

C6225222

MODEL 700TM M24

Model 700 M24TM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

88299

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225222

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	1/28/88	RW
615	MAGNAFLUX BARREL	2/18/88	R/C.
	MAGNAFLUX BOLT	5/13/88	R/C.
620	COATING	8/11/88	JA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225222

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/88	KW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/88	KW
	C) Inspect Ejector Hole for Chamfer		8/22/88	KW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/22/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		23 Aug 88	J. W. S.
	F) Safety on Force	5.75 6 6	23 Aug 88	J. W. S.
	G) Safety off Force	3.75 3.75 3.75	23 Aug 88	J. W. S.
	H) Trigger Pull Test & Retainability		23 Aug 88	J. W. S.
	I) Firing Pin Indent	.023 .023 .023	23 Aug 88	J. W. S.
	J) Assemble Stock		8/24/88	RW
	K) Assemble Swivel Studs		10-12-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/6/88	RW
	M) Iron Sight Alignment		9/6/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/6/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	J.S.
640	Gallery Target & Test	47 R 108 L	10/11/88	W.B.
	A) Optical Clarity of Scope		10/11/88	W.B.
645	Inspect for Live Ammo		10/11/88	W.B. AC
655	Final Inspection			
	A) Headspace		10-12-88	J.S.
	B) Trigger Pull		10-14-88	J.S.
	C) Function		10-12-88	J.S.
660	Pack		10-21-88	J.S.

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225222

DATE 23 Aug 88

TESTER J. U. & M. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.76	2.92	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.67	2.87	2.81	
PULL #3	2.56	2.62	2.79	2.71	
PULL #4	2.60	2.70	2.94	2.72	
PULL #5	2.54	2.69	2.91	2.70	
TOTAL	12.82	13.44	14.43	13.68	
AVG.	2.564	2.688	2.886	2.736	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.38		
PULL #2	3.18	3.13		
PULL #3	3.21	3.24		
PULL #4	3.21	3.21		
PULL #5	3.21	3.27		
TOTAL	15.99	16.23		
AVG.	3.198	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.45		4.11
PULL #2	4.29	4.31		4.13
PULL #3	4.30	4.28		4.08
PULL #4	4.24	4.31		4.14
PULL #5	4.24	4.26		4.15
TOTAL	21.39	21.61		20.61
AVG.	4.278	4.322		4.122

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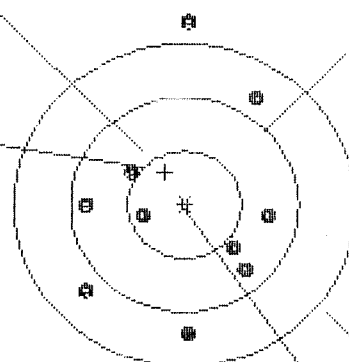
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.538

VS= 2.950

GS= 2.951

CENTROID *

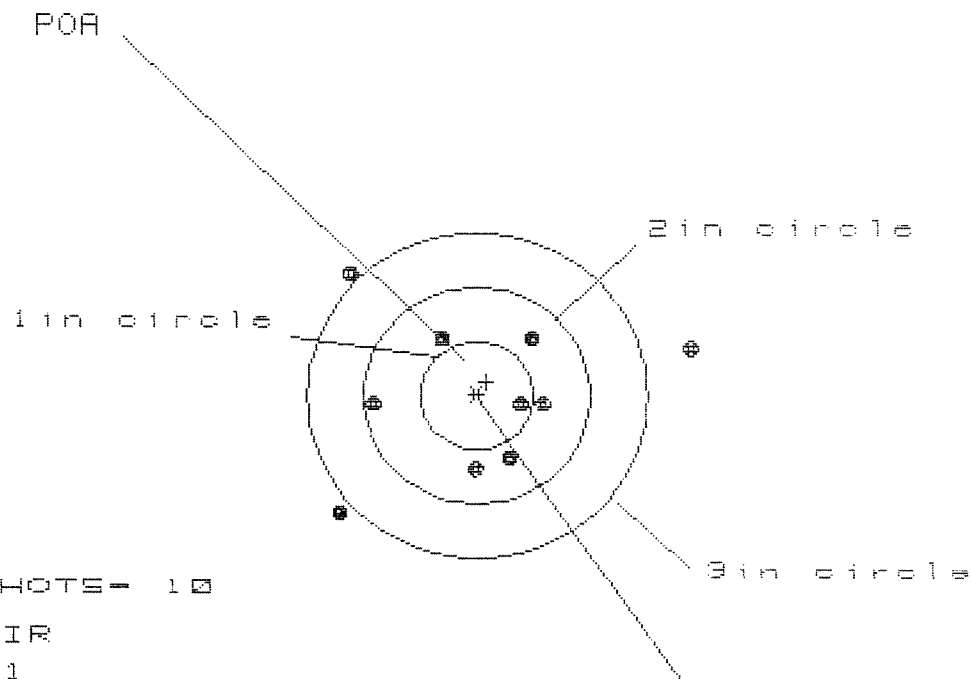
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.702	.704	.714
MINIMUM X	:	-.836	-.834	-.825
MAXIMUM Y	:	1.728	1.227	1.098
MINIMUM Y	:	-1.222	-1.029	-.726
CENTROID X	:	.170	.168	.158
CENTROID Y	:	-.303	-.495	-.366
POA TO CENTROID in.	:	.347	.522	.399
MIN RADIUS	:	.326	.345	.310
MEAN RADIUS	:	.908	.795	.760
MAX RADIUS	:	1.729	1.390	1.283
HORIZONTAL SPREAD	:	1.538	1.538	1.538
VERTICAL SPREAD	:	2.950	2.256	1.824
EXTREME SPREAD	:	2.951	2.354	2.354
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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 = 1

2in = 7

3in = 7

HS= 3.126

VS= 2.177

GS= 3.474

CENTROID #

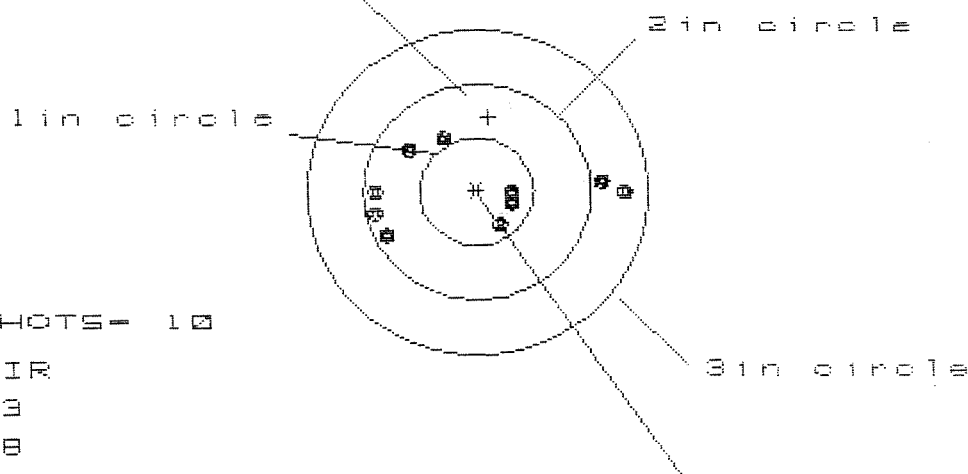
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.915	.777	.652
MINIMUM X	:	-1.211	-.998	-1.055
MAXIMUM Y	:	1.085	1.132	1.002
MINIMUM Y	:	-1.092	-1.045	-.791
CENTROID X	:	-.085	-.298	-.173
CENTROID Y	:	-.126	-.173	-.043
POA TO CENTROID in.:	:	.152	.345	.178
MIN RADIUS	:	.378	.551	.464
MEAN RADIUS	:	.972	.875	.779

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.246

VS= .920

GS= 2.257

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.277	.654
MINIMUM X	:	-.906	-.757	-.597
MAXIMUM Y	:	.474	.474	.488
MINIMUM Y	:	-.446	-.446	-.432
CENTROID X	:	-.101	-.250	-.410
CENTROID Y	:	-.697	-.697	-.711
POA TO CENTROID in.	:	.705	.741	.820
MIN RADIUS	:	.339	.484	.488
MEAN RADIUS	:	.751	.681	.594
MAX RADIUS	:	1.340	1.282	.664
HORIZONTAL SPREAD	:	2.246	2.034	1.251

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.031

VS= 2.385

GS= 2.425

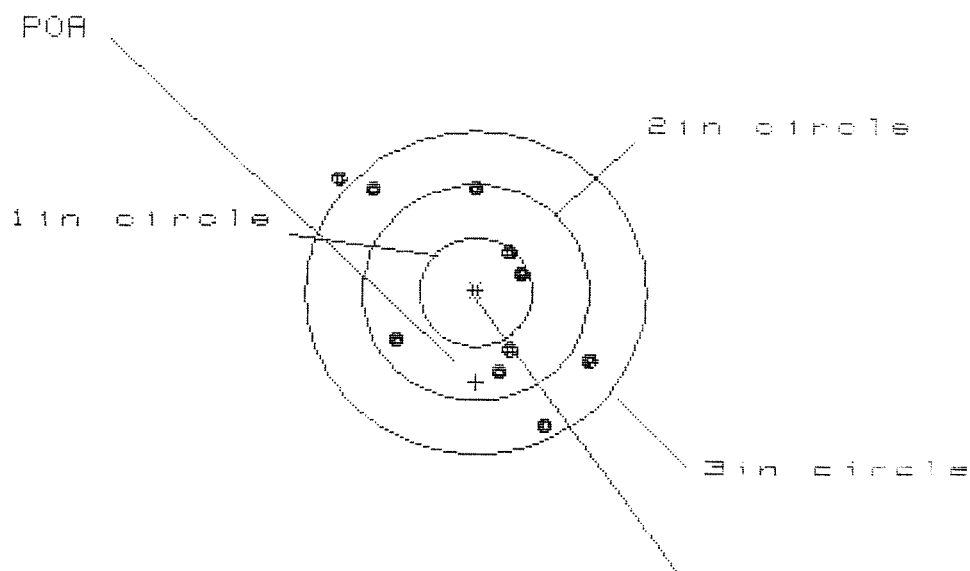
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.832	.914	.799
MINIMUM X	:	-1.199	-1.117	-1.003
MAXIMUM Y	:	1.230	.744	.617
MINIMUM Y	:	-1.155	-1.018	-.673
CENTROID X	:	.161	.079	-.035
CENTROID Y	:	-.905	-1.042	-.915
POA TO CENTROID in.	:	.920	1.045	.915
MIN RADIUS	:	.073	.232	.155
MEAN RADIUS	:	.785	.717	.614
MAX RADIUS	:	1.436	1.368	1.019
HORIZONTAL SPREAD	:	2.031	2.031	1.802
VERTICAL SPREAD	:	2.385	1.762	1.290
EXTREME SPREAD	:	2.425	2.425	1.854
NUMBER IN ONE INCH CIRCLE =	:		2	

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.199

VS= 2.289

GS= 2.917

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.024	.893	.956
MINIMUM X	:	-1.175	-1.052	-.989
MAXIMUM Y	:	1.084	1.123	.988
MINIMUM Y	:	-1.205	-1.085	-.763
CENTROID X	:	.001	.132	.069
CENTROID Y	:	.832	.712	.847
POA TO CENTROID in.	:	.832	.724	.850
MIN RADIUS	:	.427	.386	.359
MEAN RADIUS	:	.949	.847	.805
MAX RADIUS	:	1.599	1.478	1.339
HORIZONTAL SPREAD	:	2.199	1.945	1.945
VERTICAL SPREAD	:	2.289	2.208	1.751
EXTREME SPREAD	:	2.917	2.631	2.486
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225222

CENTROIDAL DISTANCES

0 TO	1	.832001
1 TO	2	1.74435
1 TO	3	1.5324
1 TO	4	.961852
1 TO	5	1.14751

1
#₅ <----FOR
3₂

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0292
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2398
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241571
THE AMR FOR THIS RIFLE IS: .873