

06522227

MODEL 700TH M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522227

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29 90		RW
600	Proof	6 29 90		RW
607	Check Headspace	6 29 90		RW
610	Dis-assemble Gun	6 29 90		RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	SS.
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/18/90	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/10/90	JP
	G) Safety Off Force	2	2	2			8/10/90	JP
	H) Trigger Pull Test & Retainability						8/18/90	JP
	I) Firing Pin Indent	.022	.0225	.0225			8/10/90	JP
	J) Assemble Stock						8/22/90	RW
	K) Assemble Swivel Studs						8/31/90	JP
	L) Attach Front and Rear Sight Assemblies						8/22/90	RW
	M) Iron Sight Alignment						8/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/22/90	RW
	O) Attach Scope to Rifle						8/22/90	RW
	P) Detach & Attach Scope 20 Times						8/22/90	RW
640	Gallery Target & Test						8/23/90	KJ
	A) Time						8/23/90	KJ
	B) Malfunctions						8/23/90	KJ
	C) Pierced Primers						8/23/90	KJ
	D) Optical Clarity of Scope						8/23/90	KJ
645	Inspect for Live Ammo						8/23/90	KJ
655	Final Inspection							
	A) Headspace						8/31/90	JP
	B) Trigger Pull	2.33	2.30	2.25	2.27	2.32	8/31/90	JP
	C) Function						8/31/90	JP
660	Pack						9/20/90	RF

MOD: _____ GA. _____ GUN _____
 CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Slide plate won't stay close	15
	2nd	New floor plate	15
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522227

DATE 8/18/90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.38	2.33	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.40	2.34	2.30	
PULL #3	2.37	2.34	2.33	2.25	
PULL #4	2.34	2.20	2.34	2.27	
PULL #5	2.32	2.33	2.33	2.32	
TOTAL	11.91	11.65	11.67	11.47	
AVG.	2.382	2.33	2.334	2.294	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.49		
PULL #2	3.46	3.51		
PULL #3	3.43	3.35		
PULL #4	3.44	3.35		
PULL #5	3.62	3.31		
TOTAL	17.35	17.01		
AVG.	3.47	3.402		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.35		4.36
PULL #2	4.36	4.34		4.39
PULL #3	4.31	4.36		4.37
PULL #4	4.33	4.31		4.39
PULL #5	4.34	4.36		4.36
TOTAL	21.79	21.62		21.87
AVG.	4.358	4.324		4.374

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522227
24 Aug 1998

CENTROIDAL DISTANCES

0 TO	1	.925277
1 TO	2	1.647
1 TO	3	.910926
1 TO	4	1.22109
1 TO	5	.547096

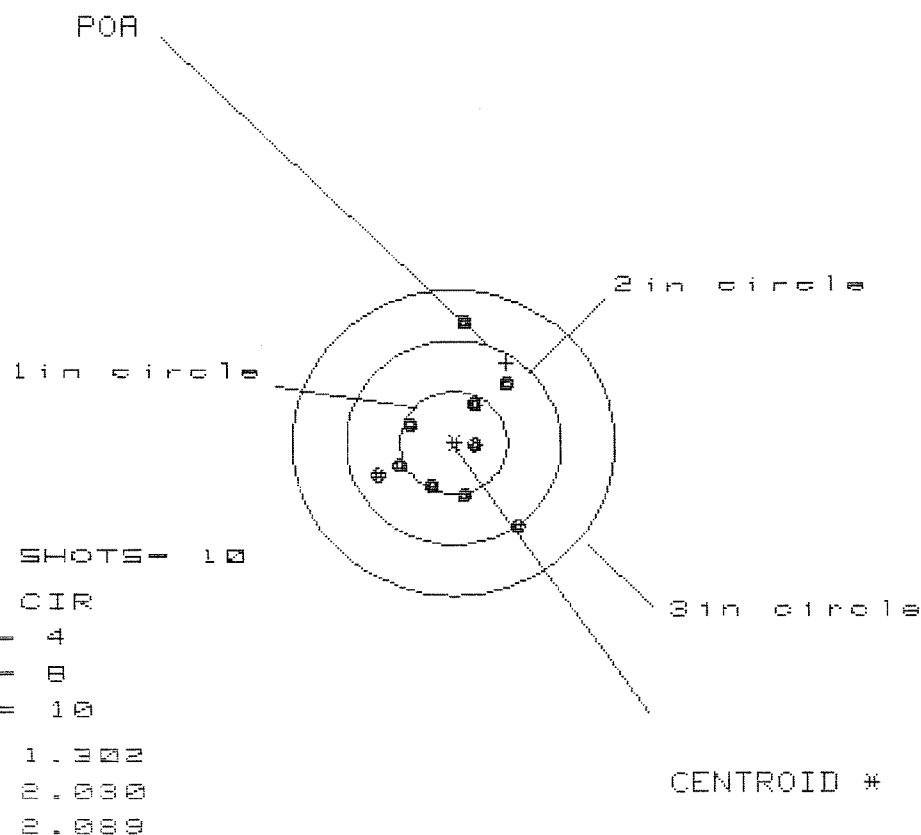
4²
5th <----FOR
L

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0758889
THE AMR FOR THIS RIFLE IS: .7914

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522227

CENTERFIRE PATTERNS # 1

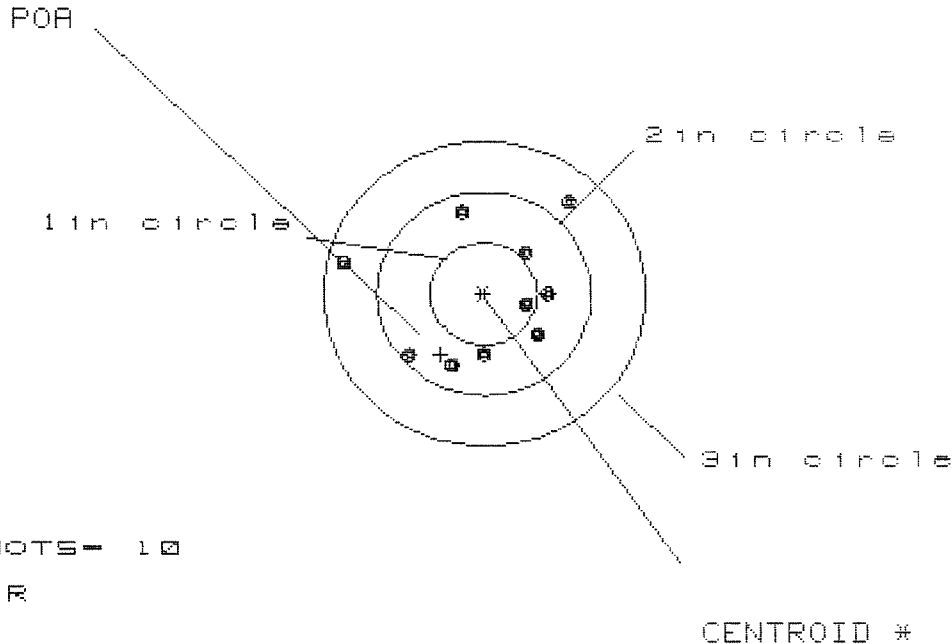


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.618	.631	.554
MINIMUM X	-.684	-.671	-.592
MAXIMUM Y	1.198	.676	.589
MINIMUM Y	-.832	-.699	-.454
CENTROID X	-.493	-.506	-.585
CENTROID Y	-.783	-.916	-.829
POA TO CENTROID in.	.925	1.047	1.014
MIN RADIUS	.233	.254	.319
MEAN RADIUS	.639	.564	.510
MAX RADIUS	1.204	.942	.808
HORIZONTAL SPREAD	1.302	1.302	1.146
VERTICAL SPREAD	2.030	1.375	1.043
EXTREME SPREAD	2.089	1.462	1.462
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.021

VS= 1.527

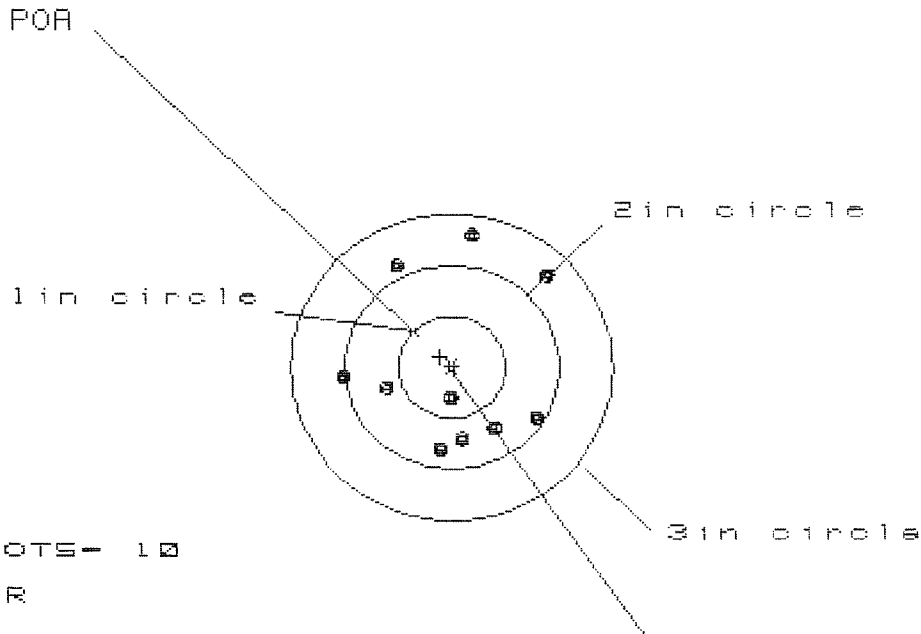
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PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.759	.619	.552
MINIMUM X	-1.262	-.880	-.802
MAXIMUM Y	.857	.888	.965
MINIMUM Y	-.669	-.639	-.528
CENTROID X	.406	.546	.469
CENTROID Y	.597	.566	.455
POA TO CENTROID in.	.721	.786	.653
MIN RADIUS	.401	.258	.340
MEAN RADIUS	.780	.689	.638
MAX RADIUS	1.291	1.082	1.012
HORIZONTAL SPREAD	2.021	1.499	1.355
VERTICAL SPREAD	1.527	1.527	1.493
EXTREME SPREAD	2.118	2.118	1.544
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.877

VS= 2.061

GS= 2.150

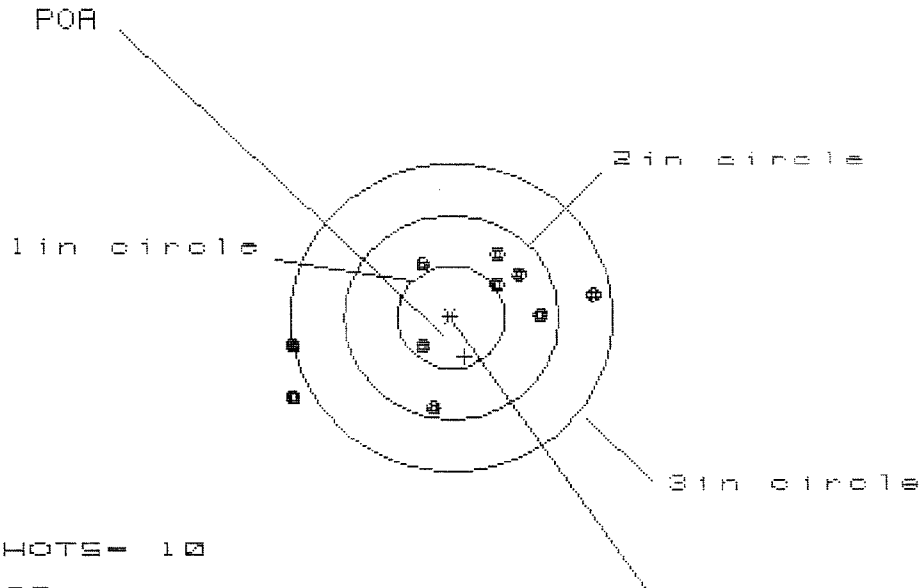
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.915	.899
MINIMUM X	:	-.986	-.962	-.848
MAXIMUM Y	:	1.282	1.179	1.311
MINIMUM Y	:	-.779	-.637	-.505
CENTROID X	:	.112	.088	-.026
CENTROID Y	:	-.102	-.244	-.376
POA TO CENTROID in.	:	.151	.260	.377
MIN RADIUS	:	.252	.107	.104
MEAN RADIUS	:	.879	.784	.670
MAX RADIUS	:	1.299	1.394	1.359
HORIZONTAL SPREAD	:	1.877	1.877	1.747
VERTICAL SPREAD	:	2.061	1.816	1.816
EXTREME SPREAD	:	2.150	2.150	2.014
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.787

VS= 1.490

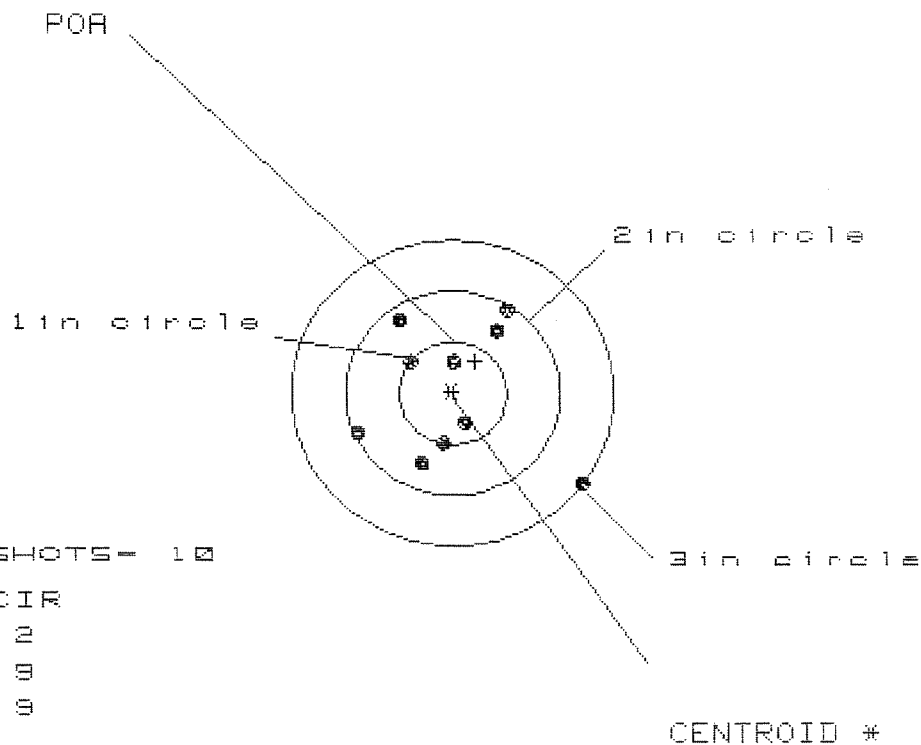
GS= 2.915

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.310	1.148	.943
MINIMUM X	:	-1.477	-1.639	-.626
MAXIMUM Y	:	.653	.571	.530
MINIMUM Y	:	-.837	-.919	-.960
CENTROID X	:	-.124	.038	.243
CENTROID Y	:	.381	.463	.504
POA TO CENTROID in.	:	.401	.465	.559
MIN RADIUS	:	.345	.310	.169
MEAN RADIUS	:	.906	.787	.629
MAX RADIUS	:	1.636	1.671	1.085
HORIZONTAL SPREAD	:	2.787	2.787	1.569
VERTICAL SPREAD	:	1.490	1.490	1.490
EXTREME SPREAD	:	2.915	2.817	1.766
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 2.088

VS= 1.771

GS= 2.406

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.215	.598	.578
MINIMUM X	:	-.873	-.738	-.663
MAXIMUM Y	:	.845	.742	.734
MINIMUM Y	:	-.926	-.836	-.743
CENTROID X	:	-.208	-.343	-.418
CENTROID Y	:	-.316	-.213	-.305
POA TO CENTROID in.	:	.378	.404	.518
MIN RADIUS	:	.284	.214	.333
MEAN RADIUS	:	.753	.648	.609
MAX RADIUS	:	1.528	.953	.859
HORIZONTAL SPREAD	:	2.088	1.336	1.241
VERTICAL SPREAD	:	1.771	1.578	1.478
EXTREME SPREAD	:	2.406	1.823	1.620
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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

MODEL 700™ H24

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

SERIAL NO.
06522227

ORDER NO.
5716

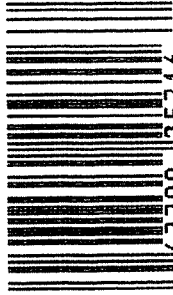
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