

C6225293

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington[®]

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225293

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	4 14	89	JB
618	Polish Barrel	4 14	89	BT
620	Apply Coatings (Barrel Action)		4-20-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/8/89	RW
	C) Inspect Ejector Hole for Chamfer		5/8/89	RW
	D) Oil Firing Pin Ass'y		5/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/10/89	WB

op. #	BARBER - M24 0012153 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/10/89	JH
	G) Safety Off Force	3	3	3			5/10/89	JH
	H) Trigger Pull Test & Retainability						5/10/89	WB
	I) Firing Pin Indent	.021	.021	.020			5/10/89	JH
	J) Assemble Stock						5/15/89	RW
	K) Assemble Swivel Studs						17 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/15/89	RW
	M) Iron Sight Alignment						5/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/89	RW
	O) Attach Scope to Rifle						5/15/89	JH
	P) Detach & Attach Scope 20 Times						5/15/89	JH
640	Gallery Target & Test	68 R	84 L				5/16/89	DH
	A) Time						5/16/89	DH
	B) Malfunctions						5/16/89	DH
	C) Pierced Primers						5/16/89	DH
	D) Optical Clarity of Scope						5/16/89	DH
645	Inspect for Live Ammo						5/16/89	DH
655	Final Inspection							
	A) Headspace						17 May 89	JS
	B) Trigger Pull	2.23	2.67	2.58	2.55	2.67	17 May 89	JS
	C) Function						17 May 89	JS
660	Pack						26 June 89	JS

C6225293

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. _____

DATE 5/10/89

TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.46	2.79	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.45	2.74	2.67	
PULL #3	2.42	2.35	2.70	2.58	
PULL #4	2.61	2.58	2.78	2.55	
PULL #5	2.59	2.58	2.66	2.67	
TOTAL	12.66	12.42	13.67	13.20	
AVG.	2.53	2.48	2.73	2.64	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.38		
PULL #2	3.27	3.25		
PULL #3	3.31	3.34		
PULL #4	3.07	3.37		
PULL #5	3.36	3.28		
TOTAL	16.25	16.62		
AVG.	3.25	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.47		4.19
PULL #2	4.42	4.40		4.29
PULL #3	4.54	4.50		4.39
PULL #4	4.27	4.27		4.32
PULL #5	4.48	4.44		4.28
TOTAL	22.08	22.08		21.47
AVG.	4.41	4.41		4.29

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225293
17 May 1989

CENTROIDAL DISTANCES

0 TO	1	.595457
1 TO	2	.172386
1 TO	3	.792235
1 TO	4	.726175
1 TO	5	.239767

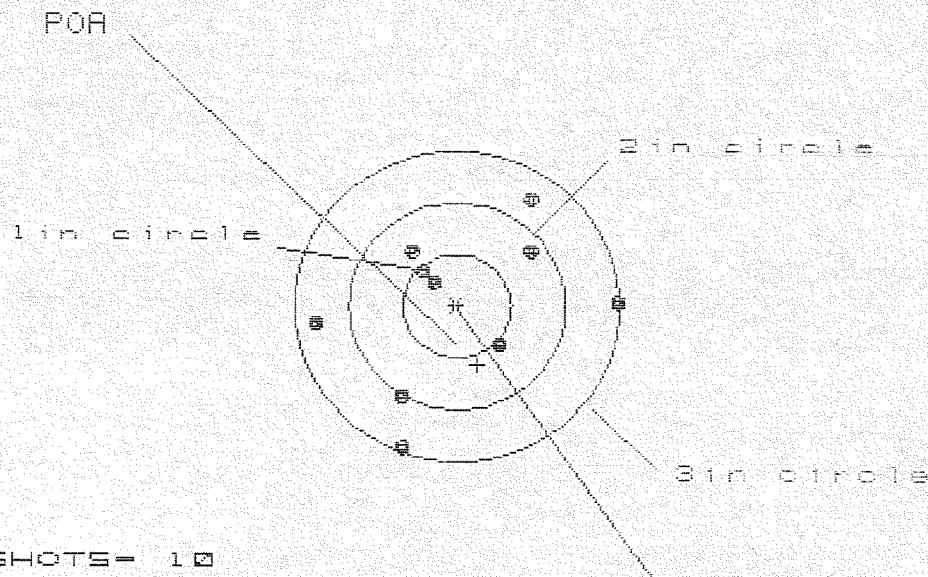
$\frac{1}{34}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0304
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .225855
THE AMR FOR THIS RIFLE IS: .8214

16 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225293

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.731

VS= 2.393

GS= 2.739

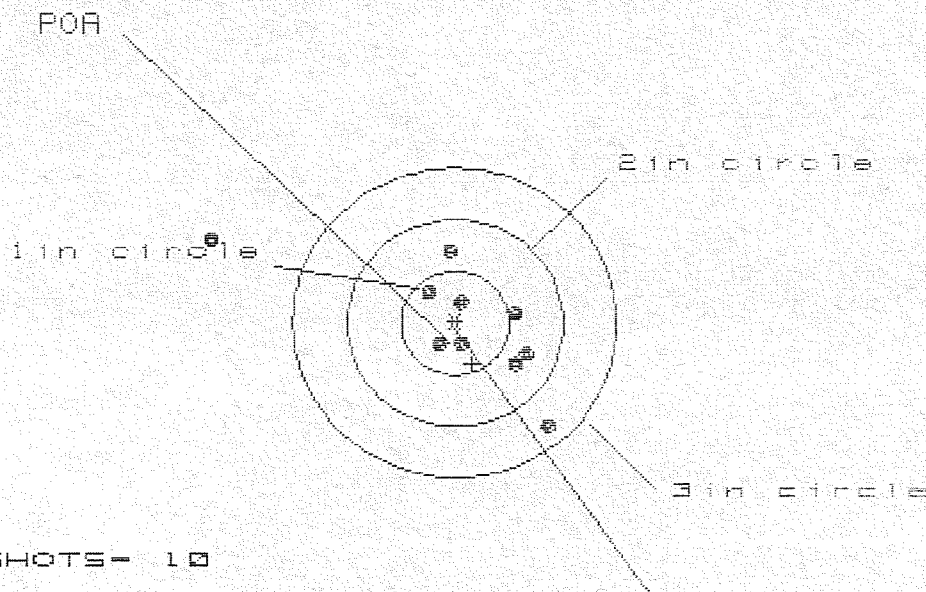
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.453	.876	.834
MINIMUM X	-1.278	-1.116	-1.158
MAXIMUM Y	1.063	1.066	.900
MINIMUM Y	-1.330	-1.327	-1.031
CENTROID X	-.188	-.350	-.308
CENTROID Y	.565	.562	.728
POA TO CENTROID in.	.596	.662	.791
MIN RADIUS	.324	.221	.142
MEAN RADIUS	.935	.857	.759
MAX RADIUS	1.454	1.368	1.208
HORIZONTAL SPREAD	2.731	1.992	1.992
VERTICAL SPREAD	2.393	2.393	1.931
EXTREME SPREAD	2.739	2.652	2.294
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 3.126

VS= 1.811

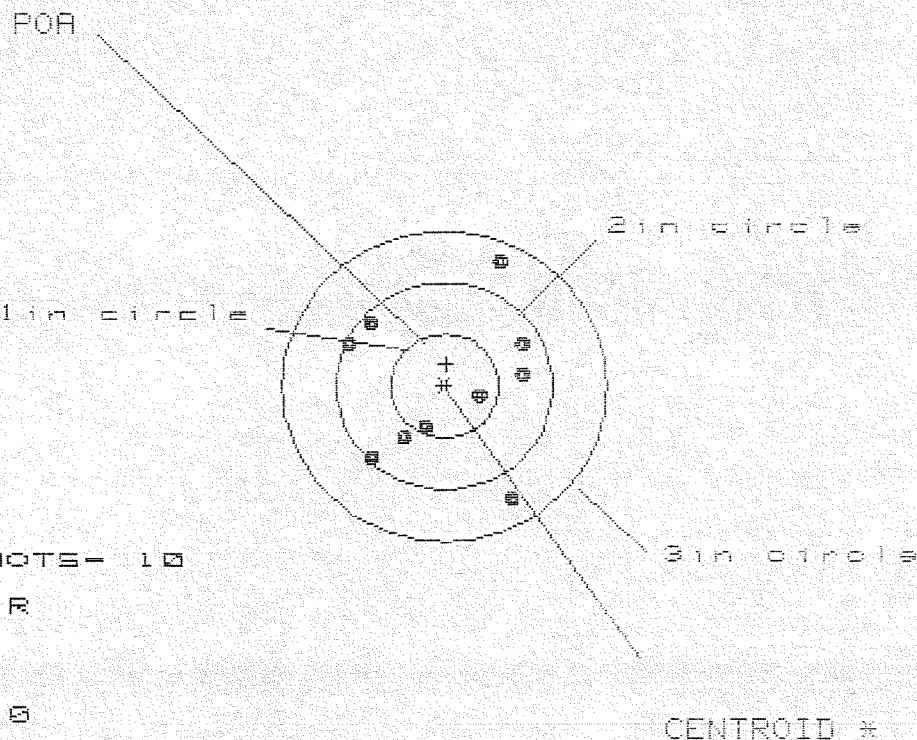
GS= 3.613

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.864	.613	.479
MINIMUM X	:	-2.262	-.450	-.373
MAXIMUM Y	:	.844	.783	.674
MINIMUM Y	:	-.967	-.874	-.459
CENTROID X	:	-.154	.097	.020
CENTROID Y	:	.396	.303	.412
POA TO CENTROID in.	:	.425	.318	.412
MIN RADIUS	:	.225	.283	.262
MEAN RADIUS	:	.749	.543	.464
MAX RADIUS	:	2.414	1.067	.705
HORIZONTAL SPREAD	:	3.126	1.063	.852
VERTICAL SPREAD	:	1.811	1.657	1.133
EXTREME SPREAD	:	3.613	1.883	1.268
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.604

VS= 2.251

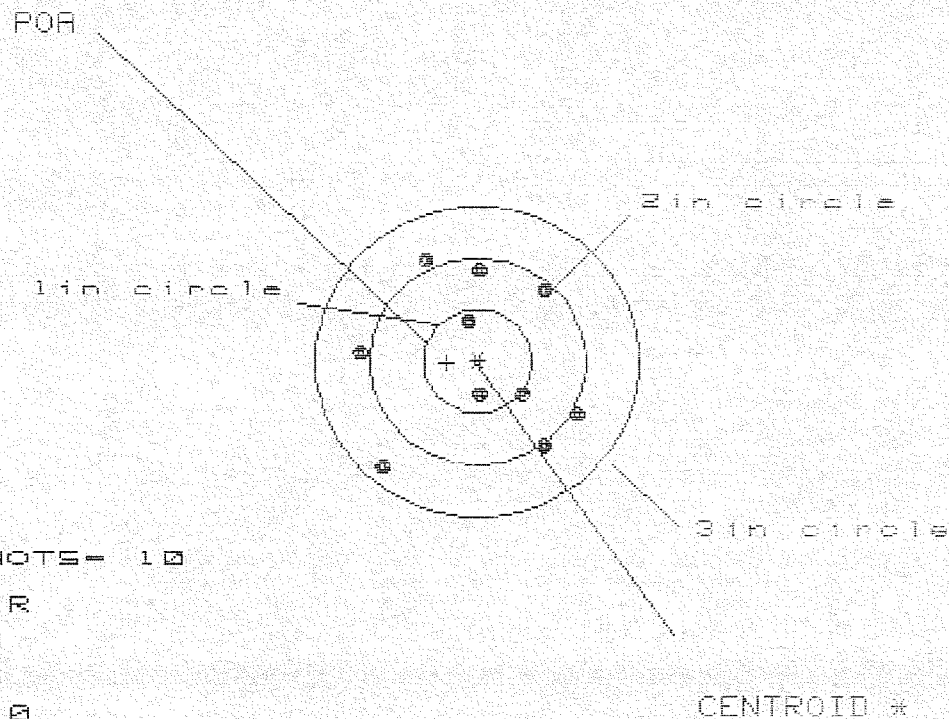
GS= 2.252

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.683	.744	.829
MINIMUM X	-.921	-.860	-.775
MAXIMUM Y	1.185	.750	.633
MINIMUM Y	-1.066	-.934	-.634
CENTROID X	-.019	-.080	-.165
CENTROID Y	-.209	-.341	-.224
POA TO CENTROID in.	.210	.350	.279
MIN RADIUS	.371	.343	.426
MEAN RADIUS	.838	.769	.724
MAX RADIUS	1.306	1.157	.910
HORIZONTAL SPREAD	1.604	1.604	1.604
VERTICAL SPREAD	2.251	1.684	1.267
EXTREME SPREAD	2.252	2.151	1.710
NUMBER IN ONE INCH CIRCLE =	2		
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 = 3

2 in = 5

3 in = 10

HS= 2.047

VS= 1.987

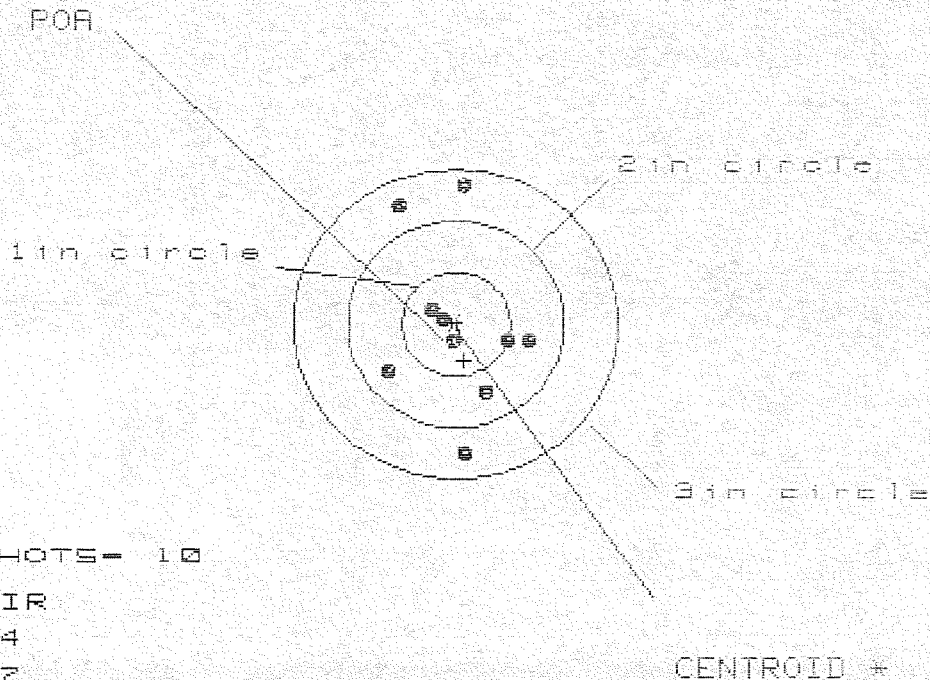
GS= 2.243

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.943	.843	.692
MINIMUM X	:	-1.104	-1.204	-.769
MAXIMUM Y	:	.941	.824	.823
MINIMUM Y	:	-1.046	-.980	-.981
CENTROID X	:	.285	.385	.536
CENTROID Y	:	.014	.131	.192
POA TO CENTROID in.	:	.285	.407	.552
MIN RADIUS	:	.279	.307	.413
MEAN RADIUS	:	.863	.792	.733
MAX RADIUS	:	1.383	1.204	1.126
HORIZONTAL SPREAD	:	2.047	2.047	1.461
VERTICAL SPREAD	:	1.987	1.804	1.804
EXTREME SPREAD	:	2.243	2.150	2.150
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

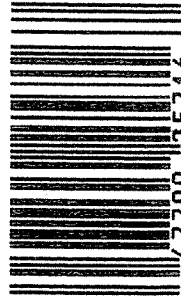
HS = 1.324

VS = 2.674

GS = 2.674

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.667
MINIMUM X	-.657
MAXIMUM Y	1.386
MINIMUM Y	-1.288
CENTROID X	-.076
CENTROID Y	.353
POA TO CENTROID in.	.362
MIN RADIUS	.120
MEAN RADIUS	.722
MAX RADIUS	1.390
HORIZONTAL SPREAD	1.324
VERTICAL SPREAD	2.674
EXTREME SPREAD	2.674
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

55



04770025716117

SERIAL NO.

03052503

ORDER NO.

15

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



5716 06225293