

C6522281

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

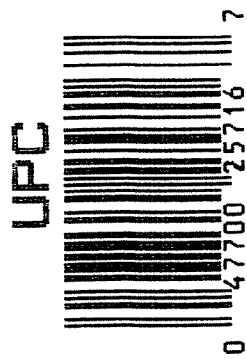
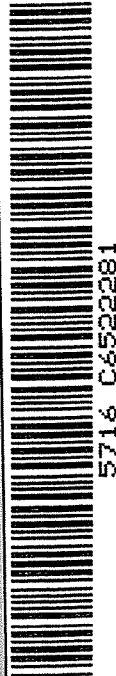
MODEL 700™ M24

SERIAL NO.
 C6522281

ORDER NO.
 5716

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

Ø1



CAN WCC

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522281

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action	NEW BARREL 8/22/90	8/23/90	KCD
	Magnaflux Bolt		8/23/90	KCD
615	Rollmark Caliber		8/23/90	CS
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-30-90	JK
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/15/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 ont.	F) Safety On Force	5	5	5			9/15/90	92
	G) Safety Off Force	2	2	2			9/15/90	92
	H) Trigger Pull Test & Retainability						9/15/90	WB
	I) Firing Pin Indent	0.023	0.025	0.025			9/15/90	92
	J) Assemble Stock						9/15/90	Rw
	K) Assemble Swivel Studs						9/17/90	92
	L) Attach Front and Rear Sight Assemblies						9/15/90	Rw
	M) Iron Sight Alignment						9/15/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	Rw
	O) Attach Scope to Rifle						9/15/90	Rw
	P) Detach & Attach Scope 20 Times						9/15/90	Rw
640	Gallery Target & Test						9/16/90	KT
	A) Time						9/16/90	KT
	B) Malfunctions						9/16/90	KT
	C) Pierced Primers						9/16/90	KT
	D) Optical Clarity of Scope						9/16/90	KT
645	Inspect for Live Ammo						9/16/90	KT
655	Final Inspection						9/17/90	92
	A) Headspace						9-17-90	92
	B) Trigger Pull	2.18	2.08	2.16	2.16	2.17	9-17-90	92
	C) Function						9/17/90	92
660	Pack						9-17-90	DA

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522281
DATE 9/14/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.46	2.54	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.50	2.08	
PULL #3	2.21	2.33	2.50	2.16	
PULL #4	2.24	2.34	2.50	2.16	
PULL #5	2.32	2.39	2.50	2.17	
TOTAL	11.60	11.91	12.54	10.75	
AVG.	2.32	2.38	2.51	2.15	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.32		
PULL #2	3.31	3.30		
PULL #3	3.30	3.31		
PULL #4	3.27	3.26		
PULL #5	3.29	3.30		
TOTAL	16.47	16.49		
AVG.	3.29	3.30		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.25		4.27
PULL #2	4.24	4.16		4.26
PULL #3	4.14	4.16		4.26
PULL #4	4.24	4.24		4.27
PULL #5	4.17	4.18		4.25
TOTAL	20.97	20.99		21.31
AVG.	4.19	4.20		4.26

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522281
16 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.14367
1 TO	2	.278916
1 TO	3	.292159
1 TO	4	.133056
1 TO	5	.0439318

06522281 (----POB

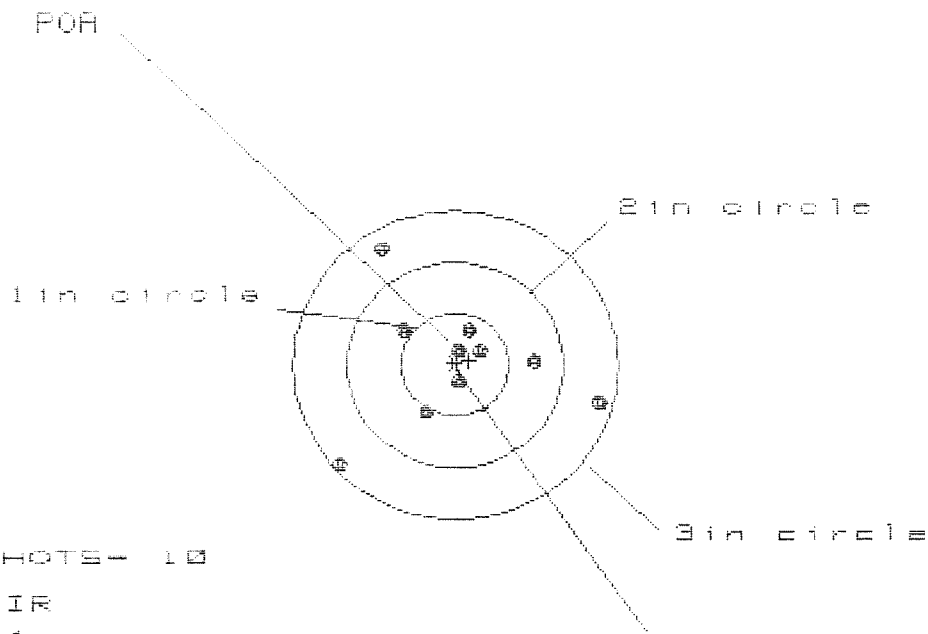
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0291548
THE AMR FOR THIS RIFLE IS: 1.118

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522281

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 3.457

VS = 2.024

GS = 2.512

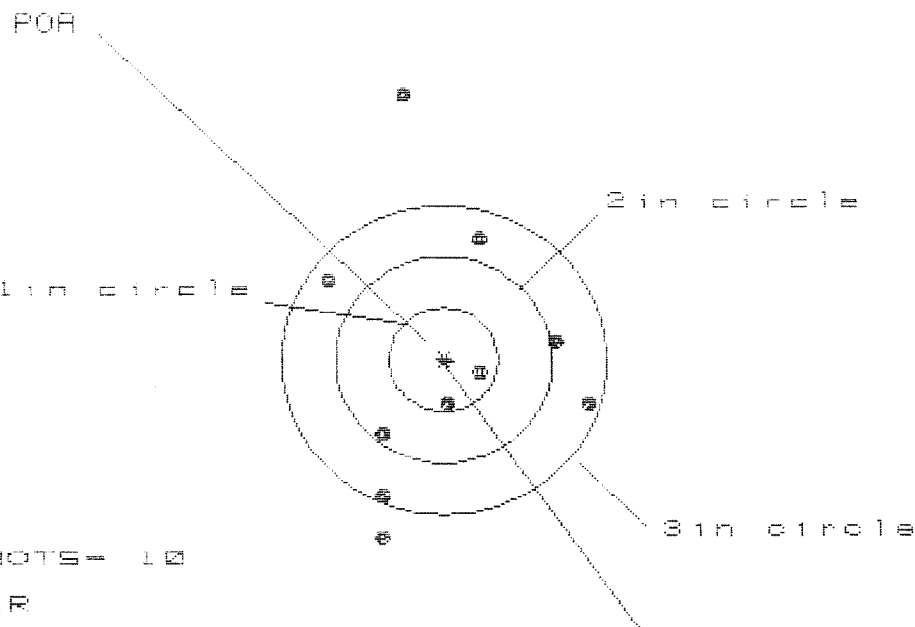
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.343	1.219	.710
MINIMUM X	-1.114	-1.785	-.633
MAXIMUM Y	1.098	.995	.932
MINIMUM Y	-.926	-.561	-.624
CENTROID X	-.129	-.005	-.157
CENTROID Y	-.036	.067	.130
POA TO CENTROID in.	.134	.067	.204
MIN RADIUS	.102	.086	.099
MEAN RADIUS	.683	.581	.498
MAX RADIUS	1.449	1.320	1.126
HORIZONTAL SPREAD	2.457	2.004	1.343
VERTICAL SPREAD	2.024	1.556	1.556
EXTREME SPREAD	2.512	2.504	1.733
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

16 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.330

VS= 4.350

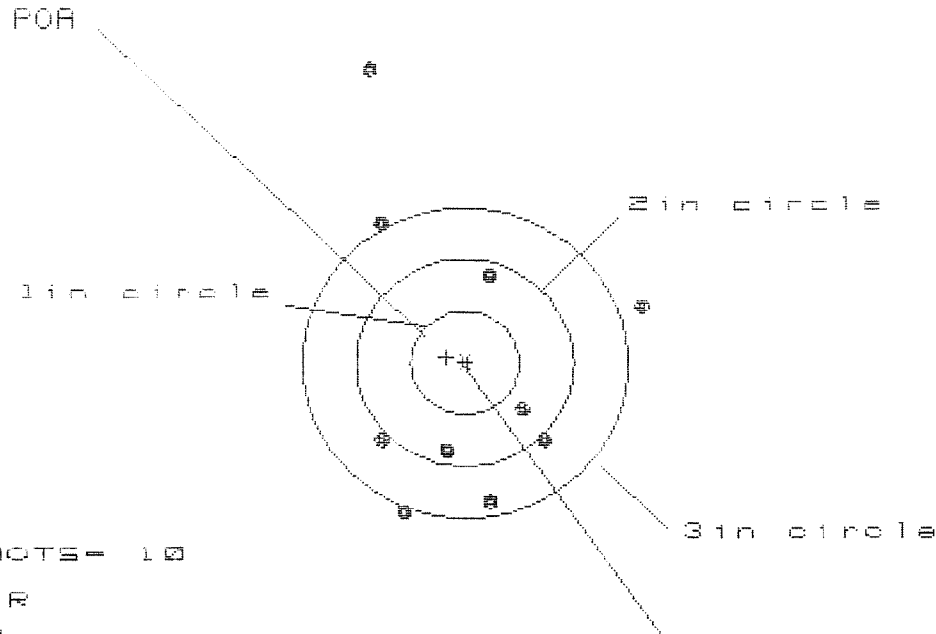
GS= 4.358

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	1.289	1.210
MINIMUM X	:	-1.063	-1.101	-1.180
MAXIMUM Y	:	2.589	1.500	1.316
MINIMUM Y	:	-1.761	-1.474	-1.233
CENTROID X	:	-.030	.008	.087
CENTROID Y	:	.019	-.268	-.084
POR TO CENTROID in.	:	.035	.269	.121
MIN RADIUS	:	.353	.092	.209
MEAN RADIUS	:	1.260	1.049	.981
MAX RADIUS	:	2.611	1.604	1.469
HORIZONTAL SPREAD	:	2.390	2.390	2.390
VERTICAL SPREAD	:	4.350	2.974	2.549
EXTREME SPREAD	:	4.358	3.109	2.686
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Sep 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS = 2.432

VS = 4.300

GS = 4.307

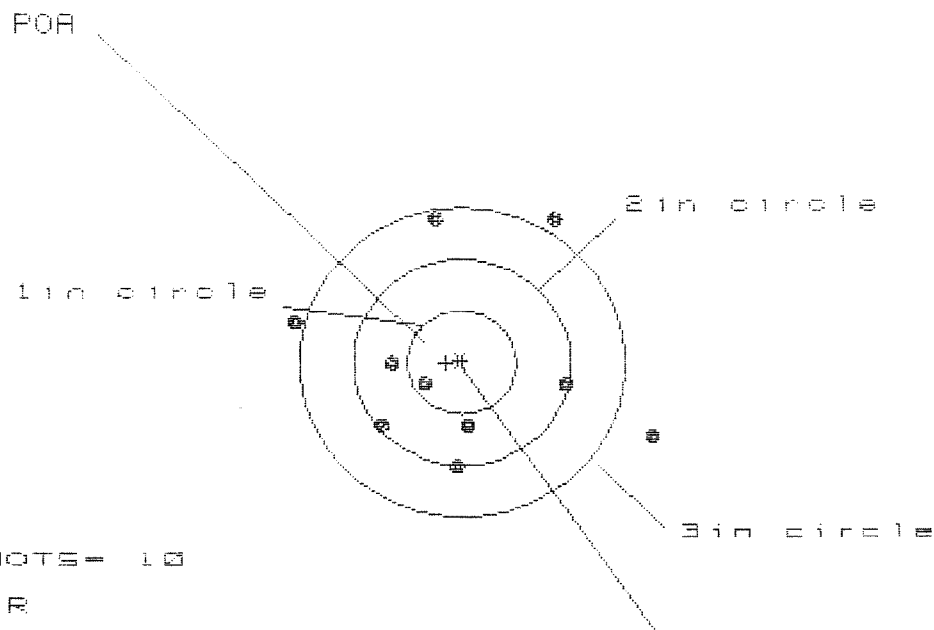
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.583	1.489	.778
MINIMUM X	:	-.849	-.857	-.671
MAXIMUM Y	:	2.820	1.704	1.808
MINIMUM Y	:	-1.480	-1.166	-1.062
CENTROID X	:	.171	.265	.079
CENTROID Y	:	-.053	-.367	-.471
POA TO CENTROID in.	:	.179	.452	.477
MIN RADIUS	:	.697	.453	.442
MEAN RADIUS	:	1.364	1.100	1.000
MAX RADIUS	:	2.945	1.900	1.922
HORIZONTAL SPREAD	:	2.432	2.346	1.449
VERTICAL SPREAD	:	4.300	2.870	2.870
EXTREME SPREAD	:	4.307	2.964	2.873
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

18 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/065222B1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.275

VS= 2.422

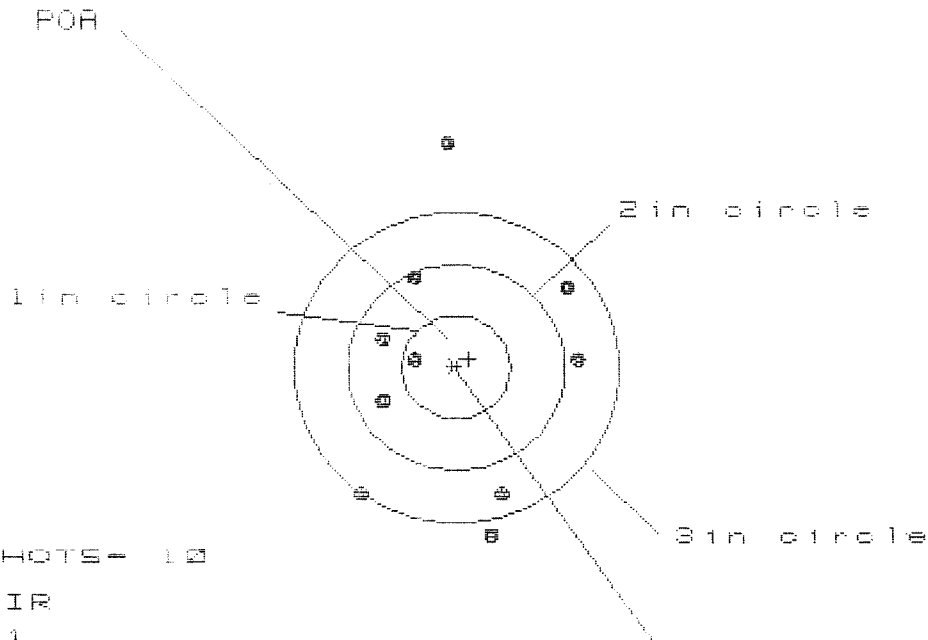
GS= 3.431

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.759	1.122	1.258
MINIMUM X	:	-1.516	-1.320	-1.184
MAXIMUM Y	:	1.439	1.366	1.496
MINIMUM Y	:	-.983	-1.056	-.885
CENTROID X	:	.145	-.051	-.187
CENTROID Y	:	.008	.081	-.090
POA TO CENTROID in.	:	.145	.095	.207
MIN RADIUS	:	.439	.339	.122
MEAN RADIUS	:	1.114	1.003	.838
MAX RADIUS	:	1.878	1.748	1.502
HORIZONTAL SPREAD	:	3.275	2.442	2.442
VERTICAL SPREAD	:	2.422	2.422	2.381
EXTREME SPREAD	:	3.431	2.638	2.514
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

16 Sep 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.936

VS= 3.841

GS= 3.867

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.092	1.082	1.127
MINIMUM X	:	-.844	-.854	-.809
MAXIMUM Y	:	2.224	1.082	.911
MINIMUM Y	:	-1.617	-1.370	-1.105
CENTROID X	:	-.120	-.110	-.154
CENTROID Y	:	-.079	-.326	-.155
POA TO CENTROID in.	:	.143	.344	.219
MIN RADIUS	:	.376	.504	.370
MEAN RADIUS	:	1.167	1.046	.970
MAX RADIUS	:	2.226	1.432	1.363
HORIZONTAL SPREAD	:	1.936	1.936	1.936
VERTICAL SPREAD	:	3.841	2.452	2.016
EXTREME SPREAD	:	3.867	2.690	2.690
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	