

C6522293

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522293

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	JS
617	Drill and Tap Sight Holes		8/10/90	WB
618	Polish Barrel RB		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	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/30/90	WB
	G) Safety Off Force	3	3	3			8/30/90	WB
	H) Trigger Pull Test & Retainability						8/30/90	SC
	I) Firing Pin Indent	.022	.022	.022			8/30/90	WB
	J) Assemble Stock						8/31/90	RW
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						8/31/90	RW
	M) Iron Sight Alignment						8/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/31/90	RW
	O) Attach Scope to Rifle						8/31/90	RW
	P) Detach & Attach Scope 20 Times						8/31/90	RW
640	Gallery Target & Test						9/4/90	KJ
	A) Time						9/4/90	KJ
	B) Malfunctions						9/4/90	KJ
	C) Pierced Primers						9/4/90	KJ
	D) Optical Clarity of Scope						9/4/90	KJ
645	Inspect for Live Ammo						9/4/90	KJ
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.16	2.15	2.24	2.22	2.27	9-5-90	SC
	C) Function						9/6/90	JS
660	Pack						2/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06522293DATE 8/30/90TESTER J. P. K.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.20	2.25	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.39	2.33	2.15	
PULL #3	2.35	2.37	2.23	2.24	
PULL #4	2.25	2.33	2.25	2.22	
PULL #5	2.24	2.22	2.20	2.27	
TOTAL	11.33	11.51	11.26	11.04	
AVG.	2.266	2.302	2.252	2.208	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.27		
PULL #2	3.62	3.43		
PULL #3	3.35	3.40		
PULL #4	3.39	3.32		
PULL #5	3.21	3.47		
TOTAL	16.90	16.89		
AVG.	3.38	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.27		4.22
PULL #2	4.28	4.22		4.19
PULL #3	4.26	4.29		4.27
PULL #4	4.20	4.26		4.23
PULL #5	4.27	4.24		4.22
TOTAL	21.12	21.28		21.13
AVG.	4.224	4.256		4.226

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522293
5 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.705698
1 TO	2	.848374
1 TO	3	.463764
1 TO	4	.79359
1 TO	5	.69148

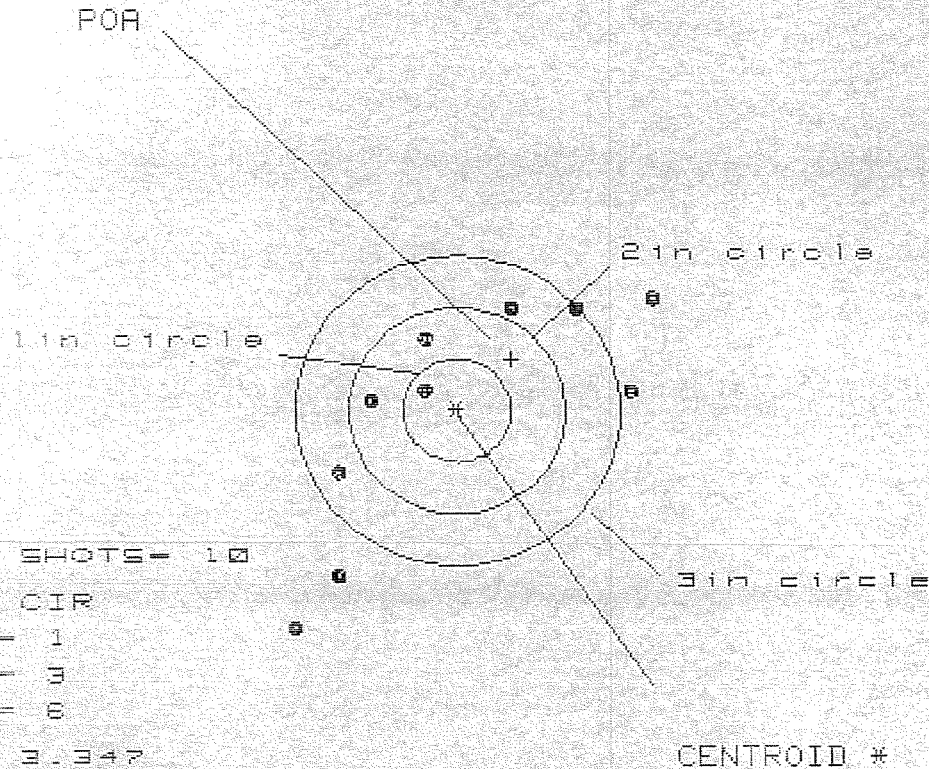
4 <----POA
34
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .259489
THE AMR FOR THIS RIFLE IS: .9682

5 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/06522293

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.347

VS= 3.106

GS= 4.566

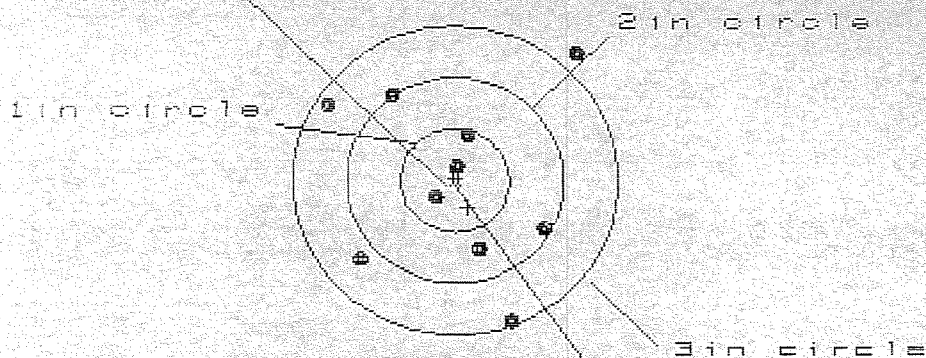
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.824	1.655	1.619
MINIMUM X	:	-1.523	-1.293	-1.087
MAXIMUM Y	:	1.050	.822	.899
MINIMUM Y	:	-2.056	-1.792	-1.690
CENTROID X	:	-.501	-.332	-.538
CENTROID Y	:	-.497	-.269	-.371
POA TO CENTROID in.	:	.706	.427	.654
MIN RADIUS	:	.378	.463	.280
MEAN RADIUS	:	1.392	1.232	1.124
MAX RADIUS	:	2.559	2.189	1.989
HORIZONTAL SPREAD	:	3.347	2.948	2.705
VERTICAL SPREAD	:	3.106	2.614	2.589
EXTREME SPREAD	:	4.566	3.912	3.365
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

5 Sep 1998

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 2

HS= 2.275

VS= 2.563

GS= 2.860

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.128	.942	1.018
MINIMUM X	-1.147	-1.021	-.945
MAXIMUM Y	1.228	.970	.821
MINIMUM Y	-1.335	-1.199	-.802
CENTROID X	-.118	-.243	-.319
CENTROID Y	.260	.124	.274
POA TO CENTROID in.	.285	.273	.420
MIN RADIUS	.107	.064	.209
MEAN RADIUS	.910	.819	.756
MAX RADIUS	1.668	1.365	1.210
HORIZONTAL SPREAD	2.275	1.963	1.963
VERTICAL SPREAD	2.563	2.169	1.623
EXTREME SPREAD	2.860	2.664	2.291
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 2.583

VS = 1.465

GS = 2.586

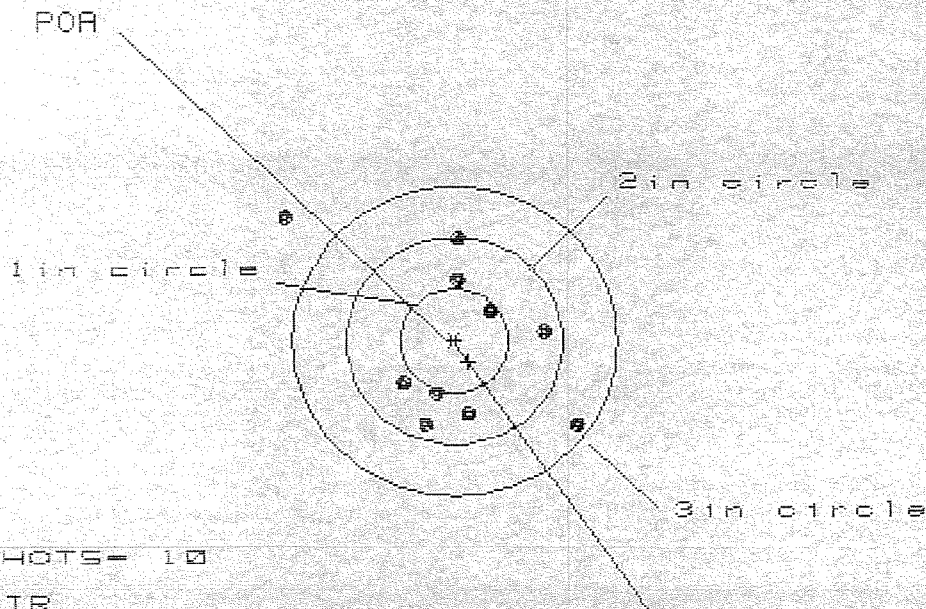
CENTROID #

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.299	1.034	.891
MINIMUM X	-1.284	-1.139	-.500
MAXIMUM Y	.737	.723	.720
MINIMUM Y	-.728	-.742	-.745
CENTROID X	-.292	-.437	-.294
CENTROID Y	-.083	-.069	-.066
POA TO CENTROID in.	.304	.442	.302
MIN RADIUS	.353	.482	.365
MEAN RADIUS	.839	.782	.725
MAX RADIUS	1.306	1.140	.981
HORIZONTAL SPREAD	2.583	2.173	1.391
VERTICAL SPREAD	1.465	1.465	1.465
EXTREME SPREAD	2.586	2.216	1.731
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE: PATTERNING/CENTERFIRE_PATT/C6522293

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.791

VS= 2.002

GS= 3.421

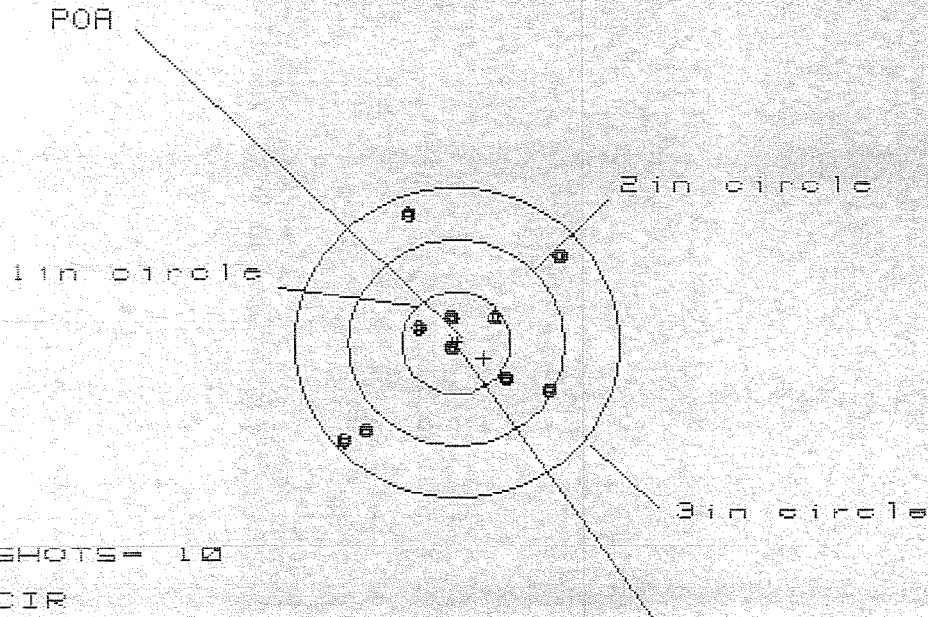
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.177	.997	.751
MINIMUM X	:	-1.614	-.656	-.531
MAXIMUM Y	:	1.218	1.154	1.076
MINIMUM Y	:	-.784	-.649	-.727
CENTROID X	:	-.129	.051	-.074
CENTROID Y	:	.204	.069	.147
POR TO CENTROID in.	:	.241	.085	.164
MIN RADIUS	:	.454	.480	.463
MEAN RADIUS	:	.910	.765	.704
MAX RADIUS	:	2.022	1.177	1.076
HORIZONTAL SPREAD	:	2.791	1.653	1.282
VERTICAL SPREAD	:	2.002	1.803	1.803
EXTREME SPREAD	:	3.421	2.097	1.843
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 2.037

VS= 2.219

GS= 2.731

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.993	.877	.811
MINIMUM X	-1.044	-.966	-1.032
MAXIMUM Y	1.233	1.124	.864
MINIMUM Y	-.986	-1.007	-.867
CENTROID X	-.257	-.141	-.075
CENTROID Y	.150	.259	.119
POA TO CENTROID in.	.297	.295	.140
MIN RADIUS	.046	.177	.215
MEAN RADIUS	.790	.713	.649
MAX RADIUS	1.436	1.396	1.348
HORIZONTAL SPREAD	2.037	1.843	1.843
VERTICAL SPREAD	2.219	2.131	1.731
EXTREME SPREAD	2.731	2.528	2.528
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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

Remington-UMC

MODEL 700TM M24

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

SERIAL NO. C6522293

ORDER NO. 5716

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



UPC

