

C6498858

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 #

CG498858

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)		8-6-90	HA
	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		8/24/90	HA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/29/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/29/90	WB
	H) Trigger Pull Test & Retainability						8/29/90	84
	I) Firing Pin Indent	.024	.0235	.0235			8/29/90	WB
	J) Assemble Stock						8/30/90	RW
	K) Assemble Swivel Studs						9/5/90	928
	L) Attach Front and Rear Sight Assemblies						8/30/90	RW
	M) Iron Sight Alignment						8/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/30/90	RW
	O) Attach Scope to Rifle						8/30/90	RW
	P) Detach & Attach Scope 20 Times						8/30/90	RW
640	Gallery Target & Test						8.31.90	DH
	A) Time						8.31.90	DH
	B) Malfunctions						8.31.90	DH
	C) Pierced Primers						8.31.90	DH
	D) Optical Clarity of Scope						8.31.90	DH
645	Inspect for Live Ammo						8.31.90	DH
655	Final Inspection							
	A) Headspace						9/5/90	928
	B) Trigger Pull	2.21	2.28	2.48	2.50	2.42	9-4-90	94
	C) Function						9/5/90	928
660	Pack						2/20/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498858

DATE 8/29/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.53	2.21	2.21	MIN. SETTING,
PULL #2	2.40	2.30	2.34	2.28	NO AVG. OF 5
PULL #3	2.46	2.16	2.25	2.48	READINGS ACCEPT-
PULL #4	2.40	2.22	2.35	2.50	ABLE LESS THAN 2#
PULL #5	2.35	2.19	2.30	2.42	
TOTAL	12.00	11.40	11.45	11.89	
AVG.	2.4	2.28	2.29	2.378	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.19		
PULL #2	3.33	3.21		
PULL #3	3.44	3.32		
PULL #4	3.31	3.35		
PULL #5	3.44	3.30		
TOTAL	17.07	16.37		
AVG.	3.414	3.274		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.27		4.25
PULL #2	4.14	4.36		4.27
PULL #3	4.04	4.23		4.22
PULL #4	4.32	4.32		4.21
PULL #5	4.34	4.32		4.18
TOTAL	20.90	21.50		21.13
AVG.	4.18	4.3		4.226

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498858
31 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.494684
1 TO	2	.612222
1 TO	3	.714037
1 TO	4	1.05414
1 TO	5	.471819

+34 <----POA
15

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2986
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2464
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .387137
THE AMR FOR THIS RIFLE IS: .7732

31 Aug 1998

FILE:\PATTERNING\CENTERFIRE_PATT\06498858

CENTERFIRE PATTERNS

1

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.159

VS = 2.341

GS = 2.341

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	.897	.909
MINIMUM X	:	-1.155	-1.044	-1.032
MAXIMUM Y	:	1.187	1.275	1.074
MINIMUM Y	:	-1.154	-1.066	-.906
CENTROID X	:	-.166	-.277	-.289
CENTROID Y	:	-.466	-.554	-.714
POR TO CENTROID in.	:	.494	.620	.770
MIN RADIUS	:	.280	.138	.103
MEAN RADIUS	:	.869	.787	.683
MAX RADIUS	:	1.281	1.281	1.407
HORIZONTAL SPREAD	:	2.159	1.941	1.941
VERTICAL SPREAD	:	2.341	2.341	1.980
EXTREME SPREAD	:	2.341	2.341	2.132
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS498858

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.493

VS = 1.552

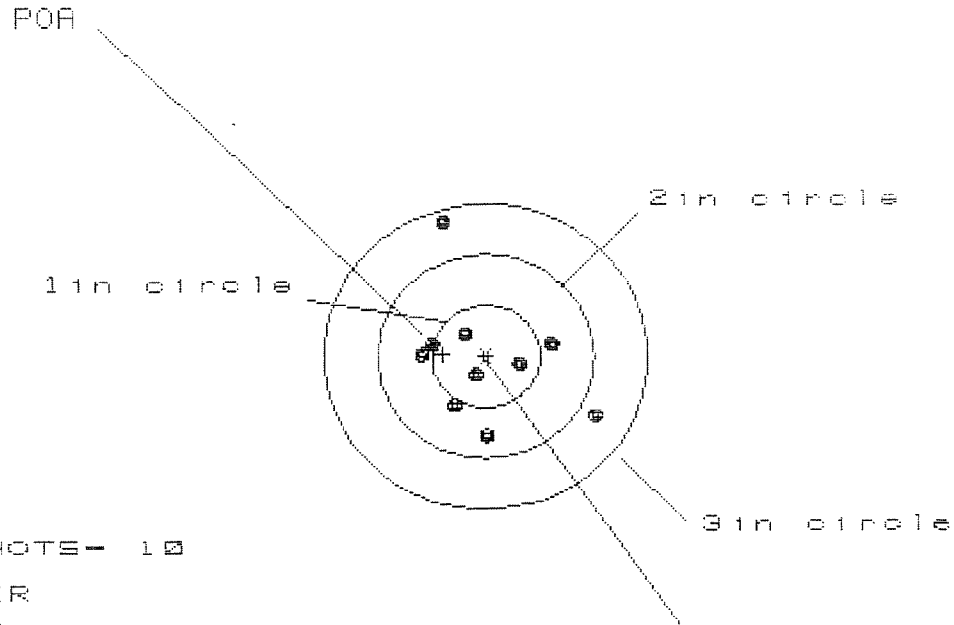
GS = 2.133

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.602
MINIMUM X	-.891
MAXIMUM Y	.704
MINIMUM Y	-.848
CENTROID X	.238
CENTROID Y	-.006
POA TO CENTROID in.	.238
MIN RADIUS	.180
MEAN RADIUS	.715
MAX RADIUS	1.211
HORIZONTAL SPREAD	1.493
VERTICAL SPREAD	1.552
EXTREME SPREAD	2.133
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10

31 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.584

VS= 2.098

GS= 2.360

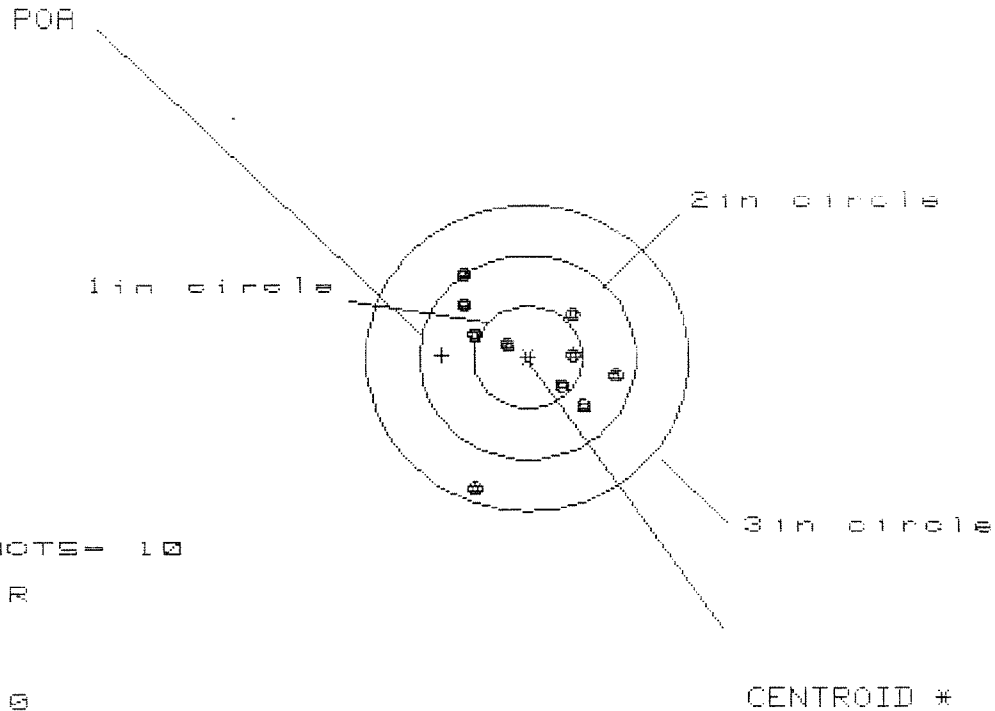
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.005	.964	.698
MINIMUM X	:	-.579	-.620	-.500
MAXIMUM Y	:	1.360	.421	.370
MINIMUM Y	:	-.738	-.587	-.638
CENTROID X	:	.394	.435	.315
CENTROID Y	:	-.023	-.174	-.123
POA TO CENTROID in.	:	.394	.469	.338
MIN RADIUS	:	.170	.087	.073
MEAN RADIUS	:	.640	.539	.458
MAX RADIUS	:	1.410	1.046	.739
HORIZONTAL SPREAD	:	1.584	1.584	1.198
VERTICAL SPREAD	:	2.098	1.008	1.008
EXTREME SPREAD	:	2.360	1.701	1.201
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.412

VS = 2.091

GS = 2.094

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.736	.657
MINIMUM X	-.623	-.676	-.755
MAXIMUM Y	.832	.692	.493
MINIMUM Y	-1.259	-.613	-.526
CENTROID X	.791	.844	.923
CENTROID Y	-.024	.116	.029
POA TO CENTROID in.	.792	.852	.923
MIN RADIUS	.253	.242	.241
MEAN RADIUS	.692	.605	.548
MAX RADIUS	1.345	.937	.902
HORIZONTAL SPREAD	1.412	1.412	1.412
VERTICAL SPREAD	2.091	1.305	1.019
EXTREME SPREAD	2.094	1.711	1.572
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.464

VS = 3.399

GS = 3.411

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.731	.745	.725
MINIMUM X	-.733	-.719	-.739
MAXIMUM Y	1.424	1.204	.910
MINIMUM Y	-1.975	-1.160	-1.009
CENTROID X	.236	.222	.242
CENTROID Y	-.713	-.493	-.644
POA TO CENTROID in.	.751	.541	.688
MIN RADIUS	.350	.350	.419
MEAN RADIUS	.950	.819	.762
MAX RADIUS	1.979	1.378	1.243
HORIZONTAL SPREAD	1.464	1.464	1.464
VERTICAL SPREAD	3.399	2.364	1.919
EXTREME SPREAD	3.411	2.530	2.414
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

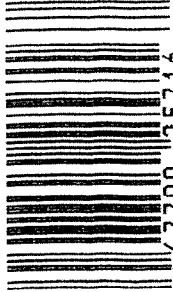
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6498858	ORDER NO. 5716
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5716 C6498858

UPC



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