

C6522305

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522305

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	LS.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/6/90	LB
	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		8/28/90	M

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/28/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	JH
	I) Firing Pin Indent	.023	.0225	.0225			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	AC
	A) Time						9-4-90	AC
	B) Malfunctions						9-4-90	AC
	C) Pierced Primers						9-4-90	AC
	D) Optical Clarity of Scope						9-4-90	AC
645	Inspect for Live Ammo						9-4-90	AC
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.13	2.17	2.25	2.21	2.16	9-5-90	JS
	C) Function						9/6/90	JS
660	Pack						9/20/90	AF

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

SERIAL NO. 06522305DATE 8/28/90TESTER 94

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.33	2.41	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.39	2.33	2.17	
PULL #3	2.28	2.33	2.45	2.25	
PULL #4	2.28	2.41	2.31	2.21	
PULL #5	2.40	2.41	2.30	2.16	
TOTAL	11.86	11.87	11.80	10.92	
AVG.	2.372	2.374	2.36	2.184	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.23		
PULL #2	3.24	3.29		
PULL #3	3.08	3.29		
PULL #4	3.27	3.34		
PULL #5	3.27	3.44		
TOTAL	16.14	16.59		
AVG.	3.228	3.318		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.19		4.20
PULL #2	4.10	4.15		4.24
PULL #3	4.10	4.19		4.24
PULL #4	4.12	4.20		4.27
PULL #5	4.20	4.21		4.18
TOTAL	20.79	20.94		21.14
AVG.	4.158	4.188		4.228

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522305
4 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.3528
1 TO	2	.89559
1 TO	3	.375757
1 TO	4	.238002
1 TO	5	.483344

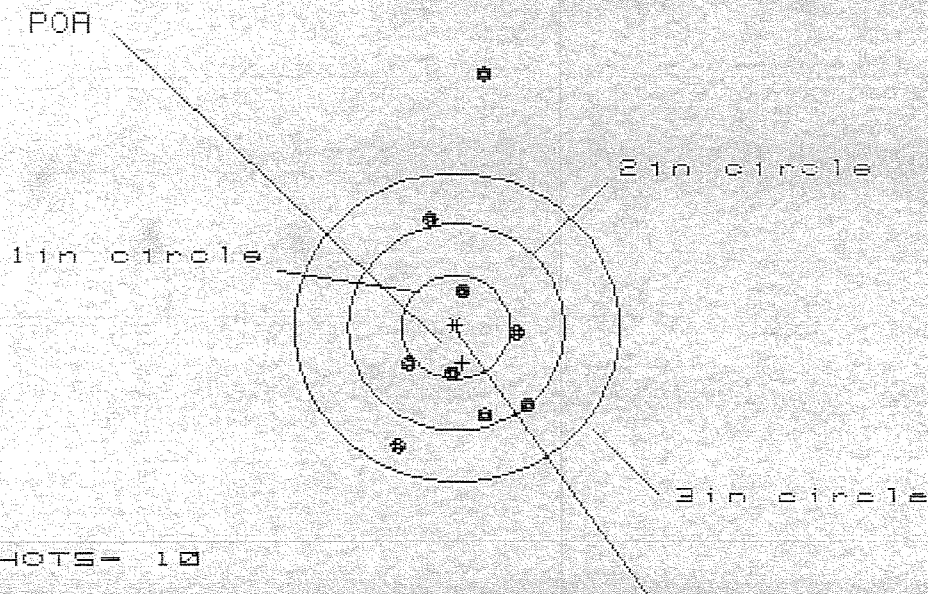
3
2 5 f c----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .36056
THE AMR FOR THIS RIFLE IS: 1.142

4 Sep 1999

FILE:/PATTERNING/CENTERFIRE_PATT/C6522305

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.183

VS= 3.636

GS= 3.721

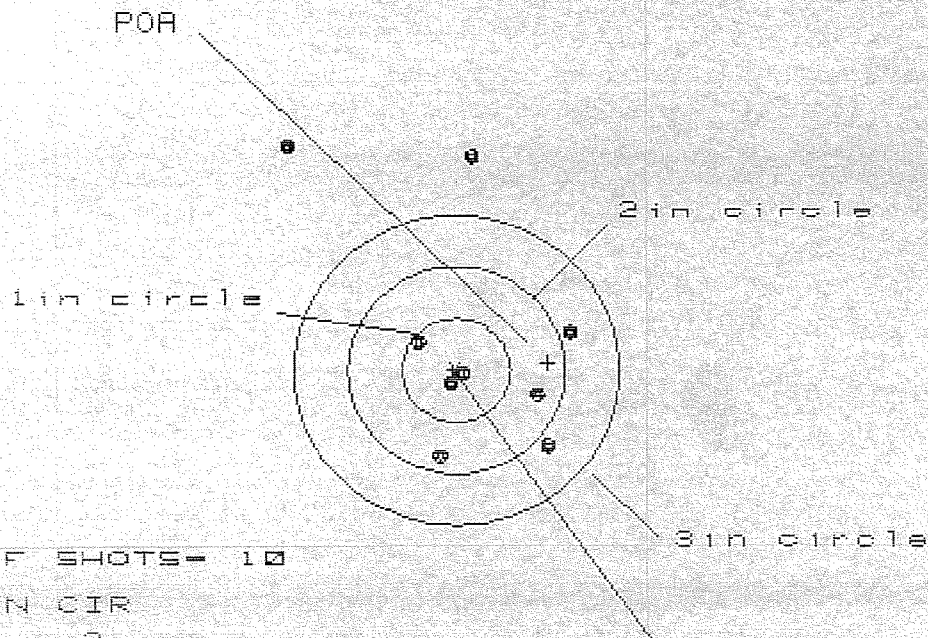
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.625	.651	.584
MINIMUM X	-.558	-.532	-.478
MAXIMUM Y	2.495	1.317	1.209
MINIMUM Y	-1.140	-.863	-.703
CENTROID X	-.058	-.084	-.017
CENTROID Y	.348	.071	.179
POA TO CENTROID in.	.353	.110	.180
MIN RADIUS	.383	.139	.261
MEAN RADIUS	.916	.671	.641
MAX RADIUS	2.506	1.334	1.241
HORIZONTAL SPREAD	1.183	1.183	1.062
VERTICAL SPREAD	3.636	2.180	1.912
EXTREME SPREAD	3.721	2.203	2.005
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

4 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.634

VS= 5.065

GS= 5.132

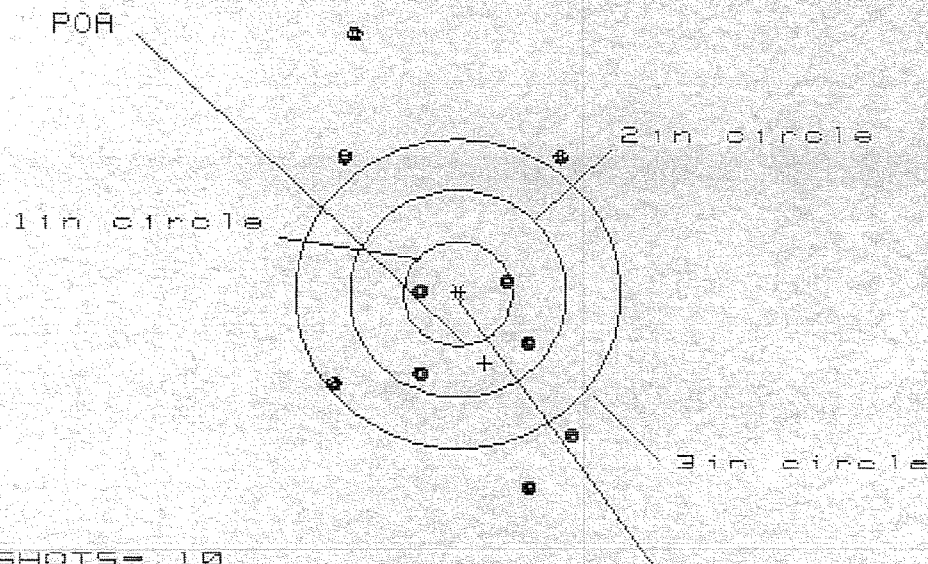
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.957	.747
MINIMUM X	:	-1.592	-1.677	-.614
MAXIMUM Y	:	2.151	1.827	1.994
MINIMUM Y	:	-2.914	-1.176	-.947
CENTROID X	:	-.849	-.764	-.554
CENTROID Y	:	-.072	.252	.023
POR TO CENTROID in.	:	.852	.804	.555
MIN RADIUS	:	.075	.402	.323
MEAN RADIUS	:	1.224	1.090	.840
MAX RADIUS	:	3.013	2.480	1.998
HORIZONTAL SPREAD	:	2.634	2.634	1.361
VERTICAL SPREAD	:	5.065	3.003	2.941
EXTREME SPREAD	:	5.132	3.801	2.958
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

4 Sep 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.165

VS = 4.402

GS = 4.683

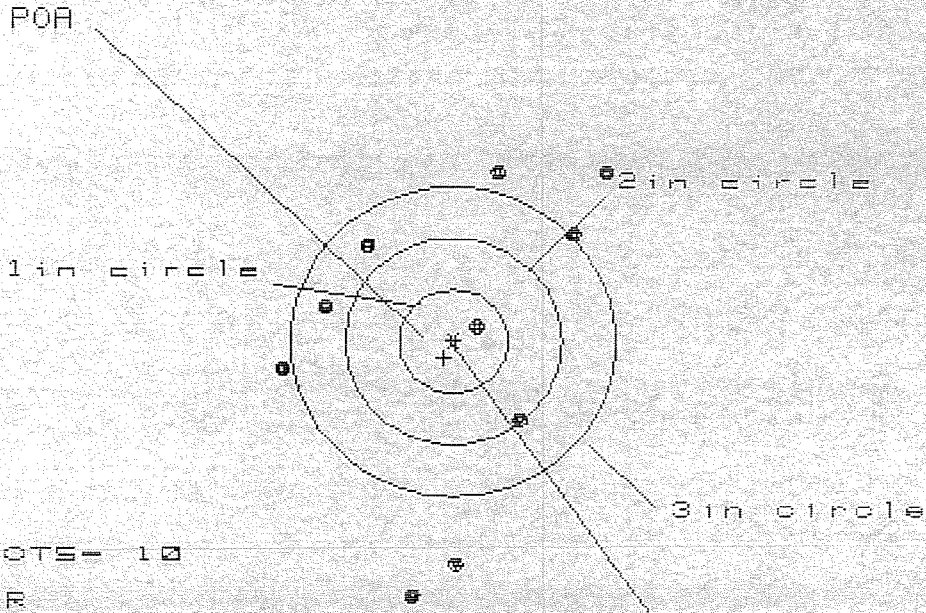
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.001	.896	.964
MINIMUM X	-1.164	-1.269	-1.201
MAXIMUM Y	2.492	1.641	1.437
MINIMUM Y	-1.910	-1.633	-1.269
CENTROID X	-.250	-.145	-.213
CENTROID Y	.671	.394	.598
POA TO CENTROID in.	.716	.420	.635
MIN RADIUS	.332	.513	.374
MEAN RADIUS	1.366	1.185	1.114
MAX RADIUS	2.665	2.002	1.796
HORIZONTAL SPREAD	2.165	2.165	2.165
VERTICAL SPREAD	4.402	3.274	2.706
EXTREME SPREAD	4.683	3.687	3.391
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

4 Sep 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 4

HS = 3.078

VS = 4.048

GS = 4.429

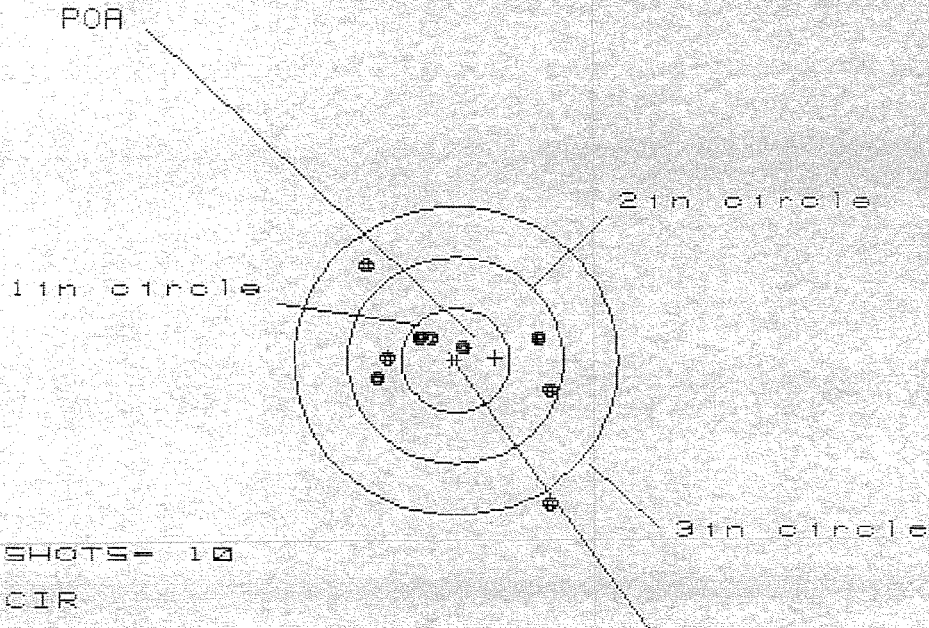
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.457	1.417	1.276
MINIMUM X	:	-1.621	-1.661	-1.483
MAXIMUM Y	:	1.607	1.336	1.502
MINIMUM Y	:	-2.441	-2.409	-2.243
CENTROID X	:	.084	.124	-.053
CENTROID Y	:	.157	.428	.262
POA TO CENTROID in.	:	.178	.446	.267
MIN RADIUS	:	.296	.265	.403
MEAN RADIUS	:	1.534	1.396	1.330
MAX RADIUS	:	2.467	2.409	2.247
HORIZONTAL SPREAD	:	3.078	3.078	2.759
VERTICAL SPREAD	:	4.048	3.745	3.745
EXTREME SPREAD	:	4.429	4.013	3.772
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

4 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522305

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 9

HS = 1.630

VS = 2.260

GS = 2.786

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.913	.827
MINIMUM X	-.787	-.693	-.692
MAXIMUM Y	.928	.781	.167
MINIMUM Y	-1.332	-.431	-.334
CENTROID X	-.369	-.463	-.377
CENTROID Y	-.022	.125	.028
POA TO CENTROID in.	.370	.480	.378
MIN RADIUS	.089	.159	.060
MEAN RADIUS	.668	.538	.473
MAX RADIUS	1.576	1.044	.891
HORIZONTAL SPREAD	1.630	1.606	1.518
VERTICAL SPREAD	2.260	1.212	.501
EXTREME SPREAD	2.786	2.012	1.554
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM M24

SERIAL NO. C6522305

ORDER NO. 5716

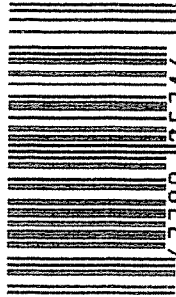
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