

C6522266

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522266

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	JS.
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel <i>WLB</i>		8/14/90	WLB
620	Apply Coatings (Barrel Action)		8/22/90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/90	KS
	C) Inspect Ejector Hole for Chamfer		8/23/90	KS
	D) Oil Firing Pin Ass'y		8/23/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/24/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/24/90	WB
	H) Trigger Pull Test & Retainability						8/24/90	JLP
	I) Firing Pin Indent	.0225	.0225	.0225			8/24/90	WB
	J) Assemble Stock						8/24/90	KS
	K) Assemble Swivel Studs						8/31/90	JS
	L) Attach Front and Rear Sight Assemblies						8/24/90	KS
	M) Iron Sight Alignment						8/24/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	KS
	O) Attach Scope to Rifle						8/24/90	KS
	P) Detach & Attach Scope 20 Times						8/24/90	KS
640	Gallery Target & Test						8/24/90	RJ
	A) Time						8/24/90	RJ
	B) Malfunctions						8/24/90	RJ
	C) Pierced Primers						8/24/90	RJ
	D) Optical Clarity of Scope						8/24/90	RJ
645	Inspect for Live Ammo						8/24/90	RJ
655	Final Inspection						8/31/90	JS
	A) Headspace						8/30/90	JS
	B) Trigger Pull	2.02	2.00	2.20	2.20	2.02	8/30/90	JS
	C) Function						8/31/90	JS
660	Pack						9/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6522266

DATE 8/24/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.21	2.23	2.02	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.19	2.21	2.00	
PULL #3	2.49	2.21	2.18	2.20	
PULL #4	2.50	2.24	2.24	2.20	
PULL #5	2.19	2.20	2.21	2.02	
TOTAL	12.08	11.05	11.07	10.44	
AVG.	2.416	2.21	2.214	2.088	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.43		
PULL #2	3.37	3.34		
PULL #3	3.36	3.36		
PULL #4	3.41	3.41		
PULL #5	3.43	3.43		
TOTAL	17.00	16.97		
AVG.	3.4	3.394		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.14		4.28
PULL #2	4.10	4.19		4.27
PULL #3	4.14	4.18		4.25
PULL #4	4.16	4.25		4.31
PULL #5	4.15	4.23		4.27
TOTAL	20.75	20.99		21.38
AVG.	4.15	4.198		4.276

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522266
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.143178
1 TO	2	.340711
1 TO	3	.1986
1 TO	4	.500681
1 TO	5	.21285

$\frac{4}{25}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .015
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0254
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0294985
THE AMR FOR THIS RIFLE IS: 1.042

24 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08522266

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.059

VS= 1.650

GS= 2.152

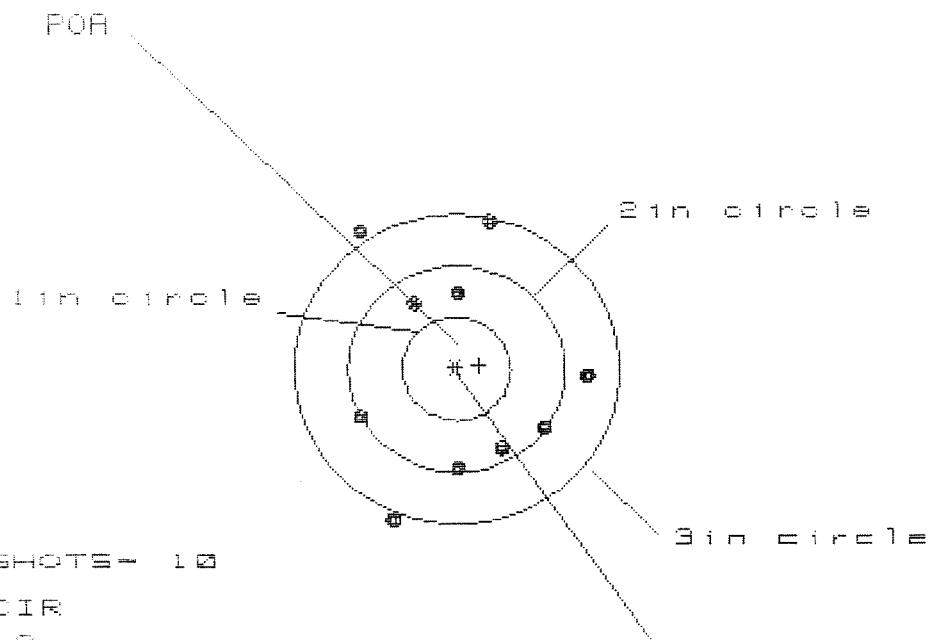
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.936	.856	.728
MINIMUM X	:	-1.123	-1.019	-.647
MAXIMUM Y	:	.735	.665	.655
MINIMUM Y	:	-.915	-.985	-.995
CENTROID X	:	.130	.026	.154
CENTROID Y	:	-.060	.010	.020
POA TO CENTROID in.	:	.143	.028	.155
MIN RADIUS	:	.238	.312	.185
MEAN RADIUS	:	.783	.741	.681
MAX RADIUS	:	1.129	1.072	1.136
HORIZONTAL SPREAD	:	2.059	1.875	1.375
VERTICAL SPREAD	:	1.650	1.650	1.650
EXTREME SPREAD	:	2.152	1.995	1.995
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522266

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HSI = 2.143

VSI = 2.821

CSI = 2.955

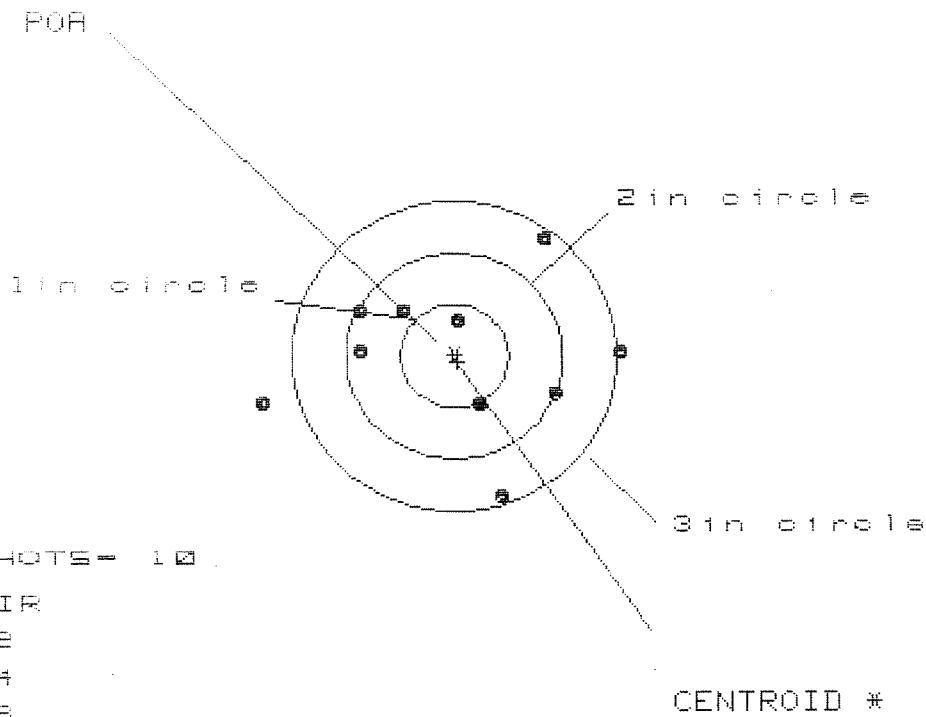
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.251
MINIMUM X	:	-0.892
MAXIMUM Y	:	1.403
MINIMUM Y	:	-1.418
CENTROID X	:	-0.210
CENTROID Y	:	-0.038
POA TO CENTROID in.	:	.214
MIN RADIUS	:	.688
MEAN RADIUS	:	1.100
MAX RADIUS	:	1.635
HORIZONTAL SPREAD	:	2.143
VERTICAL SPREAD	:	2.821
EXTREME SPREAD	:	2.955
NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	8

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522286

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.266

VS= 2.468

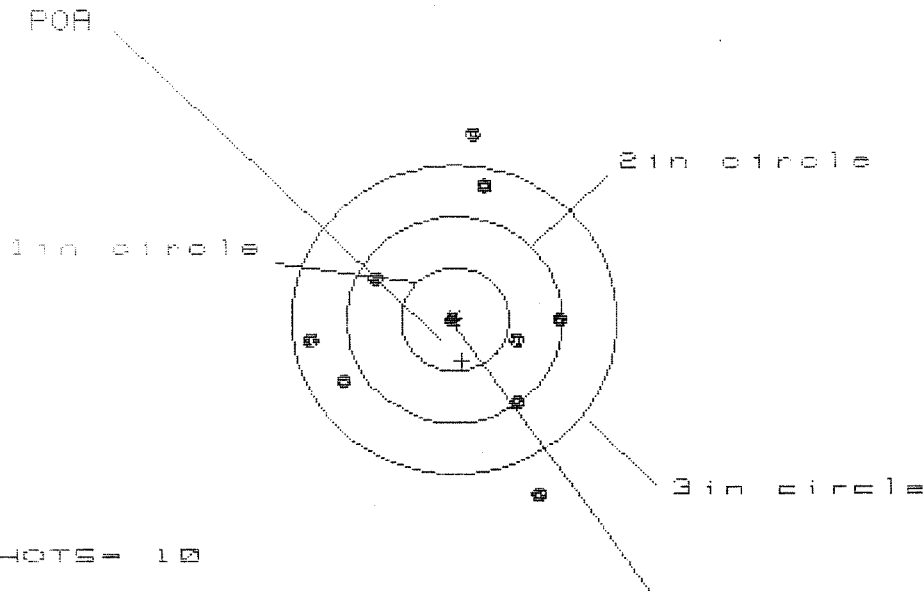
GS= 3.308

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.519
MINIMUM X	:	-1.747
MAXIMUM Y	:	1.139
MINIMUM Y	:	-1.329
CENTROID X	:	-.029
CENTROID Y	:	.059
POA TO CENTROID in.	:	.065
MIN RADIUS	:	.383
MEAN RADIUS	:	1.052
MAX RADIUS	:	1.802
HORIZONTAL SPREAD	:	3.266
VERTICAL SPREAD	:	2.468
EXTREME SPREAD	:	3.308
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	8

24 Aug 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HGT = 2.384

VGT = 3.457

GGT = 3.521

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	1.077	1.103
MINIMUM X	:	-1.375	-1.287	-1.261
MAXIMUM Y	:	1.769	1.581	1.286
MINIMUM Y	:	-1.688	-.965	-.767
CENTROID X	:	-.070	-.158	-.184
CENTROID Y	:	.399	.587	.389
POA TO CENTROID in.	:	.405	.608	.430
MIN RADIUS	:	.065	.172	.058
MEAN RADIUS	:	1.098	1.021	.918
MAX RADIUS	:	1.863	1.595	1.343
HORIZONTAL SPREAD	:	2.364	2.364	2.364
VERTICAL SPREAD	:	3.457	2.546	2.053
EXTREME SPREAD	:	3.521	2.638	2.367
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

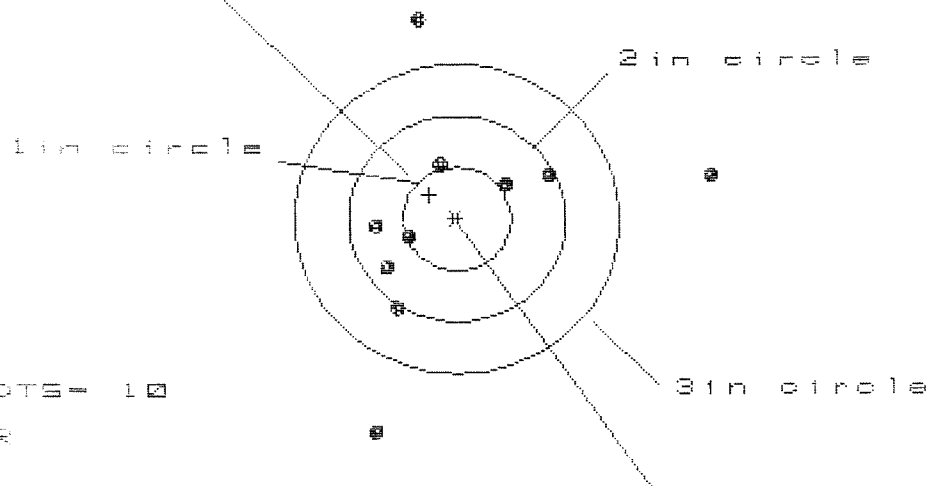
24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522266

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.190

VS= 3.981

GS= 3.993

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.388	1.158	1.102
MINIMUM X	:	-.802	-.536	-.592
MAXIMUM Y	:	1.945	1.992	1.743
MINIMUM Y	:	-2.036	-1.989	-1.091
CENTROID X	:	.254	-.012	.044
CENTROID Y	:	-.233	-.280	-.031
POA TO CENTROID in.	:	.344	.280	.054
MIN RADIUS	:	.475	.212	.294
MEAN RADIUS	:	1.176	.983	.859
MAX RADIUS	:	2.425	2.038	1.753
HORIZONTAL SPREAD	:	3.190	1.694	1.694
VERTICAL SPREAD	:	3.981	3.981	2.834
EXTREME SPREAD	:	3.993	3.993	2.838
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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

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

MODEL 700™ H24

SERIAL NO.
 C6522266

ORDER NO.
 5716

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

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