

65225439

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

88299

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225439*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY <i>2</i>	<i>26</i>	<i>FB</i>
600	PROOF <i>2</i>	<i>29</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>pfe.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>pfe.</i>
620	COATING	<i>8/1/88</i>	<i>TJA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #

1703

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225439

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	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/88	RW
	C) Inspect Ejector Hole for Chamfer		8/22/88	RW

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	2.47 2.49 2.48 2.43 2.42	19 aug 88	J.U. + J.S.
	F) Safety on Force	5 5 5.5	19 aug 88	J.U. + J.S.
	G) Safety off Force	2.5 2.5 2.5	19 aug 88	J.U. + J.S.
	H) Trigger Pull Test & Retainabilty		19 aug 88	J.U. + J.S.
	I) Firing Pin Indent	.022 .0215 .022	19 aug 88	J.U. + J.S.
	J) Assemble Stock		8/24/88	RW
	K) Assemble Swivel Studs			
	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		9/12/88	RW
	P) Detach & Attach Scope 20 times		9/12/88	W.B.
640	Gallery Target & Test	65 R 90 L	9/16/88	D. H
	A) Optical Clarity of Scope		9/16/88	W.B.
645	Inspect for Live Ammo		9/16/88	W.B.
655	Final Inspection			
	A) Headspace	OK	9/30/88	J.S.
	B) Trigger Pull	OK	9/30/88	J.S.
	C) Function	OK	9/30/88	J.S.
660	Pack		10-21-88	J.S.

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225439

CENTROIDAL DISTANCES

0 TO	1	1.08406
1 TO	2	.660186
1 TO	3	.225568
1 TO	4	.745349
1 TO	5	1.00492

1 4
3 5
2 + (----POA

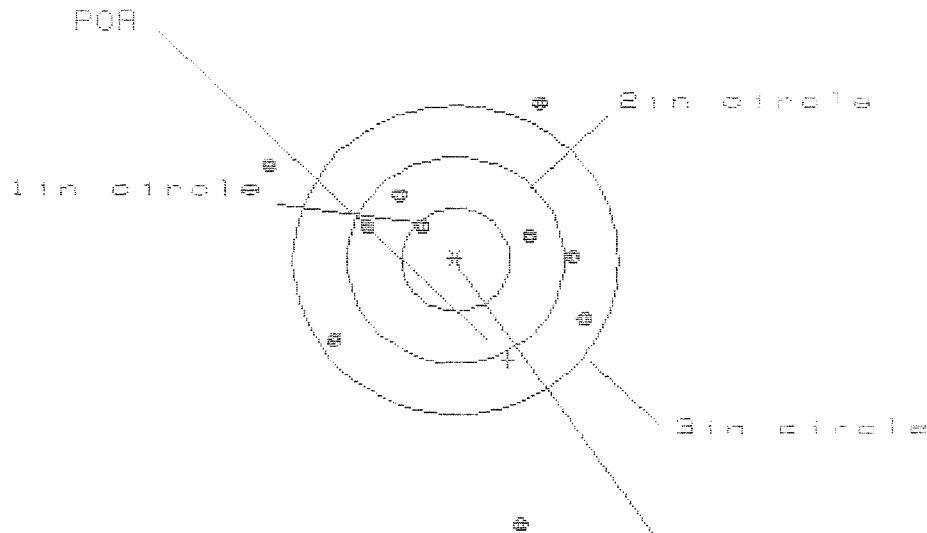
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.115
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7564
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .765092
THE AMR FOR THIS RIFLE IS: 1.085

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FILE:/PATTERNING/CENTERFIRE_PATT/C6225433

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.888

VS= 4.163

GS= 4.182

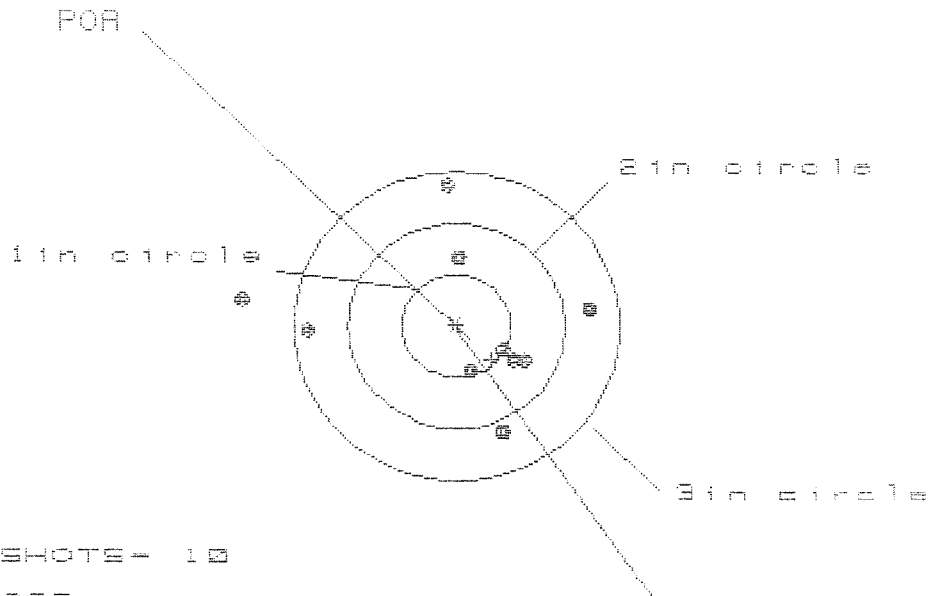
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.187	1.254	1.050
MINIMUM X	-1.701	-1.634	-1.220
MAXIMUM Y	1.565	1.277	1.352
MINIMUM Y	-2.598	-1.076	-1.001
CENTROID X	-.480	-.547	-.343
CENTROID Y	.972	1.260	1.185
POA TO CENTROID in.	1.084	1.374	1.234
MIN RADIUS	.488	.271	.488
MEAN RADIUS	1.297	1.090	1.016
MAX RADIUS	2.667	1.742	1.578
HORIZONTAL SPREAD	2.888	2.888	2.270
VERTICAL SPREAD	4.163	2.353	2.353
EXTREME SPREAD	4.182	3.232	2.986
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.152

VS = 2.380

GS = 3.157

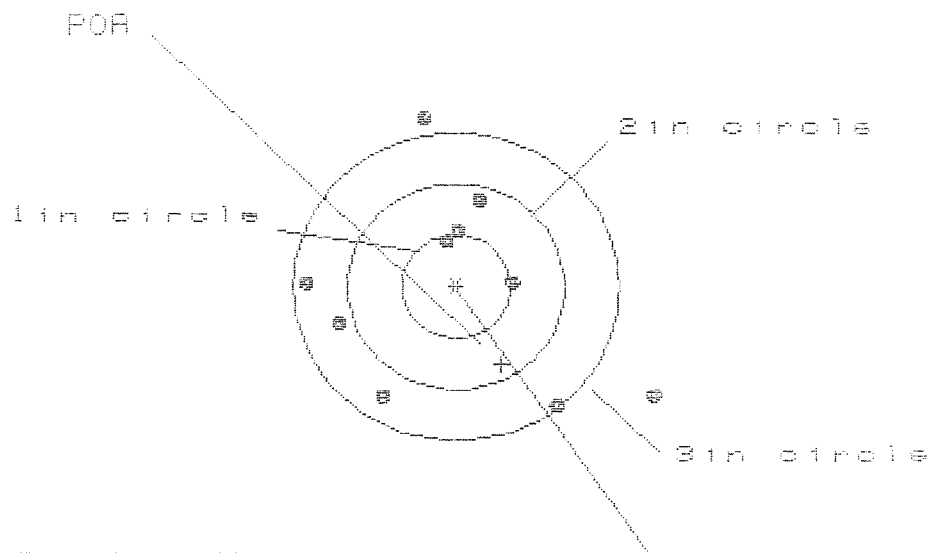
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.217	1.002	.863
MINIMUM X	-1.935	-1.589	-1.496
MAXIMUM Y	1.330	1.365	1.361
MINIMUM Y	-1.050	-1.015	-1.019
CENTROID X	-.322	-.107	.092
CENTROID Y	.331	.296	.300
POR TO CENTROID in.	.462	.315	.314
MIN RADIUS	.425	.271	.179
MEAN RADIUS	.991	.817	.677
MAX RADIUS	1.960	1.589	1.448
HORIZONTAL SPREAD	3.152	2.591	1.299
VERTICAL SPREAD	2.380	2.380	2.380
EXTREME SPREAD	3.157	2.599	2.439
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 0.147

VS = 2.813

ES = 3.402

CENTROID X

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.792	1.145	1.132
MINIMUM X	-1.355	-1.156	-1.159
MAXIMUM Y	1.672	1.560	.893
MINIMUM Y	-1.141	-1.253	-1.658
CENTROID X	-.415	-.614	-.681
CENTROID Y	.756	.868	.673
POA TO CENTROID in.	.963	1.064	.993
MIN RADIUS	.433	.336	.520
MEAN RADIUS	1.129	1.002	.951
MAX RADIUS	2.056	1.698	1.550
HORIZONTAL SPREAD	3.147	2.301	2.301
VERTICAL SPREAD	2.813	2.813	1.951
EXTREME SPREAD	3.402	3.078	2.580
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 1.887

VS= 2.837

GS= 2.972

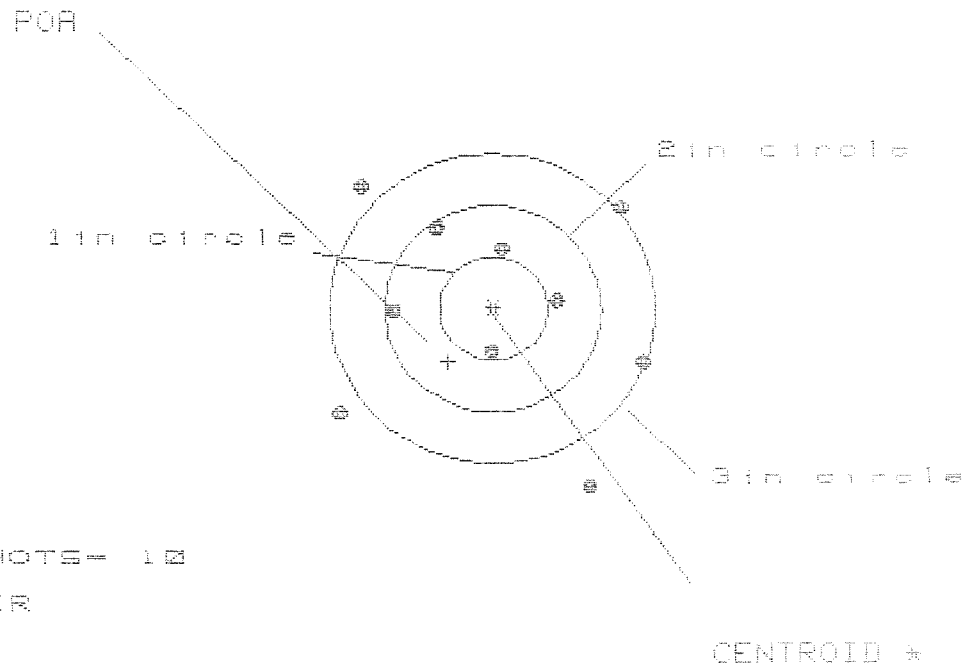
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.681	.658	.686
MINIMUM X	:	-1.006	-1.029	-.947
MAXIMUM Y	:	1.204	1.022	.551
MINIMUM Y	:	-1.633	-.875	-.747
CENTROID X	:	.227	.250	.168
CENTROID Y	:	1.208	1.390	1.262
POA TO CENTROID in.	:	1.230	1.412	1.273
MIN RADIUS	:	.113	.238	.190
MEAN RADIUS	:	.831	.735	.672
MAX RADIUS	:	1.846	1.216	1.076
HORIZONTAL SPREAD	:	1.687	1.687	1.552
VERTICAL SPREAD	:	2.837	1.897	1.298
EXTREME SPREAD	:	2.972	1.963	1.728
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 12

IN CH

115 = 1

115 = 0

115 = 0

115 = 0.884

115 = 0.812

115 = 0.507

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.395	1.489	1.320
MINIMUM X	:	-1.439	-1.345	-1.243
MAXIMUM Y	:	1.191	1.000	.854
MINIMUM Y	:	-1.721	-1.165	-.850
CENTROID X	:	.415	.321	.490
CENTROID Y	:	.515	.706	.852
POA TO CENTROID in.	:	.661	.776	.983
MIN RADIUS	:	.406	.456	.271
MEAN RADIUS	:	1.178	1.074	.962
MAX RADIUS	:	1.915	1.780	1.570
HORIZONTAL SPREAD	:	2.834	2.834	2.563
VERTICAL SPREAD	:	2.912	2.165	1.704
EXTREME SPREAD	:	3.537	3.240	3.070
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225439
DATE 19 Aug. 88
TESTER J. H. H. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.41	2.46	2.89	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.38	2.62	2.69	
PULL #3	2.42	2.38	2.45	2.61	
PULL #4	2.49	2.37	2.40	2.60	
PULL #5	2.43	2.36	2.44	2.62	
TOTAL	12.29	11.90	12.47	13.41	
AVG.	2.458	2.38	2.494	2.68	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.20		
PULL #2	3.10	3.18		
PULL #3	3.16	3.15		
PULL #4	3.08	3.17		
PULL #5	3.18	3.17		
TOTAL	15.68	15.87		
AVG.	3.136	3.174		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	3.98	4.23	4.28
PULL #2	4.00	3.99	4.18	4.24
PULL #3	3.93	4.00	4.18	4.28
PULL #4	4.01	3.91	4.16	4.27
PULL #5	4.01	4.01	4.18	4.27
TOTAL	19.99	19.89	20.93	21.34
AVG.	3.998	3.978	4.186	4.268

5439

MOD. _____ CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st 9/16	WON'T EXTRACT ON 4 th TARGET E 5 th TARGET	
	2nd	EXTRACTOR LOOSE New EXTRACTOR	
	3rd 9/21/88	100 Rds shot of	94
	4th		

FUNCTION _____ RD 6654 Rev 1



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		