

C6522239

MODEL 700™ M24

Model SMS™

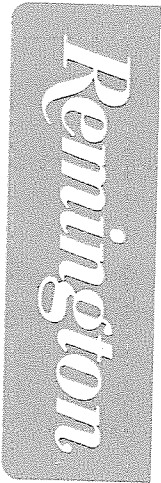
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



CAD TWC

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *26522239*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		<i>8-21-90</i>	<i>DM</i>
600	Proof		<i>8-21-90</i>	<i>DM</i>
607	Check Headspace		<i>8-21-90</i>	<i>DM</i>
610	Dis-assemble Gun		<i>8-21-90</i>	<i>DM</i>
612	Magnaflux Barrel Action		<i>8/22/90</i>	<i>KCD</i>
	Magnaflux Bolt		<i>8/22/90</i>	<i>KCD</i>
615	Rollmark Caliber		<i>8/22/90</i>	<i>GS.</i>
617	Drill and Tap Sight Holes		<i>8/27/90</i>	<i>WB</i>
618	Polish Barrel <i>WB</i>		<i>8/27/90</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>8-28-90</i>	<i>JA</i>
	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		<i>9/12/90</i>	<i>WB</i>

op. #	OP. NAME	READINGS					DATE	INIT
605 Int.	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	.0225	.022	.022			9/12/90	WB
	J) Assemble Stock						9/14/90	KA
	K) Assemble Swivel Studs						9/16/90	JD
	L) Attach Front and Rear Sight Assemblies						9/14/90	KA
	M) Iron Sight Alignment						9/14/90	KA
	N) Detach Front & Rear Sights & place in numbered container						9/14/90	KA
	O) Attach Scope to Rifle						9/14/90	KA
	P) Detach & Attach Scope 20 Times						9/14/90	KA
640	Gallery Target & Test						9/15/90	KT
	A) Time						9/15/90	KT
	B) Malfunctions						9/15/90	KT
	C) Pierced Primers						9/15/90	KT
	D) Optical Clarity of Scope						9/15/90	KT
645	Inspect for Live Ammo						9/15/90	KT
655	Final Inspection						9/16/90	JD
	A) Headspace						9/16/90	KA
	B) Trigger Pull	2-13	2-10	2-16	2-75	2-36	9-16-90	KA
	C) Function						9/16/90	JD
660	Pack						9-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6527239DATE 9/14/90TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.33	2.46	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.32	2.39	2.10	
PULL #3	2.36	2.18	2.50	2.16	
PULL #4	2.35	2.45	2.46	2.75	
PULL #5	2.33	2.25	2.53	2.36	
TOTAL	11.81	11.53	12.34	11.50	
AVG.	2.36	2.31	2.47	2.3	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.07		
PULL #2	3.13	3.23		
PULL #3	3.08	3.07		
PULL #4	3.11	3.00		
PULL #5	3.06	2.95		
TOTAL	15.53	15.32		
AVG.	3.11	3.06		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.05	4.07		4.27
PULL #2	4.06	4.04		4.37
PULL #3	4.11	4.15		4.38
PULL #4	4.06	4.00		4.26
PULL #5	4.05	4.00		4.32
TOTAL	20.33	20.26		21.60
AVG.	4.07	4.05		4.32

FOR RIFLE # 06522239

CENTROIDAL DISTANCES

<-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.027$

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0036

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0272389

THE AMR FOR THIS RIFLE IS: .9694

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522239

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 3.027

VS = 1.556

GS = 3.404

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	.939	.769
MINIMUM X	:	-1.879	-1.317	-1.200
MAXIMUM Y	:	.843	.764	.708
MINIMUM Y	:	-.713	-.712	-.617
CENTROID X	:	-.083	.126	.009
CENTROID Y	:	-.228	-.149	-.244
POA TO CENTROID in.	:	.243	.195	.244
MIN RADIUS	:	.296	.319	.342
MEAN RADIUS	:	.914	.755	.699
MAX RADIUS	:	2.010	1.497	1.349
HORIZONTAL SPREAD	:	3.027	2.256	1.969
VERTICAL SPREAD	:	1.556	1.476	1.325
EXTREME SPREAD	:	3.404	2.696	2.171
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

15 Sep 1998

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.632

VS = 2.350

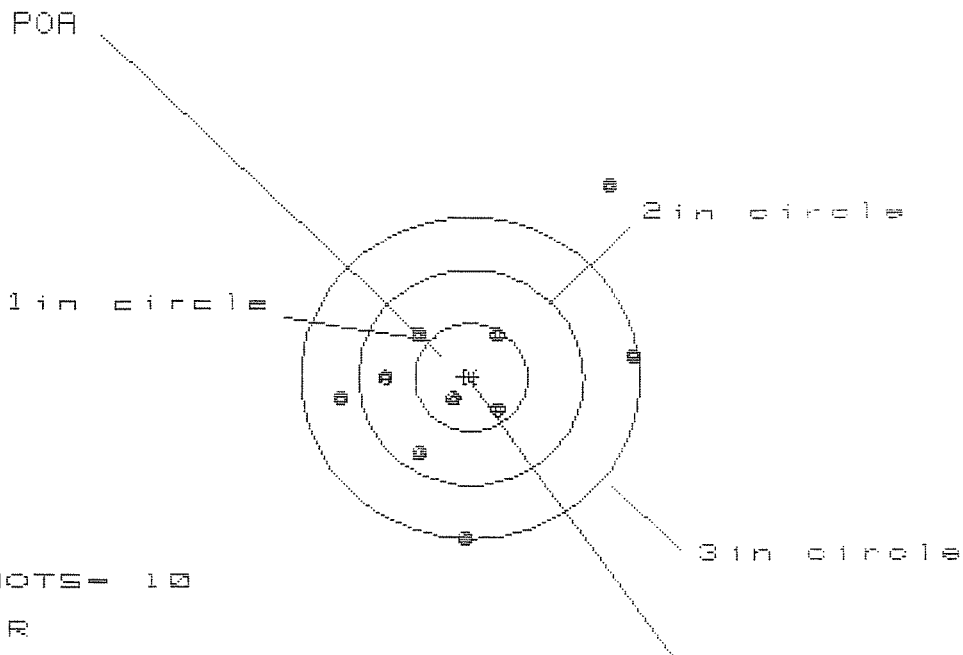
GS = 2.377

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.847	.827	.846
MINIMUM X	:	-.785	-.805	-.786
MAXIMUM Y	:	1.028	.881	.764
MINIMUM Y	:	-1.322	-.843	-.732
CENTROID X	:	-.021	-.001	-.020
CENTROID Y	:	-.102	.045	-.066
POA TO CENTROID in.	:	.104	.045	.069
MIN RADIUS	:	.089	.231	.122
MEAN RADIUS	:	.740	.677	.631
MAX RADIUS	:	1.334	.941	1.015
HORIZONTAL SPREAD	:	1.632	1.632	1.632
VERTICAL SPREAD	:	2.350	1.724	1.496
EXTREME SPREAD	:	2.377	1.799	1.755
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.629

VS = 3.333

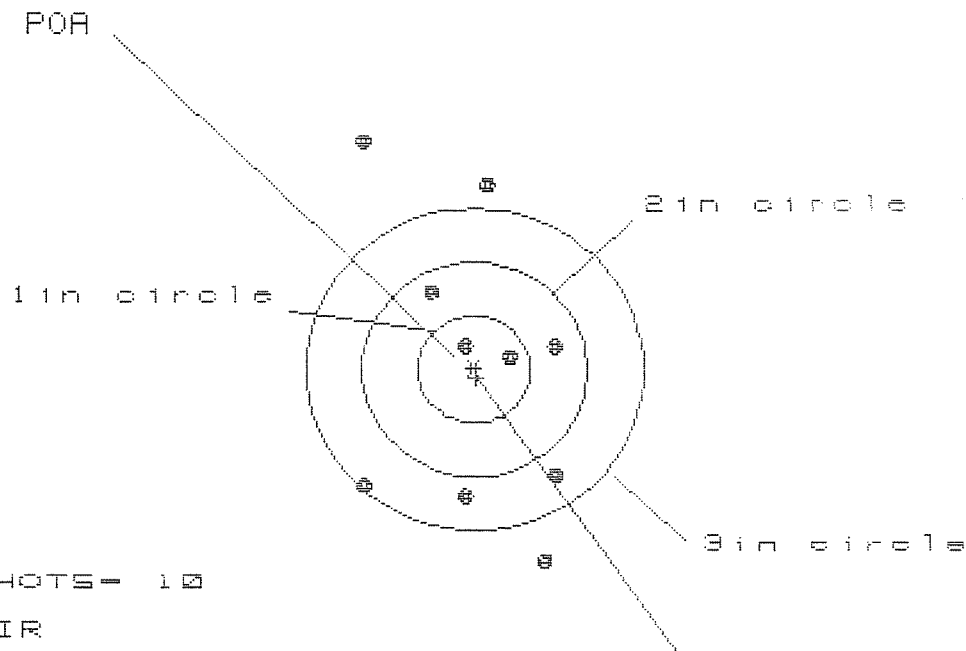
GS = 3.569

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.462	1.597	1.607
MINIMUM X	:	-1.167	-1.032	-1.022
MAXIMUM Y	:	1.849	.615	.455
MINIMUM Y	:	-1.484	-1.279	-.630
CENTROID X	:	.063	-.072	-.082
CENTROID Y	:	-.003	-.208	-.049
POA TO CENTROID in.	:	.063	.221	.095
MIN RADIUS	:	.236	.068	.113
MEAN RADIUS	:	.966	.785	.713
MAX RADIUS	:	2.214	1.648	1.626
HORIZONTAL SPREAD	:	2.629	2.629	2.629
VERTICAL SPREAD	:	3.333	1.894	1.085
EXTREME SPREAD	:	3.569	2.667	2.667
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 1.673

VS= 3.895

GS= 4.199

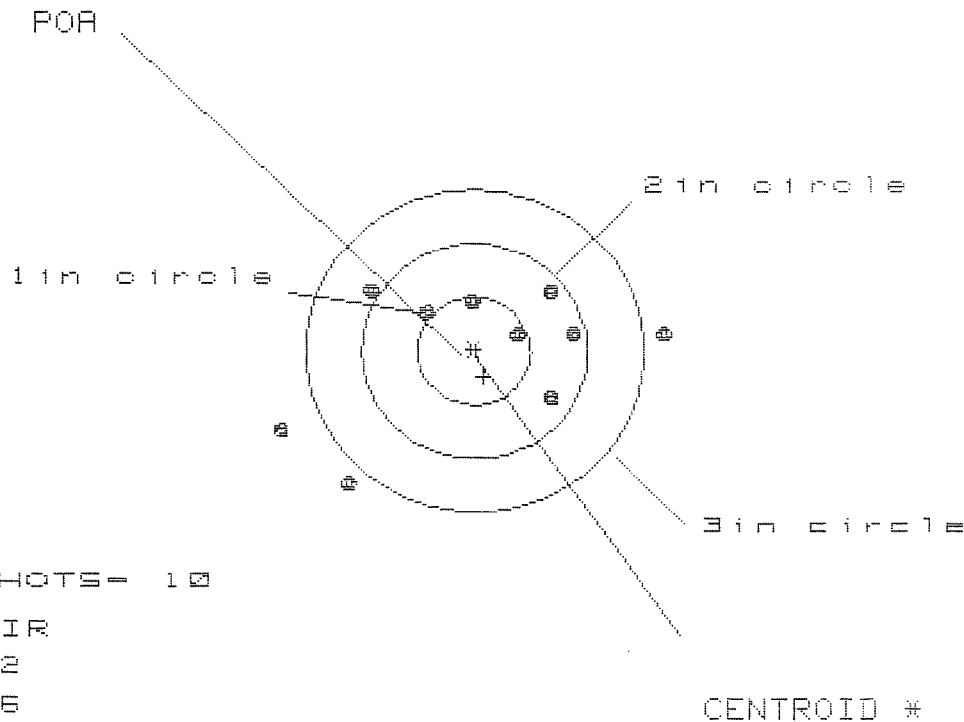
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.715	.609	.672
MINIMUM X	:	-.958	-1.051	-.988
MAXIMUM Y	:	2.090	1.974	1.778
MINIMUM Y	:	-1.805	-1.573	-1.180
CENTROID X	:	-.015	.091	.028
CENTROID Y	:	.079	-.153	.043
POA TO CENTROID in.	:	.080	.179	.051
MIN RADIUS	:	.274	.375	.303
MEAN RADIUS	:	1.198	1.074	.971
MAX RADIUS	:	2.299	1.974	1.780
HORIZONTAL SPREAD	:	1.673	1.660	1.660
VERTICAL SPREAD	:	3.895	3.547	2.958
EXTREME SPREAD	:	4.199	3.581	2.969
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.416

VS = 1.851

GS = 3.542

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.649	1.453	1.292
MINIMUM X	-1.767	-1.288	-1.270
MAXIMUM Y	.566	.482	.311
MINIMUM Y	-1.285	-1.369	-.653
CENTROID X	-.079	.117	.278
CENTROID Y	.236	.320	.491
POA TO CENTROID in.	.249	.340	.564
MIN RADIUS	.366	.153	.127
MEAN RADIUS	1.029	.874	.708
MAX RADIUS	1.921	1.879	1.308
HORIZONTAL SPREAD	3.416	2.741	2.562
VERTICAL SPREAD	1.851	1.851	.964
EXTREME SPREAD	3.542	3.108	2.591
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6522239	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	

