

C6522211

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

M-24CONTRACT # DAAA21-87-C-0086GUN SERIAL # *C6522211*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	<i>RW</i>
600	Proof	8 2	90	<i>RW</i>
607	Check Headspace	8 2		<i>RW</i>
610	Dis-assemble Gun			<i>RW</i>
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	SS
617	Drill and Tap Sight Holes		8/10/90	SS
618	Polish Barrel <i>SS</i>		8/14/90	SS
620	Apply Coatings (Barrel Action)		8-22-90	<i>SS</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/24/90	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		8/24/90	<i>RW</i>
	D) Oil Firing Pin Ass'y		8/24/90	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	<i>SS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/28/90	RW
	G) Safety Off Force	7 1/4	7 1/4	7 1/4			8/28/90	RW
	H) Trigger Pull Test & Retainability						8/28/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			8/28/90	RW
	J) Assemble Stock						8/29/90	RW
	K) Assemble Swivel Studs						9/6/90	JD
	L) Attach Front and Rear Sight Assemblies						8/29/90	RW
	M) Iron Sight Alignment						8/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	RW
	O) Attach Scope to Rifle						8/29/90	RW
	P) Detach & Attach Scope 20 Times						8/29/90	RW
640	Gallery Target & Test						9/4/90	AF
	A) Time						9/4/90	AF
	B) Malfunctions						9/4/90	AF
	C) Pierced Primers						9/4/90	AF
	D) Optical Clarity of Scope						9/4/90	AF
645	Inspect for Live Ammo						9/4/90	AF
655	Final Inspection							
	A) Headspace						9/6/90	JD
	B) Trigger Pull	2.23	2.19	2.22	2.30	2.33	9-5-90	RL
	C) Function						9/6/90	JD
660	Pack						9/20/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522211

DATE 8/28/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.31	2.49	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.33	2.45	2.19	
PULL #3	2.16	2.34	2.50	2.29	
PULL #4	2.42	2.29	2.45	2.30	
PULL #5	2.34	2.40	2.35	2.33	
TOTAL	11.86	11.67	12.24	11.34	
AVG.	2.372	2.334	2.448	2.268	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.30		
PULL #2	3.19	3.26		
PULL #3	3.26	3.22		
PULL #4	3.27	3.22		
PULL #5	3.21	3.32		
TOTAL	16.05	16.32		
AVG.	3.21	3.264		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.21		4.30
PULL #2	4.40	4.25		4.17
PULL #3	4.49	4.22		4.10
PULL #4	4.12	4.24		4.16
PULL #5	4.21	4.17		4.11
TOTAL	21.60	21.09		20.84
AVG.	4.32	4.218		4.168

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522211
5 Sep 1990

CENTROIDAL DISTANCES

0	TO	1	.195028
1	TO	2	.202062
1	TO	3	.326034
1	TO	4	.215615
1	TO	5	.112272

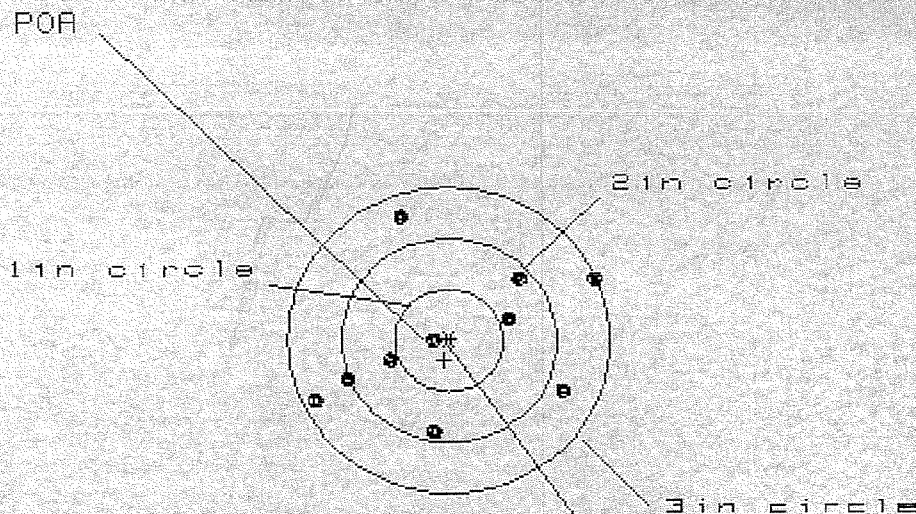
9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0882
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1498
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173837
THE AMR FOR THIS RIFLE IS: .9922

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C65222(1)

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.631

VS= 2.046

GS= 2.866

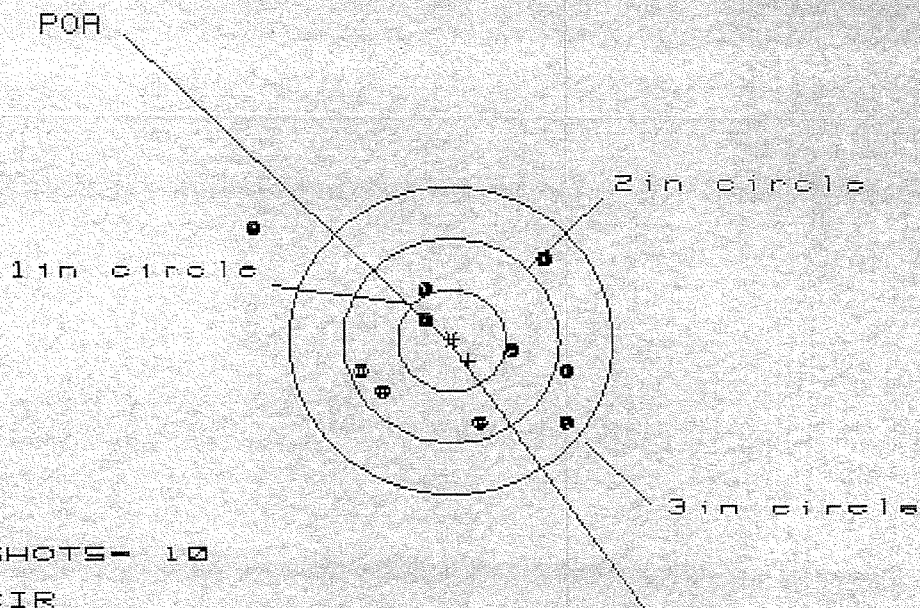
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	1.175	1.032
MINIMUM X	:	-1.287	-1.137	-.923
MAXIMUM Y	:	1.167	1.232	1.171
MINIMUM Y	:	-.879	-.814	-.875
CENTROID X	:	.044	-.106	.037
CENTROID Y	:	.190	.125	.186
POA TO CENTROID in.	:	.195	.164	.190
MIN RADIUS	:	.187	.068	.180
MEAN RADIUS	:	.938	.853	.813
MAX RADIUS	:	1.466	1.264	1.246
HORIZONTAL SPREAD	:	2.631	2.312	1.955
VERTICAL SPREAD	:	2.046	2.046	2.046
EXTREME SPREAD	:	2.866	2.312	2.220
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

5 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.835

VS= 1.931

GS= 3.396

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.028	.828	.925
MINIMUM X	:	-1.807	-1.031	-.928
MAXIMUM Y	:	1.123	.906	.829
MINIMUM Y	:	-.808	-.684	-.761
CENTROID X	:	-.158	.042	-.061
CENTROID Y	:	.195	.071	.148
POA TO CENTROID in.	:	.251	.082	.160
MIN RADIUS	:	.308	.366	.412
MEAN RADIUS	:	.961	.815	.778
MAX RADIUS	:	2.127	1.132	1.139
HORIZONTAL SPREAD	:	2.835	1.859	1.853
VERTICAL SPREAD	:	1.931	1.590	1.590
EXTREME SPREAD	:	3.396	2.002	2.002
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1998

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.751

VS= 2.298

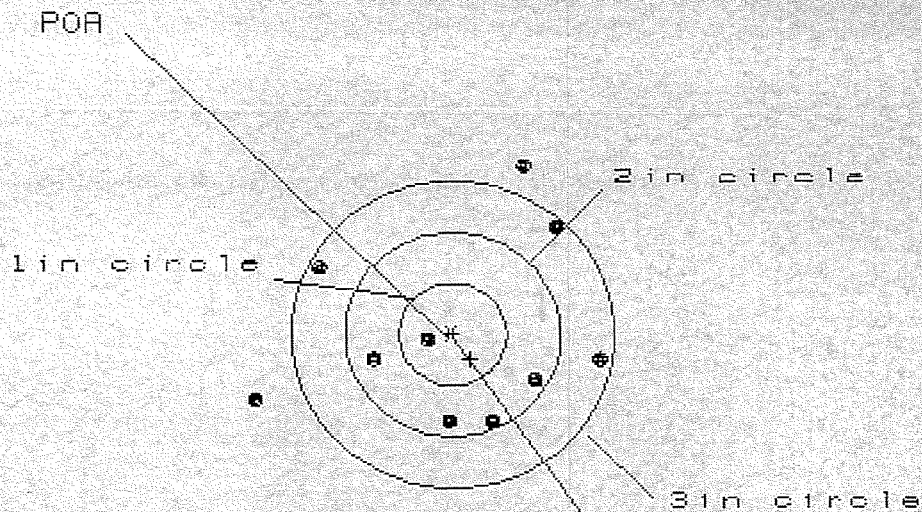
GS= 2.600

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.661	.540	.541
MINIMUM X	:	-1.090	-.999	-.998
MAXIMUM Y	:	.983	.836	.517
MINIMUM Y	:	-1.315	-.708	-.603
CENTROID X	:	-.099	.022	.021
CENTROID Y	:	-.103	.044	-.061
POA TO CENTROID in.	:	.143	.049	.065
MIN RADIUS	:	.253	.120	.199
MEAN RADIUS	:	.701	.533	.495
MAX RADIUS	:	1.708	1.071	1.037
HORIZONTAL SPREAD	:	1.751	1.539	1.539
VERTICAL SPREAD	:	2.298	1.544	1.120
EXTREME SPREAD	:	2.600	1.582	1.572
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.220

VS= 2.564

GS= 3.494

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.132	1.192
MINIMUM X	:	-1.879	-1.489	-1.429
MAXIMUM Y	:	1.694	1.619	1.153
MINIMUM Y	:	-0.870	-0.945	-0.742
CENTROID X	:	-0.165	0.044	-0.017
CENTROID Y	:	0.243	0.318	0.115
POA TO CENTROID in.	:	0.294	0.321	0.117
MIN RADIUS	:	0.216	0.433	0.383
MEAN RADIUS	:	1.176	1.094	0.972
MAX RADIUS	:	1.996	1.690	1.630
HORIZONTAL SPREAD	:	3.220	2.621	2.621
VERTICAL SPREAD	:	2.564	2.564	1.895
EXTREME SPREAD	:	3.494	2.783	2.783
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

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 2.718

VS= 3.723

GS= 3.723

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.791	1.698	1.586
MINIMUM X	:	-.927	-1.020	-1.132
MAXIMUM Y	:	1.968	.980	.788
MINIMUM Y	:	-1.755	-1.536	-.849
CENTROID X	:	-.063	.030	.142
CENTROID Y	:	.224	.005	.197
POA TO CENTROID in.	:	.232	.030	.243
MIN RADIUS	:	.306	.344	.479
MEAN RADIUS	:	1.185	1.074	.972
MAX RADIUS	:	2.140	1.778	1.599
HORIZONTAL SPREAD	:	2.718	2.718	2.718
VERTICAL SPREAD	:	3.723	2.516	1.637
EXTREME SPREAD	:	3.723	3.010	2.772
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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

Model 700™ M24

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

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

SERIAL NO.
C6522211

ORDER NO.
5716

Ø1



5716 C6522211

UPC



0 47700 25716 7

C6522210

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington