

C6522164

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 # C6522164

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	LS
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RWB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	TS
	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		8/30/90	9/1

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			8/30/90	WB
	G) Safety Off Force	2	2	2			8/30/90	WB
	H) Trigger Pull Test & Retainability						8/30/90	JLL
	I) Firing Pin Indent	.022	.022	.022			8/30/90	WB
	J) Assemble Stock						9/5/90	RW
	K) Assemble Swivel Studs						9/9/90	JS
	L) Attach Front and Rear Sight Assemblies						9/5/90	RW
	M) Iron Sight Alignment						9/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/90	RW
	O) Attach Scope to Rifle						9/5/90	RW
	P) Detach & Attach Scope 20 Times						9/5/90	RW
640	Gallery Target & Test						9-7-90	AC
	A) Time						9-7-90	AC
	B) Malfunctions						9-7-90	AC
	C) Pierced Primers						9-7-90	AC
	D) Optical Clarity of Scope						9-7-90	AC
645	Inspect for Live Ammo						9-7-90	AC
655	Final Inspection							
	A) Headspace						9/9/90	JS
	B) Trigger Pull	229	219	231	218	214	9/9/90	JS
	C) Function						9/9/90	JS
660	Pack						9-18-90	JLL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522164

DATE 8/30/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.22	2.22	229	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.49	2.27	219	
PULL #3	2.32	2.28	2.30	231	
PULL #4	2.10	2.30	2.26	218	
PULL #5	2.25	2.19	2.25	214	
TOTAL	11.43	11.48	11.30		
AVG.	2.286	2.296	2.26		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.25		
PULL #2	3.44	3.47		
PULL #3	3.46	3.40		
PULL #4	3.44	3.32		
PULL #5	3.50	3.28		
TOTAL	16.94	16.72		
AVG.	3.388	3.344		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.27		4.35
PULL #2	4.43	4.25		4.34
PULL #3	4.49	4.35		4.39
PULL #4	4.28	4.31		4.28
PULL #5	4.41	4.38		4.28
TOTAL	22.10	21.56		21.64
AVG.	4.42	4.312		4.328

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522164

DATE 11-2

TESTER Bm

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.62	2.54		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.67	2.58		
PULL #3	2.38	2.36	2.41		
PULL #4	2.40	2.47	2.51		
PULL #5	2.59	2.27	2.54		
TOTAL	12.05	12.39	12.58		
AVG.	2.41	2.47			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	2.97		
PULL #2	3.02	3.03		
PULL #3	3.02	3.16		
PULL #4	2.88	2.73		
PULL #5	3.08	3.26		
TOTAL	15.05	15.15		
AVG.	3.01	3.03		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.05	3.96		4.06
PULL #2	3.92	4.03		4.06
PULL #3	4.05	4.05		3.95
PULL #4	4.14	4.01		4.04
PULL #5	3.97	4.07		4.03
TOTAL	20.13	20.01		20.14
AVG.	4.02	4.02		4.02

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522164

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	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			

BARBER - M24 0003981

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	6	5 1/2			11/27	WB
	G) Safety Off Force	3	3	3			11/27	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.28	2.18	2.16	2.17	2.15	11/26	WB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522164
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.197899
1 TO	2	.0186815
1 TO	3	.34442
1 TO	4	.527137
1 TO	5	.275073

4
5
3

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.111
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1686
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .202026

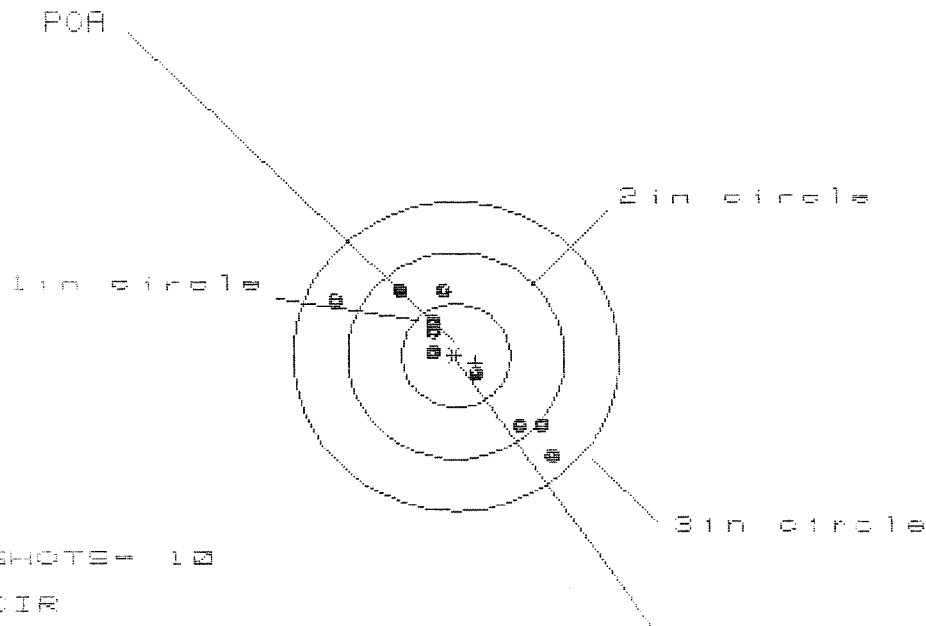
THE AMR FOR THIS RIFLE IS: .8498

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522164

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.953

VS= 1.635

GS= 2.487

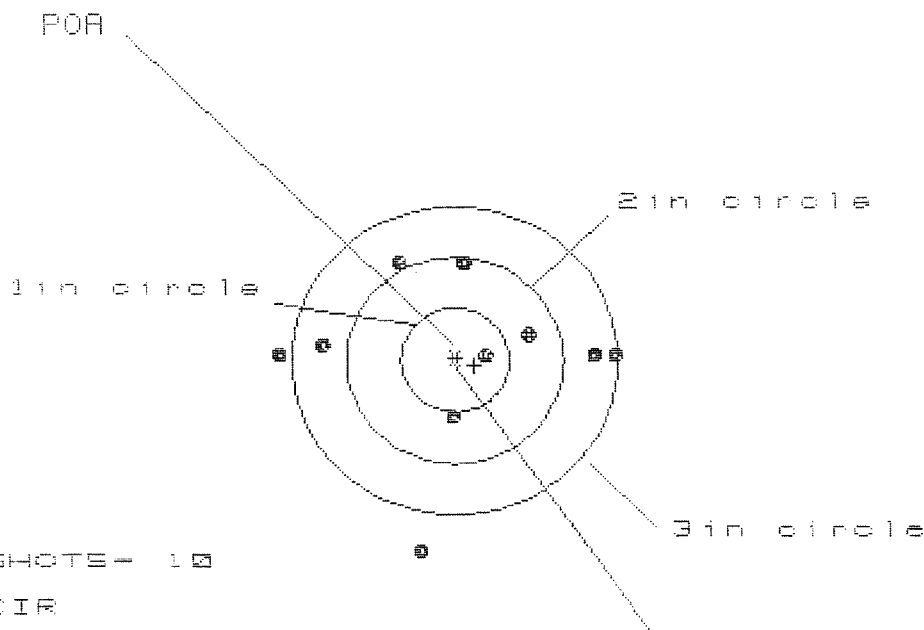
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.866	.845	.721
MINIMUM X	-1.087	-.990	-.573
MAXIMUM Y	.667	.560	.618
MINIMUM Y	-.968	-.917	-.759
CENTROID X	-.186	-.283	-.159
CENTROID Y	.067	.174	.116
POA TO CENTROID in.	.198	.332	.197
MIN RADIUS	.205	.128	.230
MEAN RADIUS	.712	.610	.571
MAX RADIUS	1.299	1.155	1.026
HORIZONTAL SPREAD	1.953	1.835	1.294
VERTICAL SPREAD	1.635	1.377	1.377
EXTREME SPREAD	2.487	2.222	1.860
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

7 Sep 1996

FILE:/PATTERNING/CENTERFIRE PATT/06522164

CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

IN CIE

1

[illegible]
$$V_A = 2.781$$

02- 3, 149

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.504	1.465	1.255
MINIMUM X	:	-1.644	-1.683	-1.502
MAXIMUM Y	:	.938	.736	.713
MINIMUM Y	:	-1.823	-.784	-.807
CENTROID X	:	-.181	-.142	.068
CENTROID Y	:	.049	.251	.274
POR TO CENTROID in.	:	.188	.289	.282
MIN RADIUS	:	.258	.236	.141
MEAN RADIUS	:	1.107	.999	.872
MAX RADIUS	:	1.856	1.692	1.505
HORIZONTAL SPREAD	:	3.148	3.148	2.757
VERTICAL SPREAD	:	2.761	1.520	1.520
EXTREME SPREAD	:	3.149	3.149	2.758
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522164

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.710

VS= 1.571

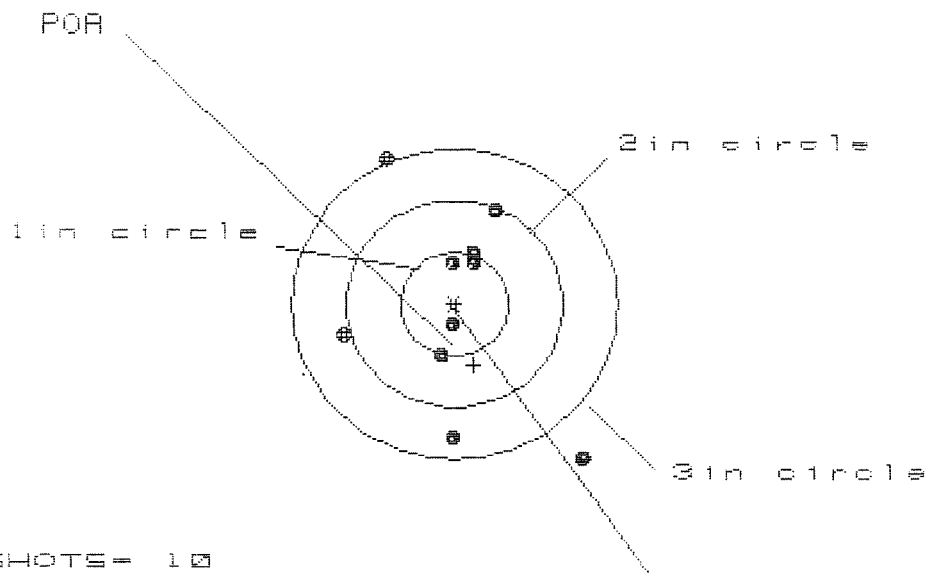
GS= 2.060

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.818	.739
MINIMUM X	:	-.766	-.661	-.740
MAXIMUM Y	:	.865	.796	.837
MINIMUM Y	:	-.706	-.518	-.467
CENTROID X	:	.053	-.052	.027
CENTROID Y	:	-.181	-.102	-.153
POA TO CENTROID in.	:	.189	.115	.156
MIN RADIUS	:	.256	.250	.254
MEAN RADIUS	:	.647	.581	.552
MAX RADIUS	:	1.179	.831	.858
HORIZONTAL SPREAD	:	1.710	1.479	1.479
VERTICAL SPREAD	:	1.571	1.304	1.304
EXTREME SPREAD	:	2.060	1.520	1.479
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522164

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.131

VS= 2.929

GS= 3.423

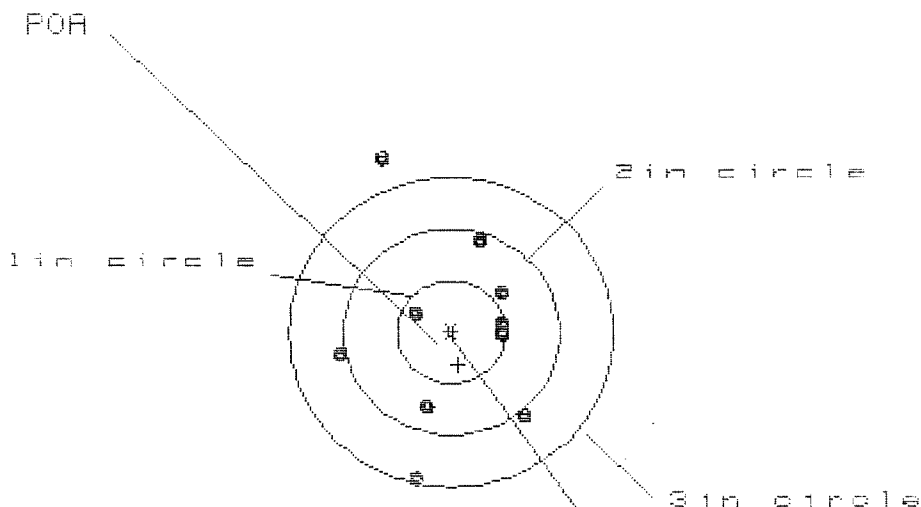
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.143	.508	.446
MINIMUM X	:	-.989	-.862	-.924
MAXIMUM Y	:	1.414	1.246	.887
MINIMUM Y	:	-1.515	-1.444	-1.288
CENTROID X	:	-.174	-.301	-.239
CENTROID Y	:	.594	.762	.607
POR TO CENTROID in.	:	.619	.820	.652
MIN RADIUS	:	.167	.302	.168
MEAN RADIUS	:	.884	.753	.672
MAX RADIUS	:	1.897	1.447	1.289
HORIZONTAL SPREAD	:	2.131	1.370	1.370
VERTICAL SPREAD	:	2.929	2.690	2.175
EXTREME SPREAD	:	3.423	2.755	2.214
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B4

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.729

VS = 3.035

GS = 3.050

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.704
MINIMUM X	-1.025
MAXIMUM Y	1.662
MINIMUM Y	-1.373
CENTROID X	-.067
CENTROID Y	.315
POA TO CENTROID in.	.322
MIN RADIUS	.383
MEAN RADIUS	.899
MAX RADIUS	1.781
HORIZONTAL SPREAD	1.729
VERTICAL SPREAD	3.035
EXTREME SPREAD	3.050
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
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.
C6522164

ORDER NO.
5716

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

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5716 C6522164

UPC



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