

C6522286

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522286

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	28
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/22/90	JA
	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		9/8/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			9/8/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/8/90	WB
	H) Trigger Pull Test & Retainability						9/8/90	WB
	I) Firing Pin Indent	.0245	.0245	.0245			9/8/90	WB
	J) Assemble Stock						9/9/90	KS
	K) Assemble Swivel Studs						9/15/90	JSB
	L) Attach Front and Rear Sight Assemblies						9/9/90	KS
	M) Iron Sight Alignment						9/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/9/90	KS
	O) Attach Scope to Rifle						9/9/90	KS
	P) Detach & Attach Scope 20 Times						9/9/90	KS
640	Gallery Target & Test						9/12/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9/12/90	AF
655	Final Inspection							
	A) Headspace						9/15/90	JSB
	B) Trigger Pull	2.17	2.20	2.18	2.38	2.23	9/14/90	JSB
	C) Function						9/15/90	JSB
660	Pack						9/19/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6527786

DATE 9/8/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.44	2.60	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.41	2.59	2.20	
PULL #3	2.25	2.37	2.58	2.18	
PULL #4	2.15	2.20	2.40	2.38	
PULL #5	2.13	2.35	2.60	2.23	
TOTAL	11.20	11.77	12.77	11.16	
AVG.	2.24	2.35	2.55	2.232	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.27		
PULL #2	3.08	3.21		
PULL #3	3.11	3.10		
PULL #4	3.31	3.07		
PULL #5	3.39	3.25		
TOTAL	16.16	15.90		
AVG.	3.23	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.09		3.90
PULL #2	4.11	4.11		4.10
PULL #3	4.04	4.16		4.20
PULL #4	4.00	4.18		4.00
PULL #5	3.90	4.05		4.15
TOTAL	20.16	20.59		20.35
AVG.	4.03	4.12		4.07

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522286
13 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.0614003
1 TO	2	.106231
1 TO	3	.128156
1 TO	4	.0474342
1 TO	5	.065

←----FOR

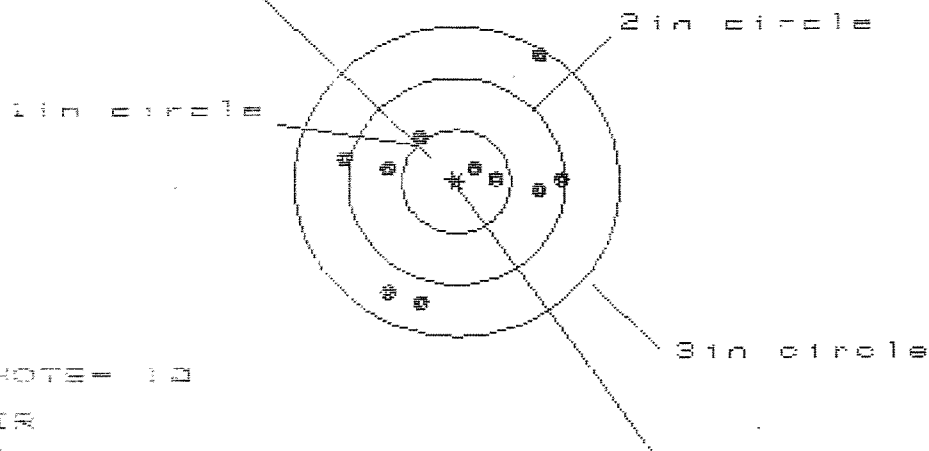
AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0092
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .024
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0257829
X FOR THIS RIFLE IS: .8422

2 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522286

CENTERFIRE PATTERNS # 2

FOR



* OF SHOTS = 12

IN CIR

1 IN = 2

2 IN = 6

3 IN = 10

CENTROID *

.01 = 2.1228

.02 = 2.3408

.03 = 2.5608

PATTERN #

2

SHOTS (BEST OF)	10	9	8
CEX-1000 X	.975	1.060	.995
CEX-1000 Y	-1.056	-.970	-1.035
CEX-1000 X	1.228	.609	.495
CEX-1000 Y	-1.147	-1.010	-1.124
CEX-1000 X	.036	-.050	.015
CEX-1000 Y	-.027	-.164	-.050
CEX-1000 CENTROID IN.	.045	.171	.053
CEX-1000 X	.236	.394	.267
CEX-1000 Y	.851	.799	.737
CEX-1000 X	1.449	1.067	1.177
CEX-1000 Y	2.030	2.030	2.030
CEX-1000 X	2.375	1.619	1.619
CEX-1000 Y	2.635	2.048	2.048
CEX-1000 ONE INCH CIRCLE =		2	
CEX-1000 TWO INCH CIRCLE =		6	
CEX-1000 THREE INCH CIRCLE =		10	

15 SEP 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C65222B6

CENTERFIRE PATTERNS

3

FOR

1in circle

2in circle

3in circle

OF SHOTS = 10

X IN CH

Y IN CH

X IN CH

Y IN CH

X IN CH

Y IN CH

X IN CH

CENTROID *

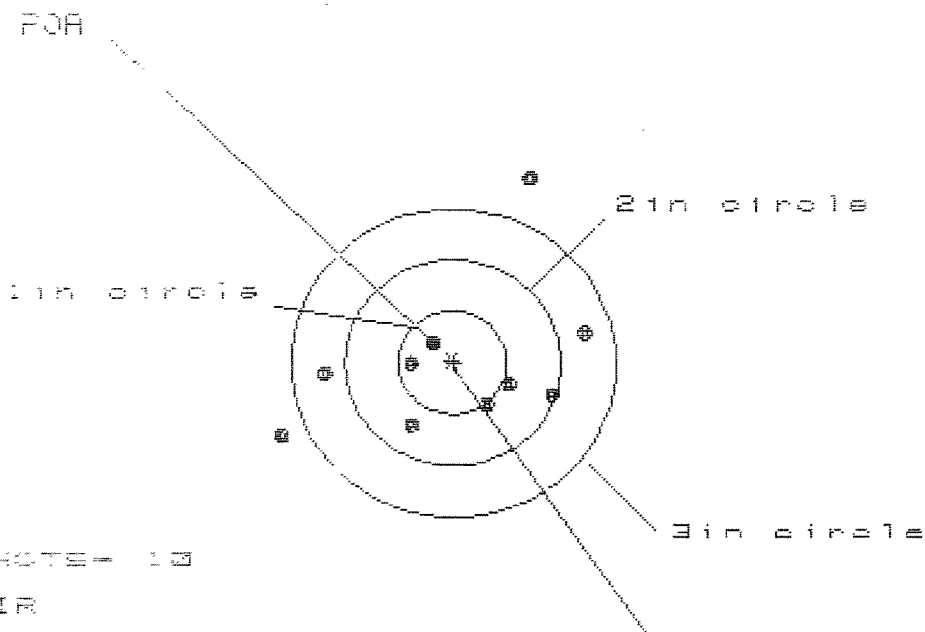
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MINIMUM X	1.020	1.010	.899
MINIMUM X	-.880	-.890	-.880
MINIMUM Y	.809	.655	.719
MINIMUM Y	-1.384	-.779	-.715
CENTROID X	.065	.075	.186
CENTROID Y	.081	.235	.171
MIN TO CENTROID in.	.104	.247	.253
MIN RADIUS	.296	.250	.205
MAX RADIUS	.789	.703	.647
MIN RADIUS	1.387	1.075	1.113
MIN ZONAL SPREAD	1.900	1.900	1.779
MIN ZONAL SPREAD	2.193	1.434	1.434
MIN ZONAL SPREAD	2.332	2.027	2.027
MIN IN ONE INCH CIRCLE	=	4	
MIN IN TWO INCH CIRCLE	=	6	
MIN IN THREE INCH CIRCLE	=	10	

13 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522286

CENTERFIRE PATTERNS

4



OF SHOTS = 10

OF CHS

CHS # 10

CHS # 10

CHS # 10

CHS # 10

CHS # 10

CHS # 10

CENTROID #

PATTERN #

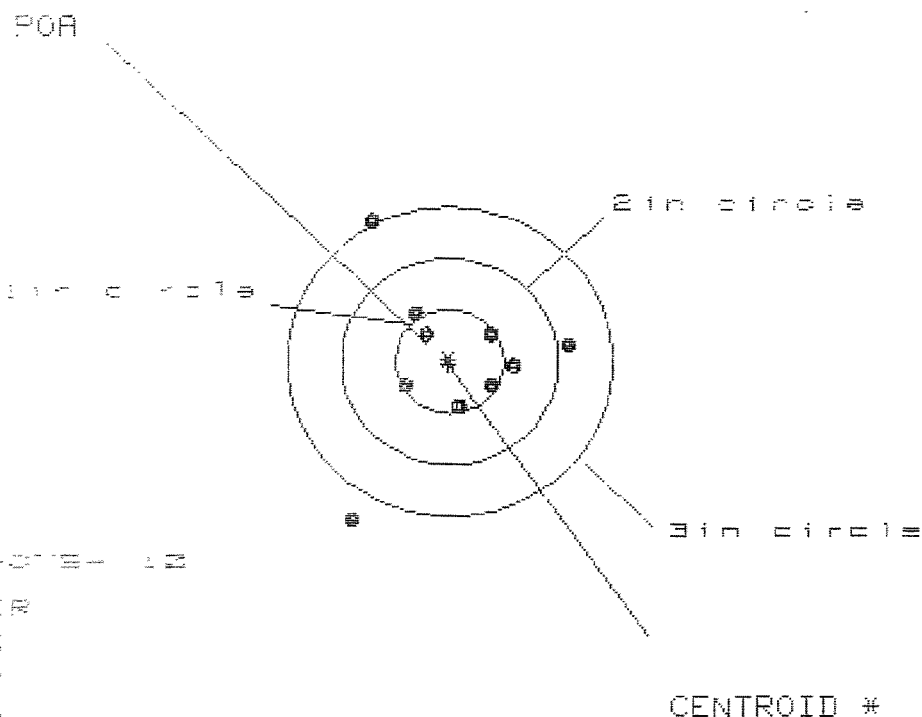
4

COORDS (FEET OF)	10	9	8
MAXIMUM X	1.209	1.284	1.093
MINIMUM X	-1.599	-1.524	-1.296
MAXIMUM Y	1.792	.479	.421
MINIMUM Y	-.668	-.469	-.445
CENTROID X	-.014	-.089	.102
CENTROID Y	.004	-.195	-.137
CHS TO CENTROID in.	.015	.214	.171
1 IN RADIUS	.269	.329	.320
2 IN RADIUS	.942	.815	.700
3 IN RADIUS	1.913	1.595	1.296
HORIZONTAL SPREAD	2.808	2.808	2.389
VERTICAL SPREAD	2.460	.948	.866
TOTAL SPREAD	3.347	2.964	2.427
CHS IN ONE INCH CIRCLE =		2	
CHS IN TWO INCH CIRCLE =		6	
CHS IN THREE INCH CIRCLE =		8	

12 Sep 1998

FILE: PATTERNING/CENTERFIRE_PATT/C8522286

CENTERFIRE PATTERNS # 5



A. 0.0000000000000000

B. 0.0000000000000000

C. 0.0000000000000000

D. 0.0000000000000000

E. 0.0000000000000000

F. 0.0000000000000000

G. 0.0000000000000000

H. 0.0000000000000000

PATTERN # : 5

	10	9	8
1. 1000000000000000	1.127	1.031	.933
2. 1000000000000000	-.866	-.785	-.685
3. 1000000000000000	1.325	1.157	.445
4. 1000000000000000	-1.516	-.617	-.472
5. 1000000000000000	.012	.108	.206
6. 1000000000000000	.031	.199	.054
7. 1000000000000000	.033	.226	.213
8. 1000000000000000	.326	.320	.385
9. 1000000000000000	.772	.655	.537
10. 1000000000000000	1.745	1.398	.938
11. 1000000000000000	1.993	1.816	1.538
12. 1000000000000000	2.841	1.774	.917
13. 1000000000000000	2.847	2.176	1.579
14. 1000000000000000		5	
15. 1000000000000000		7	
16. 1000000000000000		9	

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

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

MODEL 700™ M24

SERIAL NO. C6522286

ORDER NO. 5716

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

01

5716 C6522286

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

UPC

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