

C6522231

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522231

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			7/31/90	SL
	G) Safety Off Force	2	2	2			7/31/90	SL
	H) Trigger Pull Test & Retainability						8/25/90	SL
	I) Firing Pin Indent	.022	.022	.022			7/31/90	SL
	J) Assemble Stock						8/2/90	KS
	K) Assemble Swivel Studs						8/30/90	SL
	L) Attach Front and Rear Sight Assemblies						8/2/90	KS
	M) Iron Sight Alignment						8/2/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/3/90	KS
	O) Attach Scope to Rifle						8/2/90	KS
	P) Detach & Attach Scope 20 Times						8/2/90	KS
640	Gallery Target & Test						8/8/90	NF
	A) Time						8/8/90	NF
	B) Malfunctions						8/8/90	NF
	C) Pierced Primers						8/8/90	NF
	D) Optical Clarity of Scope						8/8/90	NF
645	Inspect for Live Ammo						8/8/90	NF
655	Final Inspection							
	A) Headspace						8/30/90	SL
	B) Trigger Pull	2.40	2.51	2.22	2.21	2.39	8/25/90	SL
	C) Function						8/30/90	SL
660	Pack						9/19/00	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522231

DATE 8/25/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.34	2.50	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.49	2.28	2.51	
PULL #3	2.37	2.50	2.21	2.22	
PULL #4	2.39	2.36	2.20	2.21	
PULL #5	2.20	2.38	2.47	2.39	
TOTAL	11.79	12.07	11.66	11.73	
AVG.	2.358	2.414	2.332	2.346	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.51		
PULL #2	3.40	3.44		
PULL #3	3.46	3.43		
PULL #4	3.40	3.39		
PULL #5	3.47	3.44		
TOTAL	17.18	17.21		
AVG.	3.436	3.442		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.37		4.17
PULL #2	4.07	4.38		4.45
PULL #3	4.22	4.30		4.39
PULL #4	4.48	4.29		4.35
PULL #5	4.22	4.50		4.37
TOTAL	21.3	21.84		21.73
AVG.	4.226	4.368		4.346

CENTROIDAL DISTANCE CALCULATIONS

RIFLE # 06522231

8 AUG 1990

CENTROIDAL DISTANCES

1	TO	1	1.00498
1	TO	2	.585219
1	TO	3	.993129
1	TO	4	.772513
1	TO	5	1.06897

$\bar{x} = -0.0056$ <----POA
 $\bar{y} = -0.3928$
 1

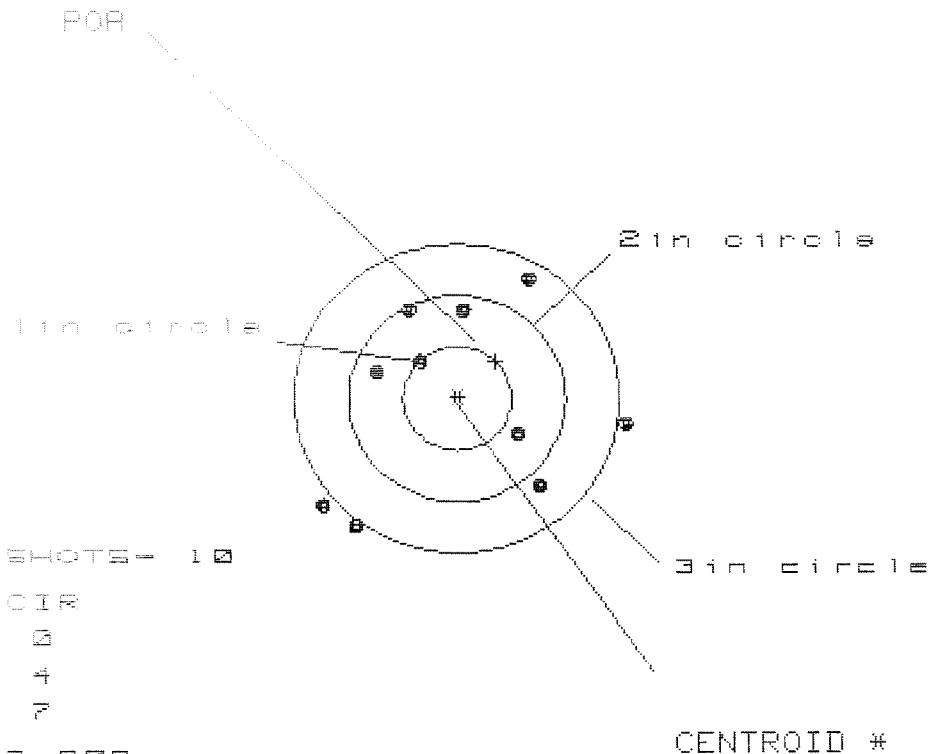
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0056
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3928
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .39284

THE AMR FOR THIS RIFLE IS: .891

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522231

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 2.808

VS = 2.363

GS = 2.930

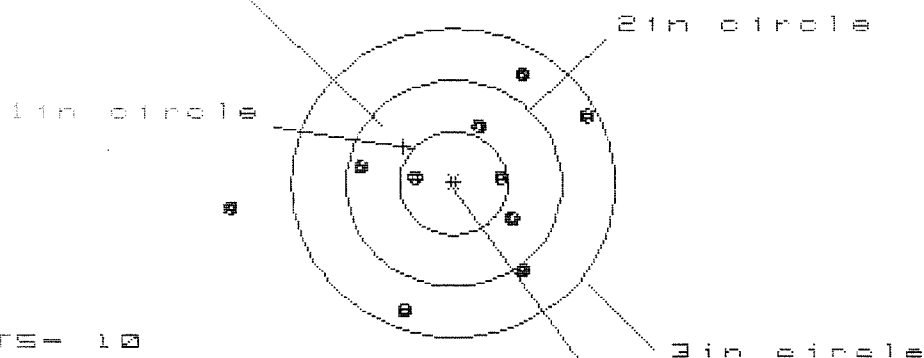
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.569	1.431	.835
MINIMUM X	:	-1.239	-1.066	-.887
MAXIMUM Y	:	1.153	1.037	.998
MINIMUM Y	:	-1.210	-1.326	-1.365
CENTROID X	:	-.358	-.220	-.399
CENTROID Y	:	-.360	-.244	-.205
POB TO CENTROID in.	:	.507	.329	.448
MIN RADIUS	:	.509	.542	.372
MEAN RADIUS	:	1.106	1.032	.948
MAX RADIUS	:	1.616	1.701	1.628
HORIZONTAL SPREAD	:	2.808	2.497	1.722
VERTICAL SPREAD	:	2.363	2.363	2.363
EXTREME SPREAD	:	2.930	2.828	2.828
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522231

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 3.330

VS= 2.257

GS= 3.462

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.272
MINIMUM X	-2.058
MAXIMUM Y	1.043
MINIMUM Y	-1.214
CENTROID X	.462
CENTROID Y	-.362
FOR TO CENTROID in.	.587
MIN RADIUS	.366
MEAN RADIUS	.997
MAX RADIUS	2.076
HORIZONTAL SPREAD	3.330
VERTICAL SPREAD	2.257
EXTREME SPREAD	3.462
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	3

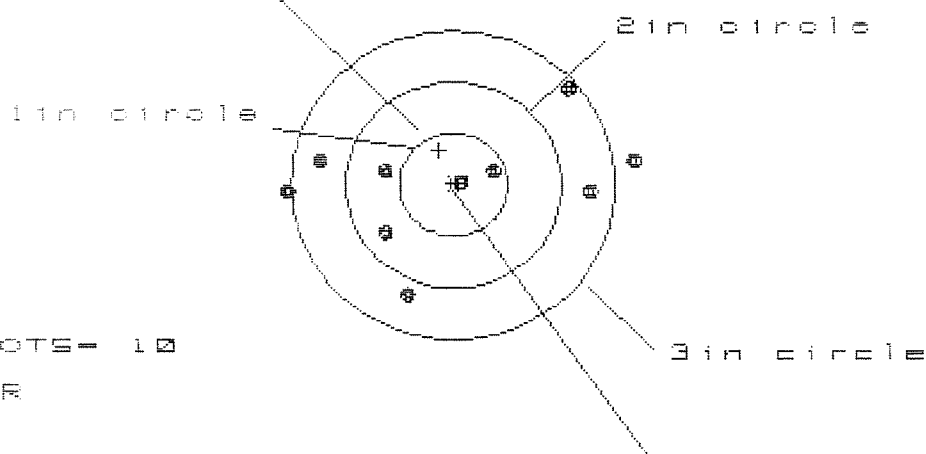
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CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 4

HS = 3.160

VS = 2.044

GS = 3.176

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.675	1.454	1.291
MINIMUM X	:	-1.485	-1.298	-1.236
MAXIMUM Y	:	.943	.975	.974
MINIMUM Y	:	-1.101	-1.069	-1.070
CENTROID X	:	.132	-.055	.108
CENTROID Y	:	-.335	-.367	-.366
POA TO CENTROID in.	:	.360	.371	.382
MIN RADIUS	:	.051	.232	.090
MEAN RADIUS	:	1.019	.936	.878
MAX RADIUS	:	1.699	1.551	1.428
HORIZONTAL SPREAD	:	3.160	2.752	2.527
VERTICAL SPREAD	:	2.044	2.044	2.044
EXTREME SPREAD	:	3.176	2.753	2.547
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Aug 1998

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.793

VS = 1.254

GS = 1.839

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.804	.694	.478
MINIMUM X	-.989	-.689	-.602
MAXIMUM Y	.555	.573	.544
MINIMUM Y	-.699	-.681	-.710
CENTROID X	.078	.188	.101
CENTROID Y	.038	.020	.049
POA TO CENTROID in.	.087	.189	.112
MIN RADIUS	.122	.161	.126
MEAN RADIUS	.581	.520	.494
MAX RADIUS	1.002	.741	.710
HORIZONTAL SPREAD	1.793	1.383	1.080
VERTICAL SPREAD	1.254	1.254	1.254
EXTREME SPREAD	1.839	1.472	1.309
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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

UPPONT

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

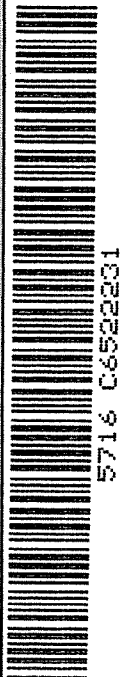
MODEL 700™ M24

SERIAL NO. C6522231

ORDER NO. 5716

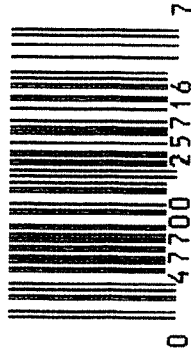
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