652301
MODEL 700 TH M24
Model SMS TH
Action
Barrel Length
Capacity
Order No. 716
*Includes 1 in chamber.
Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522301

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		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	JS.
617	Drill and Tap Sight Holes		8/10/90	KS
618	Polish Barrel KS		8/14/90	KS
620	Apply Coatings (Barrel Action)		8-22-90	JS
	Apply Coating (Bolt)		D	
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/90	KS
	C) Inspect Ejector Hole for Chamfer		8/23/90	KS
	D) Oil Firing Pin Ass'y		8/23/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	2½	2½	2½			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	RJ
	I) Firing Pin Indent	.023	.0225	.0225			9/4/90	WB
	J) Assemble Stock						9/4/90	KS
	K) Assemble Swivel Studs						9/8/90	RB
	L) Attach Front and Rear Sight Assemblies						9/4/90	KS
	M) Iron Sight Alignment						9/4/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	KS
	O) Attach Scope to Rifle						9/4/90	KS
	P) Detach & Attach Scope 20 Times						9/4/90	KS
640	Gallery Target & Test						9/6/90	RJ
	A) Time						9/6/90	RJ
	B) Malfunctions						9/6/90	RJ
	C) Pierced Primers						9/6/90	RJ
	D) Optical Clearity of Scope						9/6/90	RJ
645	Inspect for Live Ammo						9/6/90	RJ
655	Final Inspection A) Headspace						9/8/90	RB
	B) Trigger Pull	261	263	266	258	271	9/8/90	RB
	C) Function						9/8/90	RB
660	Pack						9-19-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO C6522301
DATE 9/11/90
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.38	2.25	261	MIN. SETTING,
PULL #2	2.45	2.30	2.41	263	NO AVG. OF 5
PULL #3	2.22	2.33	2.30	266	READINGS ACCEPT-
PULL #4	2.28	2.25	2.43	258	ABLE LESS THAN 2#
PULL #5	2.22	2.42	2.30	271	
TOTAL	11.37	11.68	11.69		
AVG.	2.274	2.336	2.338		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.35		
PULL #2	3.34	3.33		
PULL #3	3.30	3.34		
PULL #4	3.37	3.38		
PULL #5	3.34	3.44		
TOTAL	16.70	16.84		
AVG.	3.34	3.368		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.27		4.24
PULL #2	4.23	4.24		4.27
PULL #3	4.24	4.32		4.34
PULL #4	4.27	4.28		4.30
PULL #5	4.33	4.31		4.44
TOTAL	21.23	21.42		21.59
AVG.	4.246	4.284		4.318

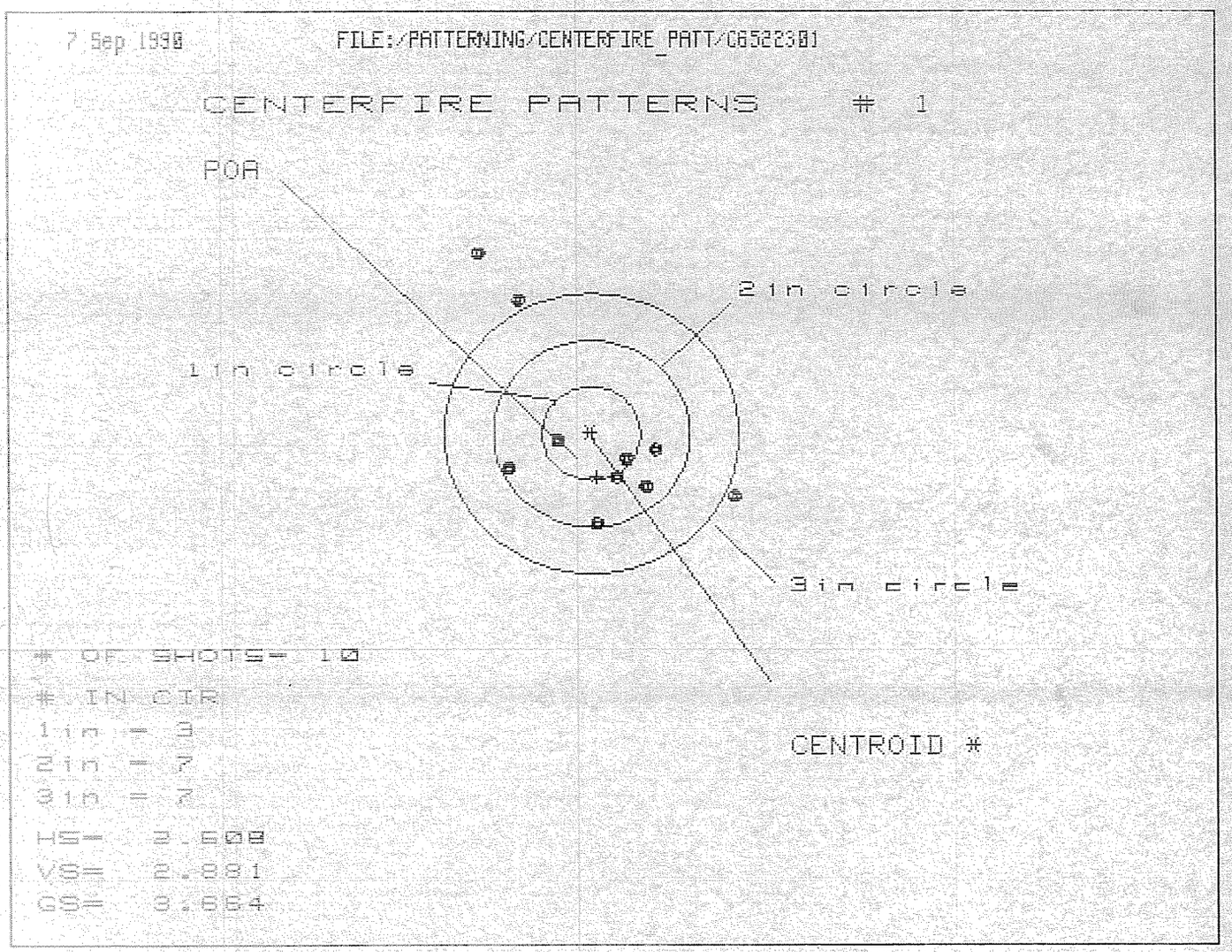
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522301
7 Sep 1990

CENTROIDAL DISTANCES

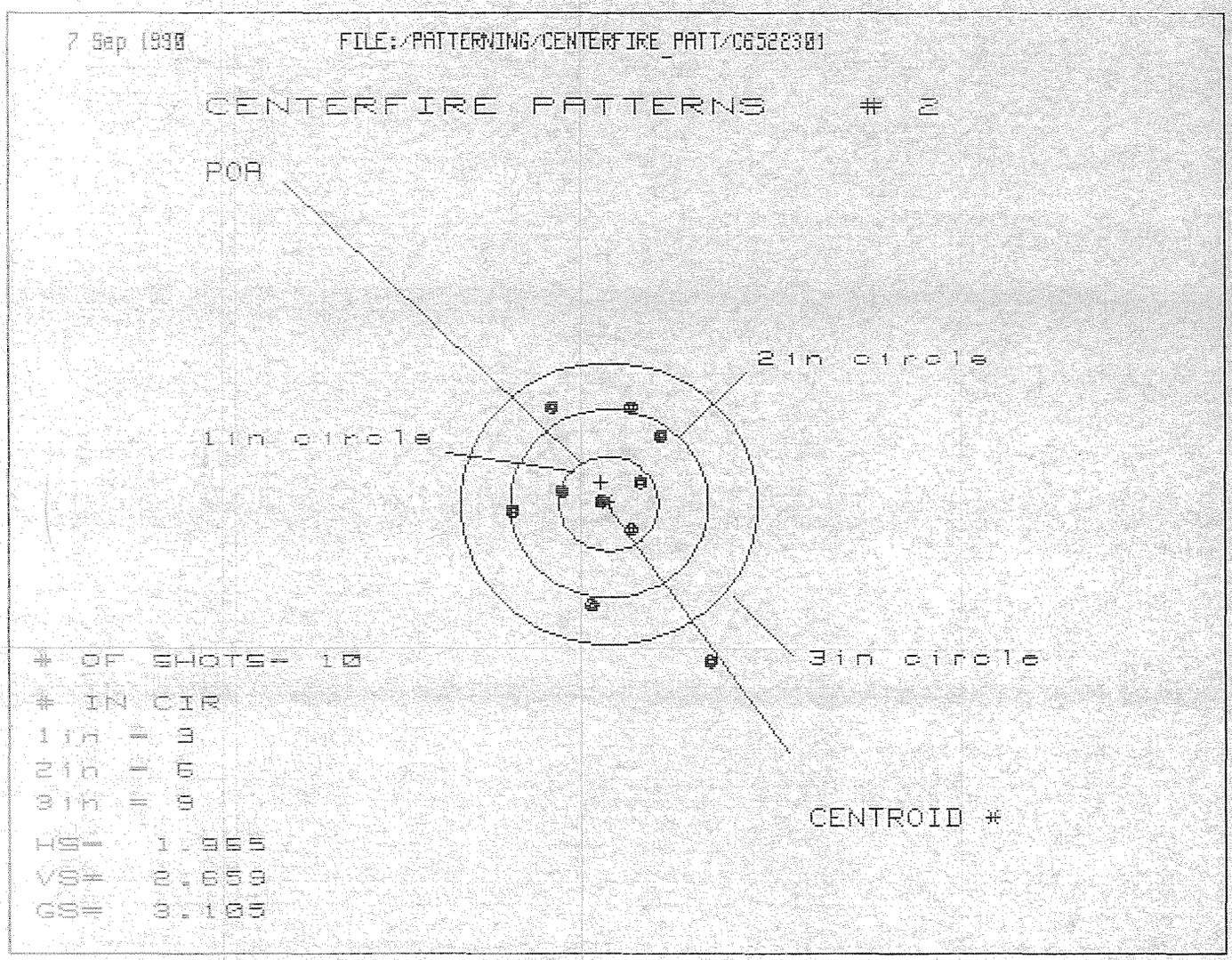
0	TO	1	.470112
1	TO	2	.705459
1	TO	3	.467658
1	TO	4	.68049
1	TO	5	.510064

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0175328

THE AMR FOR THIS RIFLE IS: .9338



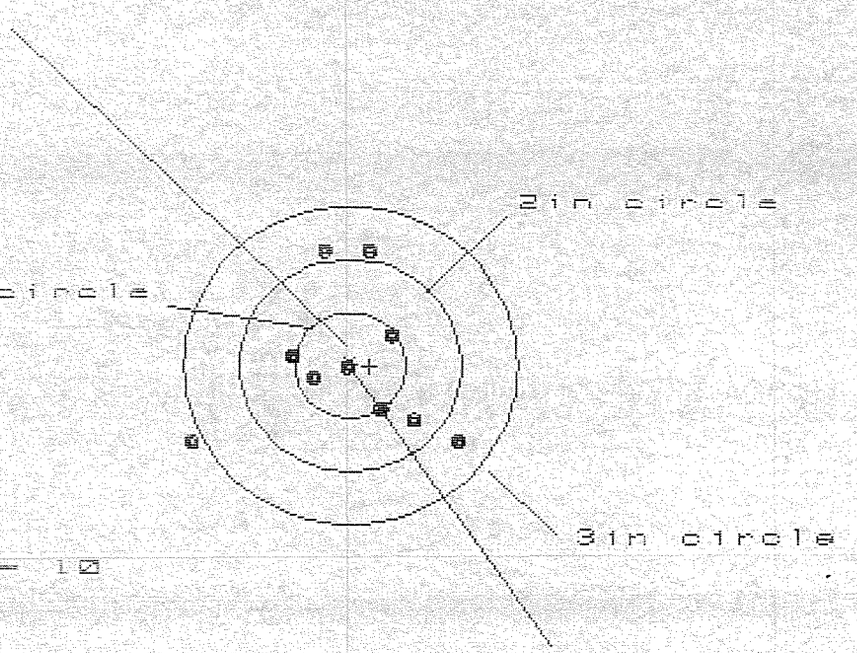
PATTERN #	:	1	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.417	1.284	1.170
MINIMUM X	:	-1.191	-1.010	-1.124
MAXIMUM Y	:	1.954	1.655	.334
MINIMUM Y	:	-.927	-.710	-.503
CENTROID X	:	-.054	.079	.193
CENTROID Y	:	.467	.250	.043
POA TO CENTROID in.	:	.470	.262	.198
MIN RADIUS	:	.324	.174	.009
MEAN RADIUS	:	.998	.765	.566
MAX RADIUS	:	2.289	1.891	1.186
HORIZONTAL SPREAD	:	2.608	2.294	2.294
VERTICAL SPREAD	:	2.881	2.365	.837
EXTREME SPREAD	:	3.664	3.011	2.306
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	.680	.618
MINIMUM X	:	-.939	-.825	-.887
MAXIMUM Y	:	.999	.814	.913
MINIMUM Y	:	-1.660	-1.258	-1.159
CENTROID X	:	.078	-.036	.026
CENTROID Y	:	-.226	-.041	-.140
POA TO CENTROID in.	:	.239	.055	.143
MIN RADIUS	:	.084	.187	.091
MEAN RADIUS	:	.837	.704	.656
MAX RADIUS	:	1.952	1.262	1.171
HORIZONTAL SPREAD	:	1.965	1.505	1.505
VERTICAL SPREAD	:	2.659	2.072	2.072
EXTREME SPREAD	:	3.105	2.118	2.118
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522301

CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 6
3in = 9
HS= 2.385
VS= 1.739
GS= 2.385

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.991	.836	.521
MINIMUM X	:	-1.394	-.662	-.558
MAXIMUM Y	:	1.048	.973	.877
MINIMUM Y	:	-.691	-.766	-.724
CENTROID X	:	-.174	-.019	-.123
CENTROID Y	:	.015	.090	.186
POA TO CENTROID in.	:	.174	.092	.223
MIN RADIUS	:	.067	.217	.176
MEAN RADIUS	:	.761	.679	.614
MAX RADIUS	:	1.552	1.134	.913
HORIZONTAL SPREAD	:	2.385	1.498	1.079
VERTICAL SPREAD	:	1.739	1.739	1.601
EXTREME SPREAD	:	2.385	2.109	1.778
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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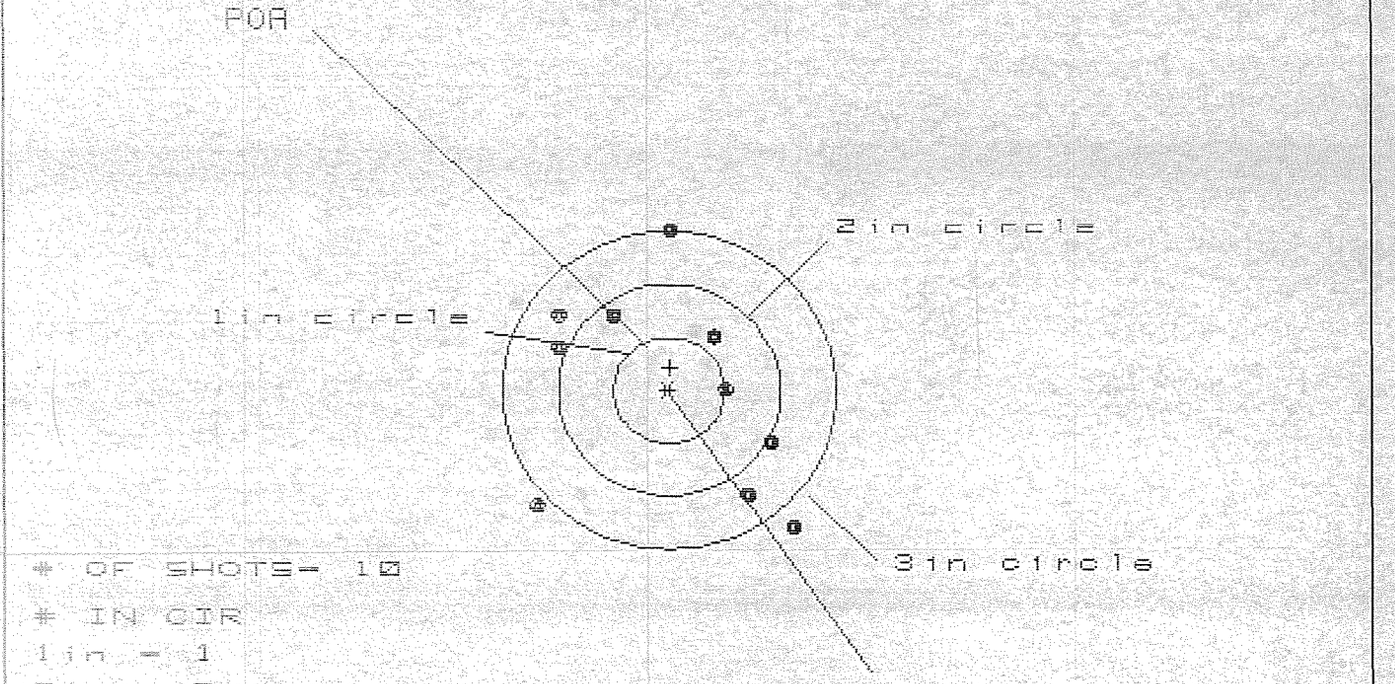
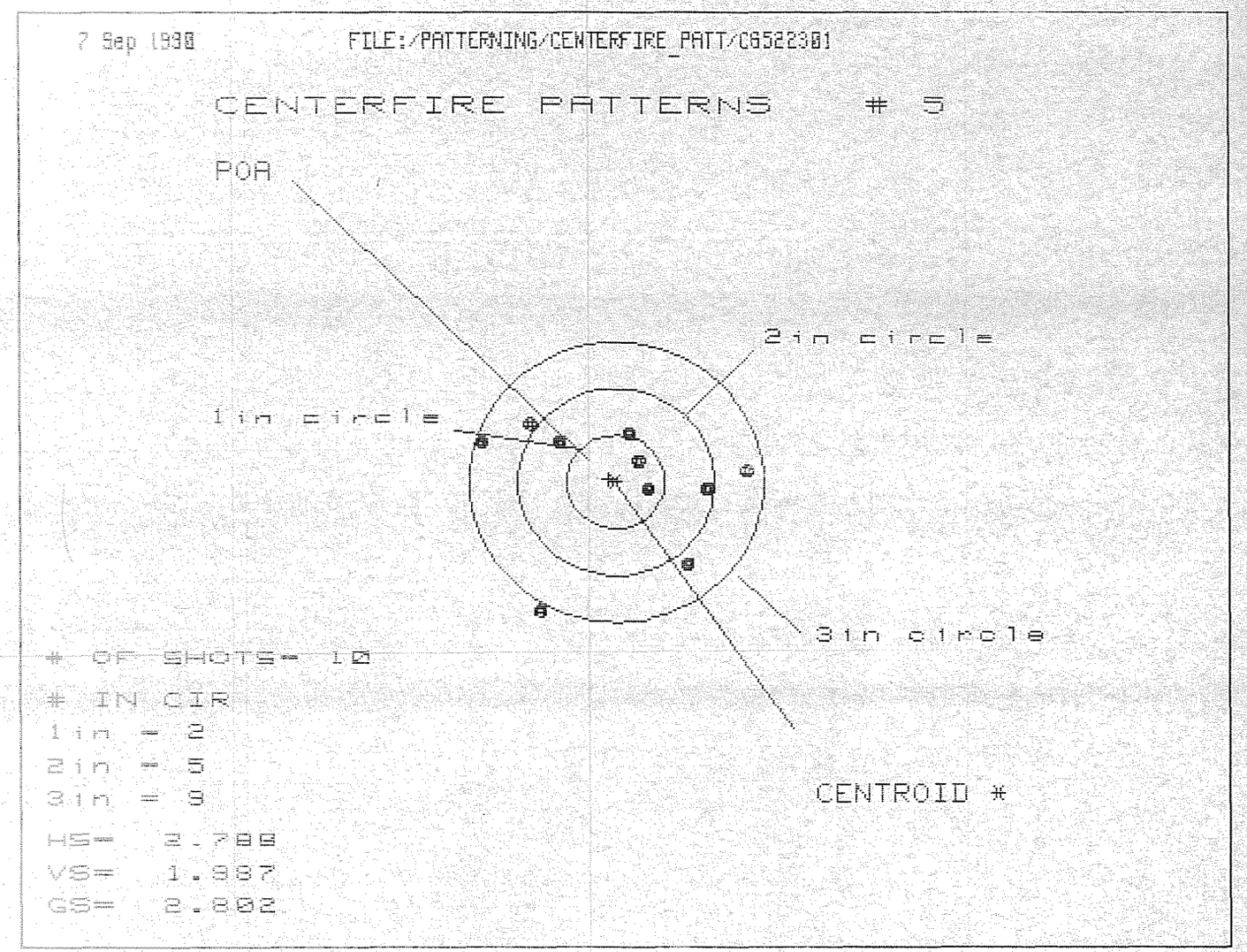
CENTERFIRE PATTERNS # 4

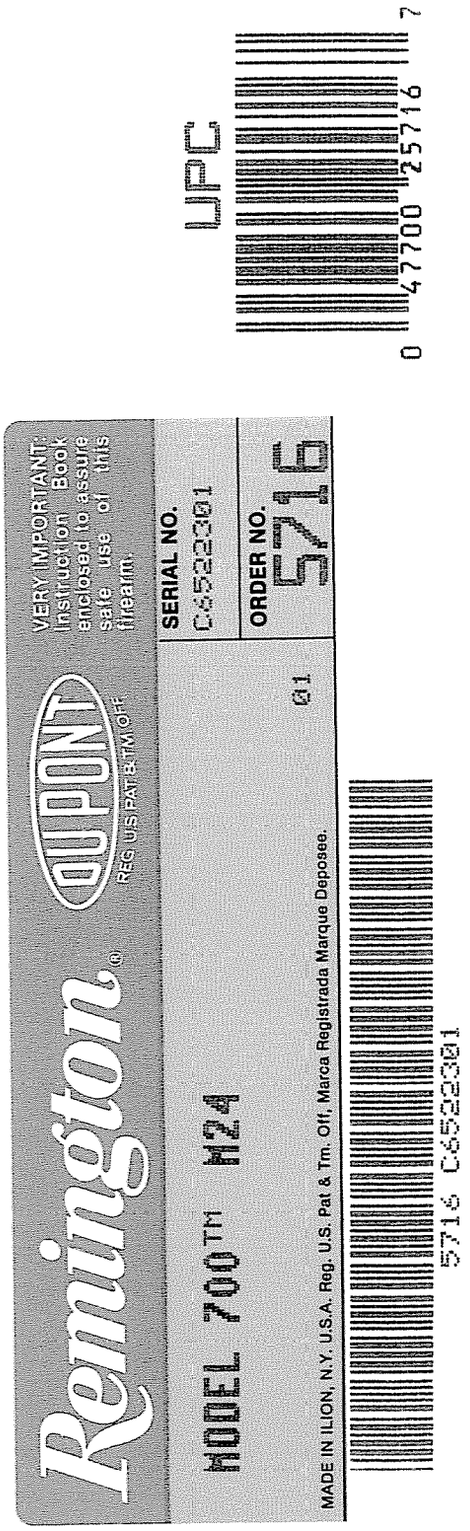


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 3
3in = 7
HS= 2.297
VS= 2.819
GS= 3.031

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.153	1.014	.887
MINIMUM X	:	-1.144	-1.015	-1.009
MAXIMUM Y	:	1.558	1.418	1.265
MINIMUM Y	:	-1.261	-1.228	-1.322
CENTROID X	:	-.009	-.138	-.011
CENTROID Y	:	-.212	-.072	.081
POA TO CENTROID in.	:	.212	.155	.082
MIN RADIUS	:	.475	.626	.452
MEAN RADIUS	:	1.139	1.059	.962
MAX RADIUS	:	1.709	1.593	1.493
HORIZONTAL SPREAD	:	2.297	2.029	1.896
VERTICAL SPREAD	:	2.819	2.646	2.587
EXTREME SPREAD	:	3.031	2.899	2.668
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.367	1.276	1.087
MINIMUM X	:	-1.421	-1.512	-1.110
MAXIMUM Y	:	.662	.514	.544
MINIMUM Y	:	-1.325	-.985	-.955
CENTROID X	:	.073	.164	.353
CENTROID Y	:	-.027	.121	.091
POA TO CENTROID in.	:	.078	.203	.364
MIN RADIUS	:	.289	.167	.130
MEAN RADIUS	:	.934	.825	.712
MAX RADIUS	:	1.557	1.530	1.236
HORIZONTAL SPREAD	:	2.788	2.788	2.197
VERTICAL SPREAD	:	1.987	1.499	1.499
EXTREME SPREAD	:	2.802	2.802	2.267
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	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DUPONT
REG U.S. PAT. & TM. OFF.
VERY IMPORTANT
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enclosed to assure
safe use of this
firearm.
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