

C6522309

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



M-24CONTRACT # DAAA21-87-C-0086GUN SERIAL # C6522309

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	5 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	LS
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel AB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/90	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/10/90	JH
	G) Safety Off Force	2	2	2			8/10/90	JH
	H) Trigger Pull Test & Retainability						8/28/90	JH
	I) Firing Pin Indent	.0225	.0225	.0225			8/10/90	JH
	J) Assemble Stock						8/24/90	RW
	K) Assemble Swivel Studs						8/31/90	JS
	L) Attach Front and Rear Sight Assemblies						8/24/90	RW
	M) Iron Sight Alignment						8/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	RW
	O) Attach Scope to Rifle						8/24/90	WB
	P) Detach & Attach Scope 20 Times						8/24/90	WB
640	Gallery Target & Test						8-24-90	DH
	A) Time						8-24-90	DH
	B) Malfunctions						8-24-90	DH
	C) Pierced Primers						8-24-90	DH
	D) Optical Clarity of Scope						8-24-90	DH
645	Inspect for Live Ammo						8-24-90	DH
655	Final Inspection							
	A) Headspace						8/31/90	JS
	B) Trigger Pull	2.53	2.50	2.53	2.50	2.51	8/30/90	JH
	C) Function						8/31/90	JS
660	Pack						9/20/90	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522309

DATE 8/20/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.32	2.35	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.28	2.40	2.50	
PULL #3	2.35	2.41	2.43	2.53	
PULL #4	2.38	2.40	2.36	2.50	
PULL #5	2.38	2.37	2.40	2.51	
TOTAL	12.04	11.78	11.94	12.57	
AVG.	2.408	2.356	2.388	2.514	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.40		
PULL #2	3.27	3.45		
PULL #3	3.40	3.36		
PULL #4	3.40	3.45		
PULL #5	3.46	3.49		
TOTAL	16.67	17.11		
AVG.	3.334	3.422		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.18		4.27
PULL #2	4.20	4.17		4.25
PULL #3	4.19	4.21		4.25
PULL #4	4.19	4.27		4.23
PULL #5	4.18	4.11		4.15
TOTAL	20.98	20.94		21.15
AVG.	4.196	4.188		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522309
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.209476
1 TO	2	.227379
1 TO	3	.532632
1 TO	4	.0986712
1 TO	5	.178216

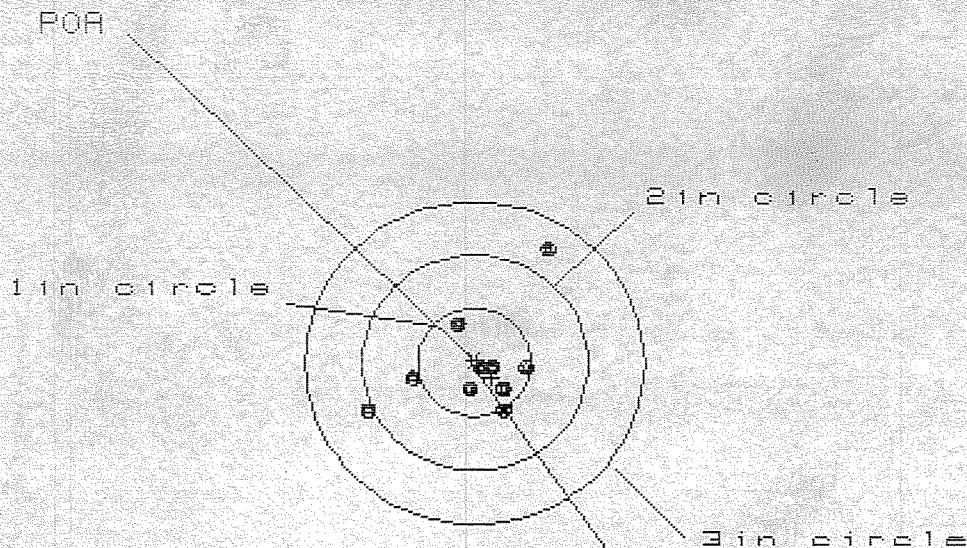
$\bar{x}_g$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .019
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0452
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .049031
THE AMR FOR THIS RIFLE IS: .6894

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522309

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 7

2in = 8

3in = 10

HS= 1.646

VS= 1.513

GS= 2.236

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.663	.526	.412
MINIMUM X	:	-.983	-.909	-.593
MAXIMUM Y	:	1.072	.471	.430
MINIMUM Y	:	-.441	-.321	-.321
CENTROID X	:	-.154	-.228	-.114
CENTROID Y	:	.142	.022	.063
POA TO CENTROID in.	:	.209	.229	.130
MIN RADIUS	:	.030	.079	.074
MEAN RADIUS	:	.489	.408	.306
MAX RADIUS	:	1.261	.964	.598
HORIZONTAL SPREAD	:	1.646	1.435	1.005
VERTICAL SPREAD	:	1.513	.792	.751
EXTREME SPREAD	:	2.236	1.495	1.015
NUMBER IN ONE INCH CIRCLE	=	7		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

24 Aug 1990

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 8

2 in = 9

3 in = 10

HS = 1.979

VS = .935

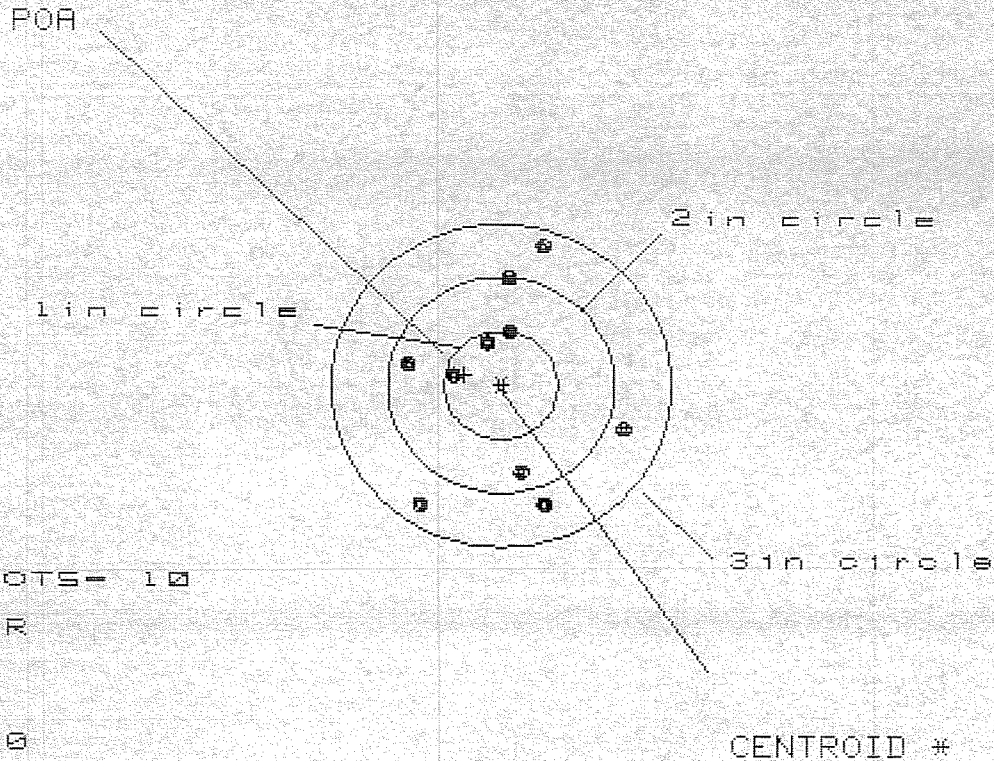
CS = 2.099

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.937	.821	.269
MINIMUM X	:	-1.042	-.364	-.262
MAXIMUM Y	:	.340	.273	.278
MINIMUM Y	:	-.595	-.211	-.206
CENTROID X	:	-.003	.113	.011
CENTROID Y	:	-.028	.039	.034
POA TO CENTROID in.	:	.028	.120	.035
MIN RADIUS	:	.088	.163	.144
MEAN RADIUS	:	.413	.325	.247
MAX RADIUS	:	1.200	.822	.320
HORIZONTAL SPREAD	:	1.979	1.185	.530
VERTICAL SPREAD	:	.935	.484	.484
EXTREME SPREAD	:	2.099	1.207	.603
NUMBER IN ONE INCH CIRCLE	=		8	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 1.850

VS= 2.403

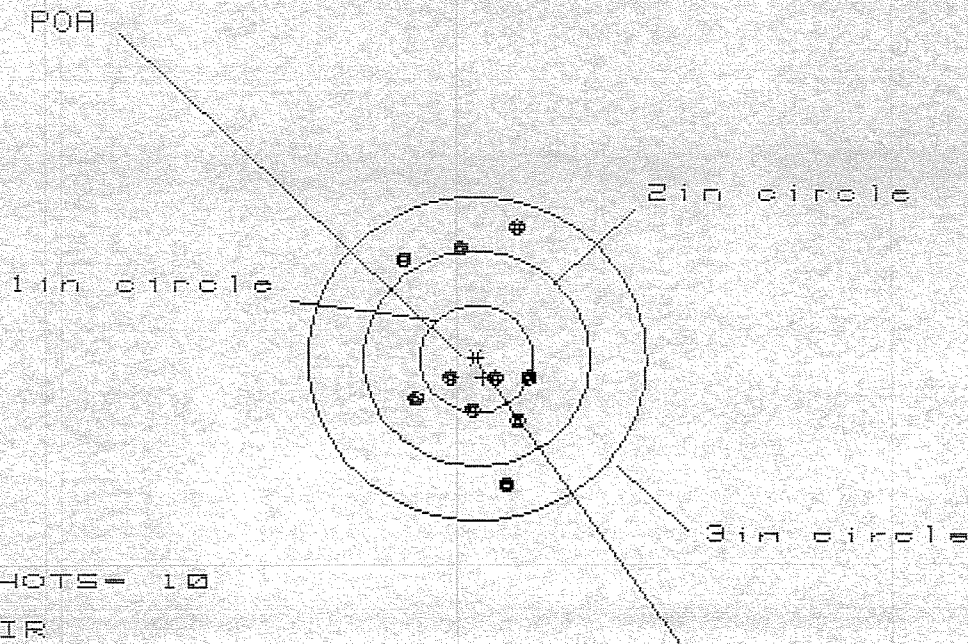
GS= 2.626

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.062	.979	1.010
MINIMUM X	:	-.788	-.871	-.841
MAXIMUM Y	:	1.283	1.160	1.038
MINIMUM Y	:	-1.120	-1.243	-1.099
CENTROID X	:	.322	.405	.374
CENTROID Y	:	-.097	.026	-.118
POA TO CENTROID in.	:	.337	.406	.393
MIN RADIUS	:	.372	.304	.411
MEAN RADIUS	:	.896	.829	.794
MAX RADIUS	:	1.340	1.284	1.153
HORIZONTAL SPREAD	:	1.850	1.850	1.850
VERTICAL SPREAD	:	2.403	2.403	2.137
EXTREME SPREAD	:	2.626	2.404	2.169
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.025

VS= 2.427

GS= 2.431

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.430	.472	.505
MINIMUM X	:	-.595	-.553	-.520
MAXIMUM Y	:	1.222	1.125	.991
MINIMUM Y	:	-1.205	-1.069	-.534
CENTROID X	:	-.060	-.102	-.135
CENTROID Y	:	.172	.036	.170
POA TO CENTROID in.	:	.182	.108	.217
MIN RADIUS	:	.233	.194	.215
MEAN RADIUS	:	.746	.650	.620
MAX RADIUS	:	1.277	1.221	1.087
HORIZONTAL SPREAD	:	1.025	1.025	1.025
VERTICAL SPREAD	:	2.427	2.194	1.525
EXTREME SPREAD	:	2.431	2.309	1.777
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.194

VS = 2.173

GS = 2.285

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	1.116	1.080
MINIMUM X	:	-.998	-.866	-.902
MAXIMUM Y	:	1.073	1.089	.880
MINIMUM Y	:	-1.100	-1.084	-.948
CENTROID X	:	-.010	-.142	-.106
CENTROID Y	:	.037	.021	-.115
POA TO CENTROID in.	:	.038	.144	.157
MIN RADIUS	:	.156	.131	.026
MEAN RADIUS	:	.903	.857	.804
MAX RADIUS	:	1.205	1.167	1.180
HORIZONTAL SPREAD	:	2.194	1.982	1.982
VERTICAL SPREAD	:	2.173	2.173	1.828
EXTREME SPREAD	:	2.285	2.285	2.079
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

Remington®

MODEL 700™ M24

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

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

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

SERIAL NO. C6522309	ORDER NO. 5716
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5716 C6522309

UPC

