

C6522303

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522303

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12	90	RW
600	Proof	7 12	90	RW
607	Check Headspace	7 12	90	RW
610	Dis-assemble Gun	7 12	90	RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	GL
617	Drill and Tap Sight Holes		7/23/90	KB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-6-90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			8/28/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/27/90	JH
	I) Firing Pin Indent	1.022	.022	.022			8/28/90	WB
	J) Assemble Stock						8/29/90	RW
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						8/29/90	RW
	M) Iron Sight Alignment						8/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	RW
	O) Attach Scope to Rifle						8/29/90	RW
	P) Detach & Attach Scope 20 Times						8/29/90	RW
640	Gallery Target & Test						9/4/90	NF
	A) Time						9/4/90	NF
	B) Malfunctions						9/4/90	NF
	C) Pierced Primers						9/4/90	NF
	D) Optical Clarity of Scope						9/4/90	NF
645	Inspect for Live Ammo						9/4/90	NF
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.28	2.38	2.41	2.40	2.49	9-5-90	JL
	C) Function						9/6/90	JS
660	Pack						9/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522303

DATE 8/27/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.30	2.32	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.32	2.35	2.38	
PULL #3	2.35	2.24	2.22	2.41	
PULL #4	2.23	2.20	2.31	2.40	
PULL #5	2.33	2.20	2.20	2.49	
TOTAL	11.65	11.26	11.40	11.96	
AVG.	2.33	2.252	2.28	2.392	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.44		
PULL #2	3.43	3.40		
PULL #3	3.40	3.43		
PULL #4	3.43	3.42		
PULL #5	3.45	3.47		
TOTAL	17.24	17.16		
AVG.	3.448	3.432		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.21		4.26
PULL #2	4.22	4.29		4.23
PULL #3	4.24	4.23		4.27
PULL #4	4.26	4.23		4.25
PULL #5	4.27	4.23		4.21
TOTAL	21.27	21.19		21.22
AVG.	4.254	4.238		4.244

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522303
5 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.091444
1 TO	2	.23145
1 TO	3	.236172
1 TO	4	.344549
1 TO	5	.159

44 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1206
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124981
THE AMR FOR THIS RIFLE IS: .8544

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522303

CENTERFIRE PATTERNS # 1

POB

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.138

VS= 1.793

GS= 2.206

PATTERN #

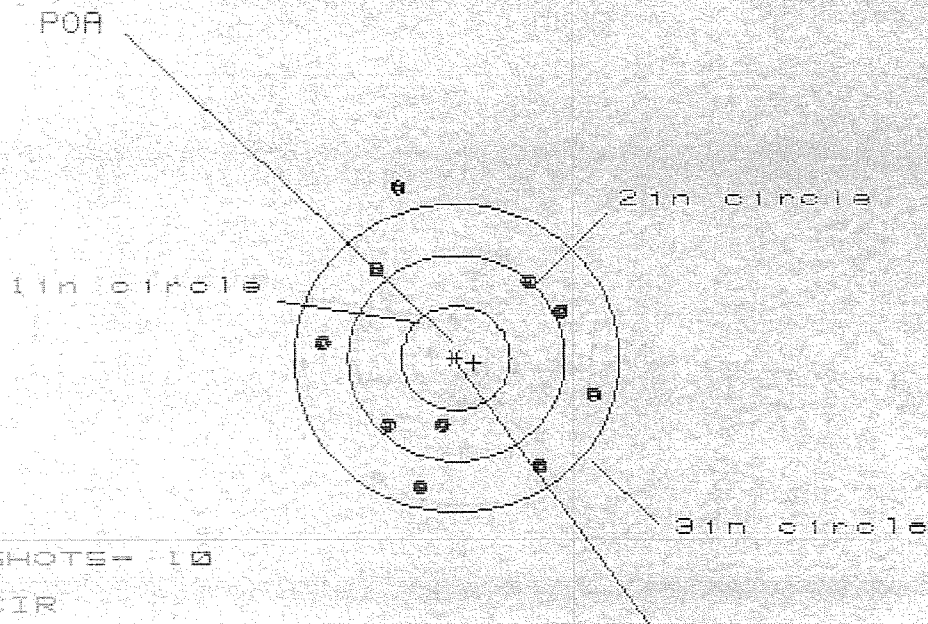
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.034	.911	.556
MINIMUM X	-1.104	-1.068	-.954
MAXIMUM Y	.834	.816	.861
MINIMUM Y	-.959	-.977	-.931
CENTROID X	.021	.144	.030
CENTROID Y	-.089	-.071	-.116
POB TO CENTROID in.	.091	.160	.120
MIN RADIUS	.143	.203	.116
MEAN RADIUS	.755	.700	.661
MAX RADIUS	1.116	1.194	1.117
HORIZONTAL SPREAD	2.138	1.979	1.510
VERTICAL SPREAD	1.793	1.793	1.793
EXTREME SPREAD	2.206	1.986	1.973
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

5 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 2.540

VS= 2.929

GS= 3.029

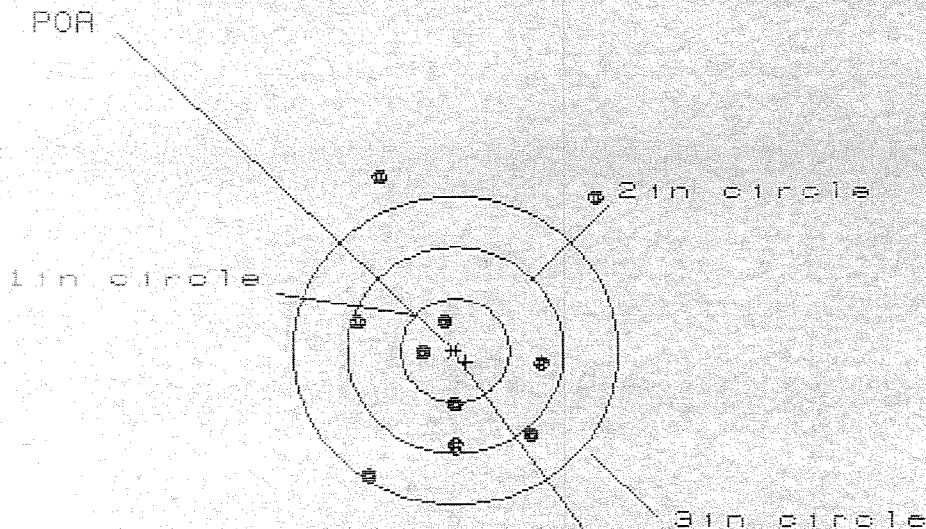
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	1.226	1.071
MINIMUM X	-1.254	-1.314	-1.150
MAXIMUM Y	1.696	1.033	1.010
MINIMUM Y	-1.203	-1.044	-1.067
CENTROID X	-.167	-.107	-.261
CENTROID Y	.046	-.143	-.120
POA TO CENTROID in.	.173	.179	.287
MIN RADIUS	.634	.465	.461
MEAN RADIUS	1.169	1.074	1.042
MAX RADIUS	1.778	1.371	1.253
HORIZONTAL SPREAD	2.540	2.540	2.231
VERTICAL SPREAD	2.929	2.077	2.077
EXTREME SPREAD	3.029	2.604	2.431
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	9	

5 Sep 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.264

VS= 2.847

GS= 3.394

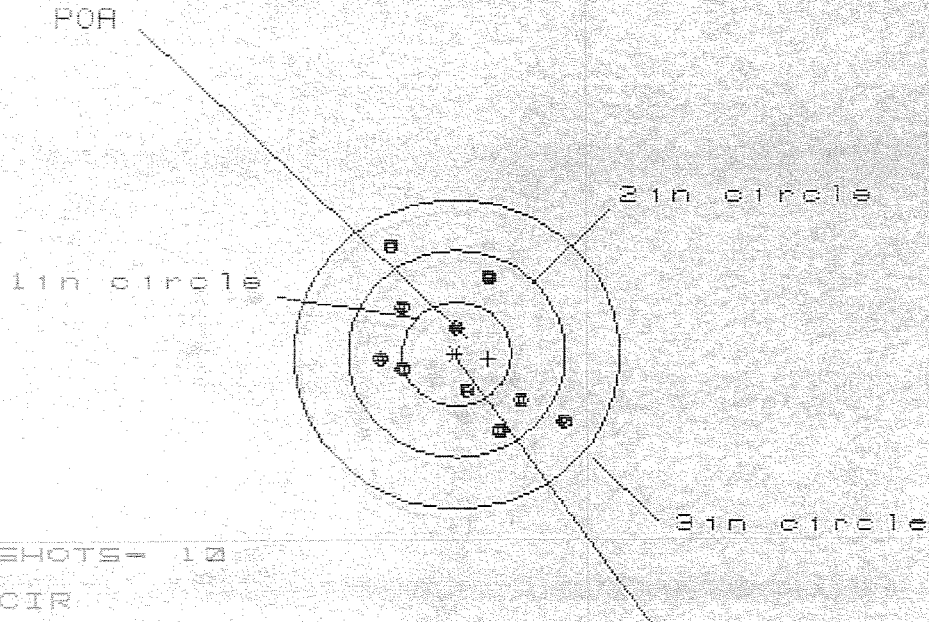
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.332	.988	.914
MINIMUM X	-.932	-.784	-.858
MAXIMUM Y	1.640	1.803	.643
MINIMUM Y	-1.207	-1.044	-.819
CENTROID X	-.098	-.246	-.172
CENTROID Y	.115	-.040	-.274
POA TO CENTROID in.	.151	.251	.323
MIN RADIUS	.279	.225	.144
MEAN RADIUS	1.015	.876	.724
MAX RADIUS	1.981	1.898	1.073
HORIZONTAL SPREAD	2.264	1.772	1.772
VERTICAL SPREAD	2.847	2.847	1.462
EXTREME SPREAD	3.394	2.856	1.973
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.642

VS = 1.870

GS = 2.418

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.985	.914	.611
MINIMUM X	-.657	-.728	-.614
MAXIMUM Y	1.100	.864	.793
MINIMUM Y	-.770	-.648	-.719
CENTROID X	-.296	-.225	-.339
CENTROID Y	.046	-.076	-.005
POA TO CENTROID in.	.299	.237	.339
MIN RADIUS	.247	.209	.302
MEAN RADIUS	.730	.664	.599
MAX RADIUS	1.273	1.076	.864
HORIZONTAL SPREAD	1.642	1.642	1.225
VERTICAL SPREAD	1.870	1.512	1.512
EXTREME SPREAD	2.418	1.827	1.513
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

5 Sep 1990

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.418

VS= 1.785

GS= 2.143

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.478	.373	.391
MINIMUM X	-.940	-.651	-.633
MAXIMUM Y	1.117	1.043	.974
MINIMUM Y	-.668	-.501	-.371
CENTROID X	-.063	.042	.024
CENTROID Y	.046	.120	-.010
POA TO CENTROID in.	.078	.127	.026
MIN RADIUS	.217	.110	.155
MEAN RADIUS	.603	.539	.443
MAX RADIUS	1.153	1.052	1.036
HORIZONTAL SPREAD	1.418	1.024	1.024
VERTICAL SPREAD	1.785	1.544	1.345
EXTREME SPREAD	2.143	1.712	1.646
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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MODEL 700™ H24

SERIAL NO. C6522003

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.

5716 C6522003

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

UPC

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