

C6522185

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522185

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	LL
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/28/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	YH
	I) Firing Pin Indent	.0225	.0225	.0225			8/28/90	WB
	J) Assemble Stock						8/29/90	RW
	K) Assemble Swivel Studs						9/5/90	YB
	L) Attach Front and Rear Sight Assemblies						8/29/90	RW
	M) Iron Sight Alignment						8/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	RW
	O) Attach Scope to Rifle						8/29/90	RW
	P) Detach & Attach Scope 20 Times						8/29/90	RW
640	Gallery Target & Test						8-30-90	DH
	A) Time						8-30-90	DH
	B) Malfunctions						8-30-90	DH
	C) Pierced Primers						8-30-90	DH
	D) Optical Clarity of Scope						8-30-90	DH
645	Inspect for Live Ammo						8-30-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	YB
	B) Trigger Pull	2.23	2.23	2.24	2.27	2.32	9/1/90	YH
	C) Function						9/5/90	YB
660	Pack						9-18-90	YH

Remington
MODEL 700™ M24

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

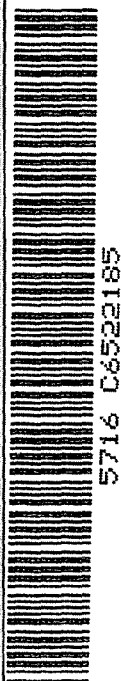
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
rifle.

SERIAL NO.
C6522185

ORDER NO.
5716

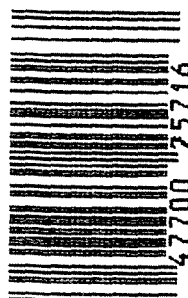
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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5716 C6522185

UPC



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

SERIAL NO. C6522185DATE 8/28/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.42	2.40	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.38	2.35	2.23	
PULL #3	2.44	2.37	2.32	2.24	
PULL #4	2.48	2.44	2.38	2.27	
PULL #5	2.48	2.32	2.32	2.32	
TOTAL	12.23	10.93	11.77	11.29	
AVG.	2.446	2.386	2.354	2.258	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.19		
PULL #2	3.46	3.45		
PULL #3	3.31	3.42		
PULL #4	3.50	3.44		
PULL #5	3.42	3.38		
TOTAL	17.18	16.88		
AVG.	3.436	3.376		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.29		4.26
PULL #2	4.23	4.24		4.11
PULL #3	4.24	4.14		4.28
PULL #4	4.20	4.23		4.39
PULL #5	4.19	4.38		4.28
TOTAL	21.06	21.28		21.32
AVG.	4.212	4.256		4.264

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522158
31 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	1.15617
1 TO	2	.840236
1 TO	3	1.05409
1 TO	4	.8608
1 TO	5	.952542

$\bar{x}^5$ <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4468
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0626
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .451164
THE AMR FOR THIS RIFLE IS: .8008

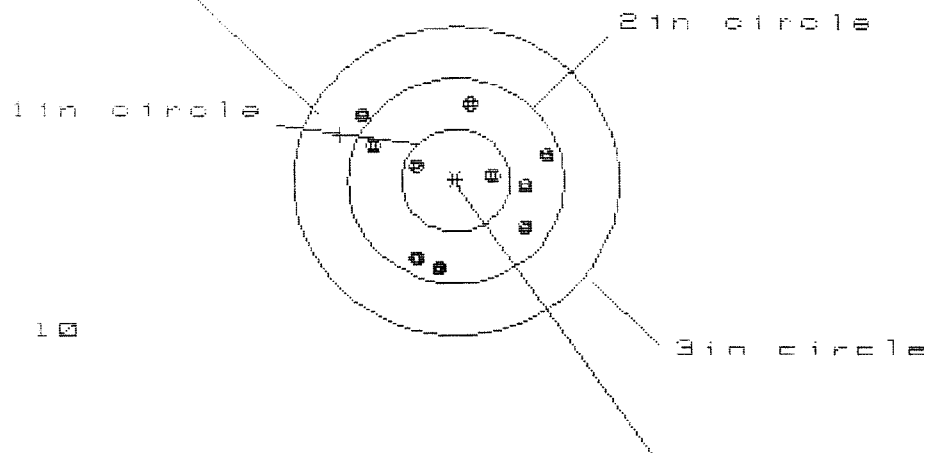
30 Aug 1990

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CENTERFIRE PATTERNS

1

POR



OF SHOTS= 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.682

VS= 1.611

GS= 1.823

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.852	.760	.730
MINIMUM X	:	-.830	-.892	-.922
MAXIMUM Y	:	.720	.791	.689
MINIMUM Y	:	-.891	-.820	-.734
CENTROID X	:	1.065	1.157	1.187
CENTROID Y	:	-.450	-.521	-.419
POR TO CENTROID in.	:	1.156	1.269	1.258
MIN RADIUS	:	.293	.235	.168
MEAN RADIUS	:	.736	.688	.653
MAX RADIUS	:	1.049	.983	.972
HORIZONTAL SPREAD	:	1.682	1.652	1.652
VERTICAL SPREAD	:	1.611	1.611	1.423
EXTREME SPREAD	:	1.823	1.658	1.658
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.894

VS= 2.629

CS= 2.649

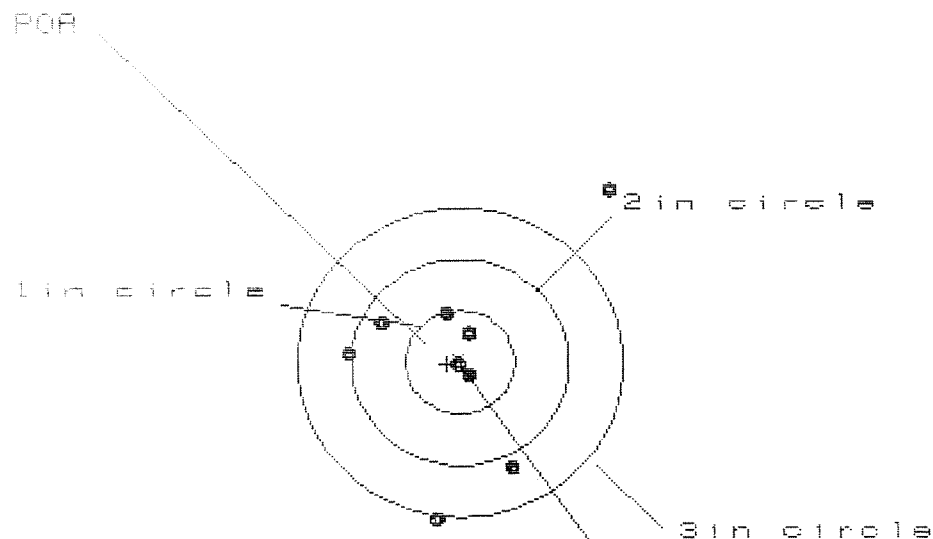
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.061	.673	.686
MINIMUM X	:	-.833	-.715	-.702
MAXIMUM Y	:	1.259	1.154	.969
MINIMUM Y	:	-1.370	-1.475	-1.108
CENTROID X	:	.294	.176	.163
CENTROID Y	:	-.116	-.011	.174
POA TO CENTROID in.	:	.316	.176	.238
MIN RADIUS	:	.366	.276	.130
MEAN RADIUS	:	.912	.836	.715
MAX RADIUS	:	1.423	1.479	1.108
HORIZONTAL SPREAD	:	1.894	1.388	1.388
VERTICAL SPREAD	:	2.629	2.629	2.077
EXTREME SPREAD	:	2.649	2.649	2.085
NUMBER IN ONE INCH CIRCLE	=		1	
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 = 5

2 in = 6

3 in = 8

CENTROID #

HS= 2.391

VS= 3.210

GS= 3.566

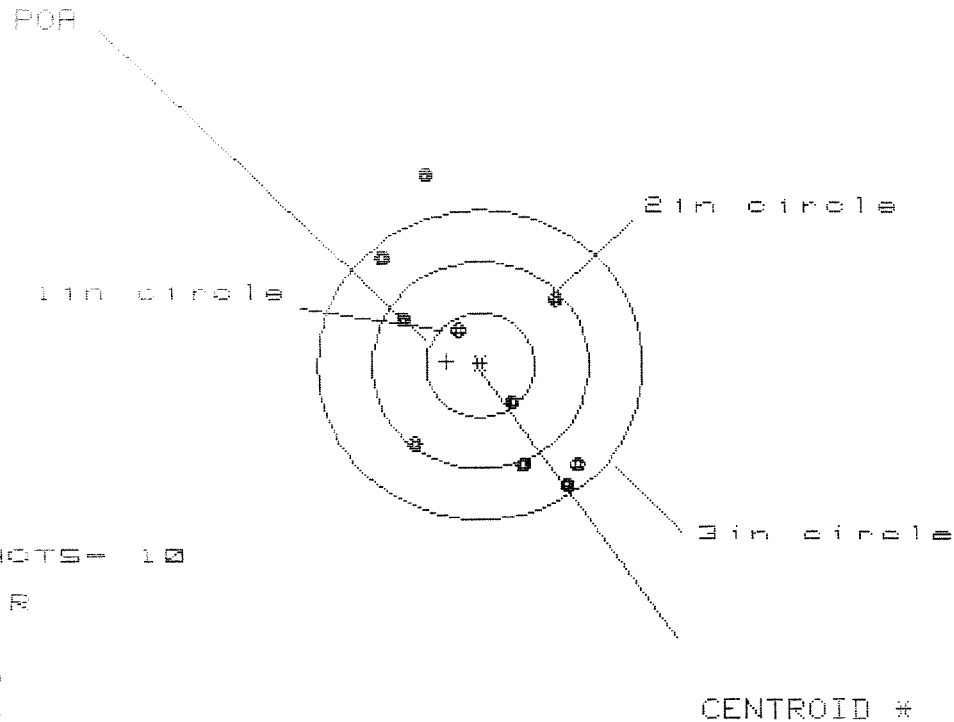
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.354	.644	.638
MINIMUM X	:	-1.037	-.887	-.893
MAXIMUM Y	:	1.648	.628	.455
MINIMUM Y	:	-1.562	-1.379	-1.007
CENTROID X	:	.121	-.029	-.023
CENTROID Y	:	.019	-.164	.009
POB TO CENTROID in.	:	.123	.166	.024
MIN RADIUS	:	.034	.228	.114
MEAN RADIUS	:	.784	.675	.537
MAX RADIUS	:	2.132	1.380	1.192
HORIZONTAL SPREAD	:	2.391	1.531	1.531
VERTICAL SPREAD	:	3.210	2.007	1.462
EXTREME SPREAD	:	3.566	2.040	1.890
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HE= 1.851

VE= 3.076

GS= 3.329

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.908	.851	.726
MINIMUM X	:	-.943	-1.000	-.849
MAXIMUM Y	:	1.873	1.279	.975
MINIMUM Y	:	-1.203	-.994	-.835
CENTROID X	:	.308	.365	.490
CENTROID Y	:	-.040	-.249	-.408
POA TO CENTROID in.	:	.310	.441	.638
MIN RADIUS	:	.393	.281	.096
MEAN RADIUS	:	1.066	.945	.824
MAX RADIUS	:	1.942	1.623	1.140
HORIZONTAL SPREAD	:	1.851	1.851	1.575
VERTICAL SPREAD	:	3.076	2.273	1.810
EXTREME SPREAD	:	3.329	2.841	2.142
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08522158

CENTERFIRE PATTERNS

5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 10

HS= 1.256

VS= 1.828

ES= 1.966

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.648	.579	.579
MINIMUM X	:	-.608	-.536	-.536
MAXIMUM Y	:	.823	.681	.567
MINIMUM Y	:	-1.005	-.914	-.229
CENTROID X	:	.446	.374	.374
CENTROID Y	:	.274	.183	.297
POR TO CENTROID in.	:	.523	.416	.478
MIN RADIUS	:	.059	.086	.030
MEAN RADIUS	:	.506	.436	.371
MAX RADIUS	:	1.047	.914	.780
HORIZONTAL SPREAD	:	1.256	1.115	1.115
VERTICAL SPREAD	:	1.828	1.595	.796
EXTREME SPREAD	:	1.966	1.682	1.348
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	