C652229

MODEL 700™ M24

Model SPS™

Action

Barrel Length

Capacity

Order No. 57116

*Includes 1 in chamber.

Remington®

Sinead®

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522229

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KER
	Magnaflux Bolt		8/16	KER
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes		8/16/90	WB
618	Polish Barrel		8/16/90	WB
620	Apply Coatings (Barrel Action)		8-31-90	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	WB
	C) Inspect Ejector Hole for Chamfer		8/16/90	WB
	D) Oil Firing Pin Ass'y		8/16/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4½	4½	4½			9/10/90	WB
	G) Safety Off Force	2	2	2			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	.023	.023	.023			9/10/90	WB
	J) Assemble Stock						9/10/90	KL
	K) Assemble Swivel Studs						9/18/90	[illegible]
	L) Attach Front and Rear Sight Assemblies						9/10/90	KL
	M) Iron Sight Alignment						9/10/90	KL
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KL
	O) Attach Scope to Rifle						9/11/90	KL
	P) Detach & Attach Scope 20 Times						9/10/90	KL
640	Gallery Target & Test						9/12/90	KT
	A) Time						9/12/90	KT
	B) Malfunctions						9/12/90	KT
	C) Pierced Primers						9/12/90	KT
	D) Optical Clearity of Scope						9/12/90	KT
645	Inspect for Live Ammo						9/12/90	KT
655	Final Inspection A) Headspace						9/18/90	[illegible]
	B) Trigger Pull	2.47	2.43	2.44	2.53	2.47	9-18-90	[illegible]
	C) Function						9/18/90	[illegible]
660	Pack						9/20/90	[illegible]

MOD. 700 SPS GA. CAL. 308 GUN # C6522229

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
	9/12	Bolt Release Sticks	KS
	2nd	Rep'd	KS 9/16/90
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF			
TEST			
TGT			
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522229
DATE 9/10/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.15	2.19	2.47	MIN. SETTING,
PULL #2	2.44	2.25	2.15	2.43	NO AVG. OF 5
PULL #3	2.38	2.22	2.14	2.44	READINGS ACCEPT-
PULL #4	2.30	2.17	2.30	2.53	ABLE LESS THAN 2#
PULL #5	2.30	2.26	2.18	2.47	
TOTAL	11.79	11.05	10.96	12.34	
AVG.	2.36	2.21	2.19	2.468	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.06		
PULL #2	3.09	3.07		
PULL #3	3.14	3.07		
PULL #4	3.08	3.10		
PULL #5	3.07	3.10		
TOTAL	15.51	15.40		
AVG.	3.10	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	3.95		4.13
PULL #2	4.02	3.95		4.17
PULL #3	4.00	3.97		4.09
PULL #4	3.95	4.03		4.10
PULL #5	4.00	3.97		4.11
TOTAL	20.08	19.87		20.60
AVG.	4.02	3.97		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522229
13 Sep 1990

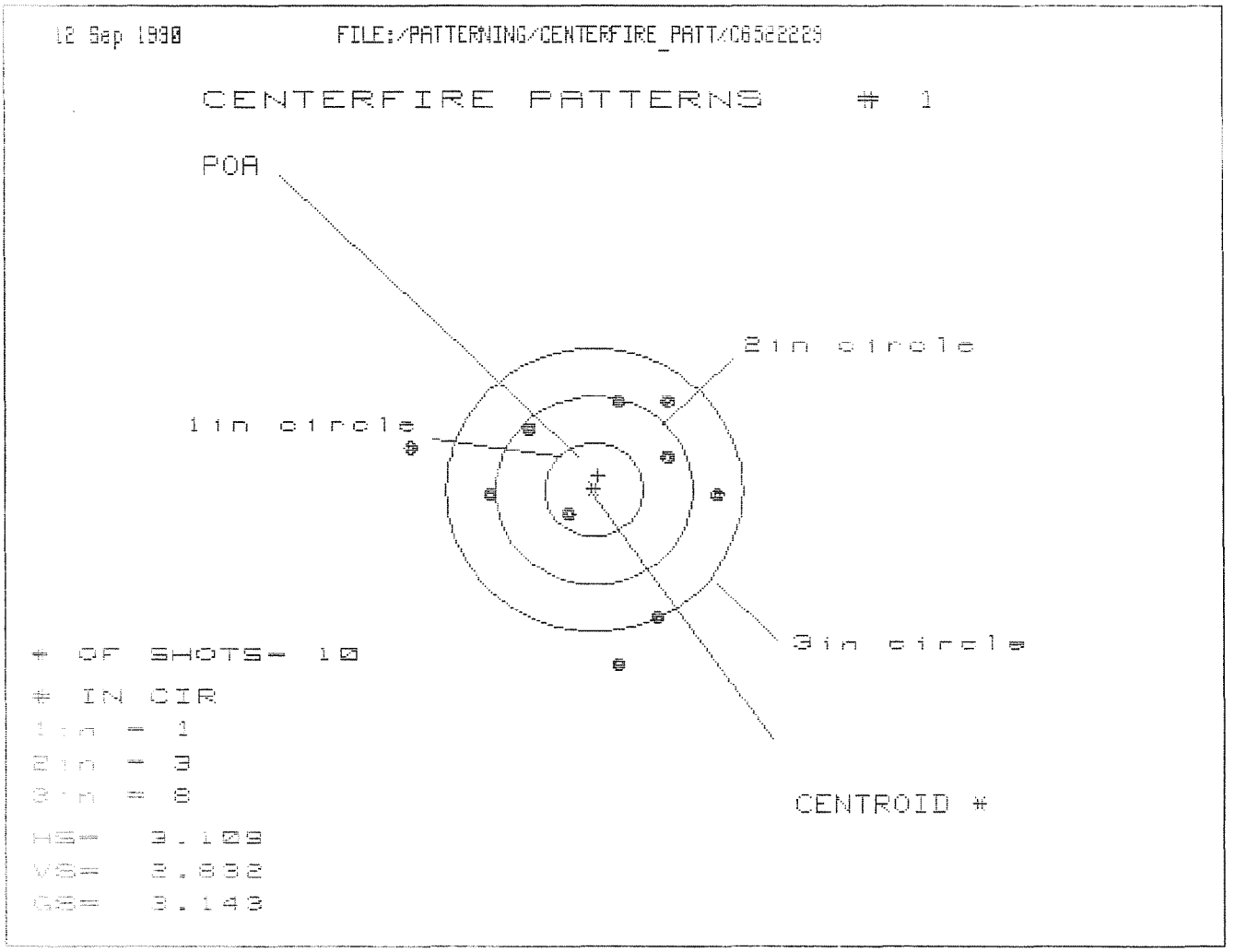
CENTROIDAL DISTANCES

0	TO	1	.156042
1	TO	2	.225754
1	TO	3	.379075
1	TO	4	.248244
1	TO	5	.401693

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0208
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0504
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0545234

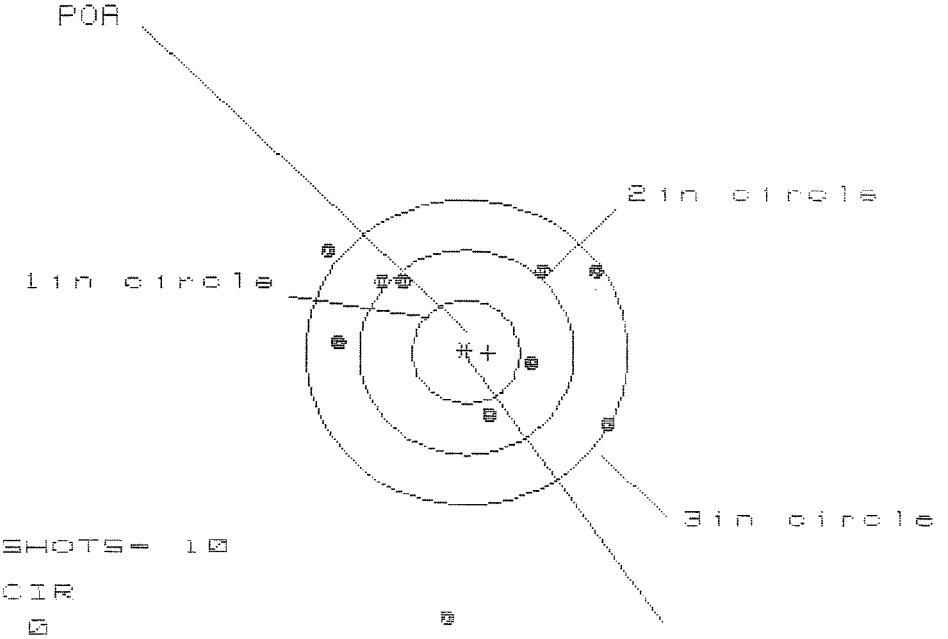
THE AMR FOR THIS RIFLE IS: 1.067



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.073	1.076
MINIMUM X	:	-1.832	-1.272	-1.269
MAXIMUM Y	:	.981	1.031	.806
MINIMUM Y	:	-1.851	-1.801	-1.508
CENTROID X	:	-.043	.161	.158
CENTROID Y	:	-.150	-.200	.025
POA TO CENTROID in.	:	.156	.257	.160
MIN RADIUS	:	.338	.497	.542
MEAN RADIUS	:	1.187	1.105	.981
MAX RADIUS	:	1.888	1.801	1.573
HORIZONTAL SPREAD	:	3.109	2.345	2.345
VERTICAL SPREAD	:	2.832	2.832	2.314
EXTREME SPREAD	:	3.143	2.865	2.377
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C8528223

CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 3
3in = 8
HS= 2.559
VS= 3.571
GS= 3.718

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.310	1.286	1.127
MINIMUM X	:	-1.249	-1.273	-1.350
MAXIMUM Y	:	.974	.686	.641
MINIMUM Y	:	-2.597	-1.011	-.926
CENTROID X	:	-.209	-.185	-.026
CENTROID Y	:	.003	.291	.206
POA TO CENTROID in.	:	.209	.345	.207
MIN RADIUS	:	.582	.685	.556
MEAN RADIUS	:	1.251	1.070	1.010
MAX RADIUS	:	2.606	1.636	1.459
HORIZONTAL SPREAD	:	2.559	2.559	2.477
VERTICAL SPREAD	:	3.571	1.697	1.567
EXTREME SPREAD	:	3.718	3.071	2.613
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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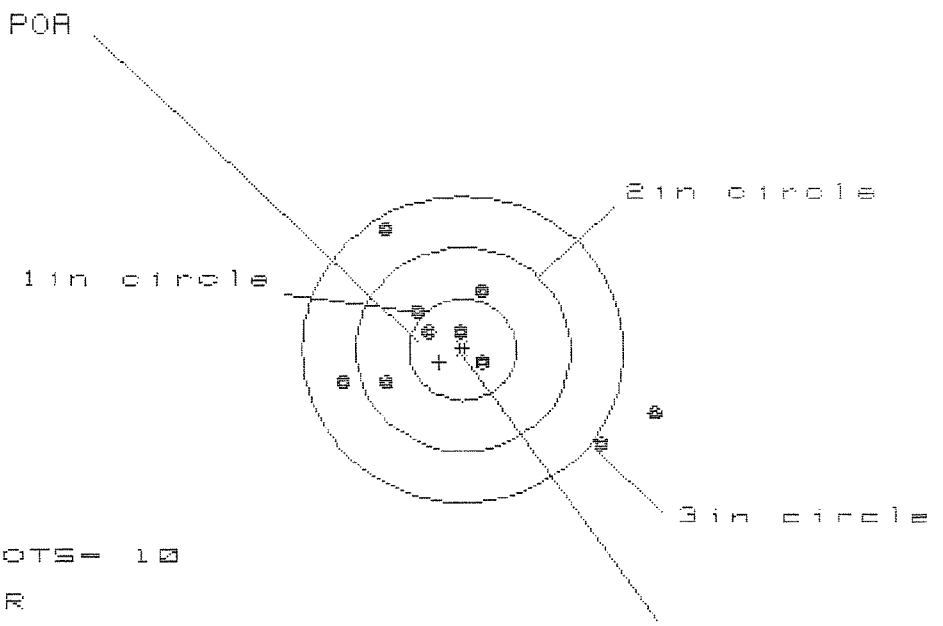
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

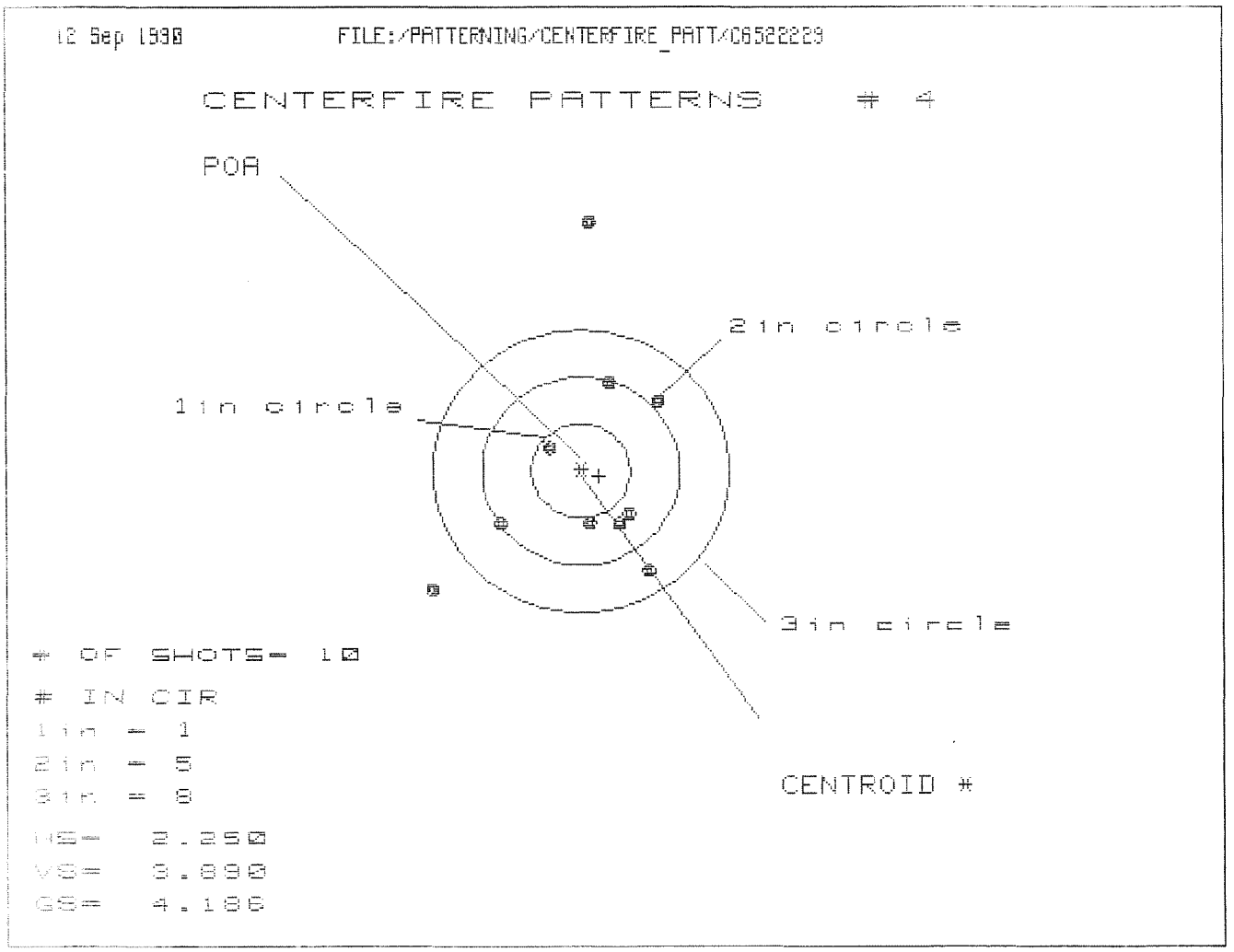
# IN CIR
1in = 3
2in = 6
3in = 8

HS= 2.859
VS= 2.053
GS= 3.069

PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.757	1.440	.579
MINIMUM X :	-1.112	-.916	-.737
MAXIMUM Y :	1.137	1.069	.946
MINIMUM Y :	-.916	-.984	-.532
CENTROID X :	.220	.024	-.155
CENTROID Y :	.123	.191	.314
POA TO CENTROID in.:	.252	.193	.351
MIN RADIUS :	.150	.128	.103
MEAN RADIUS :	.863	.710	.565
MAX RADIUS :	1.861	1.744	1.023
HORIZONTAL SPREAD :	2.869	2.356	1.316
VERTICAL SPREAD :	2.053	2.053	1.478
EXTREME SPREAD :	3.069	2.872	1.621

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.756	.762	.576
MINIMUM X	:	-1.494	-1.488	-1.017
MAXIMUM Y	:	2.626	1.230	1.108
MINIMUM Y	:	-1.264	-.972	-.900
CENTROID X	:	-.183	-.189	-.003
CENTROID Y	:	.055	-.237	-.115
POA TO CENTROID in.	:	.191	.303	.115
MIN RADIUS	:	.407	.279	.403
MEAN RADIUS	:	1.123	.902	.781
MAX RADIUS	:	2.626	1.778	1.111
HORIZONTAL SPREAD	:	2.250	2.250	1.593
VERTICAL SPREAD	:	3.890	2.202	2.008
EXTREME SPREAD	:	4.186	3.003	2.067
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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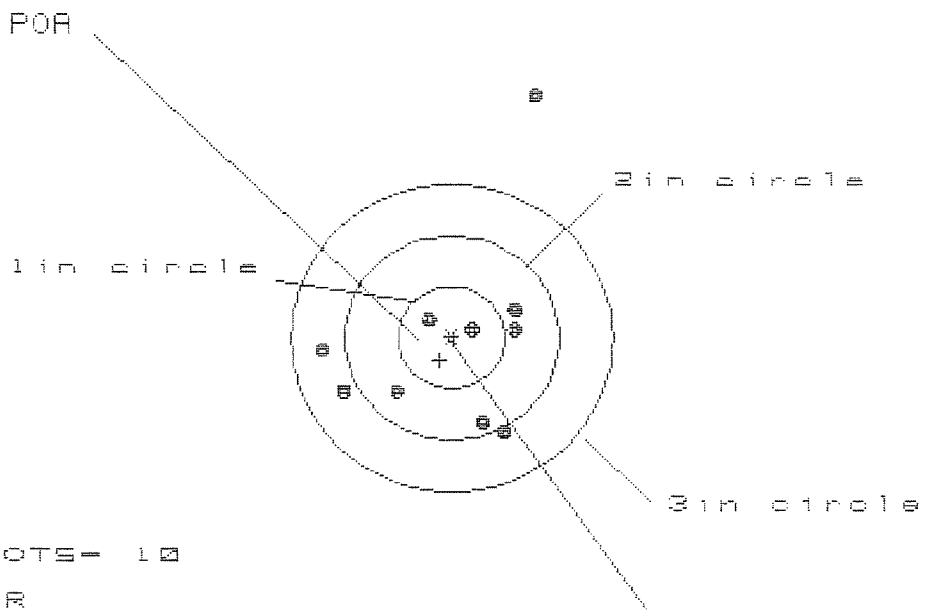
CENTERFIRE PATTERNS # 5

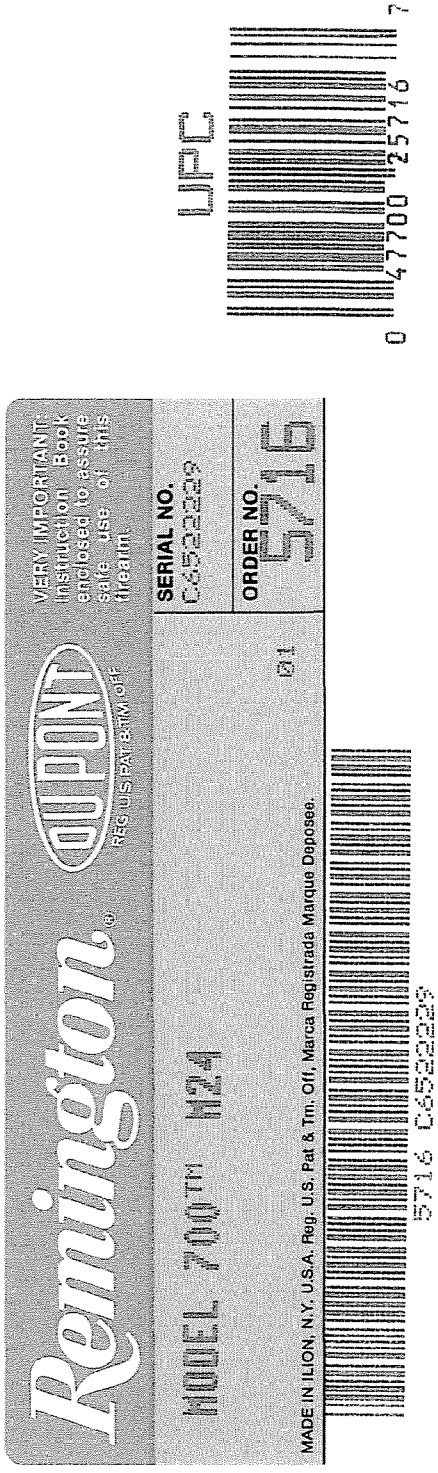


OF SHOTS= 10

# IN CIR
1in = 2
2in = 6
3in = 9

HS= 2.024
VS= 3.294
GS= 3.441

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.691	.550
MINIMUM X	:	-1.213	-1.123	-1.050
MAXIMUM Y	:	2.368	.529	.542
MINIMUM Y	:	-.926	-.663	-.650
CENTROID X	:	.111	.021	.161
CENTROID Y	:	.221	-.042	-.055
POA TO CENTROID in.	:	.247	.047	.171
MIN RADIUS	:	.154	.380	.323
MEAN RADIUS	:	.913	.726	.658
MAX RADIUS	:	2.503	1.128	1.087
HORIZONTAL SPREAD	:	2.024	1.814	1.600
VERTICAL SPREAD	:	3.294	1.192	1.192
EXTREME SPREAD	:	3.441	1.864	1.800
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TH M24
SERIAL NO.
C4522229
ORDER NO.
576
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5716 C4522229
UPC
0 47700 25716 7