

C6498788

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498788

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	L.S.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8-6-90	TH
	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		8/21/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/21/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/21/90	WB
	H) Trigger Pull Test & Retainability						8/21/90	WB
	I) Firing Pin Indent	.0215	.021	.021			8/21/90	WB
	J) Assemble Stock						8/21/90	RW
	K) Assemble Swivel Studs						8/30/90	JD
	L) Attach Front and Rear Sight Assemblies						8/21/90	RW
	M) Iron Sight Alignment						8/21/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/90	RW
	O) Attach Scope to Rifle						8/21/90	RW
	P) Detach & Attach Scope 20 Times						8/21/90	RW
640	Gallery Target & Test						8/22/90	NF
	A) Time						8/22/90	NF
	B) Malfunctions						8/22/90	NF
	C) Pierced Primers						8/22/90	NF
	D) Optical Clarity of Scope						8/22/90	NF
645	Inspect for Live Ammo						8/22/90	NF
655	Final Inspection							
	A) Headspace						8/30/90	JD
	B) Trigger Pull	2.40	2.44	2.36	2.34	2.34	8/30/90	JD
	C) Function						8/30/90	JD
660	Pack						9/19/90	NF

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

SERIAL NO. C6498788
DATE 8/21/90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.21	2.23	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.14	2.24	2.44	
PULL #3	2.26	2.10	2.24	2.36	
PULL #4	2.24	2.11	2.21	2.34	
PULL #5	2.27	2.10	2.26	2.34	
TOTAL	11.39	10.66	11.18	11.88	
AVG.	2.28	2.13	2.23	2.376	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.10		
PULL #2	3.04	3.07		
PULL #3	3.04	3.04		
PULL #4	3.00	3.04		
PULL #5	3.01	3.04		
TOTAL	15.18	15.29		
AVG.	3.03	3.06		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.09		4.32
PULL #2	4.03	4.03		4.31
PULL #3	4.12	4.01		4.30
PULL #4	4.10	3.99		4.28
PULL #5	4.10	4.02		4.32
TOTAL	20.50	20.14		21.53
AVG.	4.12	4.03		4.31

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498788
23 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.328006
1 TO	2	.197585
1 TO	3	.373269
1 TO	4	.368958
1 TO	5	.269785

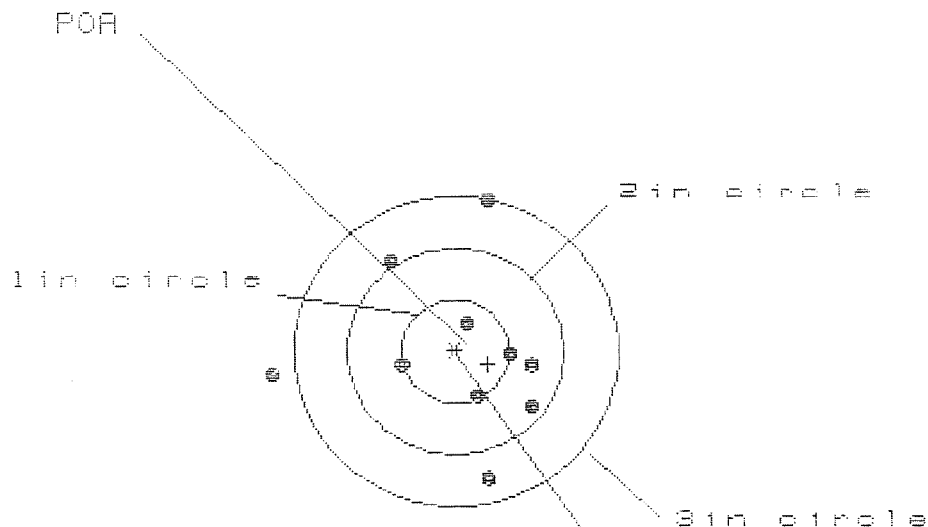
4 ⁵/₂₉ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2676
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .389149
THE AMR FOR THIS RIFLE IS: .8348

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08498788

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.430

VS= 2.724

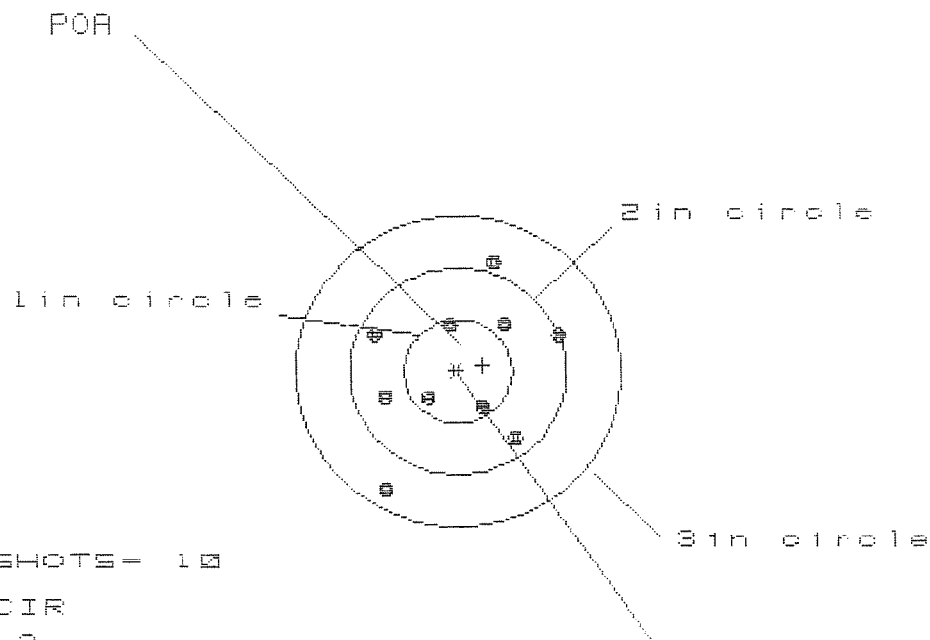
GS= 2.724

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.716	.526	.540
MINIMUM X	-1.714	-.755	-.741
MAXIMUM Y	1.519	1.489	.987
MINIMUM Y	-1.285	-1.235	-1.049
CENTROID X	-.302	-.112	-.126
CENTROID Y	.128	.158	-.028
POA TO CENTROID in.	.328	.194	.129
MIN RADIUS	.280	.216	.260
MEAN RADIUS	.880	.748	.637
MAX RADIUS	1.736	1.493	1.234
HORIZONTAL SPREAD	2.430	1.281	1.281
VERTICAL SPREAD	2.724	2.724	2.036
EXTREME SPREAD	2.724	2.724	2.197
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498788

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.715

VS= 2.186

GS= 2.386

CENTROID #

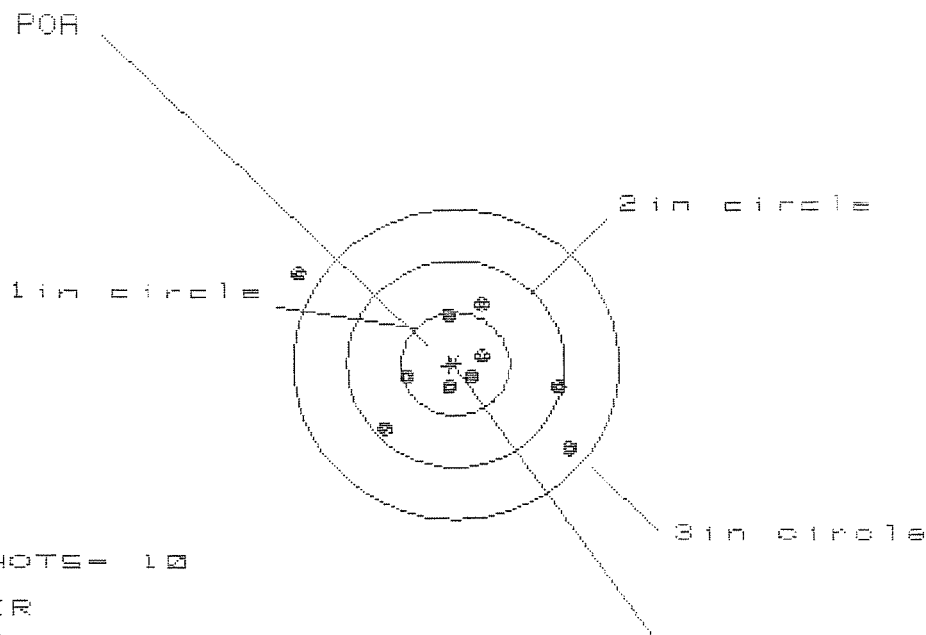
PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.979	.906	.934
MINIMUM X	-.736	-.809	-.781
MAXIMUM Y	1.014	.884	.448
MINIMUM Y	-1.172	-.745	-.635
CENTROID X	-.230	-.157	-.185
CENTROID Y	-.056	.074	-.037
POA TO CENTROID in.	.236	.173	.189
MIN RADIUS	.359	.355	.356
MEAN RADIUS	.750	.677	.638
MAX RADIUS	1.343	.933	.993
HORIZONTAL SPREAD	1.715	1.715	1.715
VERTICAL SPREAD	2.186	1.629	1.082
EXTREME SPREAD	2.386	1.716	1.716
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

29 Aug 1990

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CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 9

HS= 2.517

VS= 1.700

GS= 3.037

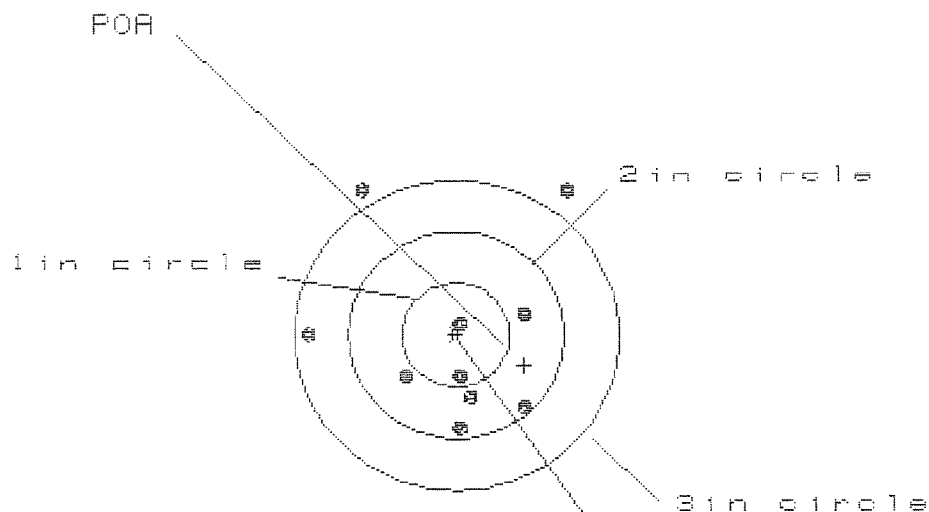
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.058	.896	.847
MINIMUM X	:	-1.459	-.773	-.661
MAXIMUM Y	:	.868	.713	.622
MINIMUM Y	:	-.832	-.736	-.581
CENTROID X	:	.055	.217	.105
CENTROID Y	:	.019	-.077	.015
POA TO CENTROID in.	:	.058	.230	.106
MIN RADIUS	:	.209	.028	.168
MEAN RADIUS	:	.709	.581	.501
MAX RADIUS	:	1.698	1.159	.880
HORIZONTAL SPREAD	:	2.517	1.669	1.508
VERTICAL SPREAD	:	1.700	1.449	1.203
EXTREME SPREAD	:	3.037	1.729	1.562
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.314

VS= 2.311

GS= 2.682

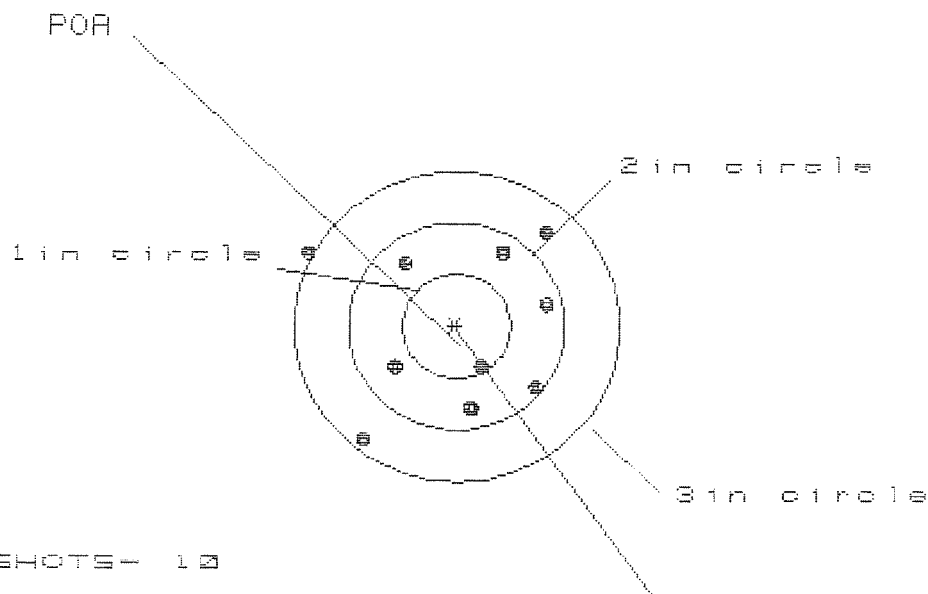
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.992
MINIMUM X	-1.322
MAXIMUM Y	1.385
MINIMUM Y	-.926
CENTROID X	-.631
CENTROID Y	.295
POA TO CENTROID in.	.696
MIN RADIUS	.103
MEAN RADIUS	.894
MAX RADIUS	1.680
HORIZONTAL SPREAD	2.314
VERTICAL SPREAD	2.311
EXTREME SPREAD	2.682
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.241

VS= 2.021

GS= 2.626

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.845
MINIMUM X	-1.396
MAXIMUM Y	.902
MINIMUM Y	-1.119
CENTROID X	-.230
CENTROID Y	.388
POA TO CENTROID in.	.450
MIN RADIUS	.433
MEAN RADIUS	.941
MAX RADIUS	1.575
HORIZONTAL SPREAD	2.241
VERTICAL SPREAD	2.021
EXTREME SPREAD	2.626
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

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

MODEL 700TM H24

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.

SERIAL NO.
 C6498788

ORDER NO.
 5715

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