

C6498772

DNS

MODEL 700TM M24

Model **SMS**

TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ M24

SERIAL NO.
C6498772

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 C6498772

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498772

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	50	RW
600	Proof	4 12	50	K
607	Check Headspace	4 12	50	K
610	Dis-assemble Gun	4 12	50	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		GL
617	Drill and Tap Sight Holes		4/27/90	FB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4-30-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/14/90	RL

BARBER - M24 0007410		READINGS			DATE	INIT
op. #	OP. NAME					
625 cont.	F) Safety On Force	4	4	4	5/17/90	981
	G) Safety Off Force	2	2	2	5/17/90	981
	H) Trigger Pull Test & Retainability				5/16/90	981
	I) Firing Pin Indent	.023	.023	.023	5/17/90	981
	J) Assemble Stock				5/17/90	RW
	K) Assemble Swivel Studs				25 May 90	98
	L) Attach Front and Rear Sight Assemblies				5/17/90	RW
	M) Iron Sight Alignment				5/17/90	RW
	N) Detach Front & Rear Sights & place in numbered container				5/17/90	RW
	O) Attach Scope to Rifle				5/17/90	981
	P) Detach & Attach Scope 20 Times				5/17/90	981
640	Gallery Target & Test				5-17-90	DH
	A) Time				5-17-90	DH
	B) Malfunctions				5-17-90	DH
	C) Pierced Primers				5-17-90	DH
	D) Optical Clarity of Scope				5-17-90	DH
645	Inspect for Live Ammo				5-17-90	DH
655	Final Inspection					
	A) Headspace				25 May 90	98
	B) Trigger Pull	2.17	2.76	2.27	5/21/90	W.B
	C) Function	2.31	2.31	2.30	2.23	2.30
660	Pack				5-19-90	DH

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

SERIAL NO 06498772DATE 5/16/90TESTER JZ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.23	2.30	237	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.35	2.31	238	
PULL #3	2.51	2.27	2.42	230	
PULL #4	2.42	2.28	2.36	223	
PULL #5	2.54	2.36	2.22	230	
TOTAL	12.35	11.49	11.61		
AVG.	2.47	2.298	2.322		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.21		
PULL #2	3.47	3.21		
PULL #3	3.53	3.17		
PULL #4	3.22	3.19		
PULL #5	3.29	3.17		
TOTAL	16.88	15.95		
AVG.	3.376	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.39		4.38
PULL #2	4.50	4.40		4.39
PULL #3	4.38	4.35		4.34
PULL #4	4.27	4.49		4.32
PULL #5	4.31	4.41		4.37
TOTAL	21.85	22.04		21.78
AVG.	4.37	4.408		4.356

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498772
18 May 1990

CENTROIDAL DISTANCES

0	TO	1	.293319
1	TO	2	.420011
1	TO	3	.21281
1	TO	4	.488807
1	TO	5	.621884

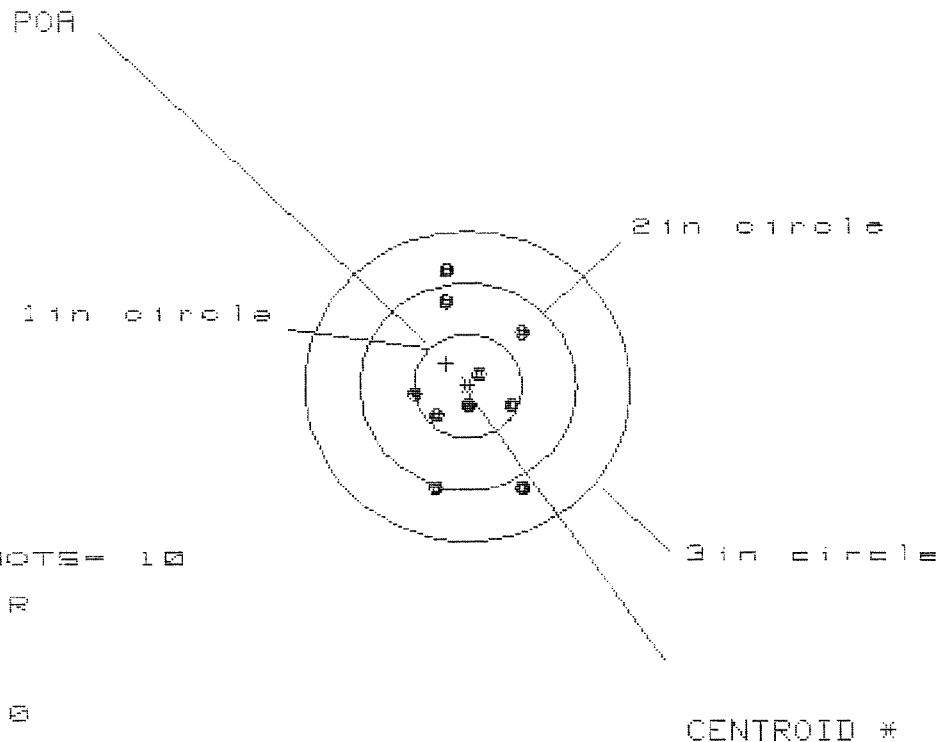
54
213 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0646
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0788429
THE AMR FOR THIS RIFLE IS: .7882

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG436772

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= .860

VS= 2.115

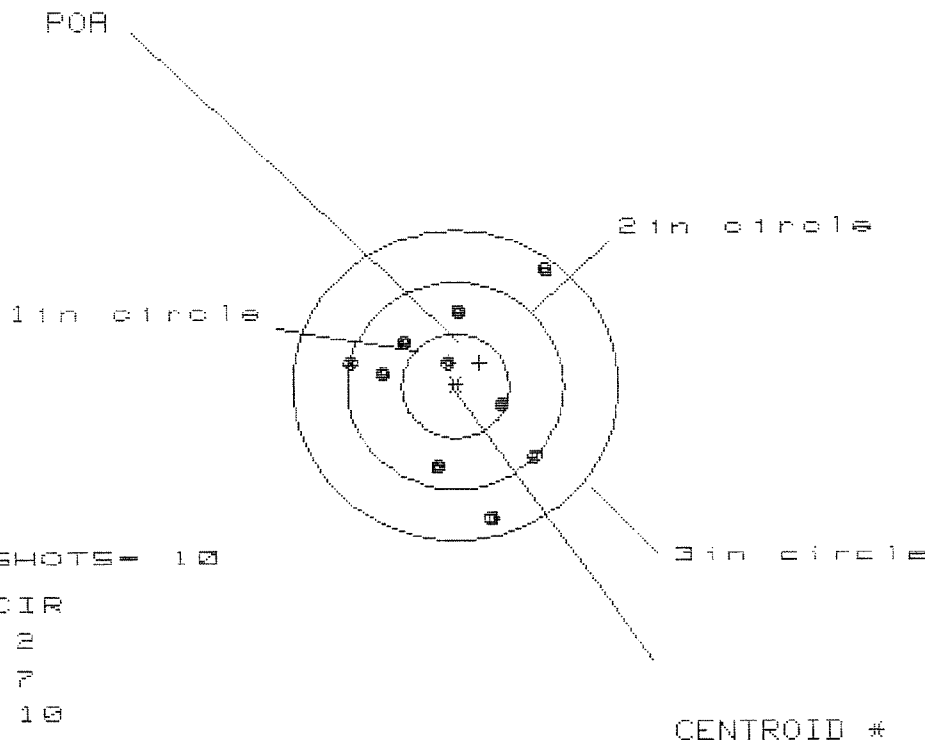
GS= 2.207

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.474	.456	.511
MINIMUM X	-.486	-.504	-.447
MAXIMUM Y	1.142	.980	.874
MINIMUM Y	-.973	-.846	-.932
CENTROID X	.194	.212	.155
CENTROID Y	-.220	-.347	-.241
POA TO CENTROID in.	.293	.406	.286
MIN RADIUS	.177	.085	.102
MEAN RADIUS	.662	.594	.546
MAX RADIUS	1.153	1.007	.963
HORIZONTAL SPREAD	.960	.960	.958
VERTICAL SPREAD	2.115	1.826	1.806
EXTREME SPREAD	2.207	1.951	1.808
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/08498772

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.802

VS = 2.366

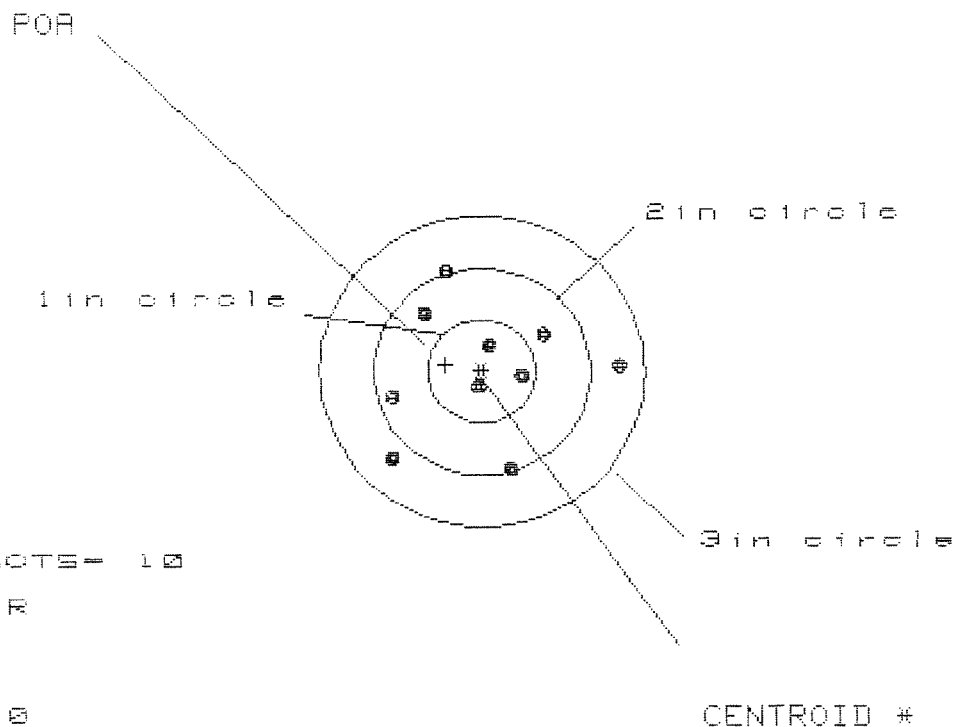
GS = 2.418

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.843	.893
MINIMUM X	:	-.988	-.897	-.847
MAXIMUM Y	:	1.073	.855	.708
MINIMUM Y	:	-1.293	-1.174	-.815
CENTROID X	:	-.226	-.317	-.367
CENTROID Y	:	-.223	-.342	-.195
POA TO CENTROID in.	:	.318	.466	.416
MIN RADIUS	:	.201	.324	.205
MEAN RADIUS	:	.819	.764	.674
MAX RADIUS	:	1.347	1.242	1.108
HORIZONTAL SPREAD	:	1.802	1.740	1.740
VERTICAL SPREAD	:	2.366	2.029	1.523
EXTREME SPREAD	:	2.418	2.044	1.946
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.106

VS= 1.862

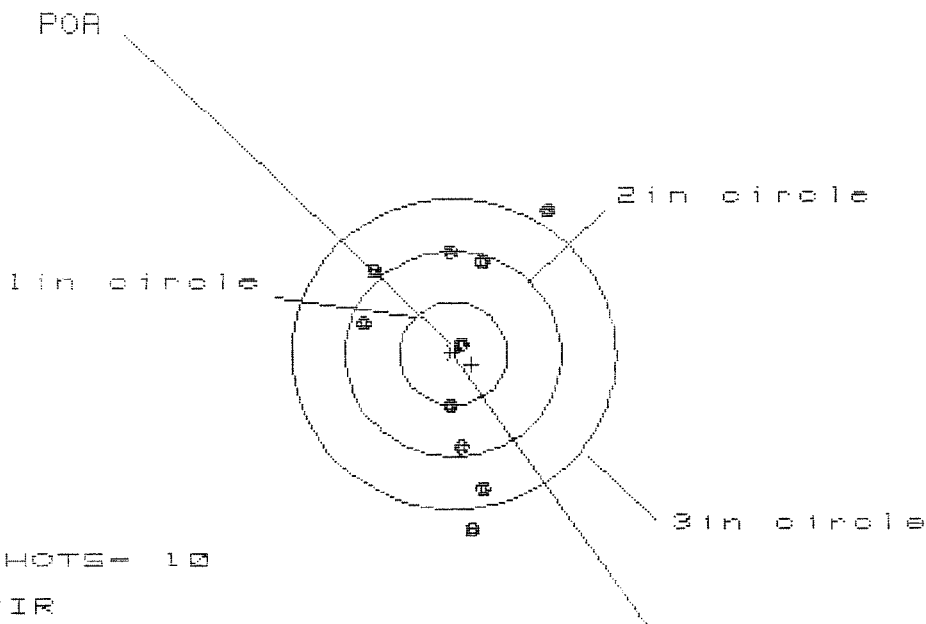
GS= 2.287

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.272	.746	.664
MINIMUM X	-.834	-.693	-.775
MAXIMUM Y	.952	.962	.853
MINIMUM Y	-.910	-.900	-1.009
CENTROID X	.332	.191	.273
CENTROID Y	-.058	-.068	.041
POA TO CENTROID in.	.337	.203	.276
MIN RADIUS	.157	.137	.218
MEAN RADIUS	.756	.699	.631
MAX RADIUS	1.275	1.092	1.076
HORIZONTAL SPREAD	2.106	1.439	1.439
VERTICAL SPREAD	1.862	1.862	1.862
EXTREME SPREAD	2.287	1.983	1.983
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.651

VS= 3.124

GS= 3.190

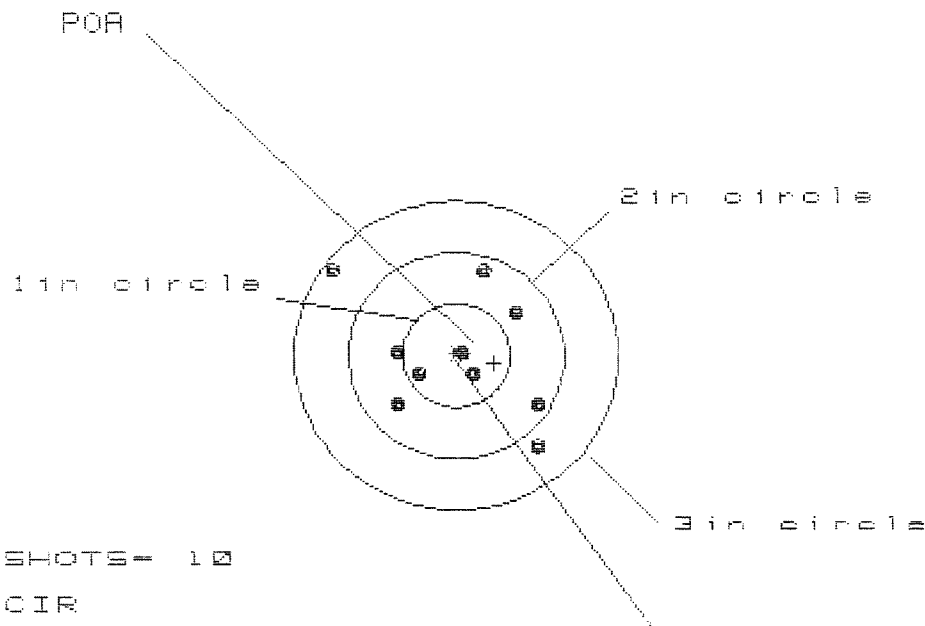
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.861	.884	.416
MINIMUM X	:	-.790	-.767	-.656
MAXIMUM Y	:	1.377	1.183	.930
MINIMUM Y	:	-1.747	-1.498	-1.351
CENTROID X	:	-.172	-.195	-.306
CENTROID Y	:	.104	.298	.151
POA TO CENTROID in.	:	.201	.357	.341
MIN RADIUS	:	.137	.076	.181
MEAN RADIUS	:	1.010	.903	.829
MAX RADIUS	:	1.760	1.521	1.401
HORIZONTAL SPREAD	:	1.651	1.651	1.072
VERTICAL SPREAD	:	3.124	2.681	2.281
EXTREME SPREAD	:	3.190	2.752	2.312
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.886

VS= 1.703

GS= 2.514

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.780	.657	.679
MINIMUM X	-1.106	-.699	-.617
MAXIMUM Y	.847	.937	.841
MINIMUM Y	-.856	-.766	-.505
CENTROID X	-.354	-.231	-.313
CENTROID Y	.074	-.016	.080
POA TO CENTROID in.	.361	.231	.323
MIN RADIUS	.041	.116	.015
MEAN RADIUS	.694	.613	.549
MAX RADIUS	1.369	1.009	.859
HORIZONTAL SPREAD	1.886	1.356	1.296
VERTICAL SPREAD	1.703	1.703	1.346
EXTREME SPREAD	2.514	1.794	1.526
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		