

C6522269

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522269

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KJ
600	Proof		7/10/90	KJ
607	Check Headspace		7/10/90	KJ
610	Dis-assemble Gun		7/10/90	KJ
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	JS
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel JB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/14/90	KS
	C) Inspect Ejector Hole for Chamfer		8/14/90	KS
	D) Oil Firing Pin Ass'y		8/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-14-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/13/90	JK
	G) Safety Off Force	3	3	3			8/13/90	JK
	H) Trigger Pull Test & Retainability						9-14-90	JK
	I) Firing Pin Indent	.0235	.0235	.0235			8/13/90	JK
	J) Assemble Stock						8/13/90	ICS
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/15/90	ICS
	M) Iron Sight Alignment						8/15/90	ICS
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	ICS
	O) Attach Scope to Rifle						8/15/90	ICS
	P) Detach & Attach Scope 20 Times						8/15/90	ICS
640	Gallery Target & Test						8-16-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						8-16-90	A
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.38	2.15	2.32	2.32	2.10	9-14-90	JK
	C) Function						9-13-90	CS
660	Pack						9-18-90	JK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522269

DATE 9-18-90

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.14	2.30	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.19	2.39	2.15	
PULL #3	2.30	2.23	2.40	2.32	
PULL #4	2.27	2.40	2.38	2.32	
PULL #5	2.08	2.43	2.44	2.10	
TOTAL	11.46	11.39	11.91	11.27	
AVG.	2.292	2.278	2.382	2.254	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.28		
PULL #2	3.11	3.27		
PULL #3	3.15	3.30		
PULL #4	3.16	3.36		
PULL #5	3.43	3.30		
TOTAL	15.96	16.51		
AVG.	3.192	3.302		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.00		4.28
PULL #2	4.17	4.17		4.22
PULL #3	4.08	4.37		4.42
PULL #4	4.12	4.26		4.21
PULL #5	4.16	4.21		4.18
TOTAL	20.77	21.01		21.31
AVG.	4.154	4.202		4.262

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522269
17 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.224401
1 TO	2	.175377
1 TO	3	.52469
1 TO	4	.247487
1 TO	5	.321014

$\bar{x}_a$ <----POA

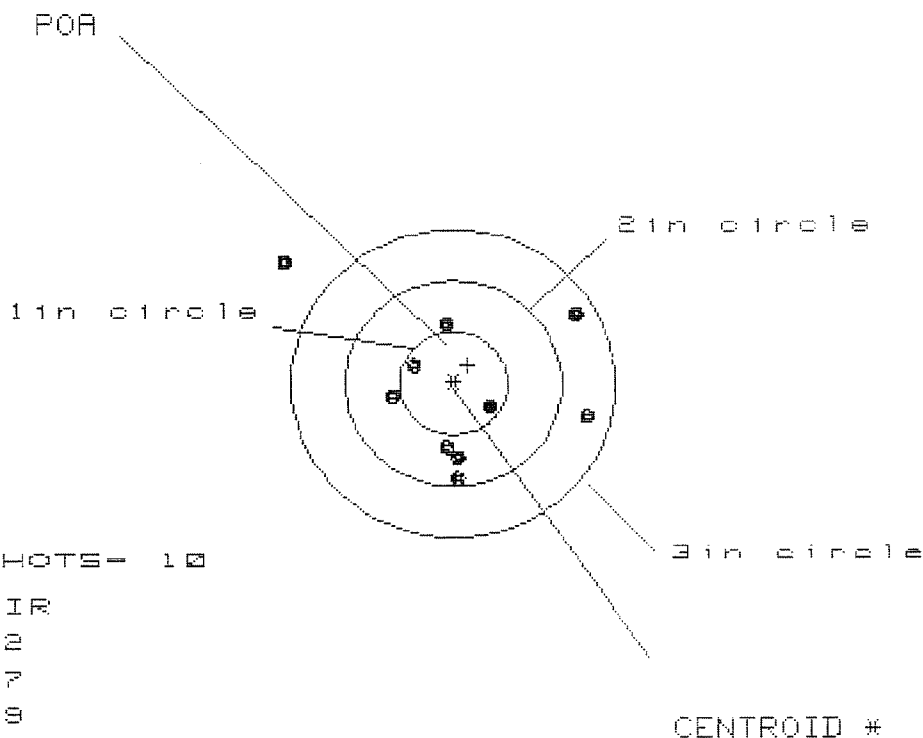
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.017
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104591

THE AMR FOR THIS RIFLE IS: .8094

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522269

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.822

VS= 2.077

GS= 3.191

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.236	1.060	1.175
MINIMUM X	-1.586	-.735	-.619
MAXIMUM Y	1.205	.835	.859
MINIMUM Y	-.872	-.738	-.634
CENTROID X	-.134	.042	-.073
CENTROID Y	-.180	-.314	-.418
POA TO CENTROID in.	.224	.317	.424
MIN RADIUS	.344	.127	.244
MEAN RADIUS	.869	.722	.630
MAX RADIUS	1.992	1.248	1.176
HORIZONTAL SPREAD	2.822	1.795	1.795
VERTICAL SPREAD	2.077	1.573	1.493
EXTREME SPREAD	3.191	1.916	1.807
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

16 Aug 1998

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.205

VS= 2.520

GS= 2.834

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	1.061	.918
MINIMUM X	:	-1.098	-1.144	-.713
MAXIMUM Y	:	1.528	.958	.855
MINIMUM Y	:	-.992	-.823	-.732
CENTROID X	:	-.025	.021	.164
CENTROID Y	:	-.106	-.276	-.173
POA TO CENTROID in.	:	.109	.277	.239
MIN RADIUS	:	.462	.337	.454
MEAN RADIUS	:	.877	.773	.699
MAX RADIUS	:	1.582	1.430	1.255
HORIZONTAL SPREAD	:	2.205	2.205	1.631
VERTICAL SPREAD	:	2.520	1.781	1.587
EXTREME SPREAD	:	2.834	2.834	2.013
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Aug 1998

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 2.200

VS = 2.032

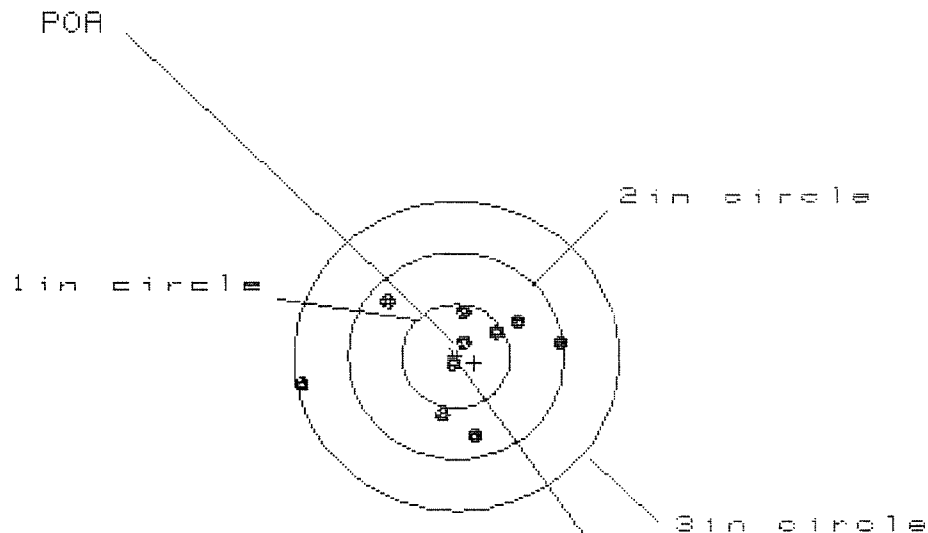
GS = 2.791

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.262	1.383
MINIMUM X	:	-.852	-.866	-.745
MAXIMUM Y	:	1.146	.707	.613
MINIMUM Y	:	-.886	-.759	-.631
CENTROID X	:	.324	.419	.298
CENTROID Y	:	-.436	-.563	-.469
POA TO CENTROID in.	:	.543	.702	.555
MIN RADIUS	:	.340	.286	.301
MEAN RADIUS	:	.924	.860	.795
MAX RADIUS	:	1.428	1.289	1.393
HORIZONTAL SPREAD	:	2.209	2.128	2.128
VERTICAL SPREAD	:	2.032	1.466	1.244
EXTREME SPREAD	:	2.791	2.316	2.146
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Aug 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.472

VS= 1.259

GS= 2.517

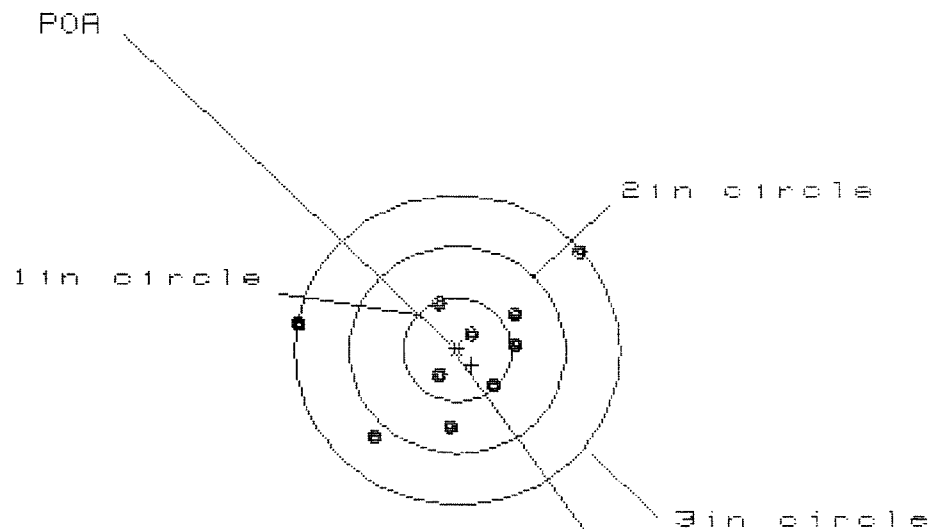
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	.830	.539
MINIMUM X	:	-1.477	-.814	-.710
MAXIMUM Y	:	.516	.482	.498
MINIMUM Y	:	-.743	-.777	-.761
CENTROID X	:	-.169	-.004	-.108
CENTROID Y	:	.065	.100	.084
POA TO CENTROID in.	:	.181	.100	.137
MIN RADIUS	:	.060	.119	.108
MEAN RADIUS	:	.645	.526	.483
MAX RADIUS	:	1.510	.946	.867
HORIZONTAL SPREAD	:	2.472	1.644	1.249
VERTICAL SPREAD	:	1.259	1.259	1.259
EXTREME SPREAD	:	2.517	1.681	1.501
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 2.559

VS = 1.749

GS = 2.635

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.124	.964	.467
MINIMUM X	:	-1.435	-.906	-.785
MAXIMUM Y	:	.920	.952	.609
MINIMUM Y	:	-.829	-.797	-.678
CENTROID X	:	-.131	.029	-.092
CENTROID Y	:	.141	.109	-.010
POA TO CENTROID in.	:	.193	.113	.092
MIN RADIUS	:	.207	.178	.260
MEAN RADIUS	:	.732	.629	.541
MAX RADIUS	:	1.464	1.355	1.038
HORIZONTAL SPREAD	:	2.559	1.870	1.252
VERTICAL SPREAD	:	1.749	1.749	1.287
EXTREME SPREAD	:	2.635	2.560	1.690
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

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

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

MODEL 700™ M24

SERIAL NO.
C6522269

ORDER NO.
5716

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

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UPC

