

C6522264

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 # C6522264

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			RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	JS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel AB		7/24/90	LB
620	Apply Coatings (Barrel Action)		7-16-90	DA
	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		9-12-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/14/90	JK
	G) Safety Off Force	3	3	3			8/14/90	JK
	H) Trigger Pull Test & Retainability						9/12/90	JK
	I) Firing Pin Indent	.0225	.0215	.0225			8/14/90	JK
	J) Assemble Stock						8/15/90	RW
	K) Assemble Swivel Studs						9/13/90	JK
	L) Attach Front and Rear Sight Assemblies						8/15/90	RW
	M) Iron Sight Alignment						8/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	RW
	O) Attach Scope to Rifle						8/15/90	RW
	P) Detach & Attach Scope 20 Times						8/15/90	RW
640	Gallery Target & Test						8/15/90	AF
	A) Time						8/15/90	AF
	B) Malfunctions						8/15/90	AF
	C) Pierced Primers						8/15/90	AF
	D) Optical Clarity of Scope						8/15/90	AF
645	Inspect for Live Ammo						8/15/90	AF
655	Final Inspection							
	A) Headspace						9/13/90	JK
	B) Trigger Pull	2.28	2.31	2.29	2.31	2.26	9-12-90	JK
	C) Function						9/13/90	JK
660	Pack						9/19/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522264DATE 9-12-90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.32	2.26	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.34	2.26	2.31	
PULL #3	2.32	2.31	2.33	2.29	
PULL #4	2.34	2.26	2.30	2.31	
PULL #5	2.35	2.24	2.21	2.26	
TOTAL	11.58	11.47	11.36	11.45	
AVG.	2.316	2.294	2.272	2.29	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.42		
PULL #2	3.50	3.45		
PULL #3	3.46	3.49		
PULL #4	3.47	3.49		
PULL #5	3.49	3.50		
TOTAL	17.35	17.35		
AVG.	3.47	3.47		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.14		4.17
PULL #2	4.27	4.21		4.17
PULL #3	4.14	4.16		4.17
PULL #4	4.16	4.22		4.18
PULL #5	4.24	4.16		4.20
TOTAL	20.95	20.89		20.89
AVG.	4.19	4.178		4.178

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522264
16 Aug 1990

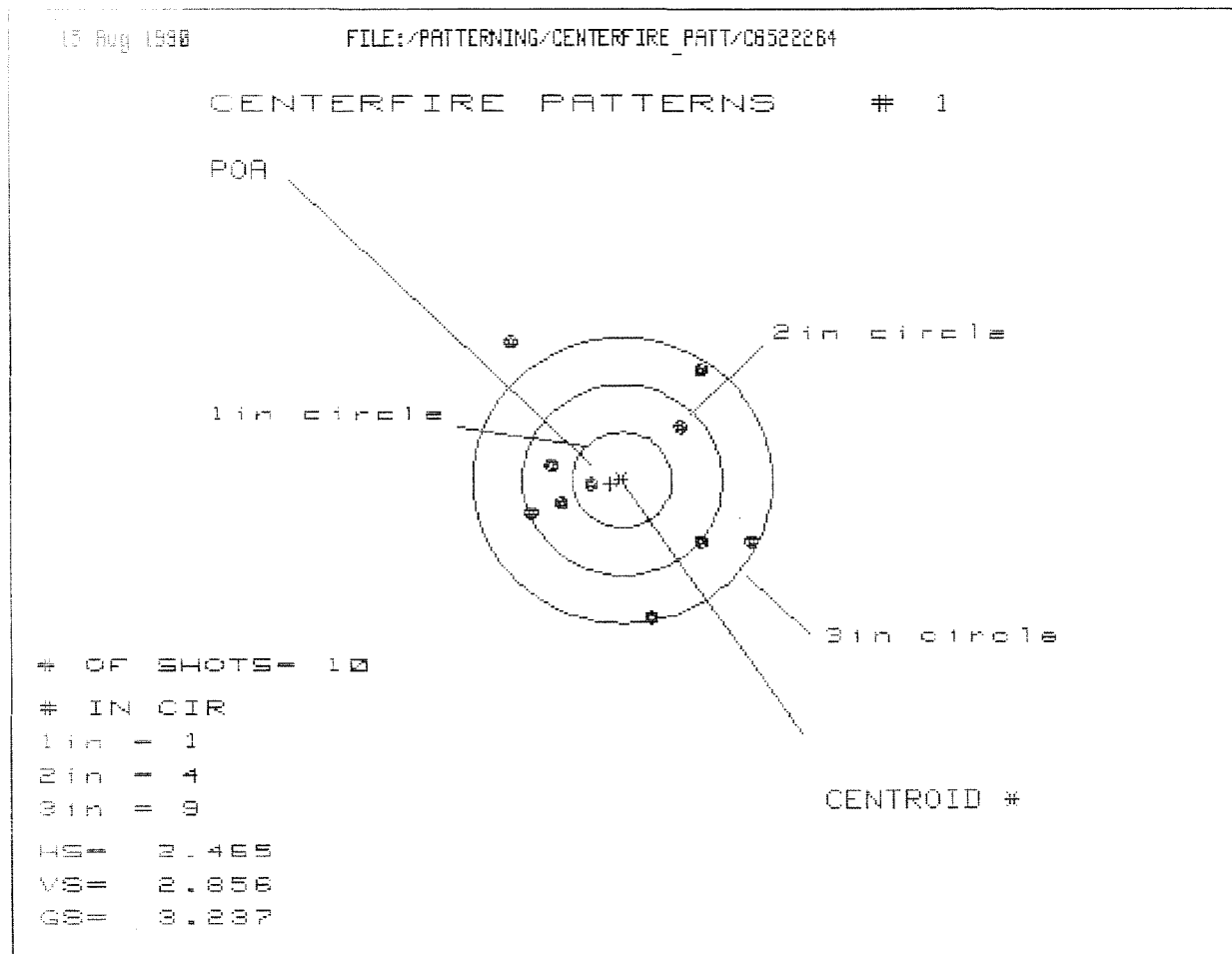
CENTROIDAL DISTANCES

0 TO	1	.123976
1 TO	2	.246018
1 TO	3	.210723
1 TO	4	.0470956
1 TO	5	.310821

54 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0594
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0598348

THE AMR FOR THIS RIFLE IS: .8796

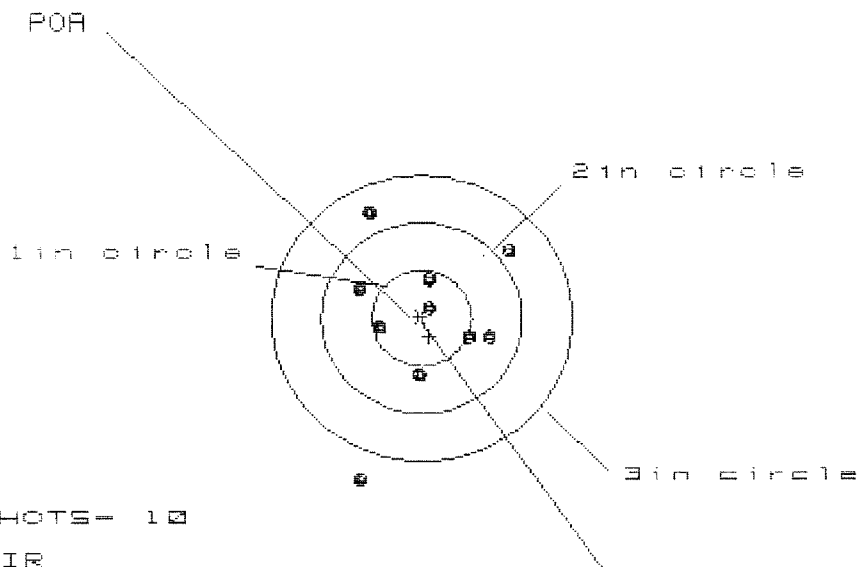


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.300	1.171	.831
MINIMUM X	-1.165	-1.081	-.935
MAXIMUM Y	1.441	1.307	1.244
MINIMUM Y	-1.415	-1.255	-1.318
CENTROID X	.117	.246	.100
CENTROID Y	.041	-.119	-.057
POA TO CENTROID in.	.124	.273	.115
MIN RADIUS	.342	.485	.329
MEAN RADIUS	1.080	.998	.929
MAX RADIUS	1.853	1.475	1.497
HORIZONTAL SPREAD	2.465	2.252	1.766
VERTICAL SPREAD	2.856	2.562	2.562
EXTREME SPREAD	3.237	2.610	2.610
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

15 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522264

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

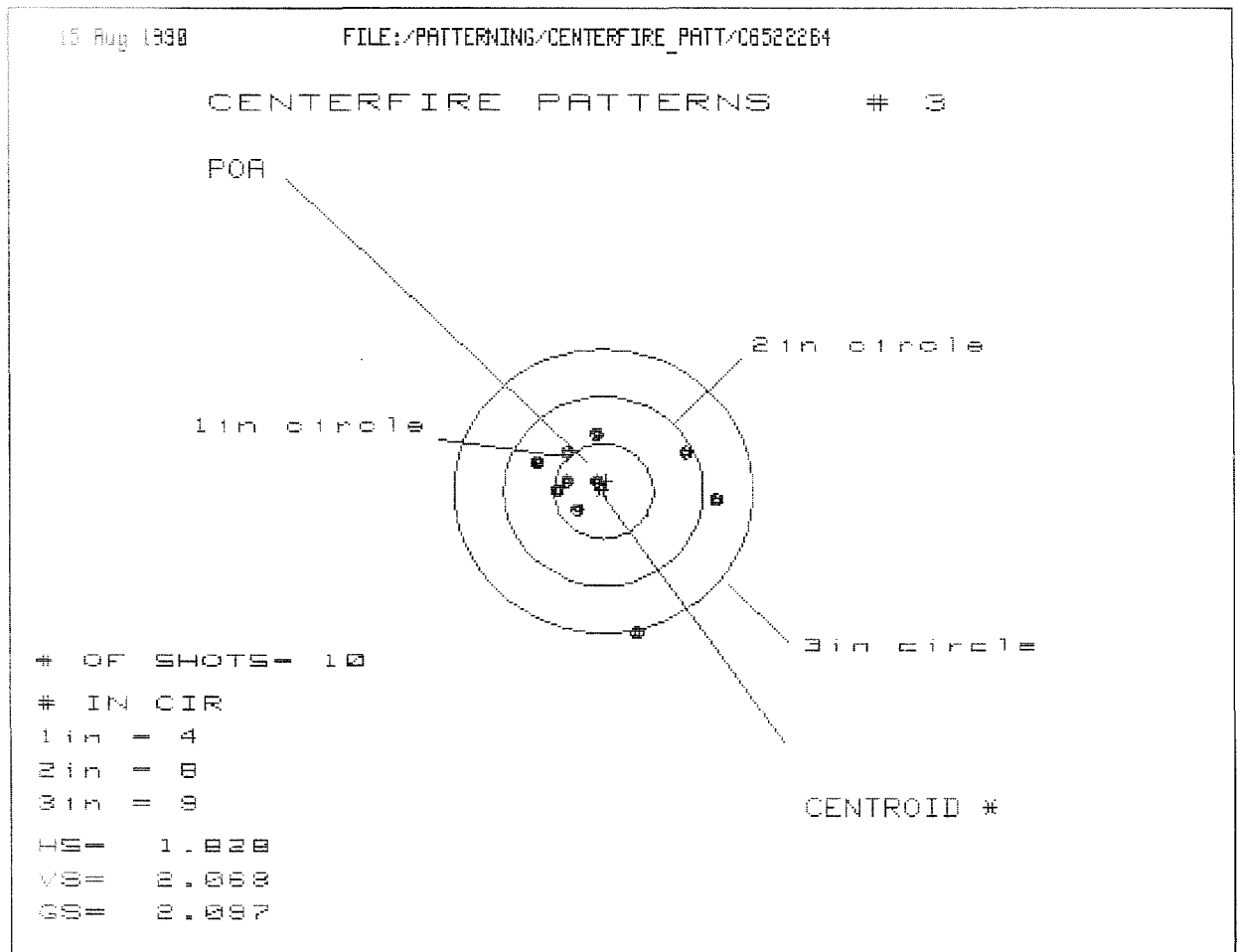
HS = 1.538

VS = 2.813

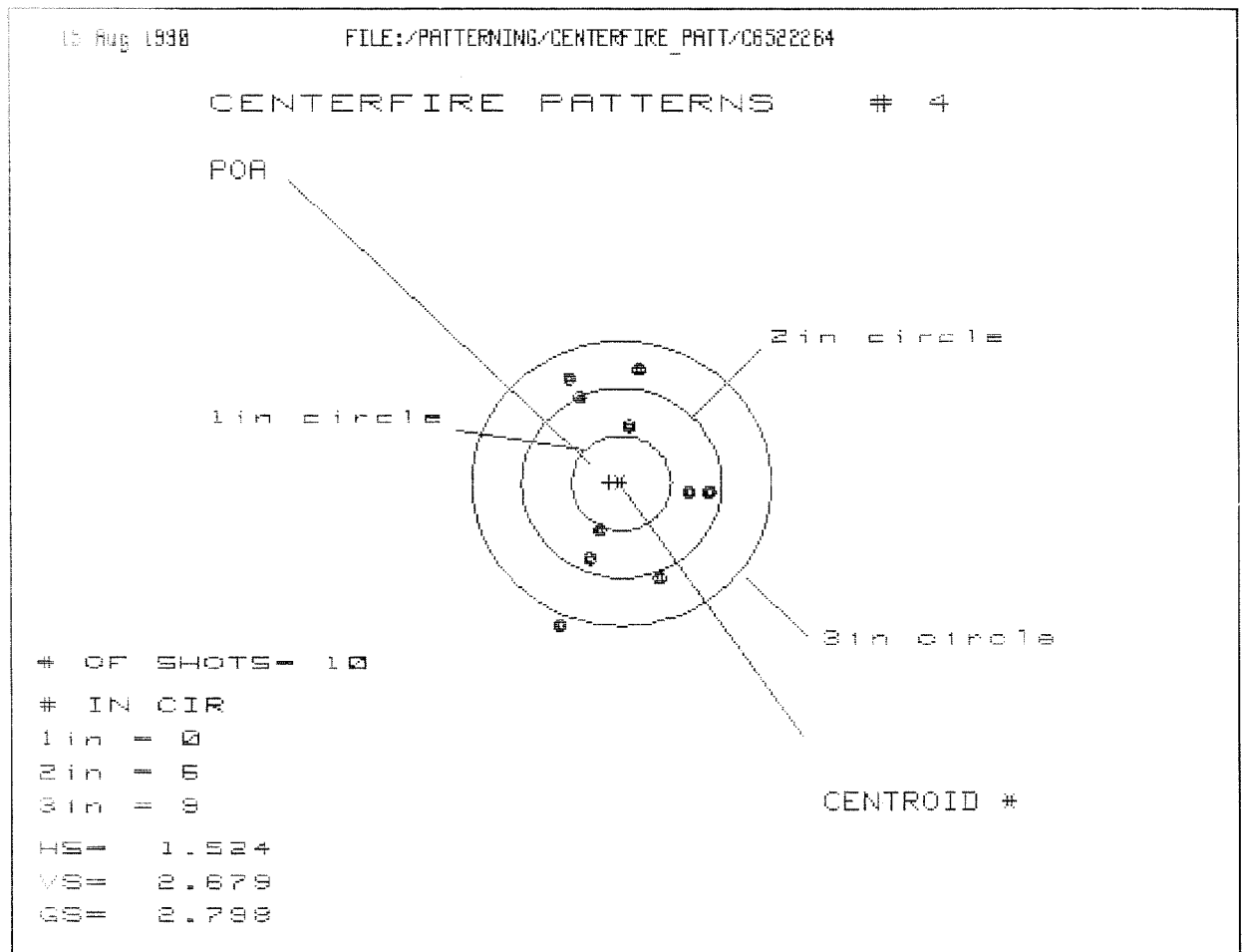
GS = 2.821

CENTROID *

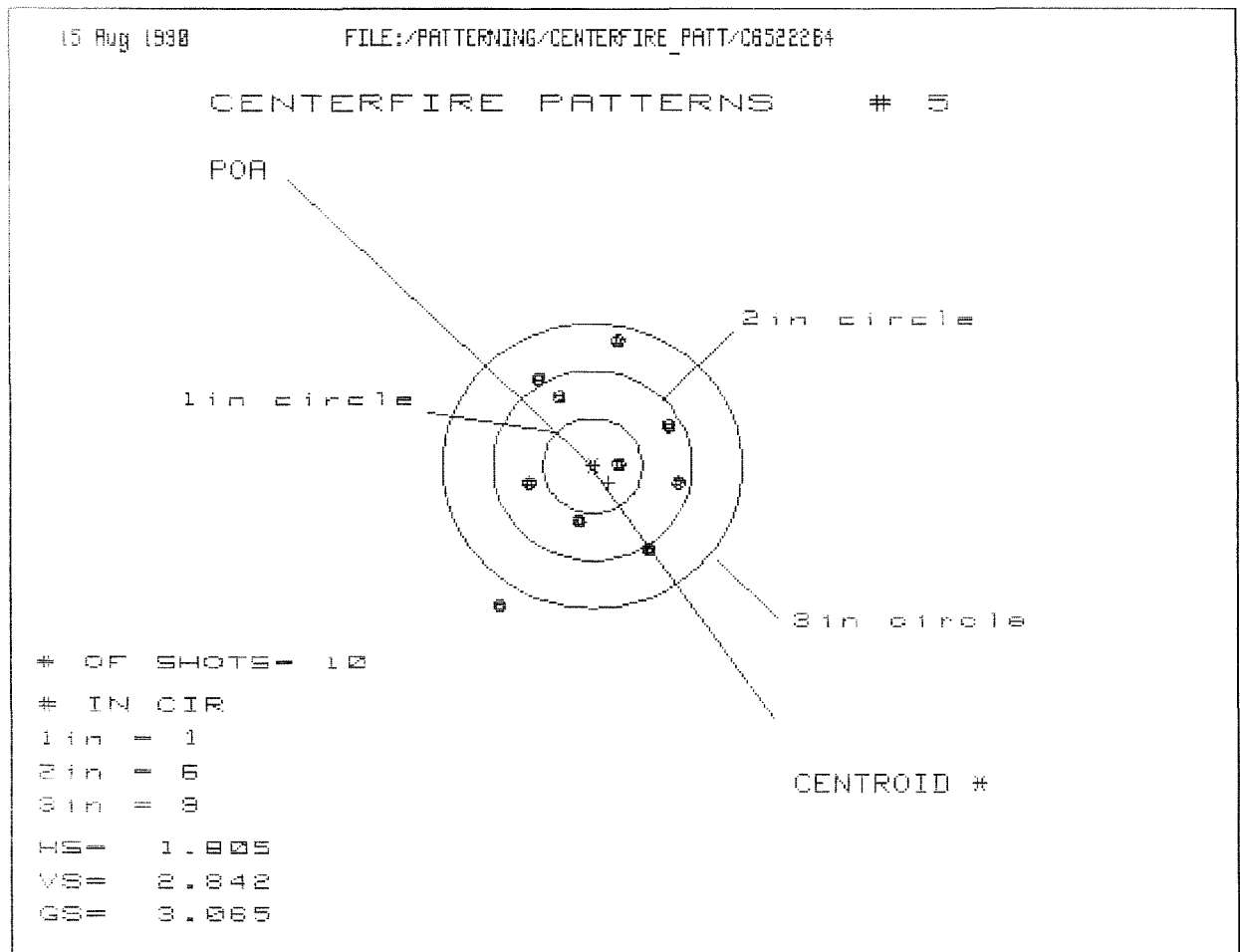
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.911	.843	.764
MINIMUM X	:	-.627	-.695	-.773
MAXIMUM Y	:	1.107	.917	.594
MINIMUM Y	:	-1.706	-.750	-.635
CENTROID X	:	-.078	-.010	.069
CENTROID Y	:	.191	.381	.266
POA TO CENTROID in.	:	.206	.381	.275
MIN RADIUS	:	.176	.038	.102
MEAN RADIUS	:	.769	.626	.559
MAX RADIUS	:	1.812	1.111	.968
HORIZONTAL SPREAD	:	1.538	1.538	1.538
VERTICAL SPREAD	:	2.813	1.667	1.229
EXTREME SPREAD	:	2.821	1.794	1.571
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.114	1.149	1.024
MINIMUM X	-.714	-.679	-.535
MAXIMUM Y	.593	.429	.398
MINIMUM Y	-1.475	-.391	-.422
CENTROID X	-.033	-.068	-.211
CENTROID Y	-.107	.057	.088
POA TO CENTROID in.	.112	.089	.229
MIN RADIUS	.129	.069	.137
MEAN RADIUS	.675	.545	.425
MAX RADIUS	1.508	1.174	1.037
HORIZONTAL SPREAD	1.828	1.828	1.559
VERTICAL SPREAD	2.068	.820	.820
EXTREME SPREAD	2.097	1.866	1.560
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		



PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.810	.822
MINIMUM X	-.642	-.598	-.586
MAXIMUM Y	1.233	1.072	1.035
MINIMUM Y	-1.446	-1.106	-.972
CENTROID X	.120	.192	.180
CENTROID Y	-.006	.155	.021
POA TO CENTROID in.	.120	.246	.181
MIN RADIUS	.512	.395	.529
MEAN RADIUS	.941	.855	.819
MAX RADIUS	1.582	1.137	1.189
HORIZONTAL SPREAD	1.524	1.408	1.408
VERTICAL SPREAD	2.679	2.178	2.007
EXTREME SPREAD	2.798	2.185	2.184
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	



PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.774	.788
MINIMUM X	-.928	-.782	-.767
MAXIMUM Y	1.323	1.154	.933
MINIMUM Y	-1.519	-1.026	-.882
CENTROID X	-.162	-.059	-.074
CENTROID Y	.178	.347	.203
POA TO CENTROID in.	.241	.352	.216
MIN RADIUS	.285	.219	.194
MEAN RADIUS	.933	.821	.765
MAX RADIUS	1.780	1.160	1.108
HORIZONTAL SPREAD	1.805	1.556	1.556
VERTICAL SPREAD	2.842	2.180	1.815
EXTREME SPREAD	3.065	2.202	2.090
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 700™ 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. C6522264

ORDER NO. 5716

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