

C6225085

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Small

MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	C6225085		
TEST	DATE	MALFUNCTION/DEFECT		
	1st	Shave Brass		
		Polish		
	2nd	Ejector & chamber edge		
	3rd	Ejector		
	4th	Shot OK		
		FUNCTION		RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6225085

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9 12 88	FB
600	Proof		9 19 88	RW
607	Check Headspace		9 19 88	RW
610	Dis-assemble Gun		9 19 88	RW
612	Magnaflux Barrel Action		9 22 88	P/C
	Magnaflux Bolt		9 22 88	P/C
615	Rollmark Caliber		10/12	WC
617	Drill and Tap Sight Holes		10/12	FB
618	Polish Barrel		10/20	WT
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/15/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/15/88	RW
	C) Inspect Ejector Hole for Chamfer		11/15/88	RW
	D) Oil Firing Pin Ass'y		11/15/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/15/88	RW
			11/15/88	JJ

op. #	OP. NAME	READINGS			DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5	17 Nov 88	JSJ
	G) Safety Off Force	3	3	3	17 Nov 88	JSJ
	H) Trigger Pull Test & Retainability				16 Nov 88	JSJ
	I) Firing Pin Indent	.020	.0205	.0205	17 Nov 88	JSJ
	J) Assemble Stock				11/17/88	RW
	K) Assemble Swivel Studs				5 Dec 88	JSJ
	L) Attach Front and Rear Sight Assemblies				11/29/88	WCB
	M) Iron Sight Alignment				11/29/88	WCB
	N) Detach Front & Rear Sights & place in numbered container				11/29/88	WCB
	O) Attach Scope to Rifle				11/28/88	WCB
	P) Detach & Attach Scope 20 Times				11/28/88	WCB
640	Gallery Target & Test				12/1/88	DH
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope				12/1/88	DH
645	Inspect for Live Ammo				12/1/88	DH
655	Final Inspection					
	A) Headspace				5 Dec 88	JSJ
	B) Trigger Pull	263	263	265	5 Dec 88	JSJ
	C) Function				5 Dec 88	JSJ
660	Pack				12/15/88	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6225
DATE 16 NOV 88
TESTER JSB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.42	2.50	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.41	2.45	2.63	
PULL #3	2.44	2.37	2.39	2.65	
PULL #4	2.26	2.34	2.41	2.65	
PULL #5	2.31	2.27	2.38	2.63	
TOTAL	11.53	11.81	12.13	13.19	
AVG.	2.306	2.332	2.426	2.638	

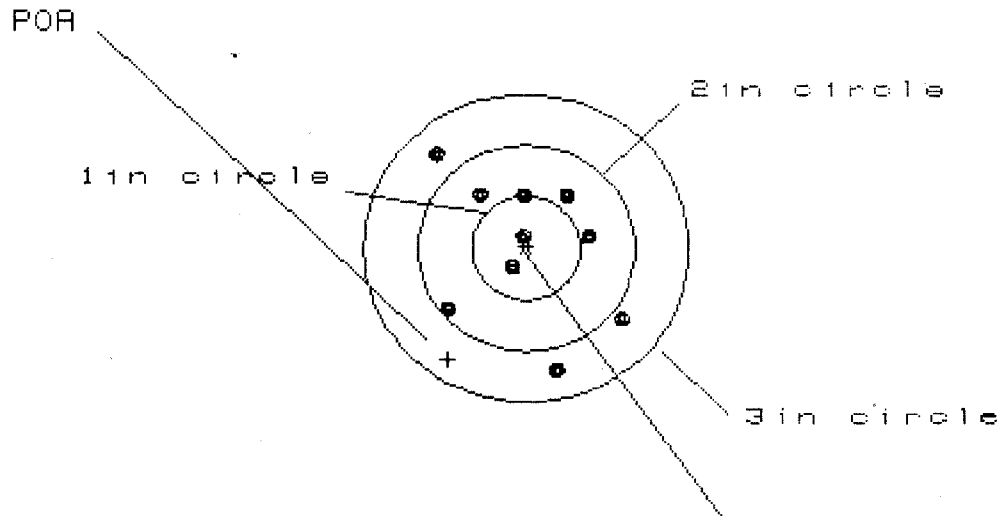
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.34		
PULL #2	3.42	3.51		
PULL #3	3.40	3.50		
PULL #4	3.39	3.48		
PULL #5	3.41	3.53		
TOTAL	16.93	17.36		
AVG.	3.386	3.472		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.05		4.23
PULL #2	4.12	3.97		4.26
PULL #3	4.09	4.18		4.08
PULL #4	3.99	4.20		4.24
PULL #5	3.94	4.11		4.09
TOTAL	20.39	20.51		20.90
AVG.	4.078	4.102		4.18

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225085

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.642

VS= 2.118

GS= 2.382

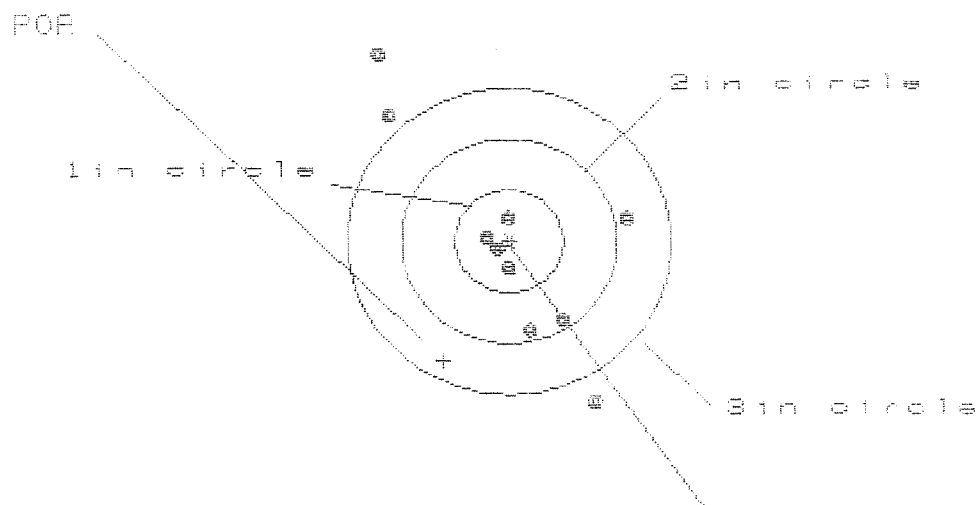
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.837	.748	.772
MINIMUM X	-.805	-.809	-.785
MAXIMUM Y	.939	.665	.530
MINIMUM Y	-1.179	-1.074	-.720
CENTROID X	.726	.815	.791
CENTROID Y	1.082	.977	1.112
POA TO CENTROID in.	1.303	1.273	1.364
MIN RADIUS	.073	.202	.083
MEAN RADIUS	.723	.680	.596
MAX RADIUS	1.237	1.092	1.055
HORIZONTAL SPREAD	1.642	1.557	1.557
VERTICAL SPREAD	2.118	1.739	1.250
EXTREME SPREAD	2.382	1.818	1.736
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

1 Oct 1988

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 7

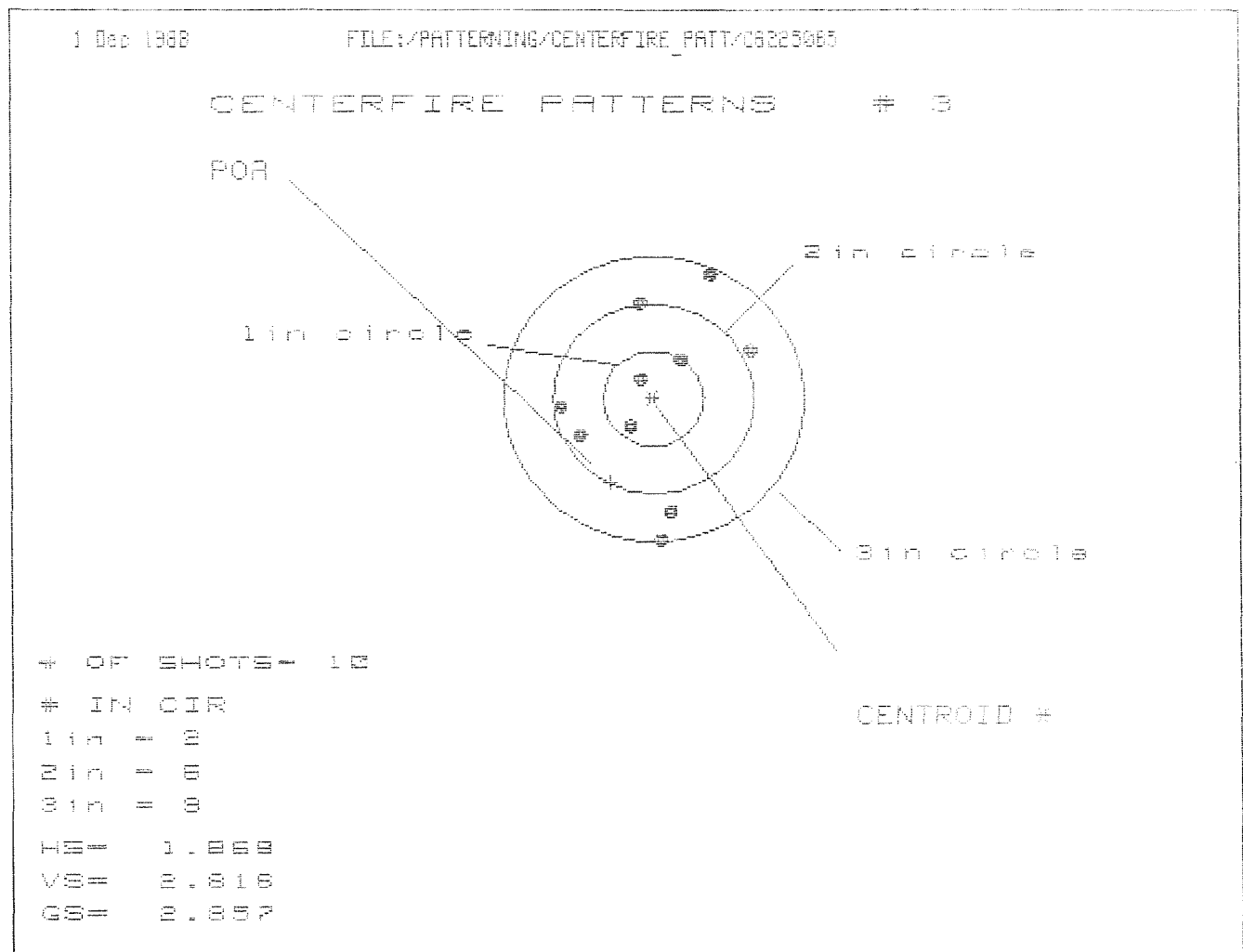
HS = 2.250

VS = 3.450

GS = 4.018

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.915	1.003
MINIMUM X	:	-1.202	-1.223	-1.135
MAXIMUM Y	:	1.060	1.445	1.271
MINIMUM Y	:	-1.600	-1.393	-1.788
CENTROID X	:	.609	.742	.654
CENTROID Y	:	1.168	.961	1.135
POI TO CENTROID in.	:	1.317	1.215	1.318
MIN RADIUS	:	.088	.148	.121
MEAN RADIUS	:	.923	.769	.651
MAX RADIUS	:	2.214	1.893	1.704
HORIZONTAL SPREAD	:	2.250	2.138	2.138
VERTICAL SPREAD	:	3.450	2.838	2.859
EXTREME SPREAD	:	4.018	3.432	2.518
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

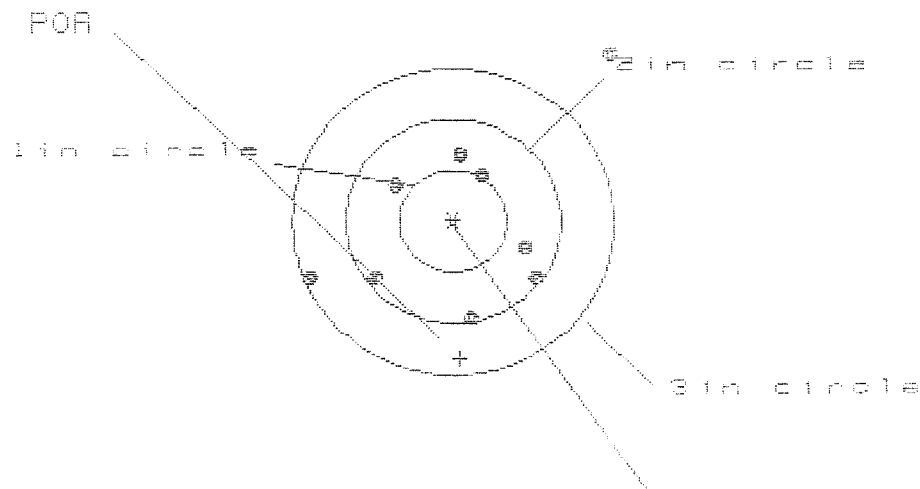


PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	.973	1.050
MINIMUM X	-.908	-.895	-.818
MAXIMUM Y	1.296	1.127	.951
MINIMUM Y	-1.520	-1.318	-1.177
CENTROID X	.429	.416	.339
CENTROID Y	.886	1.055	.914
POA TO CENTROID in.	.984	1.134	.975
MIN RADIUS	.241	.113	.183
MEAN RADIUS	.910	.817	.753
MAX RADIUS	1.525	1.334	1.210
HORIZONTAL SPREAD	1.868	1.868	1.868
VERTICAL SPREAD	2.816	2.445	2.128
EXTREME SPREAD	2.857	2.479	2.154
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

1 Dec 1988

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 0

2 in = 8

3 in = 8

HS= 2.852

VS= 2.596

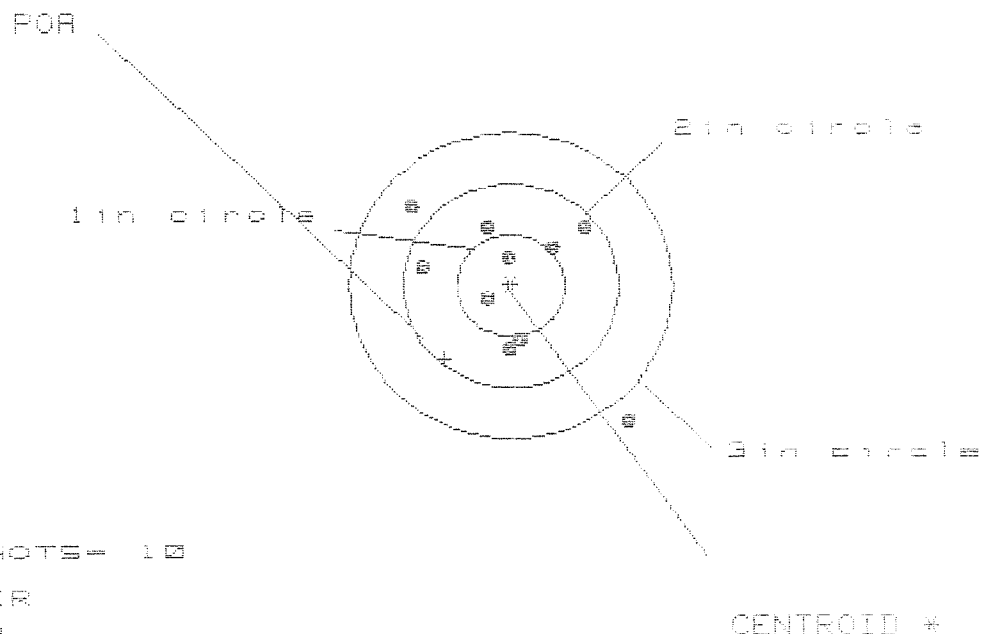
GS= 3.599

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.471	.941	.789
MINIMUM X	:	-1.381	-1.218	-.717
MAXIMUM Y	:	1.688	.882	.842
MINIMUM Y	:	-.908	-.721	-.761
CENTROID X	:	-.067	-.230	-.878
CENTROID Y	:	1.346	1.159	1.199
POA TO CENTROID in.	:	1.348	1.181	1.201
MIN RADIUS	:	.513	.636	.649
MEAN RADIUS	:	.997	.842	.779
MAX RADIUS	:	2.239	1.259	.865
HORIZONTAL SPREAD	:	2.852	2.159	1.506
VERTICAL SPREAD	:	2.596	1.603	1.603
EXTREME SPREAD	:	3.599	2.159	1.611
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Dec 1986

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS= 2.001

VS= 2.084

GS= 2.889

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.090	.788	.689
MINIMUM X	-.911	-.790	-.776
MAXIMUM Y	.738	.589	.488
MINIMUM Y	-1.346	-.758	-.684
CENTROID X	.617	.496	.595
CENTROID Y	.721	.870	.796
POR TO CENTROID in.	.949	1.082	.994
MIN RADIUS	.238	.132	.196
MEAN RADIUS	.740	.601	.552
MAX RADIUS	1.732	.985	.834
HORIZONTAL SPREAD	2.001	1.578	1.465
VERTICAL SPREAD	2.084	1.347	1.172
EXTREME SPREAD	2.889	1.623	1.520
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 9		