

C6498818

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498818

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	LS.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-26-90	AA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/21/90	WB
	G) Safety Off Force	2	2	2			8/21/90	WB
	H) Trigger Pull Test & Retainability						8/21/90	WB
	I) Firing Pin Indent	.023	.023	.023			8/21/90	WB
	J) Assemble Stock						8/22/90	RW
	K) Assemble Swivel Studs						8/30/90	JS
	L) Attach Front and Rear Sight Assemblies						8/22/90	RW
	M) Iron Sight Alignment						8/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/22/90	RW
	O) Attach Scope to Rifle						8/22/90	RW
	P) Detach & Attach Scope 20 Times						8/22/90	RW
640	Gallery Target & Test						8/22/90	KL
	A) Time						8/22/90	KL
	B) Malfunctions						8/22/90	KL
	C) Pierced Primers						8/22/90	KL
	D) Optical Clarity of Scope						8/22/90	KL
645	Inspect for Live Ammo						8/22/90	KL
655	Final Inspection						8/30/90	JS
	A) Headspace						8/30/90	JS
	B) Trigger Pull	2.25	2.23	2.24	2.26	2.24	8/30/90	JS
	C) Function						8/30/90	JS
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. C6498818

DATE 8/21/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.73	2.64	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.14	2.16	2.59	2.23	
PULL #3	2.22	2.18	2.30	2.24	
PULL #4	2.20	2.34	2.16	2.26	
PULL #5	2.14	2.33	2.14	2.24	
TOTAL	10.95	11.24	11.83	11.22	
AVG.	2.19	2.25	2.36	2.244	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.39		
PULL #2	3.37	3.49		
PULL #3	3.40	3.38		
PULL #4	3.31	3.42		
PULL #5	3.37	3.39		
TOTAL	16.82	17.05		
AVG.	3.36	3.41		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.41		4.40
PULL #2	4.35	4.37		4.31
PULL #3	4.25	4.10		4.37
PULL #4	4.33	4.16		4.32
PULL #5	4.35	4.25		4.39
TOTAL	21.62	21.29		21.79
AVG.	4.32	4.26		4.36

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498818
23 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.649998
1 TO	2	.728025
1 TO	3	.895646
1 TO	4	.872927
1 TO	5	1.10374

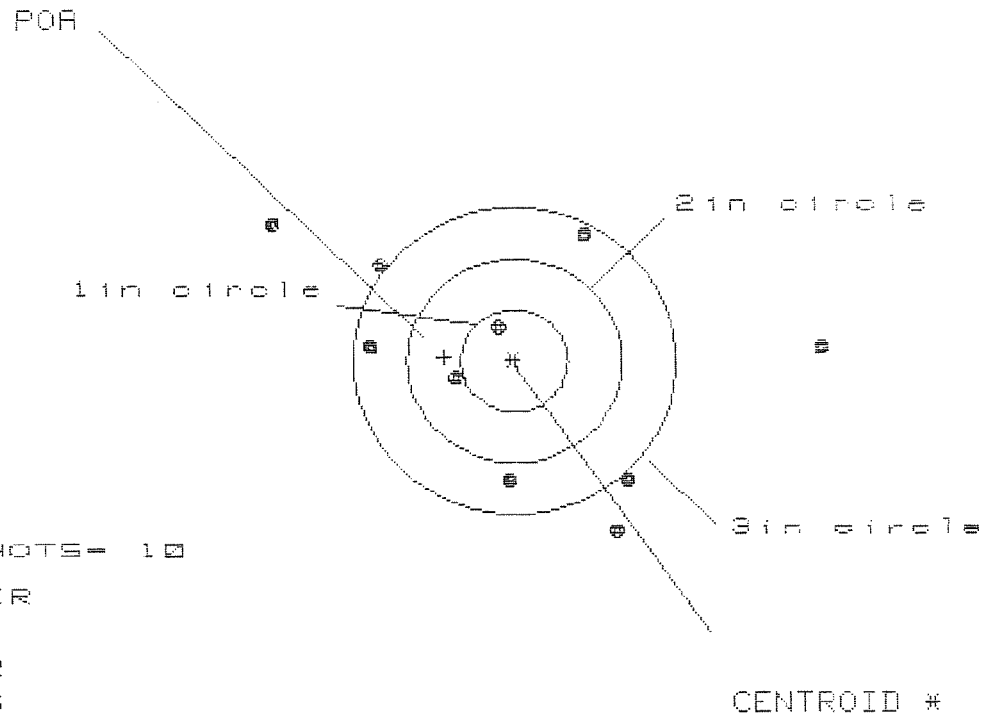
5
3
4
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0598
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.035
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0692895
THE AMR FOR THIS RIFLE IS: 1.23

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS498818

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 5

HS= 5.016

VS= 2.988

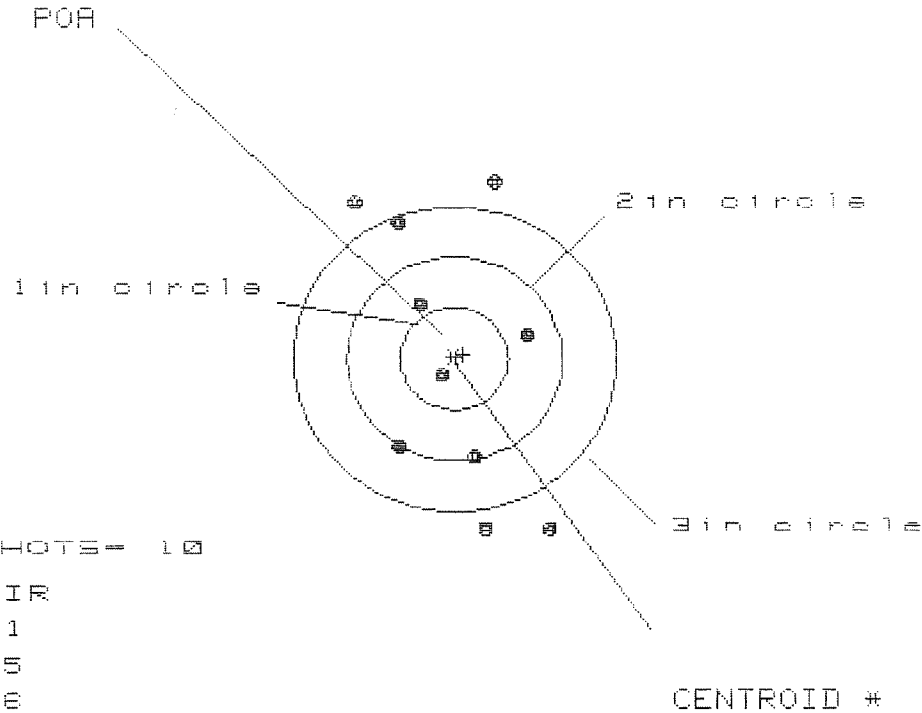
GS= 5.148

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.887	1.375	1.138
MINIMUM X	-2.209	-1.897	-1.385
MAXIMUM Y	1.339	1.359	1.409
MINIMUM Y	-1.649	-1.629	-1.460
CENTROID X	.649	.337	.574
CENTROID Y	-.036	-.056	-.225
POA TO CENTROID in.	.650	.342	.617
MIN RADIUS	.332	.250	.449
MEAN RADIUS	1.520	1.326	1.216
MAX RADIUS	2.813	2.334	1.812
HORIZONTAL SPREAD	5.016	3.272	2.443
VERTICAL SPREAD	2.988	2.988	2.869
EXTREME SPREAD	5.148	4.385	3.372
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B818

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 6

HS = 1.825

VS = 3.484

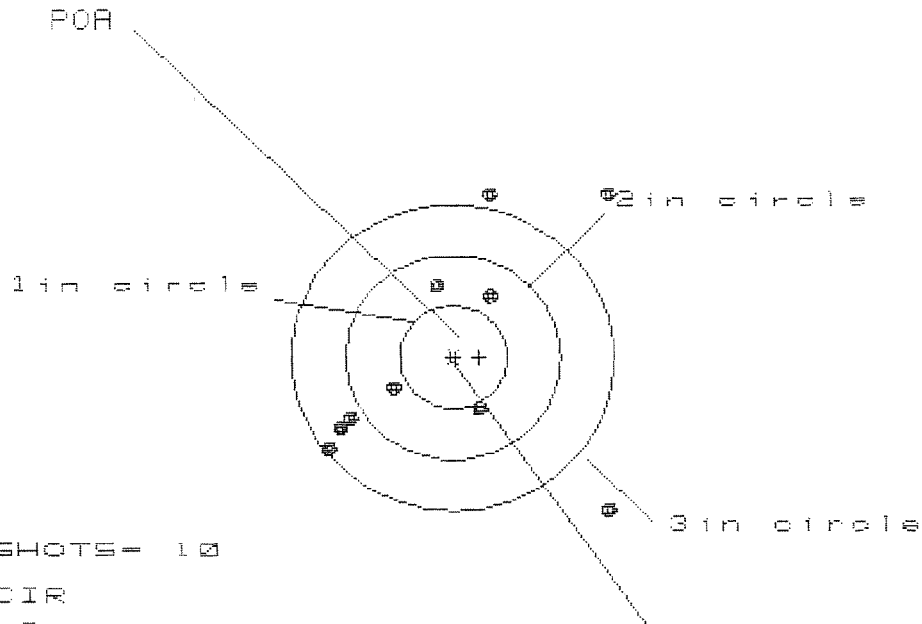
GS = 3.741

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.915	.751	.810
MINIMUM X	:	-.910	-.809	-.750
MAXIMUM Y	:	1.784	1.595	1.576
MINIMUM Y	:	-1.700	-1.872	-1.673
CENTROID X	:	-.079	-.180	-.239
CENTROID Y	:	-.042	.147	-.052
POA TO CENTROID in.	:	.089	.233	.245
MIN RADIUS	:	.254	.386	.181
MEAN RADIUS	:	1.209	1.123	1.029
MAX RADIUS	:	1.931	1.911	1.745
HORIZONTAL SPREAD	:	1.825	1.560	1.560
VERTICAL SPREAD	:	3.484	3.467	3.249
EXTREME SPREAD	:	3.741	3.468	3.460
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

23 Aug 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.635

VS= 3.065

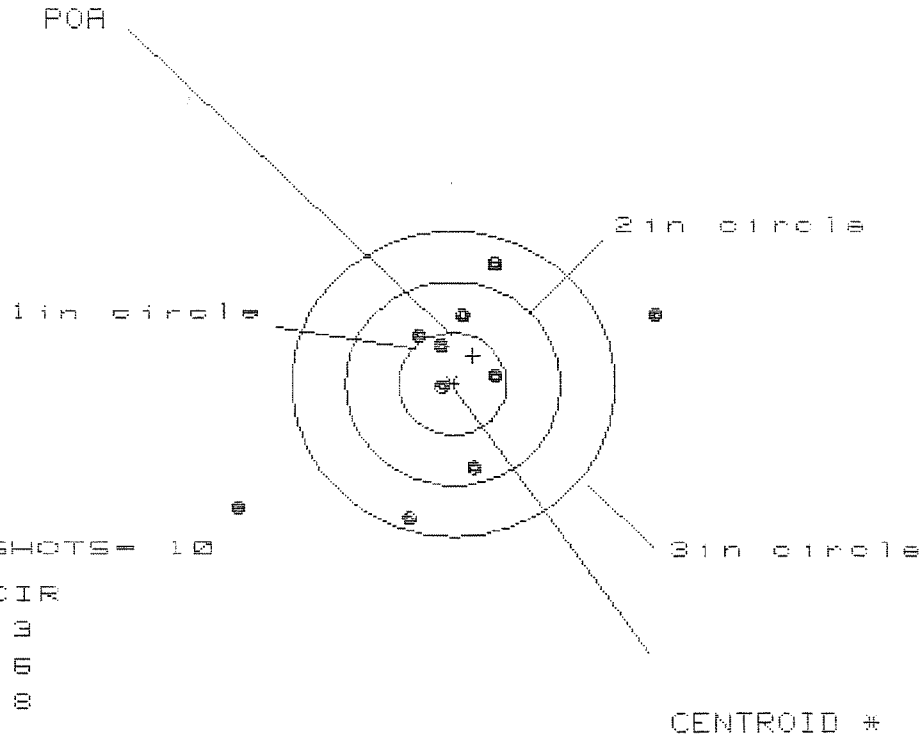
GS= 3.591

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.450
MINIMUM X	-1.185
MAXIMUM Y	1.573
MINIMUM Y	-1.492
CENTROID X	-.246
CENTROID Y	-.002
POA TO CENTROID in.	.246
MIN RADIUS	.573
MEAN RADIUS	1.220
MAX RADIUS	2.107
HORIZONTAL SPREAD	2.635
VERTICAL SPREAD	3.065
EXTREME SPREAD	3.591
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7

23 Aug 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 3.882

VS = 2.481

GS = 4.332

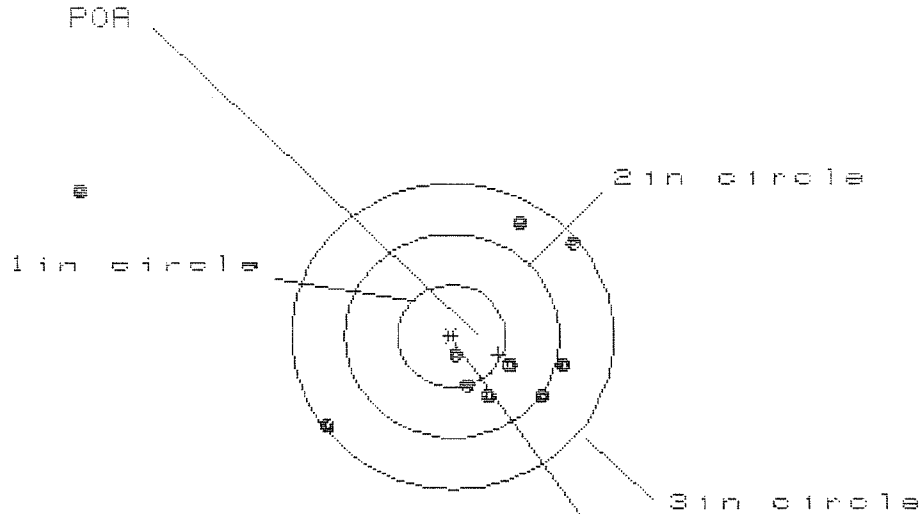
CENTROID *

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.861	1.636	.415
MINIMUM X	-2.021	-.648	-.443
MAXIMUM Y	1.172	1.032	1.097
MINIMUM Y	-1.319	-1.459	-1.394
CENTROID X	-.190	.035	-.170
CENTROID Y	-.277	-.137	-.202
POA TO CENTROID in.	.336	.141	.264
MIN RADIUS	.076	.238	.141
MEAN RADIUS	1.003	.838	.700
MAX RADIUS	2.382	1.717	1.463
HORIZONTAL SPREAD	3.882	2.284	.858
VERTICAL SPREAD	2.491	2.491	2.491
EXTREME SPREAD	4.332	3.023	2.613
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

23 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 4.579

VS = 2.211

GS = 4.832

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.100	.714	.518
MINIMUM X	-3.478	-1.567	-.556
MAXIMUM Y	1.368	1.224	1.137
MINIMUM Y	-.843	-.691	-.529
CENTROID X	-.433	-.047	.149
CENTROID Y	.182	.030	.117
POA TO CENTROID in.	.470	.056	.189
MIN RADIUS	.223	.185	.240
MEAN RADIUS	1.200	.777	.672
MAX RADIUS	3.737	1.713	1.139
HORIZONTAL SPREAD	4.578	2.281	1.074
VERTICAL SPREAD	2.211	1.915	1.666
EXTREME SPREAD	4.832	2.870	1.719
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

Remington.



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

MODEL 700™ M24

SERIAL NO.
C6498818

ORDER NO.
5716

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

01



5716 C6498818

UPC



0 47700 25716 7

BARBER - M24 0008335

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 000833508374