

C6522245

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522246

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/90	KJ
600	Proof		6/25/90	KJ
607	Check Headspace		6/25/90	KJ
610	Dis-assemble Gun		6/25/90	KJ
612	Magnaflux Barrel Action		7/10/90	K R
	Magnaflux Bolt		7/10/90	K R
615	Rollmark Caliber		7/10/90	SS
617	Drill and Tap Sight Holes		7/11/90	LB
618	Polish Barrel <i>RB</i>		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/6/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/90	KS
	C) Inspect Ejector Hole for Chamfer		8/6/90	KS
	D) Oil Firing Pin Ass'y		8/6/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-6-90	JCP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/6/90	SM
	G) Safety Off Force	2	2	2			8/6/90	SM
	H) Trigger Pull Test & Retainability						9-6-90	SM
	I) Firing Pin Indent	.023	.023	.023			8/6/90	SM
	J) Assemble Stock						8/8/90	KS
	K) Assemble Swivel Studs						9/8/90	GS
	L) Attach Front and Rear Sight Assemblies						8/8/90	KS
	M) Iron Sight Alignment						8/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/8/90	KS
	O) Attach Scope to Rifle						8/8/90	KS
	P) Detach & Attach Scope 20 Times						8/8/90	KS
640	Gallery Target & Test						8-9-90	A
	A) Time							A
	B) Malfunctions							A
	C) Pierced Primers							A
	D) Optical Clarity of Scope							A
645	Inspect for Live Ammo						8-9-90	A
655	Final Inspection							
	A) Headspace						9/8/90	GS
	B) Trigger Pull	2.27	2.19	2.19	2.22	2.24	9-6-90	SM
	C) Function						9/8/90	GS
660	Pack						9/20/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522246

DATE 9-6-90

TESTER 98.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.23	2.26	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.26	2.16	2.19	
PULL #3	2.36	2.24	2.18	2.19	
PULL #4	2.26	2.22	2.26	2.22	
PULL #5	2.24	2.17	2.15	2.24	
TOTAL	11.48	11.12	11.01	11.11	
AVG.	2.296	2.224	2.202	2.222	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.23		
PULL #2	3.19	3.23		
PULL #3	3.21	3.22		
PULL #4	3.22	3.17		
PULL #5	3.20	3.25		
TOTAL	15.98	16.10		
AVG.	3.196	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.25		4.27
PULL #2	4.22	4.24		4.30
PULL #3	4.25	4.30		4.25
PULL #4	4.22	4.24		4.25
PULL #5	4.20	4.24		4.20
TOTAL	21.19	21.27		21.27
AVG.	4.238	4.254		4.254

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522246
3 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.177138
1 TO	2	.0440454
1 TO	3	.538516
1 TO	4	.450857
1 TO	5	.282144

$\frac{3}{4}$ <----POA

COORDINATE FOR THIS RIFLE IS: .0258
COORDINATE FOR THIS RIFLE IS: -.1152
AVERAGE POI RADIUS FOR THIS RIFLE IS: .118054
THIS RIFLE IS: .751

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522246

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 2

3 in - 10

XSA = 1.746

YSA = 1.934

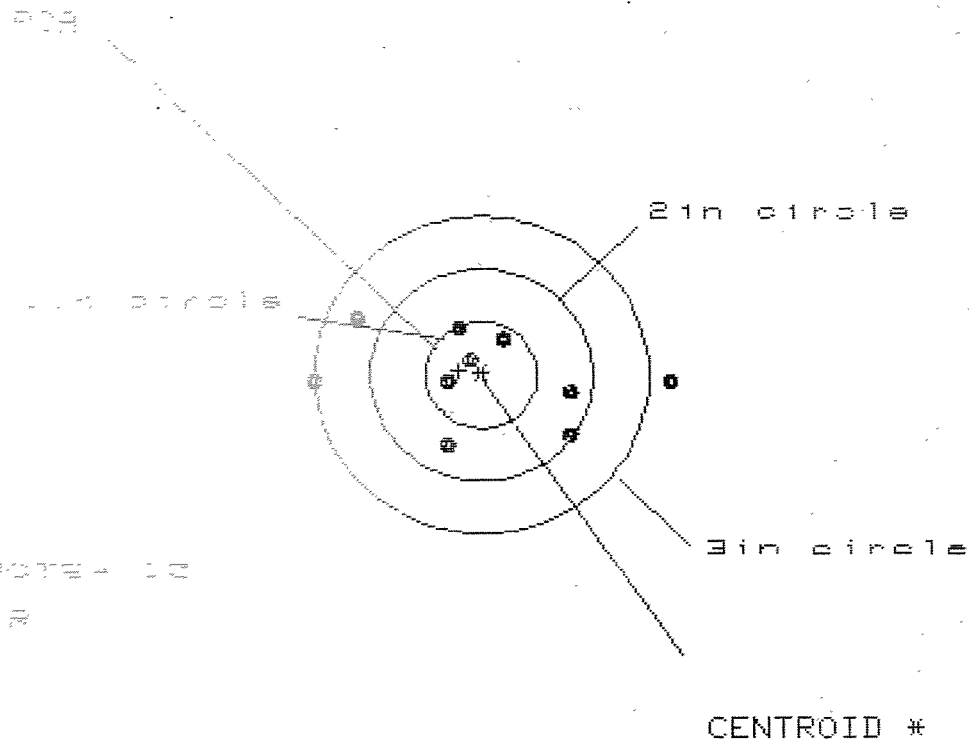
SSA = 2.251

BARBER #	:	1	9	8
SHOTS - BEST OF	:	10	9	8
MAXIMUM X	:	.732	.809	.762
MINIMUM X	:	-1.014	-.937	-.984
MAXIMUM Y	:	.984	.518	.413
MINIMUM Y	:	-.950	-.841	-.676
CENTROID X	:	.177	.100	.147
CENTROID Y	:	-.007	-.116	-.011
FOR TO CENTROID in.	:	.177	.153	.147
1 in RADIUS	:	.164	.142	.173
2 in RADIUS	:	.666	.602	.551
3 in RADIUS	:	1.205	.961	.988
HORIZONTAL SPREAD	:	1.746	1.746	1.746
VERTICAL SPREAD	:	1.934	1.359	1.089
EXTREME SPREAD	:	2.251	1.805	1.775
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1968

FILE: PATTERNING/CENTERFIRE_PATT/C6522246

CENTERFIRE PATTERNS # 2



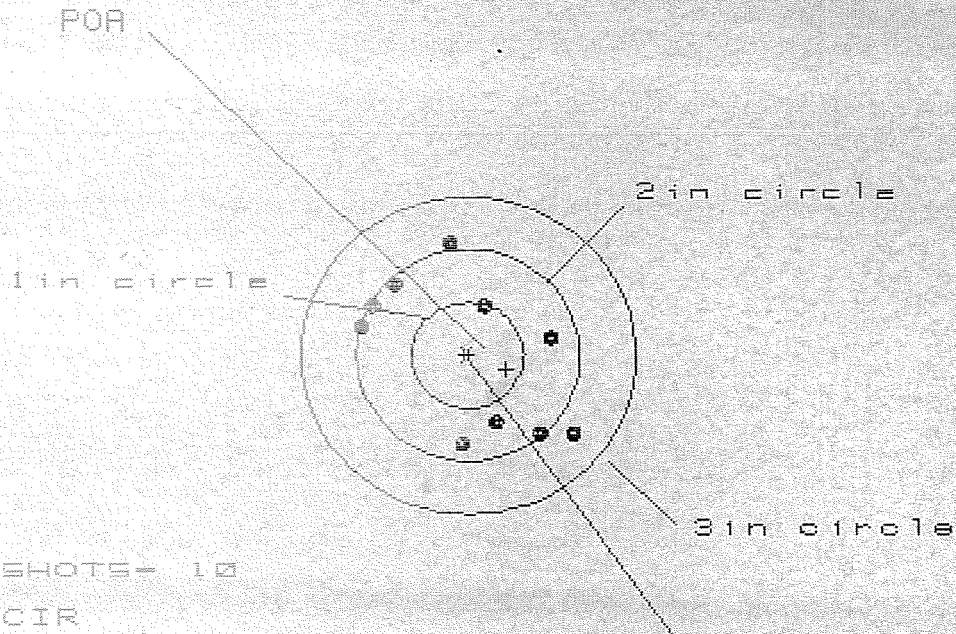
1 OF 0000000000
2 OF 0000000000
3 OF 0000000000
4 OF 0000000000
5 OF 0000000000
6 OF 0000000000
7 OF 0000000000
8 OF 0000000000
9 OF 0000000000
10 OF 0000000000

PATTERN #	1	2	3
SHOTS CENTER OF	10	9	8
MAXIMUM X	1.716	1.001	.837
MINIMUM X	-1.506	-1.315	-1.086
MAXIMUM Y	.537	.536	.531
MINIMUM Y	-.640	-.641	-.646
CENTROID X	.205	.014	.178
CENTROID Y	-.041	-.040	-.035
MIN TO CENTROID in.	.209	.042	.182
MAX SPREAD	.213	.111	.195
MIN SPREAD	.836	.718	.639
MAX SPREAD	1.716	1.316	1.209
HORIZONTAL SPREAD	3.222	2.316	1.923
VERTICAL SPREAD	1.177	1.177	1.177
CIRCLE SPREAD	3.222	2.360	2.202
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

9 Aug 1988

FILE: /PATTERNING/CENTERFIRE_PATT/C6522246

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS= 1.960

VS= 1.903

GS= 2.195

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.956	.880	.873
MINIMUM X	-1.004	-.898	-.905
MAXIMUM Y	1.062	.978	.660
MINIMUM Y	-.841	-.925	-.803
CENTROID X	-.343	-.449	-.442
CENTROID Y	.133	.217	.095
POA TO CENTROID in.	.368	.499	.453
MIN RADIUS	.518	.473	.582
MEAN RADIUS	.899	.853	.836
MAX RADIUS	1.221	1.099	1.005
HORIZONTAL SPREAD	1.960	1.778	1.778
VERTICAL SPREAD	1.903	1.903	1.463
EXTREME SPREAD	2.195	1.967	1.892
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

9 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522246

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 10

3 in = 10

HS = 1.503

VS = 1.359

GS = 1.689

CENTROID #

PATTERN #

4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.670	.577	.583
MINIMUM X	-.833	-.505	-.499
MAXIMUM Y	.752	.698	.773
MINIMUM Y	-.607	-.661	-.574
CENTROID X	.111	.204	.198
CENTROID Y	-.453	-.399	-.486
POA TO CENTROID in.	.467	.448	.525
MIN RADIUS	.438	.446	.367
MEAN RADIUS	.642	.600	.577
MAX RADIUS	.967	.718	.800
HORIZONTAL SPREAD	1.503	1.082	1.082
VERTICAL SPREAD	1.359	1.359	1.347
EXTREME SPREAD	1.689	1.393	1.393
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

9 Aug 1998

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.498

VS= 1.361

GS= 2.501

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.059	.899	.673
MINIMUM X	-1.439	-.790	-.677
MAXIMUM Y	.810	.763	.689
MINIMUM Y	-.551	-.598	-.500
CENTROID X	-.021	.139	.026
CENTROID Y	-.208	-.161	-.086
POA TO CENTROID in.	.209	.213	.090
MIN RADIUS	.120	.148	.019
MEAN RADIUS	.712	.623	.531
MAX RADIUS	1.500	1.080	.963
HORIZONTAL SPREAD	2.498	1.689	1.351
VERTICAL SPREAD	1.361	1.361	1.189
EXTREME SPREAD	2.501	1.770	1.751
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6522246

ORDER NO.
5716

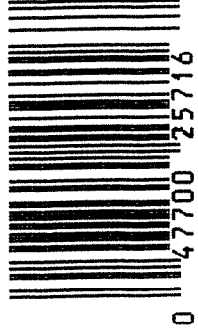
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5716 C6522246

UPC



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