

06587552

MODEL 700™ N24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
 MODEL 700™ M24

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

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

SERIAL NO.
 04587552

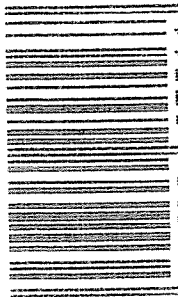
ORDER NO.
 5716

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



5716 04587552

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587552

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1	10	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	HA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			2/4/91	WB
	G) Safety Off Force	2 ¹ / ₂	2 ³ / ₄	2 ¹ / ₂			2/4/91	WB
	H) Trigger Pull Test & Retainability						1/30/91	JS
	I) Firing Pin Indent	.0225	.0215	.022			2/4/91	WB
	J) Assemble Stock						2/5/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	RW
	M) Iron Sight Alignment						2/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	RW
	O) Attach Scope to Rifle						2/5/91	RW
	P) Detach & Attach Scope 20 Times						2/5/91	RW
640	Gallery Target & Test						2/5/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						2/5/91	KS
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.49	2.53	2.46	2.39	2.38	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 06587552
DATE 1/30/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.30	2.20	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.37	2.18	2.53	
PULL #3	2.26	2.18	2.16	2.46	
PULL #4	2.35	2.32	2.25	2.39	
PULL #5	2.35	2.32	2.30	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.46		
PULL #2	3.38	3.50		
PULL #3	3.33	3.55		
PULL #4	3.22	3.57		
PULL #5	3.19	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.31		4.41
PULL #2	4.19	4.30		4.31
PULL #3	4.21	4.37		4.31
PULL #4	4.24	4.26		4.36
PULL #5	4.29	4.31		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587552
6 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.330151
1 TO	2	.393315
1 TO	3	.502482
1 TO	4	.517302
1 TO	5	.290264

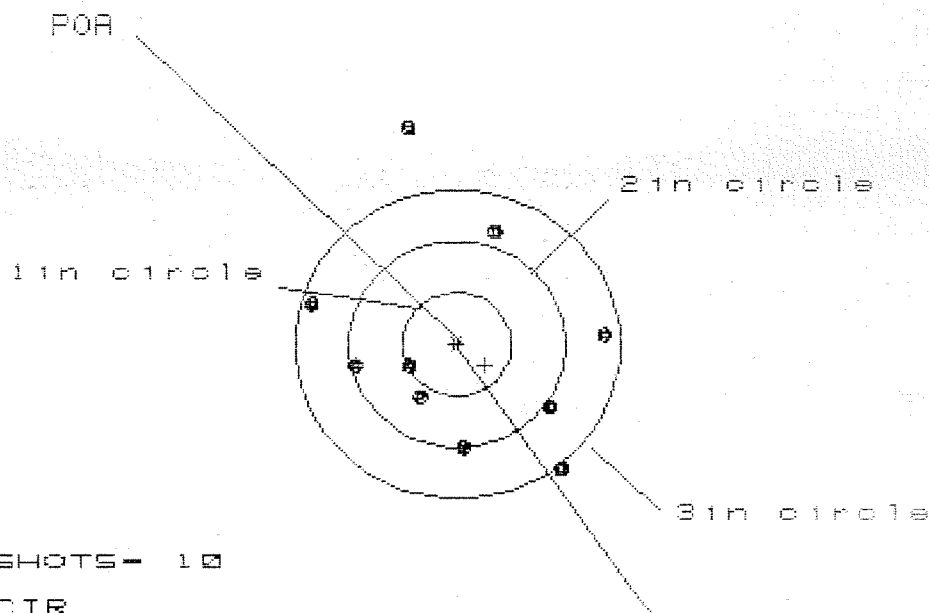
1
9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.079
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114441
THE AMR FOR THIS RIFLE IS: .9834

6 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587552

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 2.715

VS= 3.239

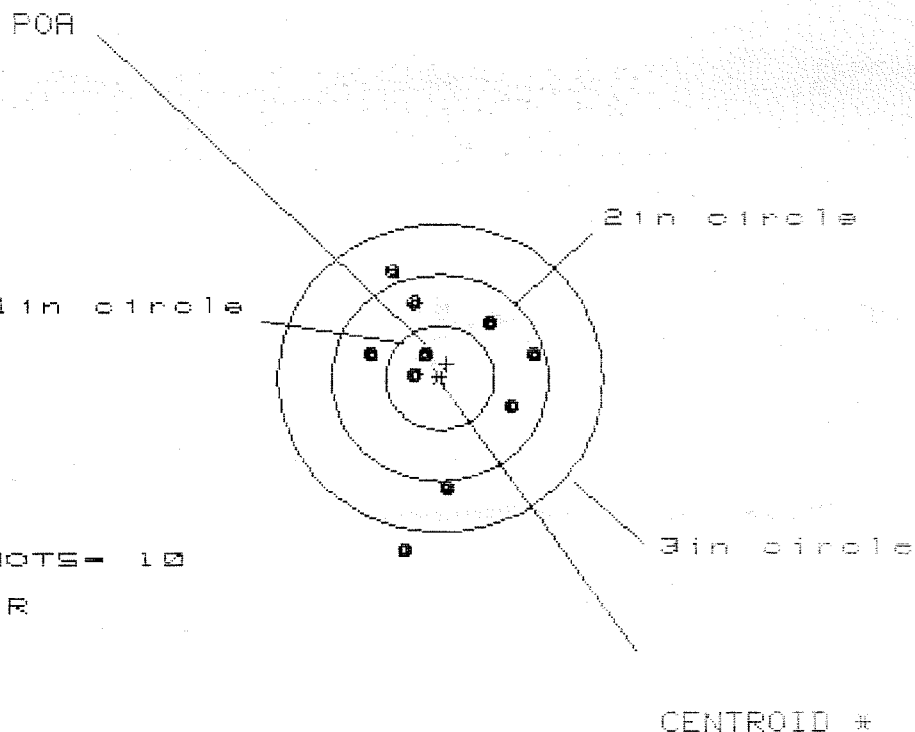
GS= 3.509

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.295	1.405
MINIMUM X	:	-1.373	-1.420	-1.310
MAXIMUM Y	:	2.050	1.368	1.248
MINIMUM Y	:	-1.189	-.961	-.900
CENTROID X	:	-.258	-.211	-.321
CENTROID Y	:	.206	-.022	.099
POA TO CENTROID in.	:	.330	.212	.335
MIN RADIUS	:	.441	.445	.347
MEAN RADIUS	:	1.162	1.018	.973
MAX RADIUS	:	2.093	1.554	1.416
HORIZONTAL SPREAD	:	2.715	2.715	2.715
VERTICAL SPREAD	:	3.239	2.329	2.147
EXTREME SPREAD	:	3.509	2.795	2.735
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2



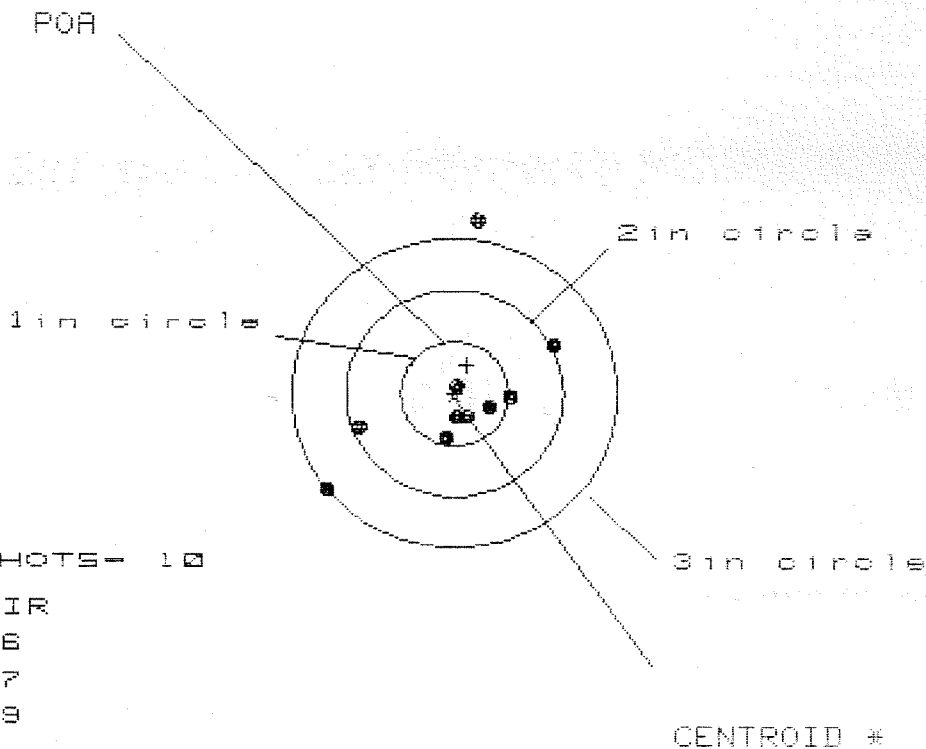
HS= 1.475
VS= 2.632
GS= 2.632

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.858	.818	.763
MINIMUM X	:	-.617	-.657	-.712
MAXIMUM Y	:	.992	.809	.631
MINIMUM Y	:	-1.640	-1.232	-1.131
CENTROID X	:	-.062	-.022	.033
CENTROID Y	:	-.135	.048	-.053
POA TO CENTROID in.	:	.148	.053	.063
MIN RADIUS	:	.247	.140	.239
MEAN RADIUS	:	.813	.682	.664
MAX RADIUS	:	1.679	1.232	1.133
HORIZONTAL SPREAD	:	1.475	1.475	1.475
VERTICAL SPREAD	:	2.632	2.041	1.762
EXTREME SPREAD	:	2.632	2.084	1.788
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 6

2in = 7

3in = 9

HS= 2.086

VS= 2.626

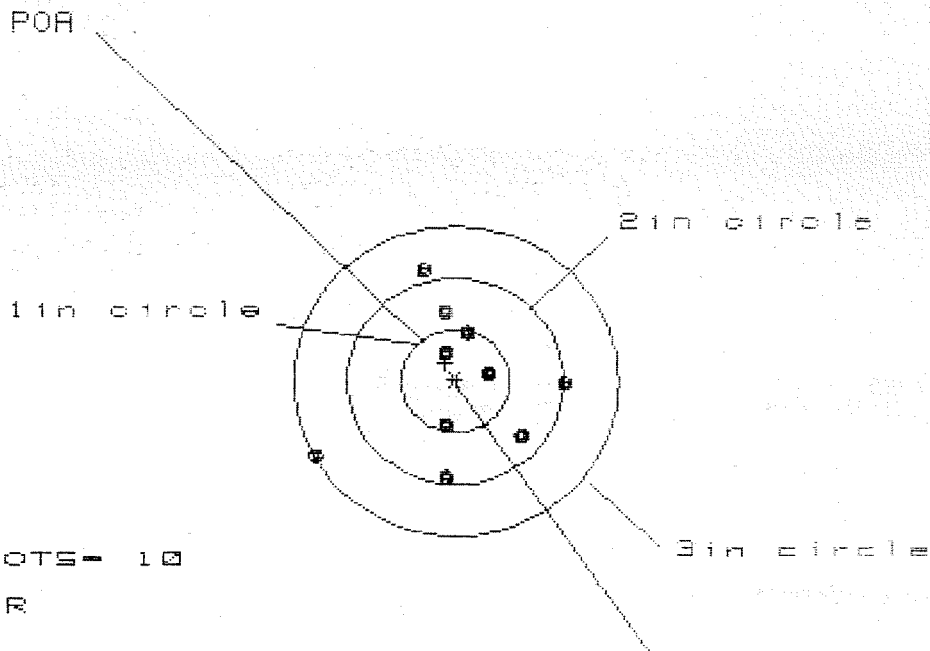
GS= 2.942

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.939	.959	.818
MINIMUM X	-1.147	-1.127	-.988
MAXIMUM Y	1.710	.711	.620
MINIMUM Y	-.916	-.726	-.371
CENTROID X	-.116	-.136	.005
CENTROID Y	-.276	-.466	-.375
POA TO CENTROID in.	.299	.485	.375
MIN RADIUS	.062	.015	.153
MEAN RADIUS	.702	.553	.442
MAX RADIUS	1.719	1.341	1.026
HORIZONTAL SPREAD	2.086	2.086	1.798
VERTICAL SPREAD	2.626	1.437	.991
EXTREME SPREAD	2.942	2.533	2.000
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in - 10

HS- 2.249

VS= 2.054

GS= 2.354

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.859	.886
MINIMUM X	:	-1.251	-.427	-.315
MAXIMUM Y	:	1.118	1.034	.768
MINIMUM Y	:	-.936	-1.020	-.891
CENTROID X	:	.093	.232	.285
CENTROID Y	:	-.174	-.098	-.219
POA TO CENTROID in.	:	.198	.249	.360
MIN RADIUS	:	.259	.137	.185
MEAN RADIUS	:	.756	.650	.599
MAX RADIUS	:	1.464	1.119	.934
HORIZONTAL SPREAD	:	2.249	1.286	1.121
VERTICAL SPREAD	:	2.054	2.054	1.659
EXTREME SPREAD	:	2.354	2.064	1.659
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 8

HS- 2.407

VS= 2.422

GS= 3.160

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.112	1.229	1.122
MINIMUM X	:	-1.295	-1.178	-1.285
MAXIMUM Y	:	1.252	1.023	.894
MINIMUM Y	:	-1.170	-1.031	-1.056
CENTROID X	:	-.071	-.188	-.081
CENTROID Y	:	-.016	-.155	-.026
POA TO CENTROID in.	:	.073	.244	.085
MIN RADIUS	:	.278	.356	.282
MEAN RADIUS	:	.984	.910	.806
MAX RADIUS	:	1.637	1.345	1.387
HORIZONTAL SPREAD	:	2.407	2.407	2.407
VERTICAL SPREAD	:	2.422	2.054	1.950
EXTREME SPREAD	:	3.160	2.533	2.420
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	