

C6522165

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522165

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		90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	GS
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	SA
	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		8/31/90	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/6/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/6/90	WB
	H) Trigger Pull Test & Retainability						8/31/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			9/6/90	WB
	J) Assemble Stock						9/10/90	RW
	K) Assemble Swivel Studs						9/15/90	DB
	L) Attach Front and Rear Sight Assemblies						9/10/90	RW
	M) Iron Sight Alignment						9/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	RW
	O) Attach Scope to Rifle						9/10/90	RW
	P) Detach & Attach Scope 20 Times						9/10/90	RW
640	Gallery Target & Test						9-12-90	AC
	A) Time						9-12-90	AC
	B) Malfunctions						9-12-90	AC
	C) Pierced Primers						9-12-90	AC
	D) Optical Clarity of Scope						9-12-90	AC
645	Inspect for Live Ammo						9-12-90	AC
655	Final Inspection							
	A) Headspace						9/15/90	DB
	B) Trigger Pull	2.46	2.51	2.19	2.34	2.33	9-14-90	RL
	C) Function						9/15/90	DB
660	Pack						2/20/90	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522165

DATE 8/31/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.42	2.42	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.40	2.45	2.51	
PULL #3	2.43	2.41	2.30	2.19	
PULL #4	2.51	2.49	2.44	2.34	
PULL #5	2.39	2.58	2.41	2.33	
TOTAL	12.19	12.30	12.02	11.83	
AVG.	2.438	2.46	2.404	2.366	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.36		
PULL #2	3.26	3.33		
PULL #3	3.25	3.19		
PULL #4	3.49	3.34		
PULL #5	3.30	3.44		
TOTAL	16.73	16.66		
AVG.	3.346	3.332		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.34		4.06
PULL #2	4.29	4.20		4.16
PULL #3	4.24	4.20		4.28
PULL #4	4.02	4.26		4.29
PULL #5	4.34	4.25		4.36
TOTAL	21.26	21.39		21.15
AVG.	4.252	4.278		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522165
12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.306751
1 TO	2	.224147
1 TO	3	.821892
1 TO	4	.69817
1 TO	5	.614363

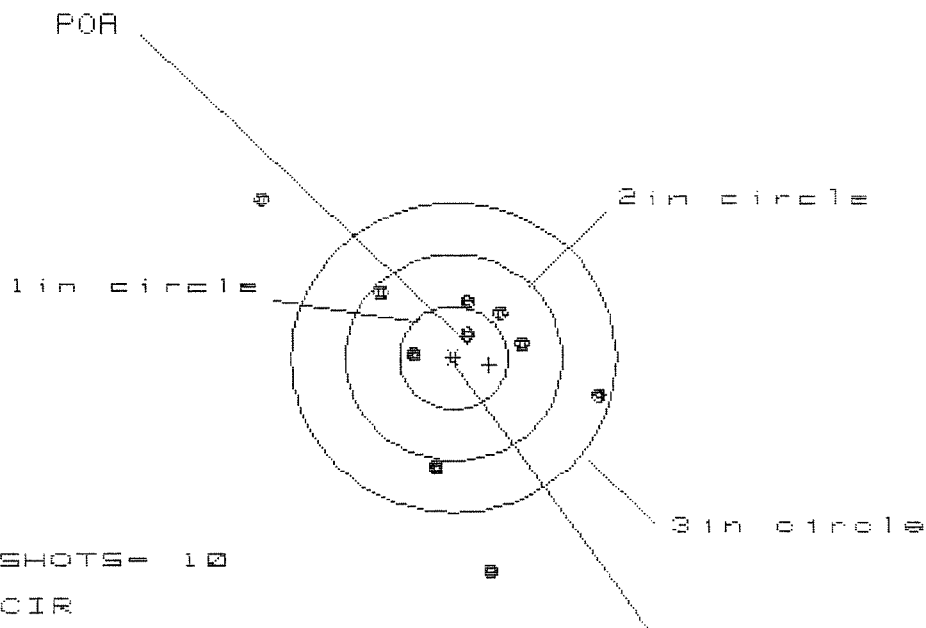
21+30 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .081
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .024
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844808
THE AMR FOR THIS RIFLE IS: .9256

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522165

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.067

VS = 3.654

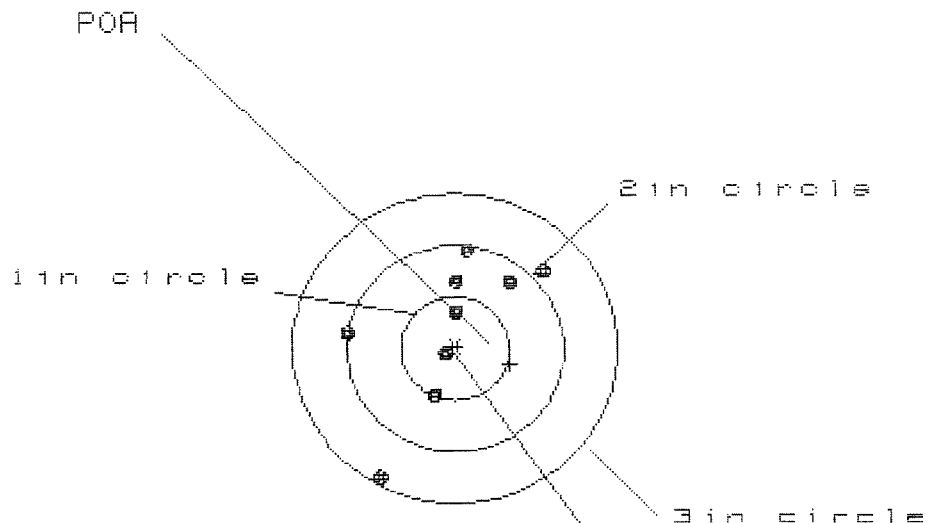
GS = 4.191

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.334	1.142	1.158
MINIMUM X	-1.733	-.897	-.881
MAXIMUM Y	1.541	.810	.567
MINIMUM Y	-2.113	-1.942	-1.142
CENTROID X	-.330	-.138	-.154
CENTROID Y	.064	-.107	.136
POA TO CENTROID in.	.337	.175	.205
MIN RADIUS	.303	.462	.222
MEAN RADIUS	1.028	.905	.690
MAX RADIUS	2.319	1.946	1.234
HORIZONTAL SPREAD	3.067	2.039	2.039
VERTICAL SPREAD	3.654	2.752	1.710
EXTREME SPREAD	4.191	2.937	2.269
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522185

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.773

VS= 2.788

GS= 2.812

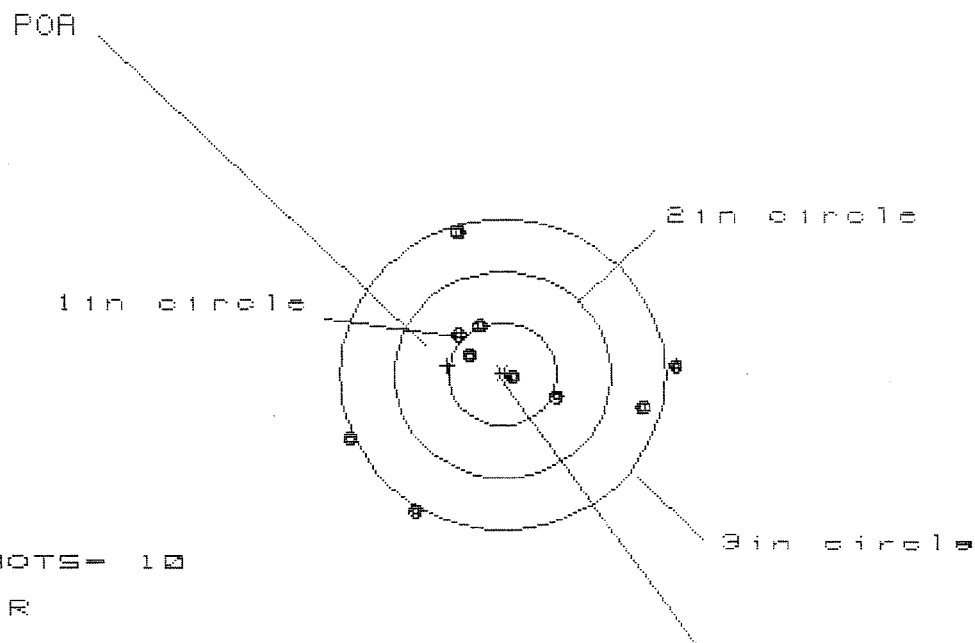
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.778	.828	.744
MINIMUM X	:	-.995	-.945	-1.029
MAXIMUM Y	:	.977	.776	.598
MINIMUM Y	:	-1.811	-1.424	-.887
CENTROID X	:	-.509	-.559	-.475
CENTROID Y	:	.145	.346	.524
POA TO CENTROID in.	:	.529	.658	.787
MIN RADIUS	:	.091	.198	.084
MEAN RADIUS	:	.875	.732	.576
MAX RADIUS	:	1.866	1.577	1.052
HORIZONTAL SPREAD	:	1.773	1.773	1.773
VERTICAL SPREAD	:	2.788	2.200	1.485
EXTREME SPREAD	:	2.812	2.498	1.874
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522165

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 2

2in - 5

3in - 7

HS= 2.973

VS= 2.641

GS= 3.056

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.601	1.432	1.349
MINIMUM X	:	-1.372	-1.194	-1.277
MAXIMUM Y	:	1.365	1.372	1.214
MINIMUM Y	:	-1.276	-1.269	-1.794
CENTROID X	:	.509	.331	.414
CENTROID Y	:	-.081	-.088	.070
POA TO CENTROID in.	:	.515	.342	.420
MIN RADIUS	:	.088	.225	.178
MEAN RADIUS	:	.941	.865	.757
MAX RADIUS	:	1.602	1.460	1.504
HORIZONTAL SPREAD	:	2.973	2.626	2.626
VERTICAL SPREAD	:	2.641	2.641	2.008
EXTREME SPREAD	:	3.056	2.682	2.649
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Sep 1998

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.668

VS = 2.795

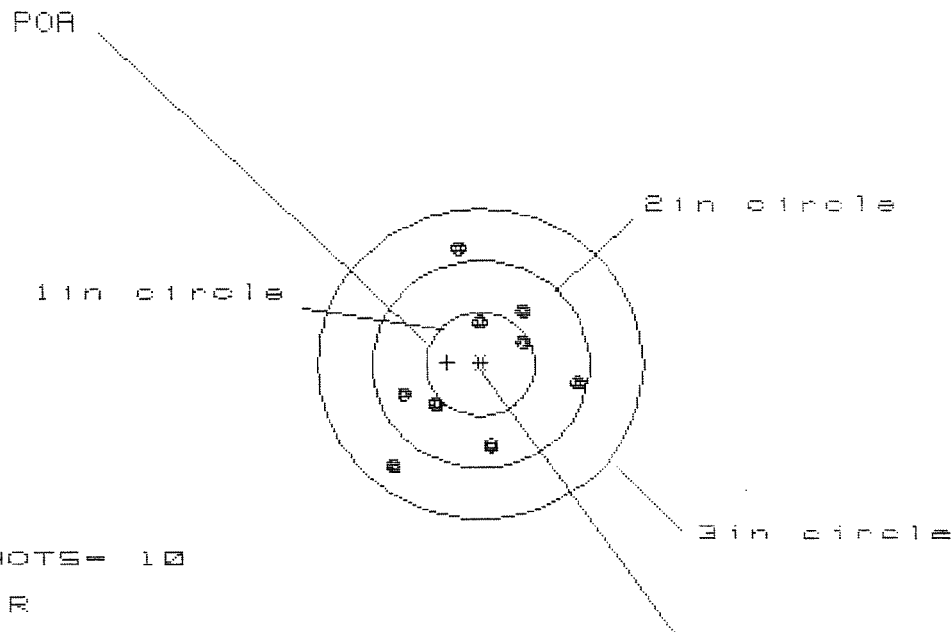
GS = 3.009

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.561	1.064	.972
MINIMUM X	:	-1.107	-.933	-1.026
MAXIMUM Y	:	1.369	1.285	1.096
MINIMUM Y	:	-1.426	-1.510	-1.023
CENTROID X	:	.396	.222	.315
CENTROID Y	:	.009	.093	.282
POA TO CENTROID in.	:	.396	.241	.422
MIN RADIUS	:	.028	.188	.260
MEAN RADIUS	:	1.055	.988	.903
MAX RADIUS	:	1.733	1.680	1.199
HORIZONTAL SPREAD	:	2.668	1.997	1.997
VERTICAL SPREAD	:	2.795	2.795	2.119
EXTREME SPREAD	:	3.009	3.009	2.295
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.655

VS = 2.091

GS = 2.159

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.867	.780	.737
MINIMUM X	-.788	-.748	-.790
MAXIMUM Y	1.146	1.041	.497
MINIMUM Y	-.945	-.881	-.751
CENTROID X	.309	.396	.439
CENTROID Y	-.017	.088	-.042
POA TO CENTROID in.	.309	.406	.441
MIN RADIUS	.418	.299	.323
MEAN RADIUS	.729	.644	.592
MAX RADIUS	1.230	1.095	.821
HORIZONTAL SPREAD	1.655	1.528	1.528
VERTICAL SPREAD	2.091	1.922	1.248
EXTREME SPREAD	2.159	1.960	1.529
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

Remington ®		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6522165	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	



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