

06522241

MODEL 700™ M24

Model **SM5**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522241

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	CB
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-28-90	DB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/3/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			9/13/90	WB
	G) Safety Off Force	3	3	3			9/13/90	WB
	H) Trigger Pull Test & Retainability						9/13/90	WB
	I) Firing Pin Indent	.0205	.0215	.021			9/13/90	WB
	J) Assemble Stock						9/13/90	RW
	K) Assemble Swivel Studs						9/15/90	928
	L) Attach Front and Rear Sight Assemblies						9/13/90	RW
	M) Iron Sight Alignment						9/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/13/90	RW
	O) Attach Scope to Rifle						9/13/90	RW
	P) Detach & Attach Scope 20 Times						9/13/90	RW
640	Gallery Target & Test						9-14-90	DH
	A) Time						9-14-90	DH
	B) Malfunctions						9-14-90	DH
	C) Pierced Primers						9-14-90	DH
	D) Optical Clarity of Scope						9-14-90	DH
645	Inspect for Live Ammo						9-14-90	DH
655	Final Inspection							
	A) Headspace						9/15/90	928
	B) Trigger Pull	2.54	2.26	2.26	2.32	2.14	9-15-90	941
	C) Function						9/15/90	928
660	Pack						9/19/90	15

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6522241

DATE 9/13/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.20	2.46	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.16	2.41	2.26	
PULL #3	2.35	2.15	2.39	2.26	
PULL #4	2.24	2.13	2.41	2.32	
PULL #5	2.22	2.14	2.44	2.14	
TOTAL	11.54	10.78	12.11	11.52	
AVG.	2.31	2.16	2.42	2.304	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.10		
PULL #2	3.09	3.02		
PULL #3	3.09	3.04		
PULL #4	3.12	3.11		
PULL #5	3.12	3.10		
TOTAL	15.42	15.37		
AVG.	3.08	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.01		4.07
PULL #2	4.02	4.00		4.03
PULL #3	4.01	4.01		4.00
PULL #4	3.95	4.01		4.06
PULL #5	4.00	4.04		4.01
TOTAL	20.02	20.07		20.17
AVG.	4.00	4.01		4.03

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522241
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.569549
1 TO	2	.493138
1 TO	3	.299713
1 TO	4	.131183
1 TO	5	.102343

10th <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0656
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3756
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .381286

THE AMR FOR THIS RIFLE IS: 1.097

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522241

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

H0 = 2.814

V0 = 1.737

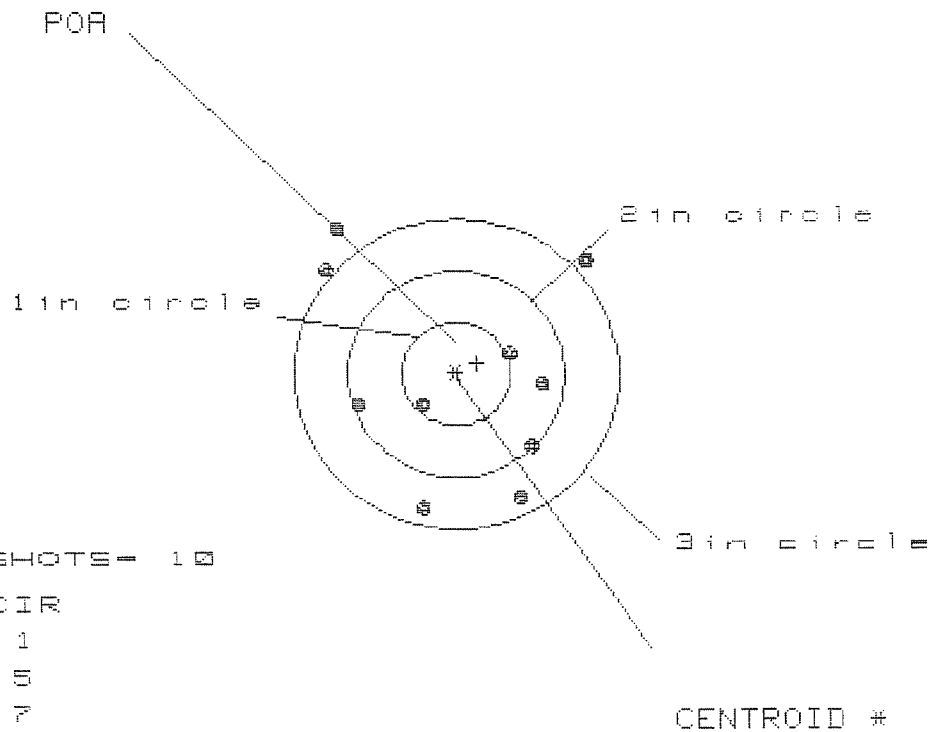
G0 = 2.975

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.562	1.728	1.191
MINIMUM X	-1.252	-1.086	-.870
MAXIMUM Y	.992	.909	.896
MINIMUM Y	-.745	-.748	-.761
CENTROID X	-.025	-.191	-.407
CENTROID Y	-.569	-.486	-.473
POA TO CENTROID in.	.570	.523	.625
MIN RADIUS	.183	.140	.286
MEAN RADIUS	.979	.879	.759
MAX RADIUS	1.670	1.731	1.233
HORIZONTAL SPREAD	2.814	2.814	2.061
VERTICAL SPREAD	1.737	1.657	1.657
EXTREME SPREAD	2.975	2.887	2.326
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 2.413

VS= 2.628

GS= 3.075

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.238	1.110	.794
MINIMUM X	:	-1.175	-1.303	-1.165
MAXIMUM Y	:	1.357	1.266	1.331
MINIMUM Y	:	-1.271	-1.120	-.962
CENTROID X	:	-.192	-.064	-.202
CENTROID Y	:	-.185	-.256	-.414
POR TO CENTROID in.	:	.219	.263	.461
MIN RADIUS	:	.408	.449	.296
MEAN RADIUS	:	1.126	1.019	.919
MAX RADIUS	:	1.783	1.753	1.769
HORIZONTAL SPREAD	:	2.413	2.413	1.959
VERTICAL SPREAD	:	2.628	2.386	2.293
EXTREME SPREAD	:	3.075	2.833	2.820
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 1.844

VS= 3.334

GS= 3.354

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.733	.783	.801
MINIMUM X	:	-1.112	-1.061	-1.043
MAXIMUM Y	:	2.065	1.012	.882
MINIMUM Y	:	-1.269	-1.040	-.911
CENTROID X	:	-.057	-.108	-.126
CENTROID Y	:	-.271	-.500	-.370
POA TO CENTROID in.	:	.277	.511	.391
MIN RADIUS	:	.348	.554	.462
MEAN RADIUS	:	1.047	.911	.885
MAX RADIUS	:	2.114	1.280	1.191
HORIZONTAL SPREAD	:	1.844	1.844	1.844
VERTICAL SPREAD	:	3.334	2.052	1.793
EXTREME SPREAD	:	3.354	2.150	2.096
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.211

VS= 2.744

GS= 3.718

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.587	1.466	1.053
MINIMUM X	:	-1.625	-1.745	-1.561
MAXIMUM Y	:	1.725	1.129	1.045
MINIMUM Y	:	-1.018	-.827	-.911
CENTROID X	:	.028	.148	-.036
CENTROID Y	:	-.449	-.640	-.556
POA TO CENTROID in.	:	.449	.657	.557
MIN RADIUS	:	.454	.422	.474
MEAN RADIUS	:	1.143	1.020	.949
MAX RADIUS	:	2.036	1.773	1.578
HORIZONTAL SPREAD	:	3.211	3.211	2.614
VERTICAL SPREAD	:	2.744	1.956	1.956
EXTREME SPREAD	:	3.718	3.360	2.853
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS= 3.389

VS= 2.608

GS= 3.635

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.257
MINIMUM X	-1.132
MAXIMUM Y	1.231
MINIMUM Y	-1.377
CENTROID X	-.082
CENTROID Y	-.484
POA TO CENTROID in.	.491
MIN RADIUS	.177
MEAN RADIUS	1.190
MAX RADIUS	2.326
HORIZONTAL SPREAD	3.389
VERTICAL SPREAD	2.608
EXTREME SPREAD	3.635
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	8

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
Remington® 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.	
SERIAL NO. C6522241	ORDER NO. 5716

UPC

