11-19-90	D/H
	C) Function						11-19-90	D/H
660	Pack						12-17-90	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587746

DATE 11-13-90

TESTER Jef.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.31	2.36	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.27	2.36	2.41	
PULL #3	2.21	2.20	2.17	2.36	
PULL #4	2.24	2.24	2.17	2.44	
PULL #5	2.32	2.28	2.27	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.40		
PULL #2	3.35	3.33		
PULL #3	3.27	3.36		
PULL #4	3.41	3.29		
PULL #5	3.40	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.37		4.36
PULL #2	4.37	4.42		4.47
PULL #3	4.34	4.40		4.44
PULL #4	4.42	4.43		4.45
PULL #5	4.43	4.32		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587746
15 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0962081
1 TO	2	.187297
1 TO	3	.243822
1 TO	4	.348402
1 TO	5	.184391

<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.003
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0540833
THE AMR FOR THIS RIFLE IS: .841

15 May 1990

FILE: \PATTERNING\CENTERFIRE_PATT\06587746

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.161

VS = 1.925

GS = 1.950

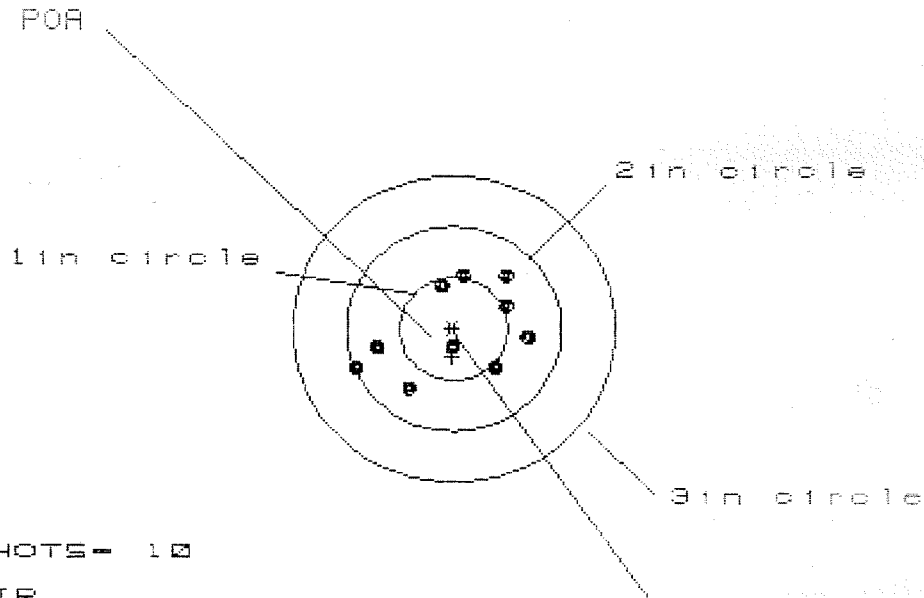
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.632	.630	.590
MINIMUM X	:	-.529	-.531	-.571
MAXIMUM Y	:	1.113	1.131	.734
MINIMUM Y	:	-.812	-.688	-.547
CENTROID X	:	.034	.036	.076
CENTROID Y	:	.090	-.034	-.175
POA TO CENTROID in.	:	.096	.049	.191
MIN RADIUS	:	.254	.250	.238
MEAN RADIUS	:	.667	.598	.509
MAX RADIUS	:	1.113	1.175	.744
HORIZONTAL SPREAD	:	1.161	1.161	1.161
VERTICAL SPREAD	:	1.925	1.819	1.281
EXTREME SPREAD	:	1.950	1.891	1.366
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Nov 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.562

VS= 1.080

GS= 1.639

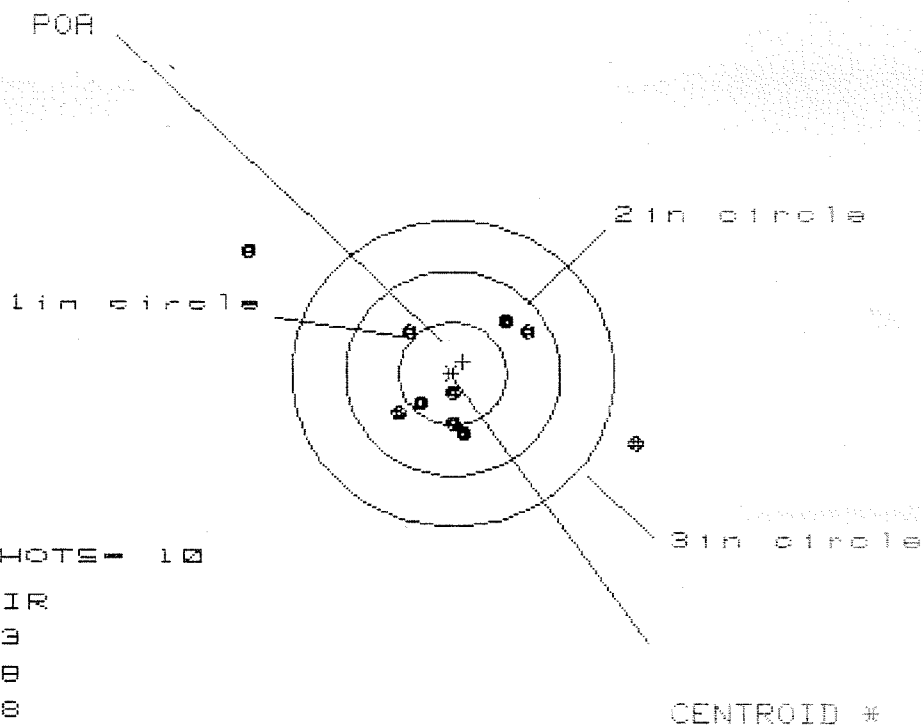
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.643	.541	.445
MINIMUM X	:	-.919	-.770	-.576
MAXIMUM Y	:	.523	.477	.453
MINIMUM Y	:	-.557	-.603	-.627
CENTROID X	:	.012	.114	.210
CENTROID Y	:	.276	.322	.346
POA TO CENTROID in.	:	.276	.342	.405
MIN RADIUS	:	.146	.242	.309
MEAN RADIUS	:	.593	.534	.488
MAX RADIUS	:	1.008	.793	.851
HORIZONTAL SPREAD	:	1.562	1.311	1.021
VERTICAL SPREAD	:	1.080	1.080	1.080
EXTREME SPREAD	:	1.639	1.338	1.338
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 8

3 in - 8

HS - 3.596

VS - 1.824

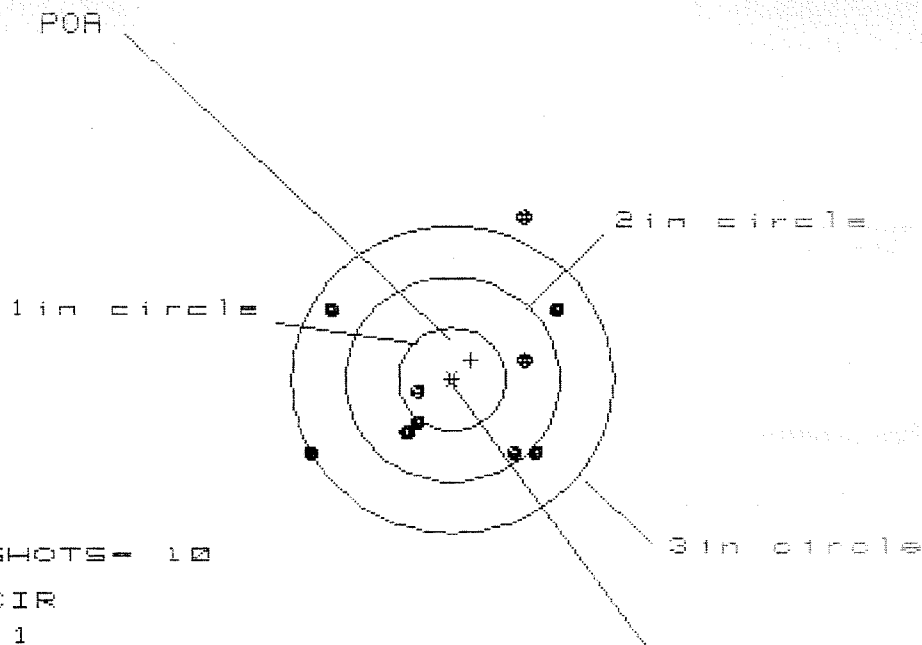
GS - 4.032

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.739	1.533	.725
MINIMUM X	:	-1.857	-.722	-.531
MAXIMUM Y	:	1.180	.676	.611
MINIMUM Y	:	-.644	-.512	-.487
CENTROID X	:	-.098	.108	-.083
CENTROID Y	:	-.115	-.247	-.182
POA TO CENTROID in.	:	.151	.269	.201
MIN RADIUS	:	.233	.227	.166
MEAN RADIUS	:	.847	.693	.536
MAX RADIUS	:	2.200	1.616	.865
HORIZONTAL SPREAD	:	3.596	2.255	1.256
VERTICAL SPREAD	:	1.824	1.188	1.098
EXTREME SPREAD	:	4.032	2.384	1.466
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

15 May 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS - 2.304

VS - 2.340

GS - 3.038

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	1.063	.908
MINIMUM X	:	-1.311	-1.241	-1.205
MAXIMUM Y	:	1.609	.914	.845
MINIMUM Y	:	-.731	-.552	-.610
CENTROID X	:	-.176	-.246	-.091
CENTROID Y	:	-.188	-.366	-.297
POA TO CENTROID in.	:	.257	.441	.311
MIN RADIUS	:	.385	.301	.451
MEAN RADIUS	:	1.007	.886	.838
MAX RADIUS	:	1.727	1.392	1.472
HORIZONTAL SPREAD	:	2.304	2.304	2.113
VERTICAL SPREAD	:	2.340	1.466	1.455
EXTREME SPREAD	:	3.038	2.710	2.395
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		

15 May 1990

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.537

VS = 2.777

GS = 2.888

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.598	.621	.561
MINIMUM X	:	-.939	-.761	-.821
MAXIMUM Y	:	1.457	1.491	1.331
MINIMUM Y	:	-1.320	-1.286	-1.430
CENTROID X	:	-.042	-.220	-.160
CENTROID Y	:	-.078	-.112	.049
POA TO CENTROID in.	:	.089	.247	.167
MIN RADIUS	:	.646	.651	.699
MEAN RADIUS	:	1.091	1.018	.953
MAX RADIUS	:	1.627	1.523	1.476
HORIZONTAL SPREAD	:	2.537	1.382	1.382
VERTICAL SPREAD	:	2.777	2.777	2.761
EXTREME SPREAD	:	2.888	2.888	2.753
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	