

66225265

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225265*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY <i>2</i>	<i>26</i>	<i>FB</i>
600	PROOF	<i>29</i>	<i>Ru</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>p/c.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>p/c.</i>
620	COATING	<i>8/11/88</i>	<i>ISA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225265

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/26/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/26/88	RW
	C) Inspect Ejector Hole for Chamfer		8/26/88	RW

OVER

C6225265

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/26/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		26 Aug 88	W.B. + J.S.
	F) Safety on Force	5.25 5.25 5	26 Aug 88	W.B. + J.S.
	G) Safety off Force	3.25 3.25 3	26 Aug 88	W.B. + J.S.
	H) Trigger Pull Test & Retainability		26 Aug 88	W.B. + J.S.
	I) Firing Pin Indent	.023 .0225 .023	26 Aug 88	W.B. + J.S.
	J) Assemble Stock		9/27/88	RW
	K) Assemble Swivel Studs		10-12-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/27/88	RW
	M) Iron Sight Alignment		9/27/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/27/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/7/88	J.C.
640	Gallery Target & Test	60 R 95L	10-8-88	J.E.S.
	A) Optical Clarity of Scope		10-8-88	J.E.S.
645	Inspect for Live Ammo		10-8-88	J.E.S.
655	Final Inspection			
	A) Headspace		10-12-88	J.S.
	B) Trigger Pull		10-14-88	J.S.
	C) Function		10-12-88	J.S.
660	Pack		10-21-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225265

DATE 20 Aug 88

TESTER W.B. #158

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.71	2.30	2.62	MIN. SETTING,
PULL #2	2.73	2.67	2.37	2.65	NO AVG. OF 5
PULL #3	2.83	2.58	2.58	2.65	READINGS ACCEPT-
PULL #4	2.73	2.70	2.39	2.68	ABLE LESS THAN 2#
PULL #5	2.85	2.51	2.51	2.70	
TOTAL	13.76	13.17	12.10	13.30	
AVG.	2.752	2.634	2.42	2.66	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.32		
PULL #2	3.38	3.38		
PULL #3	3.43	3.35		
PULL #4	3.45	3.45		
PULL #5	3.49	3.17		
TOTAL	17.19	16.67		
AVG.	3.438	3.334		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.51		4.19
PULL #2	4.23	4.39		4.22
PULL #3	4.39	4.49		4.26
PULL #4	4.38	4.34		4.21
PULL #5	4.30	4.32		4.24
TOTAL	21.55	22.05		21.12
AVG.	4.31	4.41		4.224

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225265

CENTROIDAL DISTANCES

0	TO	1	.657853
1	TO	2	.732585
1	TO	3	.427814
1	TO	4	.239708
1	TO	5	.910528

+ 1 <----POA
4
5 2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6622
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.5524
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .862354

THE AMR FOR THIS RIFLE IS: .8578

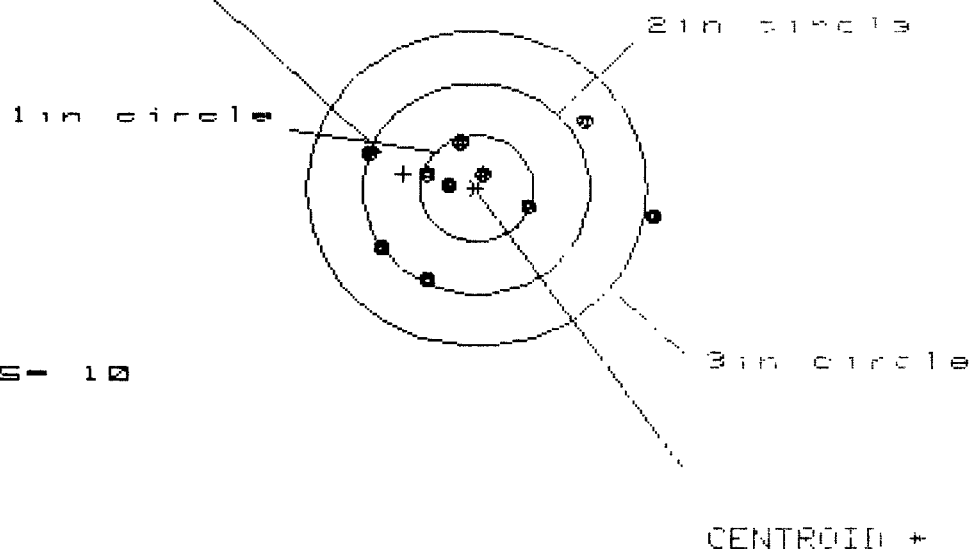
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CENTERFIRE PATTERNS

1

POA



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 8

3 in = 9

HS = 2.430

VS = 1.517

GS = 2.496

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.532	1.084	.769
MINIMUM X	:	-.898	-.728	-.593
MAXIMUM Y	:	.657	.633	.541
MINIMUM Y	:	-.861	-.884	-.805
CENTROID X	:	.643	.473	.338
CENTROID Y	:	-.139	-.115	-.194
POA TO CENTROID in.	:	.658	.487	.389
MIN RADIUS	:	.150	.091	.075
MEAN RADIUS	:	.744	.622	.541
MAX RADIUS	:	1.547	1.255	.825
HORIZONTAL SPREAD	:	2.430	1.812	1.361
VERTICAL SPREAD	:	1.517	1.517	1.346
EXTREME SPREAD	:	2.496	2.120	1.458
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

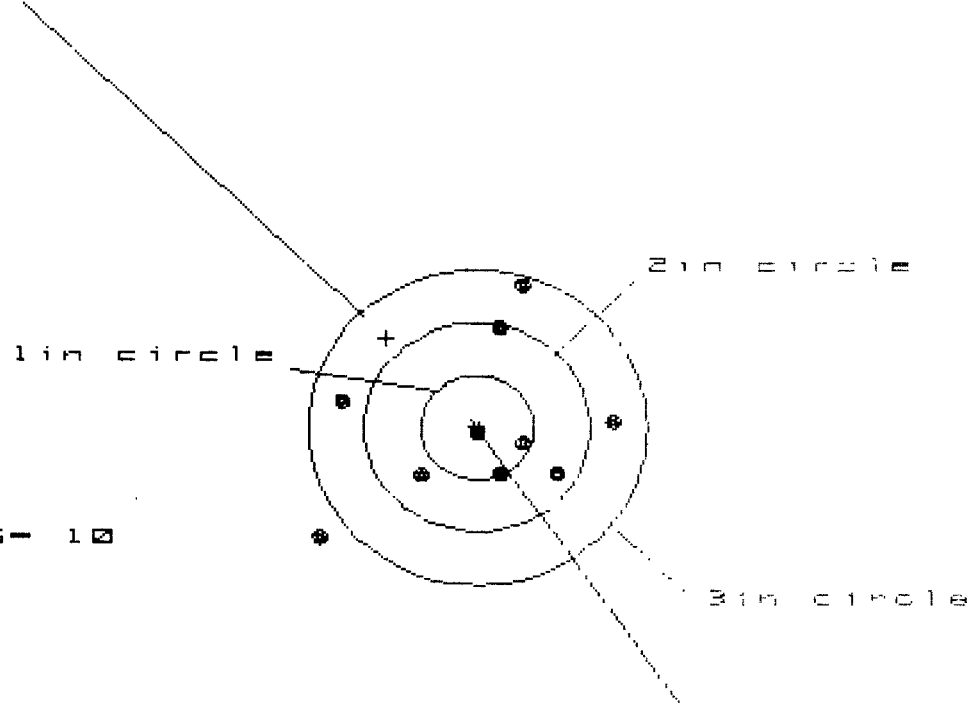
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CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.529

VS= 2.481

GS= 3.066

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.162	1.010	1.045
MINIMUM X	:	-1.367	-1.302	-1.267
MAXIMUM Y	:	1.394	1.274	.962
MINIMUM Y	:	-1.087	-.602	-.443
CENTROID X	:	.798	.950	.915
CENTROID Y	:	-.855	-.735	-.894
POA TO CENTROID in.	:	1.170	1.201	1.279
MIN RADIUS	:	.056	.218	.098
MEAN RADIUS	:	.888	.797	.689
MAX RADIUS	:	1.746	1.306	1.293
HORIZONTAL SPREAD	:	2.529	2.312	2.312
VERTICAL SPREAD	:	2.481	1.876	1.405
EXTREME SPREAD	:	3.066	2.319	2.319
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		9	

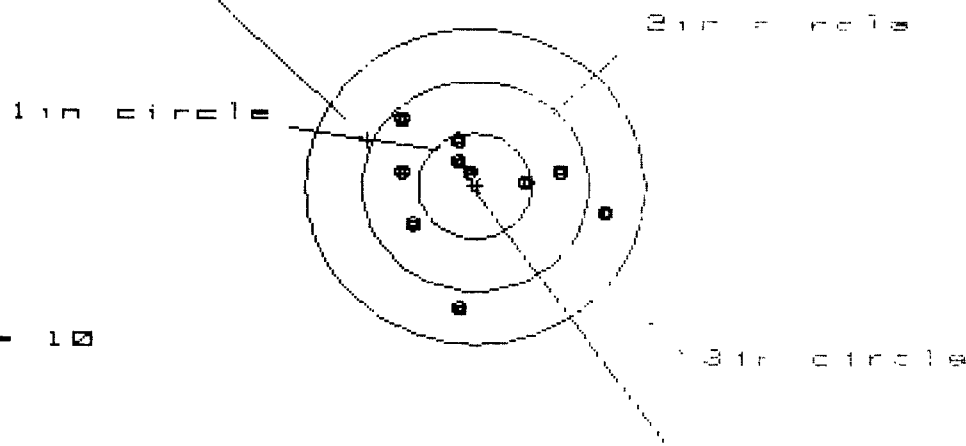
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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.789

VS = 1.740

GS = 2.010

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.102	1.081	.898
MINIMUM X	-.687	-.708	-.573
MAXIMUM Y	.612	.487	.433
MINIMUM Y	-1.128	-.525	-.579
CENTROID X	.948	.969	.834
CENTROID Y	-.439	-.314	-.261
POA TO CENTROID in.	1.045	1.019	.874
MIN RADIUS	.177	.058	.068
MEAN RADIUS	.665	.578	.477
MAX RADIUS	1.144	1.163	.901
HORIZONTAL SPREAD	1.789	1.789	1.471
VERTICAL SPREAD	1.740	1.012	1.012
EXTREME SPREAD	2.010	2.010	1.559
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 1.997

VS= 1.575

GS= 2.414

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.937	.820	.823
MINIMUM X	:	-1.060	-1.044	-.942
MAXIMUM Y	:	.685	.586	.632
MINIMUM Y	:	-.890	-.789	-.743
CENTROID X	:	.685	.802	.700
CENTROID Y	:	-.375	-.276	-.322
POA TO CENTROID in.	:	.780	.848	.770
MIN RADIUS	:	.057	.191	.078
MEAN RADIUS	:	.793	.726	.689
MAX RADIUS	:	1.384	1.071	.961
HORIZONTAL SPREAD	:	1.997	1.864	1.765
VERTICAL SPREAD	:	1.575	1.375	1.375
EXTREME SPREAD	:	2.414	1.959	1.767
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 3

3in = 7

HS = 3.003

VS = 3.029

GS = 3.372

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	1.033	1.129
MINIMUM X	:	-1.527	-1.363	-1.267
MAXIMUM Y	:	1.406	1.305	1.089
MINIMUM Y	:	-1.623	-1.724	-1.254
CENTROID X	:	.237	.073	-.023
CENTROID Y	:	-.954	-.853	-.637
POA TO CENTROID in.	:	.983	.856	.638
MIN RADIUS	:	.333	.202	.120
MEAN RADIUS	:	1.199	1.127	1.013
MAX RADIUS	:	1.734	1.888	1.412
HORIZONTAL SPREAD	:	3.003	2.396	2.396
VERTICAL SPREAD	:	3.029	3.029	2.343
EXTREME SPREAD	:	3.372	3.151	2.557
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	7		

BARBER - M24 ~~0041749~~ **M2400011788**