

C6498873

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498873

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		30	RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	G.S.
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel AB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8-6-90	JA
	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	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			8/28/90	WB
	G) Safety Off Force	2	2	2			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/27/90	gH
	I) Firing Pin Indent	.023	.023	.023			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	RJ
	A) Time						9/4/90	RJ
	B) Malfunctions						9/4/90	RJ
	C) Pierced Primers						9/4/90	RJ
	D) Optical Clarity of Scope						9/4/90	RJ
645	Inspect for Live Ammo						9/4/90	RJ
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.38	2.22	2.21	2.27	2.40	9-5-90	gH
	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. C6498873

DATE 8/27/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.13	2.40	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.28	2.35	2.22	
PULL #3	2.39	2.35	2.26	2.21	
PULL #4	2.22	2.26	2.32	2.27	
PULL #5	2.25	2.32	2.30	2.40	
TOTAL	11.54	11.34	10.63	11.48	
AVG.	2.308	2.268	2.126	2.296	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.34		
PULL #2	3.03	3.27		
PULL #3	3.37	3.12		
PULL #4	3.35	3.22		
PULL #5	3.44	3.27		
TOTAL	15.31	16.22		
AVG.	3.062	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.145		4.44
PULL #2	4.11	4.28		4.36
PULL #3	4.46	4.46		4.33
PULL #4	4.34	4.16		4.09
PULL #5	4.37	4.10		4.23
TOTAL	21.42	21.35		21.45
AVG.	4.284	4.27		4.29

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498873
5 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.369283
1 TO	2	.24168
1 TO	3	.391155
1 TO	4	.490734
1 TO	5	.525115

$\bar{x}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0436
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0514
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0674012

THE AMR FOR THIS RIFLE IS: 1.053

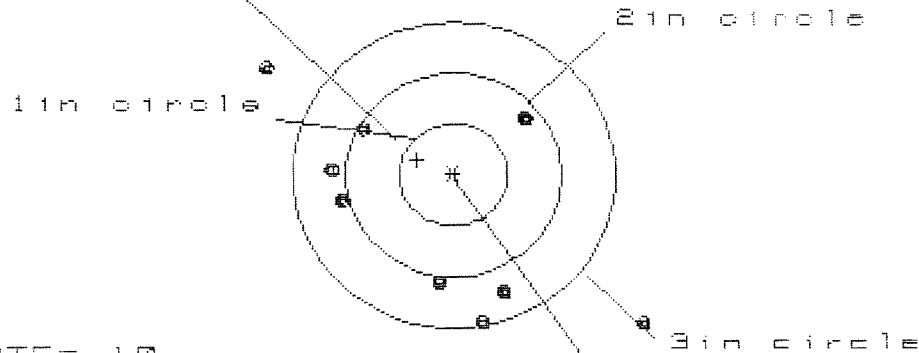
5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498873

CENTERFIRE PATTERNS

1

POR



OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 7

HS = 3.557

VS = 4.743

GS = 4.975

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.808	1.919	1.083
MINIMUM X	-1.749	-1.548	-1.308
MAXIMUM Y	3.312	1.407	1.274
MINIMUM Y	-1.431	-1.063	-1.188
CENTROID X	.337	.136	-.103
CENTROID Y	-.151	-.519	-.387
POR TO CENTROID in.	.370	.537	.400
MIN RADIUS	.877	.711	.593
MEAN RADIUS	1.582	1.255	1.102
MAX RADIUS	3.774	2.193	1.827
HORIZONTAL SPREAD	3.557	3.467	2.392
VERTICAL SPREAD	4.743	2.470	2.463
EXTREME SPREAD	4.975	4.257	3.193
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		7	

5 Sep 1998

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 1.725

VS= 3.025

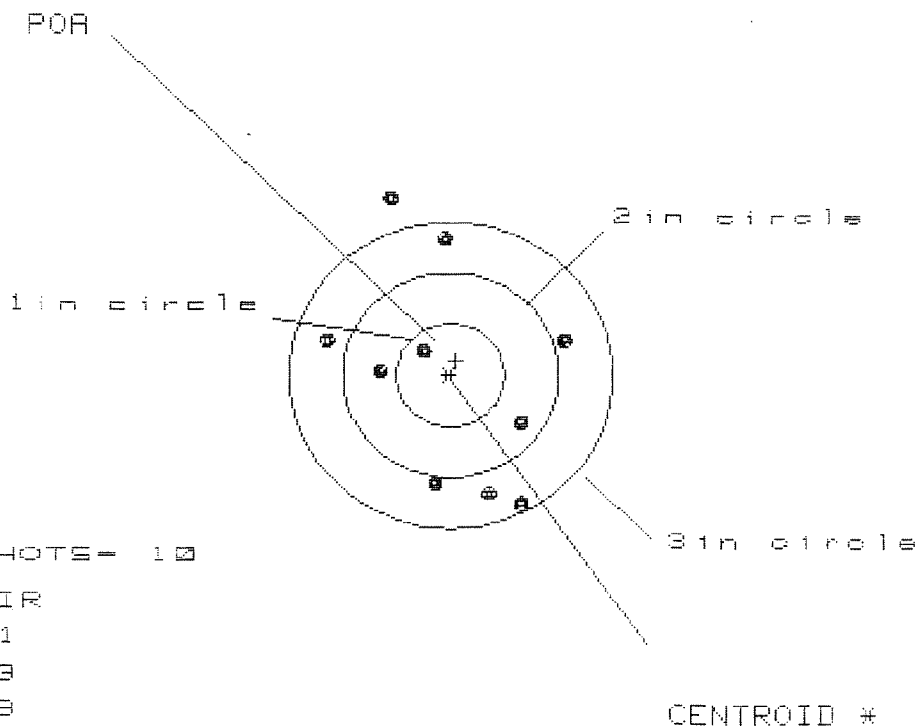
GS= 3.038

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.989	.827
MINIMUM X	:	-.808	-.736	-.613
MAXIMUM Y	:	1.720	.845	.706
MINIMUM Y	:	-1.305	-1.114	-.756
CENTROID X	:	.132	.060	-.063
CENTROID Y	:	-.023	-.214	-.075
POA TO CENTROID in.	:	.133	.222	.098
MIN RADIUS	:	.225	.317	.412
MEAN RADIUS	:	.867	.748	.632
MAX RADIUS	:	1.835	1.489	.893
HORIZONTAL SPREAD	:	1.725	1.725	1.440
VERTICAL SPREAD	:	3.025	1.959	1.462
EXTREME SPREAD	:	3.038	2.290	1.510
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Sep 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.147

VS= 3.017

GS= 3.226

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	.992	1.063
MINIMUM X	:	-1.098	-1.155	-1.083
MAXIMUM Y	:	1.739	1.505	1.369
MINIMUM Y	:	-1.278	-1.084	-1.130
CENTROID X	:	-.054	.003	-.068
CENTROID Y	:	-.140	-.334	-.198
POR TO CENTROID in.	:	.150	.334	.210
MIN RADIUS	:	.311	.491	.341
MEAN RADIUS	:	1.084	.990	.948
MAX RADIUS	:	1.813	1.510	1.370
HORIZONTAL SPREAD	:	2.147	2.147	2.147
VERTICAL SPREAD	:	3.017	2.589	2.499
EXTREME SPREAD	:	3.226	2.682	2.535
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

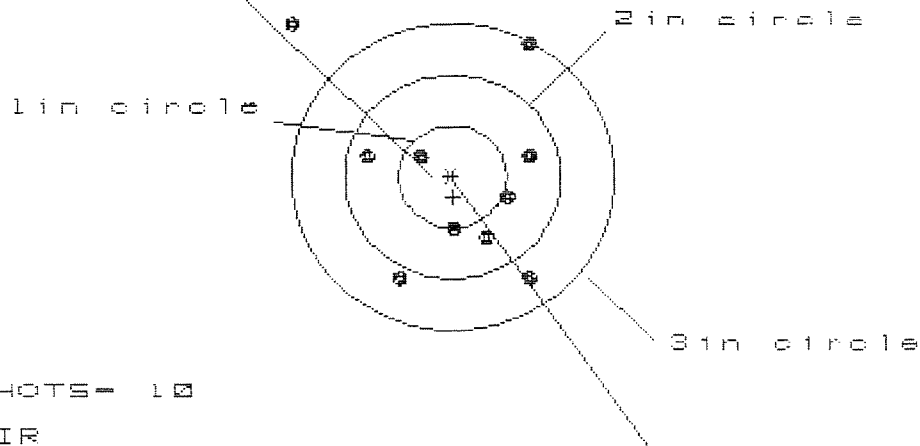
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.212

VS= 2.506

GS= 3.340

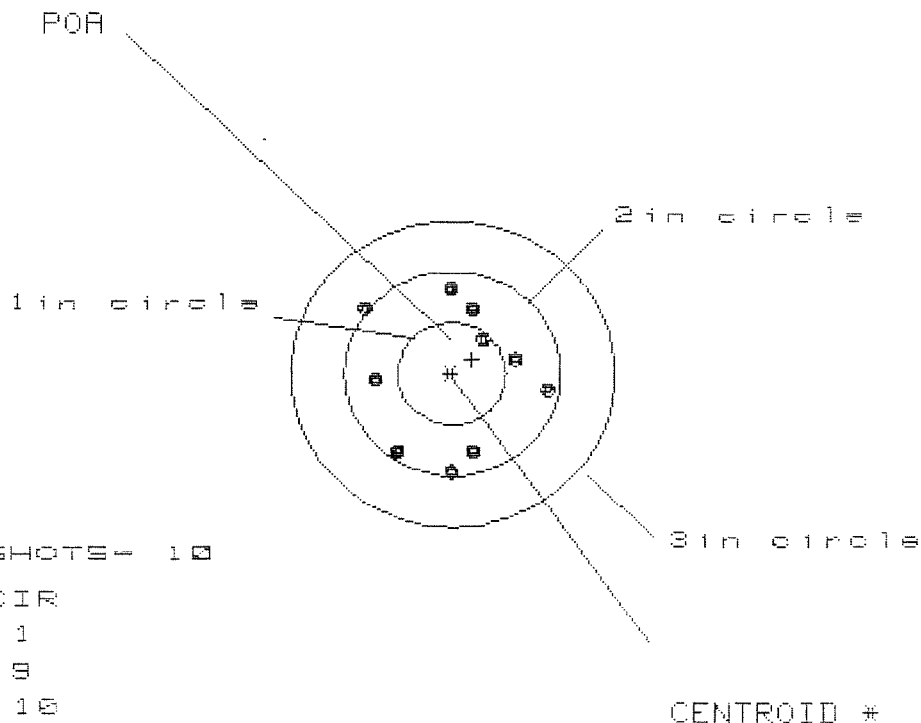
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.745	.582	.651
MINIMUM X	:	-1.467	-.934	-.861
MAXIMUM Y	:	1.460	1.501	.577
MINIMUM Y	:	-1.046	-.884	-.696
CENTROID X	:	-.009	.154	.081
CENTROID Y	:	.197	.035	-.153
POA TO CENTROID in.	:	.197	.157	.173
MIN RADIUS	:	.329	.320	.120
MEAN RADIUS	:	.960	.795	.662
MAX RADIUS	:	2.069	1.610	1.002
HORIZONTAL SPREAD	:	2.212	1.516	1.512
VERTICAL SPREAD	:	2.506	2.385	1.273
EXTREME SPREAD	:	3.340	2.693	1.935
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

1 in = 1

2 in = 9

3 in = 10

HS = 1.584

VS = 1.784

GS = 1.879

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.750	.739
MINIMUM X	-.841	-.828	-.839
MAXIMUM Y	.790	.866	.761
MINIMUM Y	-.914	-.838	-.771
CENTROID X	-.188	-.095	-.084
CENTROID Y	-.140	-.216	-.111
POA TO CENTROID in.	.234	.236	.139
MIN RADIUS	.404	.418	.320
MEAN RADIUS	.770	.724	.693
MAX RADIUS	1.084	.880	.968
HORIZONTAL SPREAD	1.684	1.578	1.578
VERTICAL SPREAD	1.784	1.784	1.532
EXTREME SPREAD	1.879	1.705	1.591
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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

MODEL 700™ M24

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

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

SERIAL NO.
C6498873

ORDER NO.
5716

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

Q1

