

C6522260

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522260

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7 12 90	RW
600	Proof		7 12 90	RW
607	Check Headspace		7 12 90	RW
610	Dis-assemble Gun		8 13 90	RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	LS
617	Drill and Tap Sight Holes		7/27/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-6-90	JA
	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		8-26-90	DH

BARBER - M24 0002099								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5.5	6			8/24/90	RW
	G) Safety Off Force	3.5	3	3.5			8/24/90	RW
	H) Trigger Pull Test & Retainability						8-26-90	DH
	I) Firing Pin Indent	.023	.023	.023			8/24/90	RW
	J) Assemble Stock						8/27/90	RW
	K) Assemble Swivel Studs						9/8/90	ES
	L) Attach Front and Rear Sight Assemblies						8/27/90	RW
	M) Iron Sight Alignment						8/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	RW
	O) Attach Scope to Rifle						8/27/90	RW
	P) Detach & Attach Scope 20 Times						8/27/90	RW
640	Gallery Target & Test						9/5/90	KJ
	A) Time						9/5/90	KJ
	B) Malfunctions						9/5/90	KJ
	C) Pierced Primers						9/5/90	KJ
	D) Optical Clarity of Scope						9/5/90	KJ
645	Inspect for Live Ammo						9/5/90	KJ
655	Final Inspection						9/8/90	QJ
	A) Headspace						9/8/90	QJ
	B) Trigger Pull	278	276	271	281	286	9/8/90	QJ
	C) Function						9/8/90	QJ
660	Pack						9/20/90	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522260

DATE 8-23-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.65	2.67	278	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.74	2.65	276	
PULL #3	2.54	2.64	2.61	271	
PULL #4	2.58	2.64	2.73	281	
PULL #5	2.47	2.66	2.38	284	
TOTAL	12.71	13.33	13.04		
AVG.	2.54	2.66	2.47		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.39		
PULL #2	3.32	3.44		
PULL #3	3.29	3.46		
PULL #4	3.24	3.50		
PULL #5	3.34	3.55		
TOTAL	16.47	17.34		
AVG.	3.29	3.47		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.24		4.43
PULL #2	4.24	4.33		4.43
PULL #3	4.29	4.36		4.36
PULL #4	4.31	4.12		4.41
PULL #5	4.26	4.04		4.31
TOTAL	21.36	21.09		21.94
AVG.	4.27	4.21		4.38

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522260
6 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.35249
1 TO	2	.156678
1 TO	3	.255155
1 TO	4	.127664
1 TO	5	.113741

34 <----POA

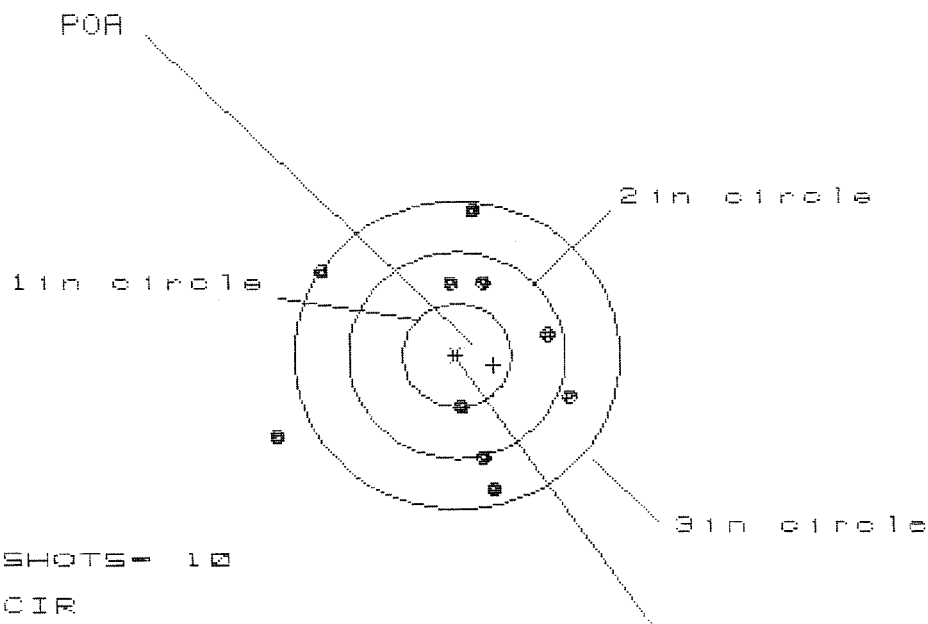
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2806
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0938
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .295863
THE AMR FOR THIS RIFLE IS: 1.033

8 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C6522260

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.722

VS= 2.672

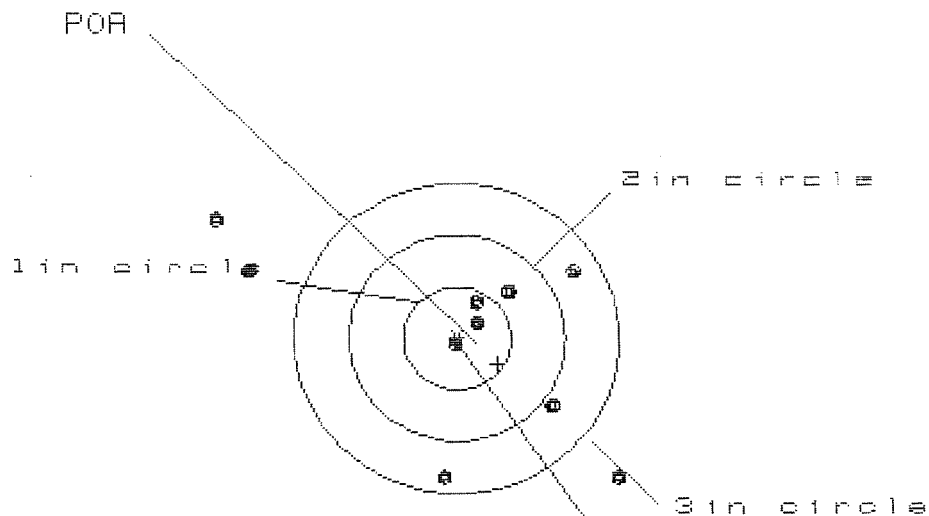
GS= 2.833

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.053	.868	.693
MINIMUM X	-1.669	-1.402	-.371
MAXIMUM Y	1.428	1.342	1.430
MINIMUM Y	-1.244	-1.330	-1.242
CENTROID X	-.340	-.155	.020
CENTROID Y	.093	.179	.090
POA TO CENTROID in.	.353	.237	.093
MIN RADIUS	.471	.556	.551
MEAN RADIUS	1.098	.985	.890
MAX RADIUS	1.839	1.569	1.452
HORIZONTAL SPREAD	2.722	2.270	1.064
VERTICAL SPREAD	2.672	2.672	2.672
EXTREME SPREAD	2.833	2.680	2.680
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

6 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C85222B0

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 3.667

VS= 2.513

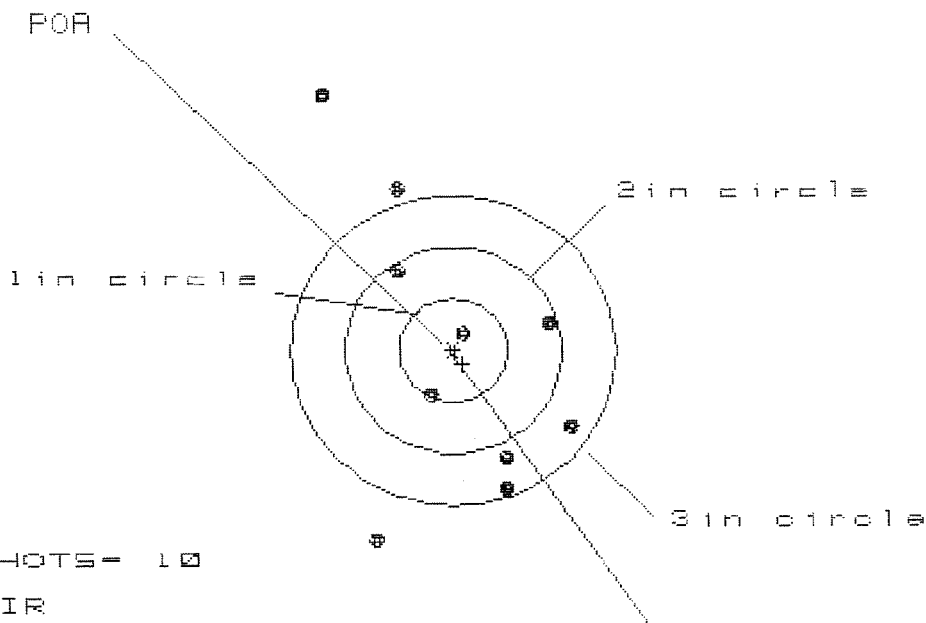
GS= 4.445

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.466	1.221	.947
MINIMUM X	:	-2.202	-2.188	-.609
MAXIMUM Y	:	1.156	.784	.849
MINIMUM Y	:	-1.357	-1.229	-1.131
CENTROID X	:	-.378	-.133	.141
CENTROID Y	:	.245	.117	.019
POA TO CENTROID in.	:	.450	.177	.142
MIN RADIUS	:	.045	.244	.457
MEAN RADIUS	:	1.160	1.000	.852
MAX RADIUS	:	2.486	2.324	1.475
HORIZONTAL SPREAD	:	3.667	3.409	1.556
VERTICAL SPREAD	:	2.513	2.013	1.980
EXTREME SPREAD	:	4.445	3.959	2.265
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522260

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.275

VS= 4.295

GS= 4.318

CENTROID #

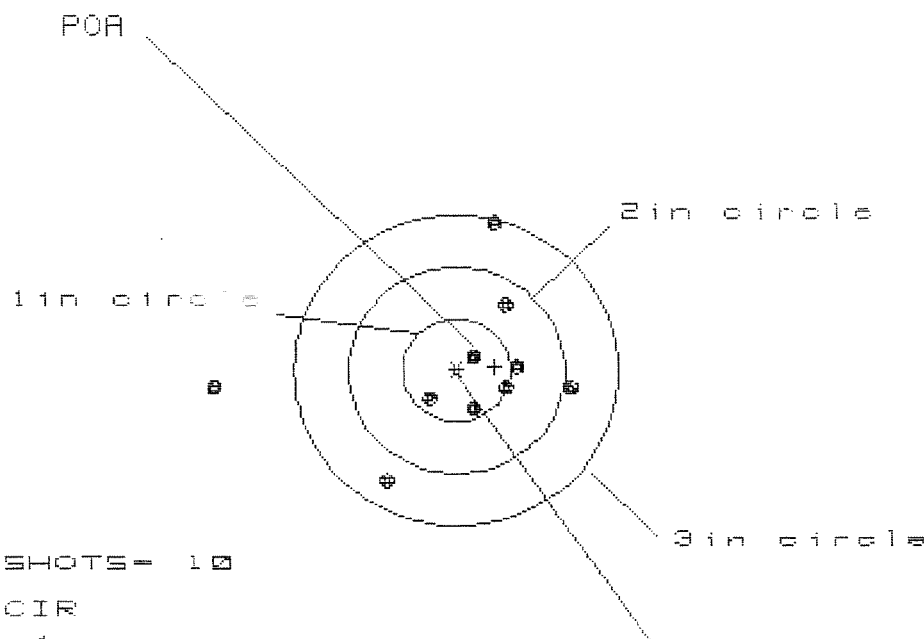
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	.978	.872
MINIMUM X	:	-1.167	-.851	-.742
MAXIMUM Y	:	2.488	1.871	1.680
MINIMUM Y	:	-1.807	-1.531	-1.211
CENTROID X	:	-.088	.042	.148
CENTROID Y	:	.133	-.143	.048
POA TO CENTROID in.	:	.159	.149	.156
MIN RADIUS	:	.199	.377	.313
MEAN RADIUS	:	1.289	1.094	1.003
MAX RADIUS	:	2.748	1.974	1.833
HORIZONTAL SPREAD	:	2.275	1.829	1.614
VERTICAL SPREAD	:	4.295	3.402	2.891
EXTREME SPREAD	:	4.318	3.409	3.069
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522260

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 3.283

VS = 2.446

GS = 3.283

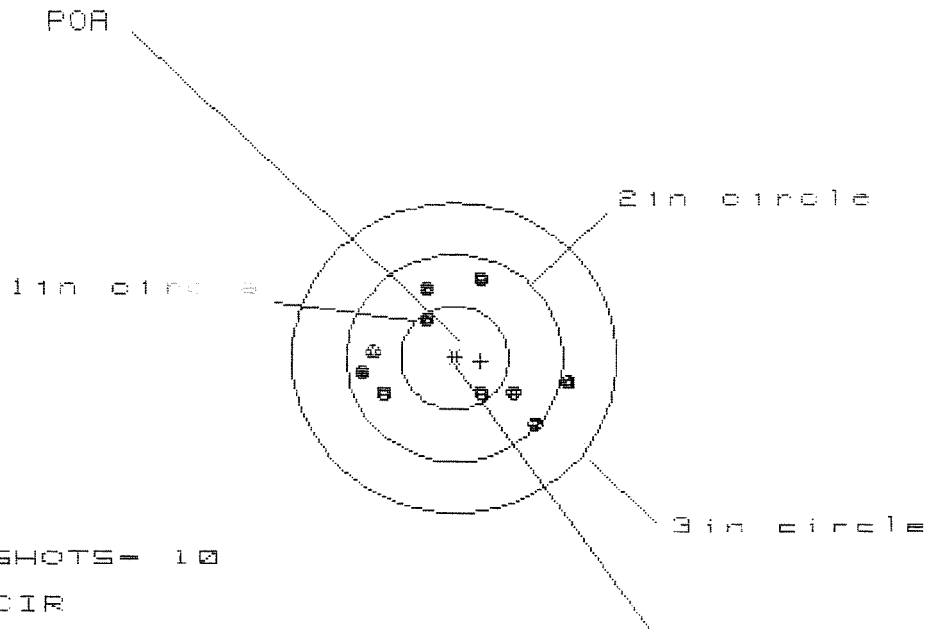
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	.833	.841
MINIMUM X	:	-2.205	-.862	-.855
MAXIMUM Y	:	1.388	1.372	.745
MINIMUM Y	:	-1.058	-1.074	-.903
CENTROID X	:	-.353	-.108	-.115
CENTROID Y	:	-.034	-.018	-.189
POA TO CENTROID in.	:	.355	.109	.222
MIN RADIUS	:	.214	.160	.172
MEAN RADIUS	:	.863	.653	.551
MAX RADIUS	:	2.210	1.377	1.243
HORIZONTAL SPREAD	:	3.283	1.695	1.695
VERTICAL SPREAD	:	2.446	2.446	1.648
EXTREME SPREAD	:	3.283	2.614	1.951
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522260

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

CENTROID #

HS= 1.947

VS= 1.410

GS= 1.949

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.045	.853	.781
MINIMUM X	-.902	-.786	-.680
MAXIMUM Y	.740	.717	.631
MINIMUM Y	-.670	-.693	-.471
CENTROID X	-.244	-.360	-.466
CENTROID Y	.032	.055	.141
POA TO CENTROID in.	.246	.364	.487
MIN RADIUS	.394	.415	.303
MEAN RADIUS	.757	.711	.640
MAX RADIUS	1.064	1.099	.894
HORIZONTAL SPREAD	1.947	1.639	1.461
VERTICAL SPREAD	1.410	1.410	1.102
EXTREME SPREAD	1.949	1.733	1.477
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

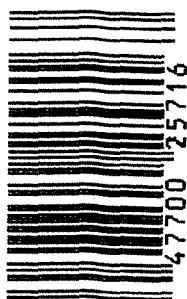
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. C6522260	ORDER NO. 5716
-------------------------------	---------------------------------



5716 C6522260

UPC



0 47700 25716 7