

C6587550

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6587550	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.			
 5716 C6587550			

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587550

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	Rw
600	Proof	1019	90	Rw
607	Check Headspace	1019	90	Rw
610	Dis-assemble Gun	1019	90	Rw
612	Magnaflux Barrel Action		10/23/90	KP
	Magnaflux Bolt		10/23/90	KP
615	Rollmark Caliber		10/23/90	JS
617	Drill and Tap Sight Holes		10/26/90	KB
618	Polish Barrel RB		10/29/90	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		11/27/90	JS

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	3.25 3 .25 3	11/30/90	JL
	G) Safety Off Force	2 2 2	11/30/90	JL
	H) Trigger Pull Test & Retainability		11/27/90	JL
	I) Firing Pin Indent	.0225 .023 .023	11/30/90	JL
	J) Assemble Stock		12/6/90	RW
	K) Assemble Swivel Studs		12-7-90	JS
	L) Attach Front and Rear Sight Assemblies		12/6/90	RW
	M) Iron Sight Alignment		12/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container		12/6/90	RW
	O) Attach Scope to Rifle		12/6/90	RW
	P) Detach & Attach Scope 20 Times		12/6/90	RW
640	Gallery Target & Test		12/6/90	NF
	A) Time		"	NF
	B) Malfunctions		"	NF
	C) Pierced Primers		"	NF
	D) Optical Clarity of Scope		"	NF
645	Inspect for Live Ammo		12/6/90	NF
655	Final Inspection			
	A) Headspace		12-7-90	JS
	B) Trigger Pull	267 273 285 272 273	12-7-90	JS
	C) Function		12-7-90	JS
660	Pack		12-7-90	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587550

DATE 11/27/90

TESTER JE

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.38	2.39	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.30	2.46	2.73	
PULL #3	2.31	2.28	2.49	2.85	
PULL #4	2.31	2.22	2.40	2.72	
PULL #5	2.30	2.39	2.44	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.23		
PULL #2	3.41	3.39		
PULL #3	3.28	3.41		
PULL #4	3.30	3.43		
PULL #5	3.35	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.31		4.42
PULL #2	4.22	4.37		4.46
PULL #3	4.12	4.41		4.43
PULL #4	4.45	4.27		4.42
PULL #5	4.30	4.37		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587750
7 Dec 1990

CENTROIDAL DISTANCES

0 TO 1	.161839
1 TO 2	.358022
1 TO 3	.315006
1 TO 4	.1447
1 TO 5	.167872

4

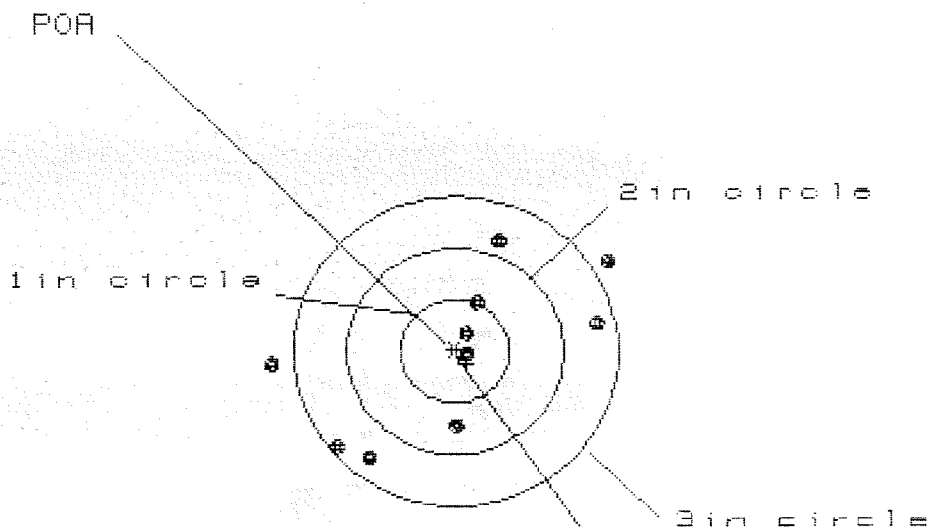
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0376
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0236
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0443928
THE AMR FOR THIS RIFLE IS: .7868

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587750.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 3.109

VS= 2.167

GS= 3.273

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.411	1.223	1.312
MINIMUM X	-1.698	-1.262	-1.110
MAXIMUM Y	1.115	1.097	1.201
MINIMUM Y	-1.052	-1.070	-0.966
CENTROID X	-0.104	.084	-0.068
CENTROID Y	.124	.142	.038
POA TO CENTROID in.	.162	.166	.078
MIN RADIUS	.121	.070	.138
MEAN RADIUS	1.014	.909	.853
MAX RADIUS	1.706	1.551	1.366
HORIZONTAL SPREAD	3.109	2.485	2.422
VERTICAL SPREAD	2.167	2.167	2.167
EXTREME SPREAD	3.273	3.034	2.668
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 8

HS= 1.598

VS= 4.040

GS= 4.182

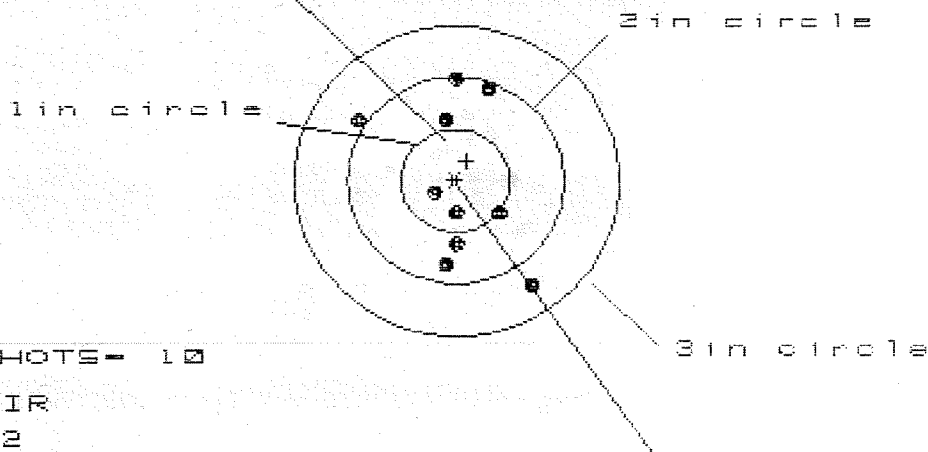
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.602	.435	.384
MINIMUM X	-.996	-.930	-.981
MAXIMUM Y	1.821	1.574	.448
MINIMUM Y	-2.219	-.754	-.557
CENTROID X	.068	.002	.053
CENTROID Y	-.190	.057	-.140
POA TO CENTROID in.	.202	.057	.150
MIN RADIUS	.103	.126	.065
MEAN RADIUS	.771	.604	.438
MAX RADIUS	2.299	1.627	1.128
HORIZONTAL SPREAD	1.598	1.365	1.365
VERTICAL SPREAD	4.040	2.328	1.005
EXTREME SPREAD	4.182	2.385	1.655
NUMBER IN ONE INCH CIRCLE	=	5	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.645

VS= 1.969

GS= 2.293

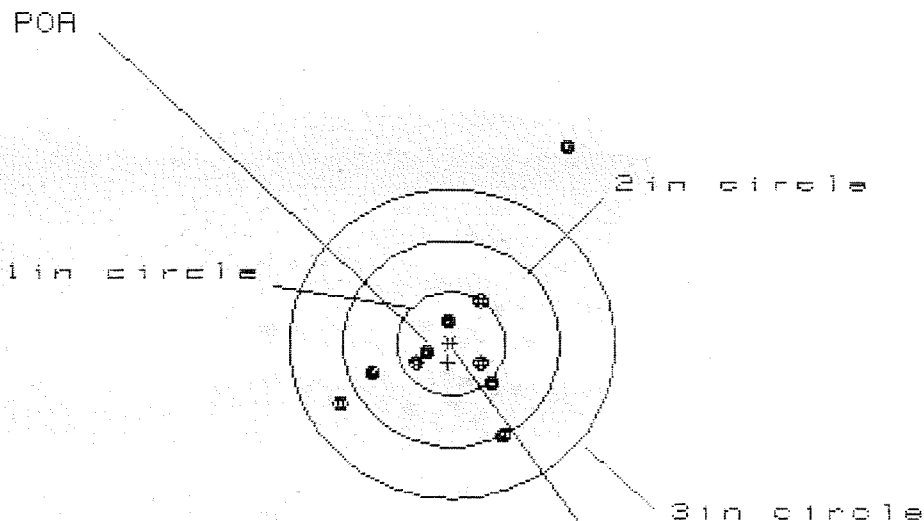
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.721	.487	.381
MINIMUM X	:	-.924	-.844	-.213
MAXIMUM Y	:	.969	.858	.918
MINIMUM Y	:	-1.000	-.900	-.840
CENTROID X	:	-.102	-.182	-.076
CENTROID Y	:	-.191	-.080	-.140
POA TO CENTROID in.	:	.216	.198	.160
MIN RADIUS	:	.203	.218	.249
MEAN RADIUS	:	.735	.684	.635
MAX RADIUS	:	1.233	.974	.922
HORIZONTAL SPREAD	:	1.645	1.331	.594
VERTICAL SPREAD	:	1.969	1.758	1.758
EXTREME SPREAD	:	2.293	1.765	1.765
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.070

VS= 2.786

GS= 3.247

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	.547	.440
MINIMUM X	:	-.979	-.858	-.691
MAXIMUM Y	:	1.896	.638	.588
MINIMUM Y	:	-.890	-.679	-.729
CENTROID X	:	.029	-.092	.015
CENTROID Y	:	.181	-.030	.020
POA TO CENTROID in.	:	.183	.097	.025
MIN RADIUS	:	.230	.202	.246
MEAN RADIUS	:	.731	.549	.489
MAX RADIUS	:	2.187	.945	.851
HORIZONTAL SPREAD	:	2.070	1.405	1.131
VERTICAL SPREAD	:	2.786	1.317	1.317
EXTREME SPREAD	:	3.247	1.615	1.327
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1998

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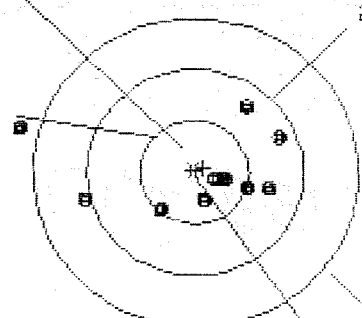
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 2.355

VS = 1.040

GS = 2.395

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X : .758

.581

.425

MINIMUM X : -1.597

-1.242

-.609

MAXIMUM Y : .686

.732

.700

MINIMUM Y : -.354

-.308

-.340

CENTROID X : -.079

.098

.254

CENTROID Y : -.042

-.088

-.056

POA TO CENTROID in. : .089

.132

.260

MIN RADIUS : .131

.060

.101

MEAN RADIUS : .683

.512

.469

MAX RADIUS : 1.651

1.269

.723

HORIZONTAL SPREAD : 2.355

1.823

1.034

VERTICAL SPREAD : 1.040

1.040

1.040

EXTREME SPREAD : 2.395

1.921

1.304

NUMBER IN ONE INCH CIRCLE = 4

4

NUMBER IN TWO INCH CIRCLE = 8

8

NUMBER IN THREE INCH CIRCLE = 9

9