

C6522255

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Call

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522255

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	g.f.
617	Drill and Tap Sight Holes		8/22/90	FB
618	Polish Barrel RLB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-21-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/12/90	WB

op. #	BARBER - M24 0002192					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2		9/12/90	WB
	G) Safety Off Force	2	2	2		9/12/90	WB
	H) Trigger Pull Test & Retainability					9/12/90	WB
	I) Firing Pin Indent	.023	.023	.023		9/12/90	WB
	J) Assemble Stock					9/12/90	KA
	K) Assemble Swivel Studs					9/15/90	JS
	L) Attach Front and Rear Sight Assemblies					9/12/90	KA
	M) Iron Sight Alignment					9/12/90	KA
	N) Detach Front & Rear Sights & place in numbered container					9/12/90	KA
	O) Attach Scope to Rifle					9/12/90	KA
	P) Detach & Attach Scope 20 Times					9/12/90	KA
640	Gallery Target & Test					9/14/90	KT
	A) Time					9/14/90	KT
	B) Malfunctions					9/14/90	KT
	C) Pierced Primers					9/14/90	KT
	D) Optical Clarity of Scope					9/14/90	KT
645	Inspect for Live Ammo					9/14/90	KT
655	Final Inspection					9/15/90	JS
	A) Headspace					9/15/90	JS
	B) Trigger Pull	2.13	2.02	2.18	2.10	2.16	9-15-90
	C) Function					9/15/90	JS
660	Pack					9-18-90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6527255

DATE 9/17/90

TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.44	2.47	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.41	2.54	2.02	
PULL #3	2.47	2.41	2.55	2.18	
PULL #4	2.44	2.46	2.48	2.10	
PULL #5	2.45	2.46	2.60	2.16	
TOTAL	12.18	12.18	12.64	10.59	
AVG.	2.43	2.43	2.53	2.118	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.00		
PULL #2	3.01	3.07		
PULL #3	3.05	3.05		
PULL #4	2.90	3.00		
PULL #5	3.02	3.00		
TOTAL	15.00	15.12		
AVG.	3.00	3.02		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	3.95		4.14
PULL #2	4.05	4.05		4.05
PULL #3	4.06	4.04		4.06
PULL #4	4.05	4.05		4.12
PULL #5	4.10	4.08		4.15
TOTAL	20.28	20.17		20.52
AVG.	4.06	4.03		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522255
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.338824
1 TO	2	.571424
1 TO	3	.0447214
1 TO	4	.247986
1 TO	5	.130177

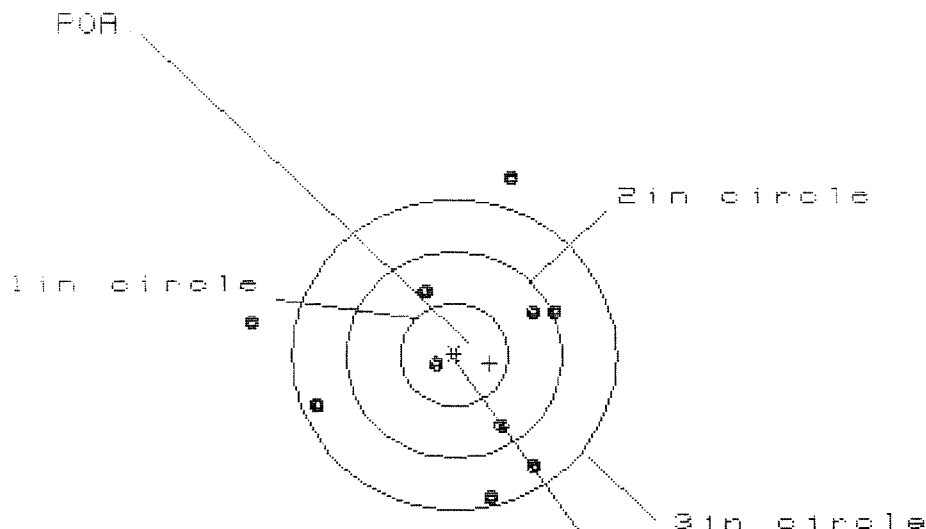
$\bar{x}^2$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1782
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197091
THE AMP FOR THIS RIFLE IS: 1.278

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522255

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.815

VS= 3.109

GS= 3.120

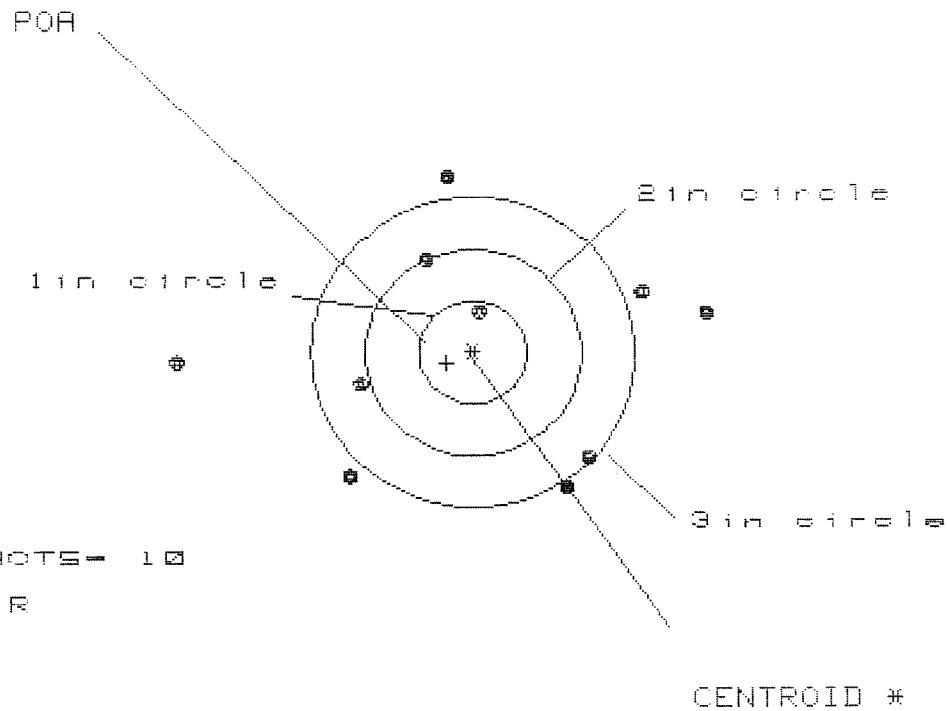
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.902	.690	.733
MINIMUM X	-1.913	-1.463	-1.420
MAXIMUM Y	1.741	1.781	.879
MINIMUM Y	-1.368	-1.328	-1.105
CENTROID X	-.329	-.116	-.159
CENTROID Y	.081	.041	-.182
FOR TO CENTROID in.	.338	.123	.242
MIN RADIUS	.224	.433	.448
MEAN RADIUS	1.140	1.037	.926
MAX RADIUS	1.947	1.815	1.434
HORIZONTAL SPREAD	2.815	2.153	2.153
VERTICAL SPREAD	3.109	3.109	1.984
EXTREME SPREAD	3.120	3.120	2.341
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/06522255

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 1

3in = 4

HS= 4.965

VS= 2.984

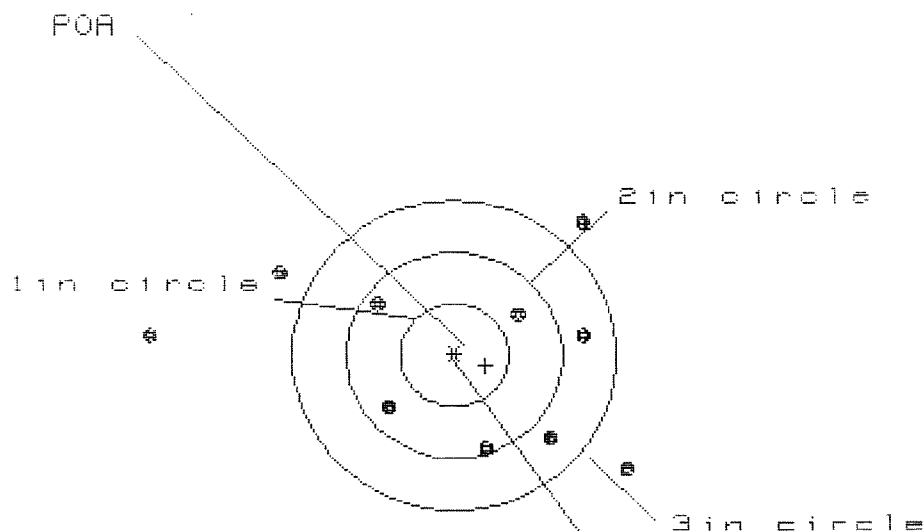
GS= 4.988

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.186	1.877	1.513
MINIMUM X	:	-2.779	-1.446	-1.211
MAXIMUM Y	:	1.677	1.662	1.704
MINIMUM Y	:	-1.307	-1.322	-1.280
CENTROID X	:	.242	.551	.316
CENTROID Y	:	.103	.118	.076
POA TO CENTROID in.	:	.263	.563	.325
MIN RADIUS	:	.416	.489	.444
MEAN RADIUS	:	1.552	1.406	1.320
MAX RADIUS	:	2.782	1.906	1.740
HORIZONTAL SPREAD	:	4.965	3.323	2.724
VERTICAL SPREAD	:	2.984	2.984	2.984
EXTREME SPREAD	:	4.988	3.655	3.233
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	4		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6522255

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 4.389

VS= 2.429

GS= 4.581

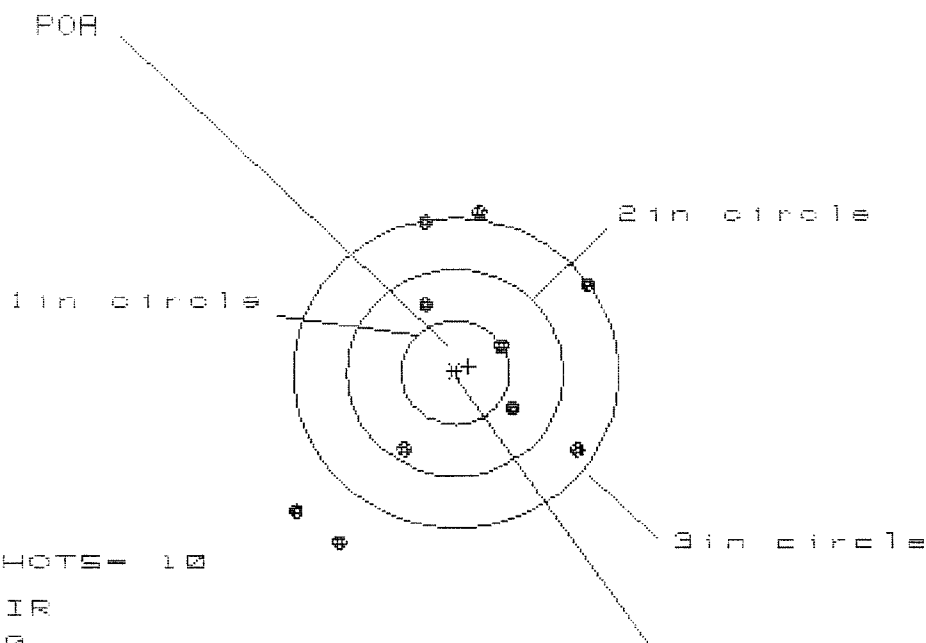
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.565	1.251	1.069
MINIMUM X	:	-2.824	-1.946	-1.790
MAXIMUM Y	:	1.287	1.306	1.166
MINIMUM Y	:	-1.142	-1.123	-1.036
CENTROID X	:	-.289	.025	-.131
CENTROID Y	:	.101	.082	.222
POA TO CENTROID in.	:	.306	.086	.258
MIN RADIUS	:	.673	.474	.475
MEAN RADIUS	:	1.401	1.197	1.140
MAX RADIUS	:	2.829	2.103	1.907
HORIZONTAL SPREAD	:	4.389	3.197	2.858
VERTICAL SPREAD	:	2.429	2.429	2.202
EXTREME SPREAD	:	4.581	3.730	3.002
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS = 3.581

VS = 3.261

GS = 3.493

PATTERN #

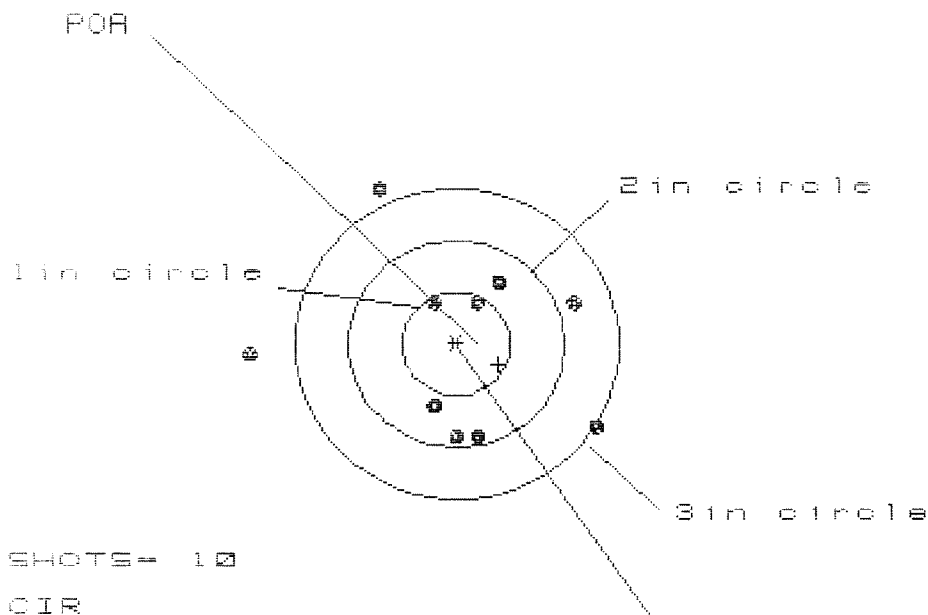
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.232	1.071	.917
MINIMUM X	-1.449	-1.225	-.742
MAXIMUM Y	1.598	1.444	1.217
MINIMUM Y	-1.663	-1.817	-1.093
CENTROID X	-.125	.036	.190
CENTROID Y	-.060	.094	.321
POA TO CENTROID in.	.138	.101	.373
MIN RADIUS	.540	.329	.197
MEAN RADIUS	1.259	1.137	.971
MAX RADIUS	2.007	2.192	1.332
HORIZONTAL SPREAD	2.681	2.296	1.659
VERTICAL SPREAD	3.261	3.261	2.310
EXTREME SPREAD	3.493	3.493	2.572
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		6	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8522255

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 3.197

VS= 2.455

GS= 3.283

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.261	1.046	.927
MINIMUM X	-1.936	-.953	-.569
MAXIMUM Y	1.532	1.525	.805
MINIMUM Y	-.923	-.930	-.739
CENTROID X	-.390	-.175	-.056
CENTROID Y	.196	.203	.012
POA TO CENTROID in.	.437	.268	.057
MIN RADIUS	.415	.398	.601
MEAN RADIUS	1.037	.918	.809
MAX RADIUS	1.937	1.798	1.119
HORIZONTAL SPREAD	3.197	1.999	1.496
VERTICAL SPREAD	2.455	2.455	1.544
EXTREME SPREAD	3.283	3.079	1.868
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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. C6522255	Ø1
ORDER NO. 5716	

