

C6522269

MODEL 700TM M24

Model **SMS**

TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522269

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KJ
600	Proof		7/10/90	KJ
607	Check Headspace		7/10/90	KJ
610	Dis-assemble Gun		7/10/90	KJ
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	JS
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel JB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/14/90	KS
	C) Inspect Ejector Hole for Chamfer		8/14/90	KS
	D) Oil Firing Pin Ass'y		8/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-14-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/13/90	JK
	G) Safety Off Force	3	3	3			8/13/90	JK
	H) Trigger Pull Test & Retainability						9-14-90	JK
	I) Firing Pin Indent	.0235	.0235	.0235			8/13/90	JK
	J) Assemble Stock						8/13/90	ICS
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/15/90	ICS
	M) Iron Sight Alignment						8/15/90	ICS
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	ICS
	O) Attach Scope to Rifle						8/15/90	ICS
	P) Detach & Attach Scope 20 Times						8/15/90	ICS
640	Gallery Target & Test						8-16-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						8-16-90	A
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.38	2.15	2.32	2.32	2.10	9-14-90	JK
	C) Function						9-13-90	CS
660	Pack						9-18-90	JK

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6522269

DATE 9-18-90

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.14	2.30	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.19	2.39	2.15	
PULL #3	2.30	2.23	2.40	2.32	
PULL #4	2.27	2.40	2.38	2.32	
PULL #5	2.08	2.43	2.44	2.10	
TOTAL	11.46	11.39	11.91	11.27	
AVG.	2.292	2.278	2.382	2.254	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.28		
PULL #2	3.11	3.27		
PULL #3	3.15	3.30		
PULL #4	3.16	3.36		
PULL #5	3.43	3.30		
TOTAL	15.96	16.51		
AVG.	3.192	3.302		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.00		4.28
PULL #2	4.17	4.17		4.22
PULL #3	4.08	4.37		4.42
PULL #4	4.12	4.26		4.21
PULL #5	4.16	4.21		4.18
TOTAL	20.77	21.01		21.31
AVG.	4.154	4.202		4.262

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522269
17 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.224401
1 TO	2	.175377
1 TO	3	.52469
1 TO	4	.247487
1 TO	5	.321014

$\bar{x}_a$ <----POA

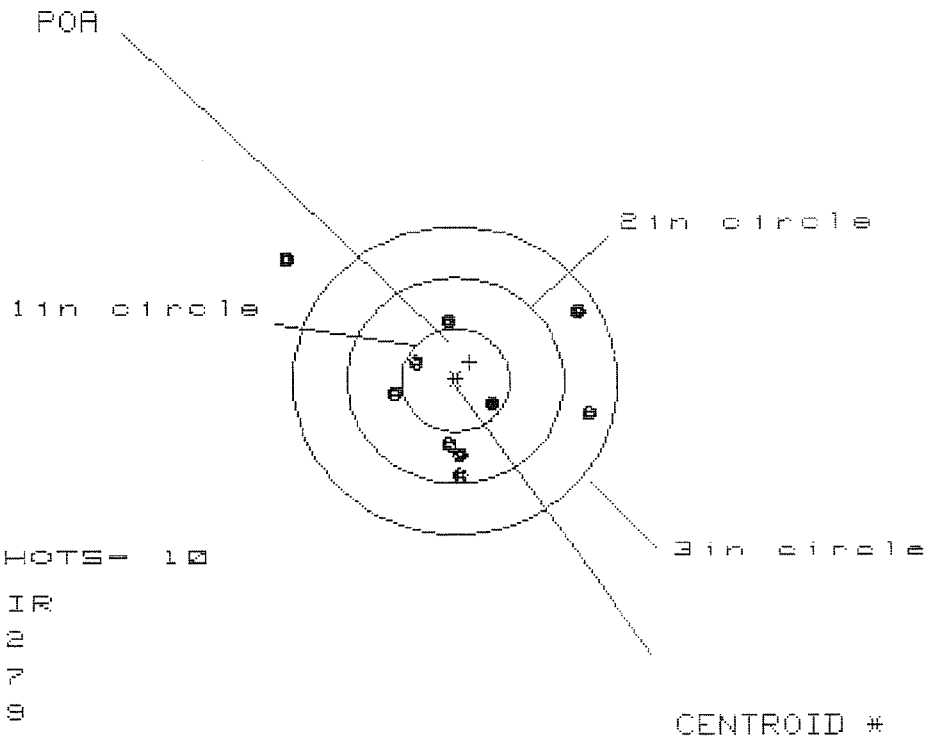
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.017
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104591

THE AMR FOR THIS RIFLE IS: .8094

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522269

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.822

VS= 2.077

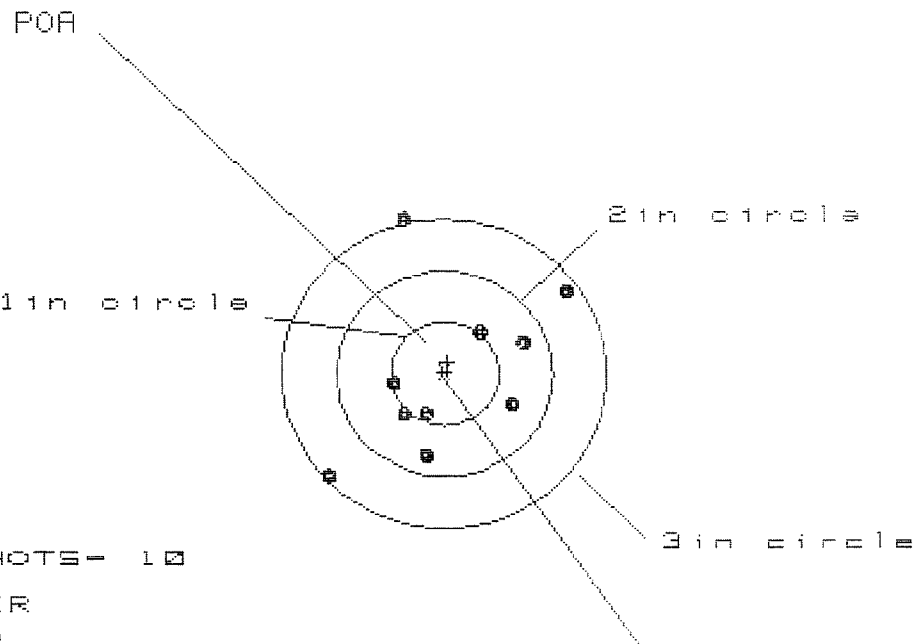
GS= 3.191

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.236	1.060	1.175
MINIMUM X	:	-1.586	-.735	-.619
MAXIMUM Y	:	1.205	.835	.859
MINIMUM Y	:	-.872	-.738	-.634
CENTROID X	:	-.134	.042	-.073
CENTROID Y	:	-.180	-.314	-.418
POA TO CENTROID in.	:	.224	.317	.424
MIN RADIUS	:	.344	.127	.244
MEAN RADIUS	:	.869	.722	.630
MAX RADIUS	:	1.992	1.248	1.176
HORIZONTAL SPREAD	:	2.822	1.795	1.795
VERTICAL SPREAD	:	2.077	1.573	1.493
EXTREME SPREAD	:	3.191	1.916	1.807
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.205

VS= 2.520

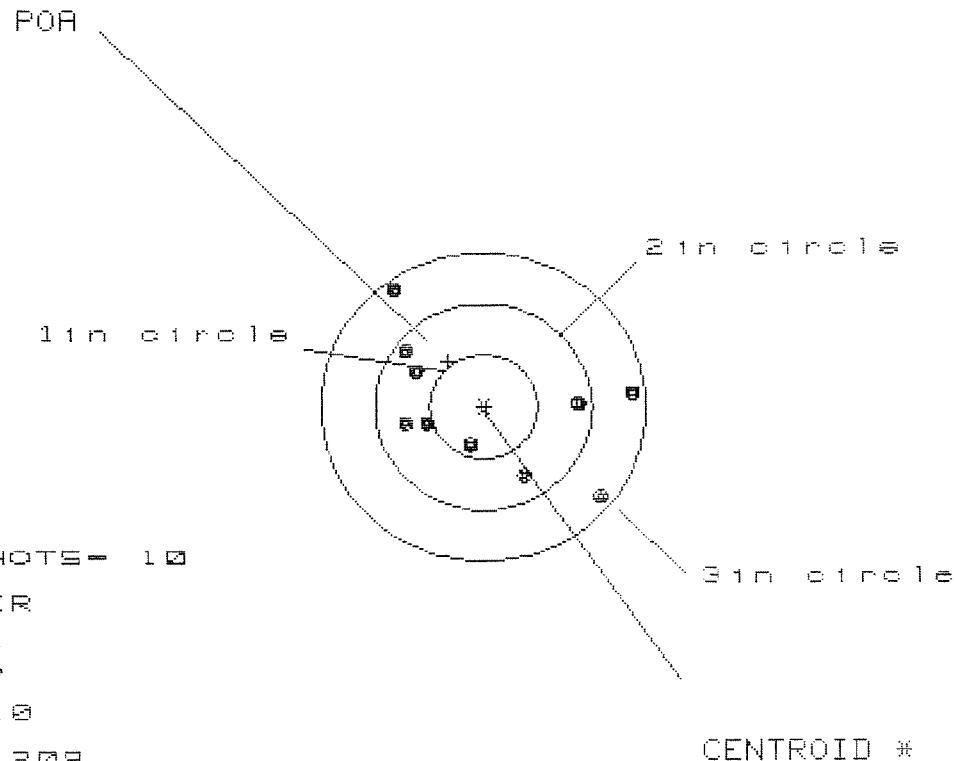
GS= 2.834

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	1.061	.918
MINIMUM X	:	-1.098	-1.144	-.713
MAXIMUM Y	:	1.528	.958	.855
MINIMUM Y	:	-.992	-.823	-.732
CENTROID X	:	-.025	.021	.164
CENTROID Y	:	-.106	-.276	-.173
POA TO CENTROID in.	:	.109	.277	.239
MIN RADIUS	:	.462	.337	.454
MEAN RADIUS	:	.877	.773	.699
MAX RADIUS	:	1.582	1.430	1.255
HORIZONTAL SPREAD	:	2.205	2.205	1.631
VERTICAL SPREAD	:	2.520	1.781	1.587
EXTREME SPREAD	:	2.834	2.834	2.013
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.200

VS= 2.032

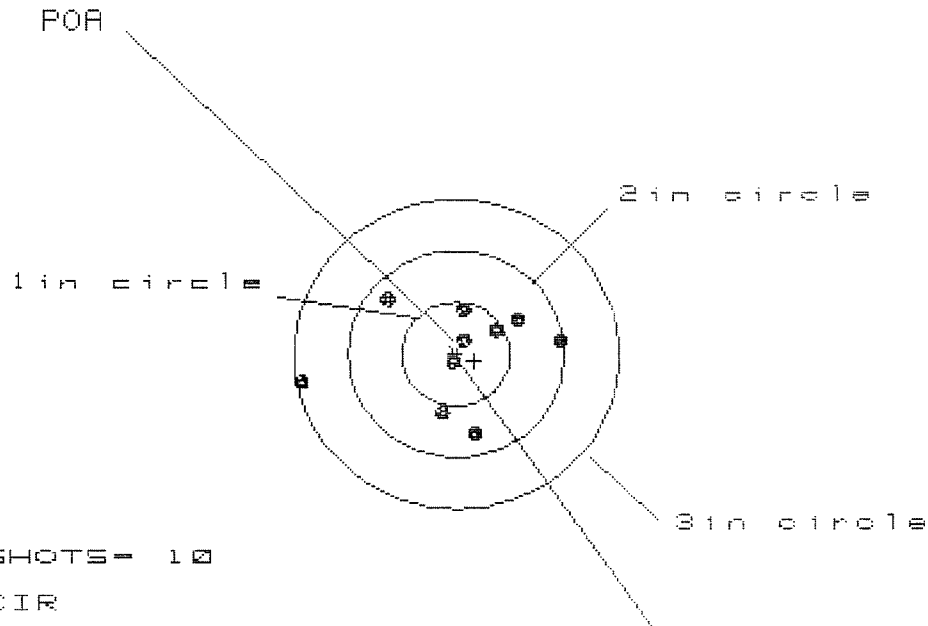
GS= 2.791

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.262	1.383
MINIMUM X	:	-.852	-.866	-.745
MAXIMUM Y	:	1.146	.707	.613
MINIMUM Y	:	-.886	-.759	-.631
CENTROID X	:	.324	.419	.298
CENTROID Y	:	-.436	-.563	-.469
POA TO CENTROID in.	:	.543	.702	.555
MIN RADIUS	:	.340	.286	.301
MEAN RADIUS	:	.924	.860	.795
MAX RADIUS	:	1.428	1.289	1.393
HORIZONTAL SPREAD	:	2.209	2.128	2.128
VERTICAL SPREAD	:	2.032	1.466	1.244
EXTREME SPREAD	:	2.791	2.316	2.146
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.472

VS= 1.259

GS= 2.517

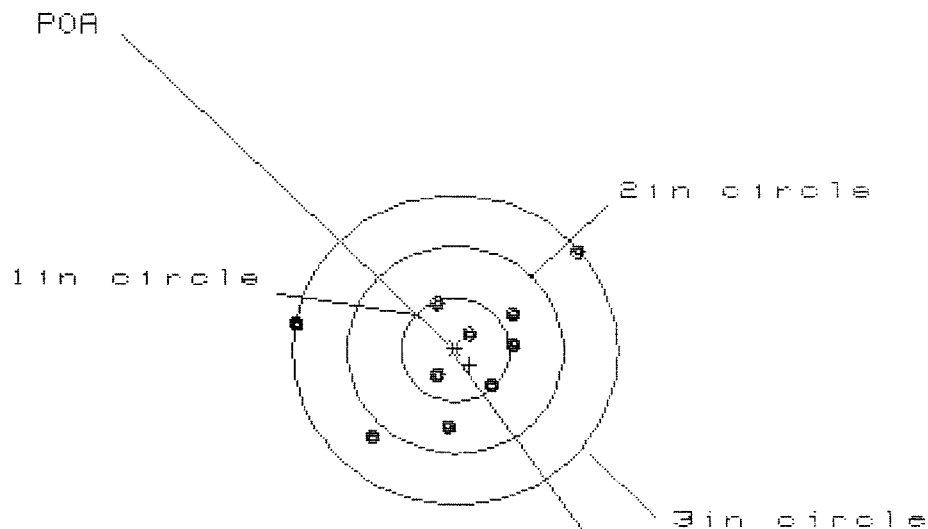
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	.830	.539
MINIMUM X	:	-1.477	-.814	-.710
MAXIMUM Y	:	.516	.482	.498
MINIMUM Y	:	-.743	-.777	-.761
CENTROID X	:	-.169	-.004	-.108
CENTROID Y	:	.065	.100	.084
POA TO CENTROID in.	:	.181	.100	.137
MIN RADIUS	:	.060	.119	.108
MEAN RADIUS	:	.645	.526	.483
MAX RADIUS	:	1.510	.946	.867
HORIZONTAL SPREAD	:	2.472	1.644	1.249
VERTICAL SPREAD	:	1.259	1.259	1.259
EXTREME SPREAD	:	2.517	1.681	1.501
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.559

VS= 1.749

GS= 2.635

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.124	.964	.467
MINIMUM X	:	-1.435	-.906	-.785
MAXIMUM Y	:	.920	.952	.609
MINIMUM Y	:	-.829	-.797	-.678
CENTROID X	:	-.131	.029	-.092
CENTROID Y	:	.141	.109	-.010
POA TO CENTROID in.	:	.193	.113	.092
MIN RADIUS	:	.207	.178	.260
MEAN RADIUS	:	.732	.629	.541
MAX RADIUS	:	1.464	1.355	1.038
HORIZONTAL SPREAD	:	2.559	1.870	1.252
VERTICAL SPREAD	:	1.749	1.749	1.287
EXTREME SPREAD	:	2.635	2.560	1.690
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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

MODEL 700™ H24

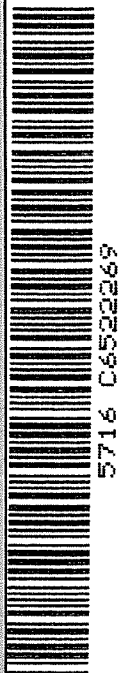
DU PONT
 REG. U.S. PAT. & TM. OFF.

SERIAL NO. C6522269

ORDER NO. 5716

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