

C6225583

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

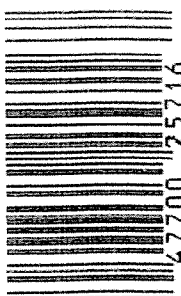
Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] REG. U.S. PAT. & TM. OFF. DUPONT VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.		SERIAL NO. 06225583	ORDER NO. 5716
MODEL 700TM H24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	

LPC



0 47700 25716 7



5716 06225583

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225583

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	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/K.
	Magnaflux Bolt		9 22 88	P/K.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		1/11/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/11/89	RW
	C) Inspect Ejector Hole for Chamfer		1/11/89	RW

OVER

OP. #		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		1/11/89	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		10 Jan 89	JSJ
	F) Safety on Force	5 : 5 : 5	11 Jan 89	JSJ
	G) Safety off Force	3 : 3 : 3	11 Jan 89	JSJ
	H) Trigger Pull Test & Retainability		10 Jan 89	JSJ
	I) Firing Pin Indent	.020 : .020 : .020	11 Jan 89	JSJ
	J) Assemble Stock		1/11/89	RW
	K) Attach Front & Rear Sight Assemblies		1/11/89	RW
	L) Iron Sight Alignment		1/11/89	RW
	M) Detach Front & Rear Sights & place in numbered container		1/11/89	RW
	N) Attach Scope to Rifle		17 Jan 89	JSJ
	O) Detach & Attach Scope 20 times		17 Jan 89	JSJ
640	Gallery Target & Test	52R 98L	1/23/89	DH
	A) Optical Clarity of Scope		1/23/89	DH
645	Inspect for Live Ammo		1/23/89	DH
655	Final Inspection			
	A) Headspace		31 Jan 89	JSJ
	B) Trigger Pull	2.53 : 2.48 : 2.54	2.55 : 2.62	JSJ
	C) Function		31 Jan 89	JSJ
	D) Assemble Swivel Studs		31 Jan 89	JSJ
660	Pack		22 Nov 89	JSJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06225583

DATE 4/3/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.27	2.20	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.18	2.38	
PULL #3	2.48	2.17	2.47	
PULL #4	2.27	2.20	2.48	
PULL #5	2.38	2.15	2.44	
TOTAL	11.76	10.90	12.18	
AVG.	2.35	2.18	2.43	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.22	
PULL #2	3.18	3.30	
PULL #3	3.13	3.10	
PULL #4	3.18	3.12	
PULL #5	3.17	3.14	
TOTAL	15.90	15.88	
AVG.	3.18	3.17	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.35		
PULL #2	4.22	4.10		
PULL #3	4.24	4.25		
PULL #4	4.19	4.16		
PULL #5	4.24	4.29		
TOTAL	21.12	21.15		
AVG.	4.22	4.23		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225583
26 Jan 1989

CENTROIDAL DISTANCES

0 TO	1	.503954
1 TO	2	.699972
1 TO	3	.616319
1 TO	4	.800171
1 TO	5	.716341

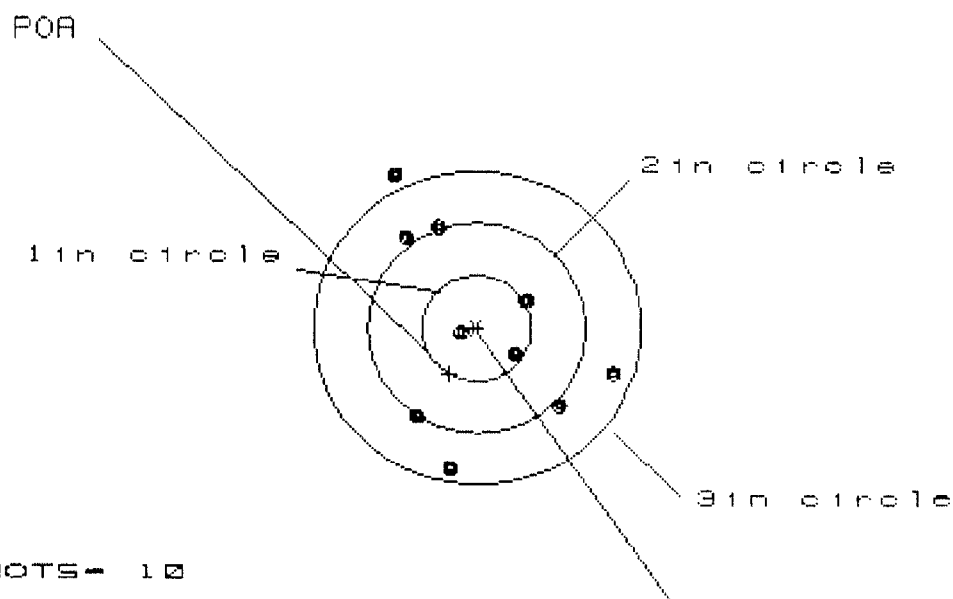
$\frac{1}{2}$ $\frac{3}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0788
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .420254
THE AMR FOR THIS RIFLE IS: 1.101

25 Jan 1989

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 1.989

VS= 2.728

GS= 2.769

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.134	1.086
MINIMUM X	:	-.770	-.738	-.786
MAXIMUM Y	:	1.439	1.131	.990
MINIMUM Y	:	-1.289	-1.129	-.768
CENTROID X	:	.251	.336	.384
CENTROID Y	:	.437	.277	.418
POA TO CENTROID in.	:	.504	.435	.567
MIN RADIUS	:	.134	.233	.258
MEAN RADIUS	:	.943	.853	.800
MAX RADIUS	:	1.632	1.224	1.174
HORIZONTAL SPREAD	:	1.989	1.872	1.872
VERTICAL SPREAD	:	2.728	2.260	1.758
EXTREME SPREAD	:	2.769	2.267	2.267
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6225583

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.733

VS= 3.115

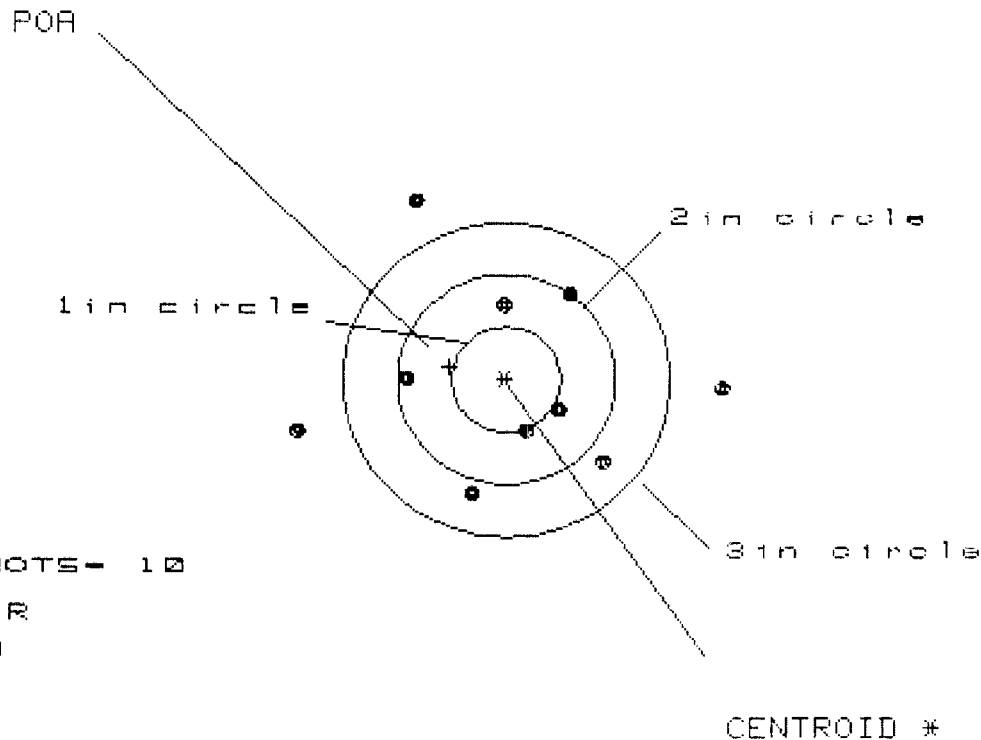
GS= 3.226

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.524	1.432	.905
MINIMUM X	:	-1.208	-1.301	-1.122
MAXIMUM Y	:	1.129	.908	.887
MINIMUM Y	:	-1.986	-.974	-.995
CENTROID X	:	.107	.200	.021
CENTROID Y	:	-.248	-.027	-.006
POA TO CENTROID in.	:	.270	.202	.022
MIN RADIUS	:	.253	.048	.228
MEAN RADIUS	:	1.040	.853	.779
MAX RADIUS	:	2.152	1.442	1.189
HORIZONTAL SPREAD	:	2.733	2.733	2.027
VERTICAL SPREAD	:	3.115	1.882	1.882
EXTREME SPREAD	:	3.226	2.733	2.104
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.847

VS= 2.865

GS= 3.868

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.973	1.052	.972
MINIMUM X	:	-1.874	-1.655	-1.735
MAXIMUM Y	:	1.766	1.756	1.014
MINIMUM Y	:	-1.099	-1.109	-.890
CENTROID X	:	.519	.300	.380
CENTROID Y	:	-.118	-.108	-.327
POA TO CENTROID in.	:	.532	.319	.501
MIN RADIUS	:	.534	.664	.456
MEAN RADIUS	:	1.187	1.108	.977
MAX RADIUS	:	1.975	1.868	1.757
HORIZONTAL SPREAD	:	3.847	2.707	2.707
VERTICAL SPREAD	:	2.865	2.865	1.904
EXTREME SPREAD	:	3.868	3.080	2.766
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

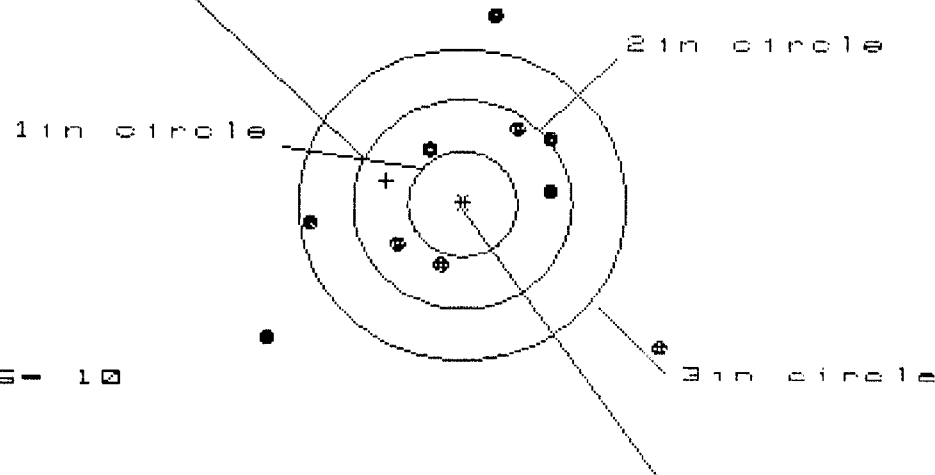
25 Jan 1989

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 3.582

VS= 3.129

GS= 3.717

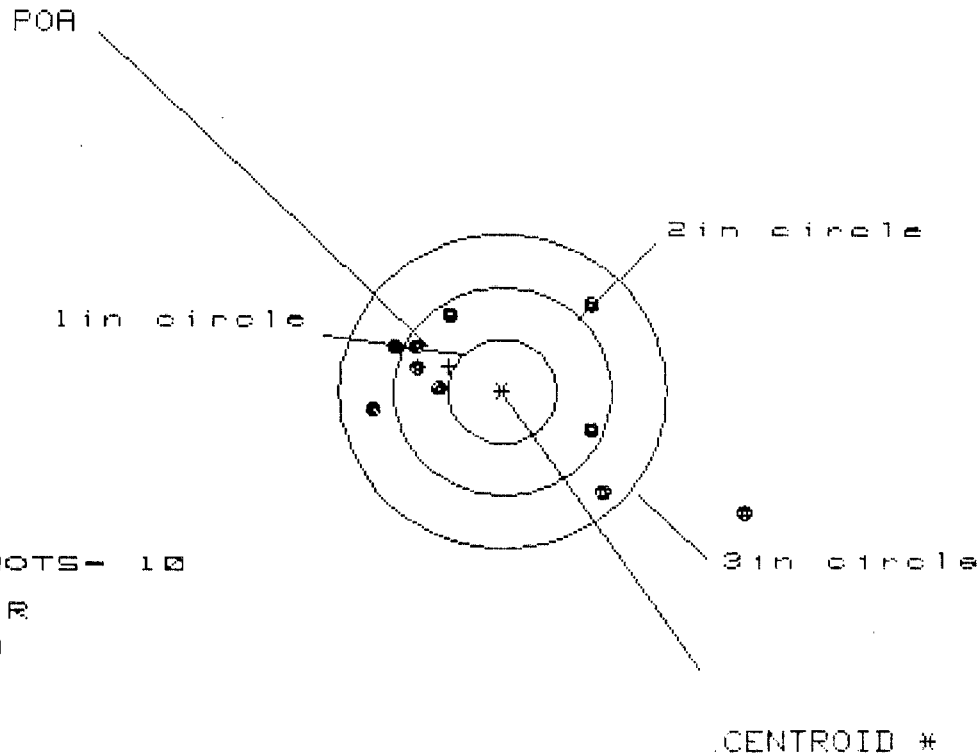
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.778	.989	.788
MINIMUM X	-1.804	-1.606	-1.403
MAXIMUM Y	1.805	1.657	1.485
MINIMUM Y	-1.324	-1.383	-.931
CENTROID X	.699	.501	.702
CENTROID Y	-.226	-.078	.094
POA TO CENTROID in.	.734	.507	.708
MIN RADIUS	.556	.348	.318
MEAN RADIUS	1.221	1.096	.937
MAX RADIUS	2.217	2.119	1.521
HORIZONTAL SPREAD	3.582	2.595	2.191
VERTICAL SPREAD	3.129	3.040	2.416
EXTREME SPREAD	3.717	3.717	2.636
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 3.332

VS= 2.039

GS= 3.535

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.188	1.111	1.187
MINIMUM X	:	-1.144	-.901	-.762
MAXIMUM Y	:	.833	.699	.557
MINIMUM Y	:	-1.206	-1.132	-.627
CENTROID X	:	.488	.245	.106
CENTROID Y	:	-.239	-.105	.037
POA TO CENTROID in.	:	.543	.266	.112
MIN RADIUS	:	.556	.337	.318
MEAN RADIUS	:	1.115	.868	.710
MAX RADIUS	:	2.499	1.586	1.342
HORIZONTAL SPREAD	:	3.332	2.012	1.949
VERTICAL SPREAD	:	2.039	1.831	1.184
EXTREME SPREAD	:	3.535	2.304	2.151
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	