

C6522242

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522242

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/9/90	KJ
600	Proof		7/9/90	KJ
607	Check Headspace		7/9/90	KJ
610	Dis-assemble Gun		7/9/90	KJ
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	LS
617	Drill and Tap Sight Holes		7/23/90	WB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/15/90	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	9/15/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	9/15/90	WB		
	H) Trigger Pull Test & Retainability				9/15/90	WB		
	I) Firing Pin Indent	.0235	.0235	.0235	9/15/90	WB		
	J) Assemble Stock				9/15/90	KA		
	K) Assemble Swivel Studs				9/17/90	JS		
	L) Attach Front and Rear Sight Assemblies				9/15/90	KA		
	M) Iron Sight Alignment				9/15/90	KA		
	N) Detach Front & Rear Sights & place in numbered container				9/15/90	KA		
	O) Attach Scope to Rifle				9/15/90	KA		
P) Detach & Attach Scope 20 Times				9/15/90	KA			
640	Gallery Target & Test				9/16/90	AF		
	A) Time				"	AF		
	B) Malfunctions				"	AF		
	C) Pierced Primers				"	AF		
	D) Optical Clarity of Scope				"	AF		
645	Inspect for Live Ammo				9/16/90	AF		
655	Final Inspection							
	A) Headspace				9/17/90	JS		
	B) Trigger Pull	2.37	2.29	2.41	2.49	2.22	9-17-90	KA
	C) Function						9/17/90	JS
660	Pack						9-19-90	OH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522242

DATE 9/15/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.39	2.51	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.47	2.56	2.29	
PULL #3	2.30	2.55	2.44	2.41	
PULL #4	2.33	2.50	2.39	2.49	
PULL #5	2.24	2.46	2.35	2.22	
TOTAL	11.58	12.37	12.25	11.78	
AVG.	2.32	2.47	2.45	2.356	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	2.95		
PULL #2	3.01	3.07		
PULL #3	3.01	2.86		
PULL #4	3.04	3.05		
PULL #5	3.11	2.90		
TOTAL	15.36	14.83		
AVG.	3.07	2.97		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.00		4.16
PULL #2	4.09	4.02		4.11
PULL #3	3.90	4.00		4.01
PULL #4	3.92	4.11		4.05
PULL #5	4.01	4.02		4.00
TOTAL	20.01	20.15		20.33
AVG.	4.00	4.03		4.06

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522242
16 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.182789
1 TO	2	.297753
1 TO	3	.139635
1 TO	4	.357459
1 TO	5	.294966

$\frac{45}{27}$ <----POA

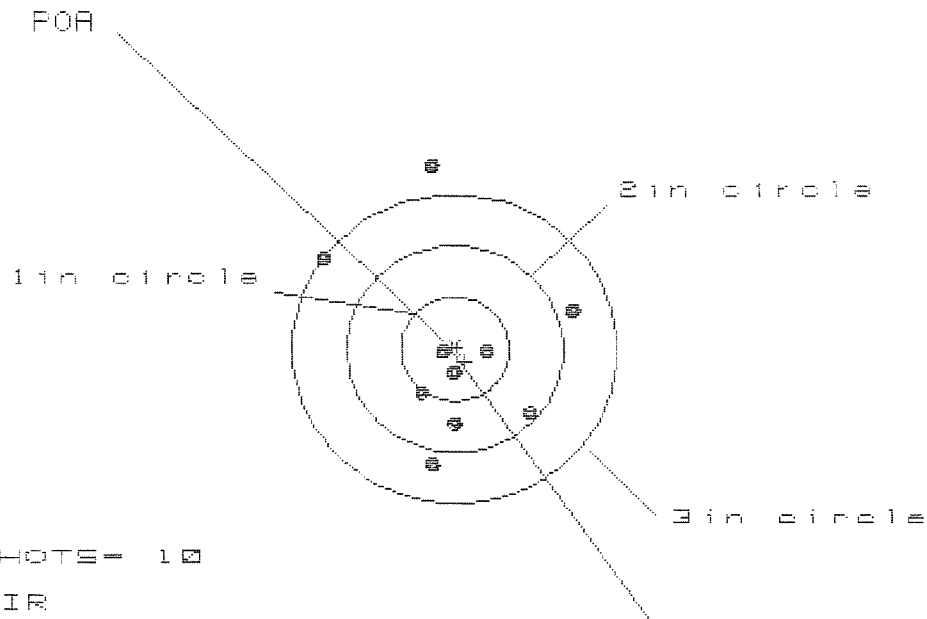
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162041
THE AMR FOR THIS RIFLE IS: 1.02

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522242

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.280

VS= 2.847

GS= 2.847

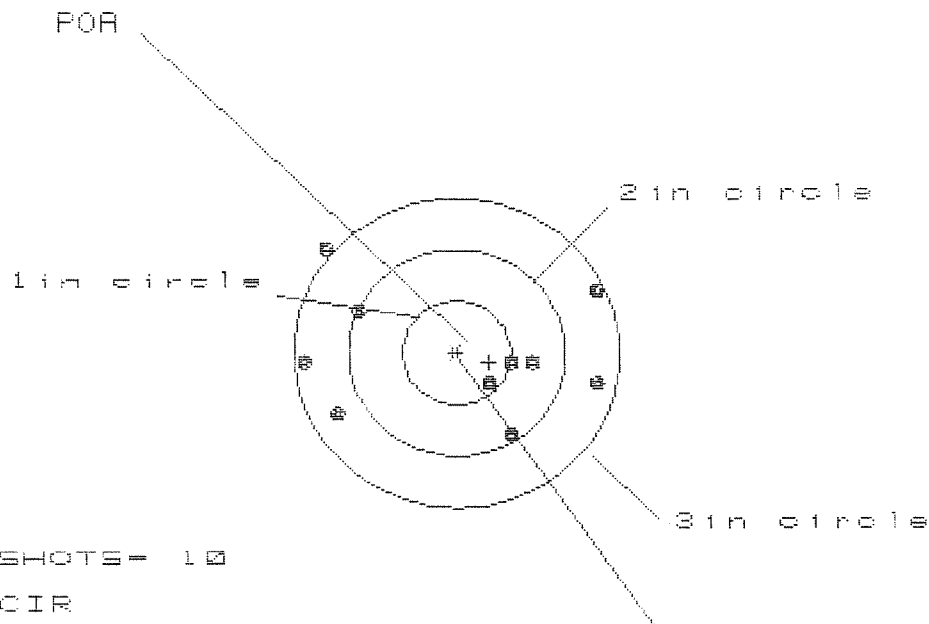
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	1.026	.869
MINIMUM X	:	-1.236	-1.254	-.478
MAXIMUM Y	:	1.771	1.057	.718
MINIMUM Y	:	-1.076	-.879	-.747
CENTROID X	:	-.090	-.072	.085
CENTROID Y	:	.119	-.078	-.210
POA TO CENTROID in.	:	.149	.106	.227
MIN RADIUS	:	.063	.019	.197
MEAN RADIUS	:	.818	.663	.550
MAX RADIUS	:	1.779	1.640	1.128
HORIZONTAL SPREAD	:	2.280	2.280	1.347
VERTICAL SPREAD	:	2.847	1.936	1.465
EXTREME SPREAD	:	2.847	2.406	1.934
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.743

VS= 1.849

GS= 2.828

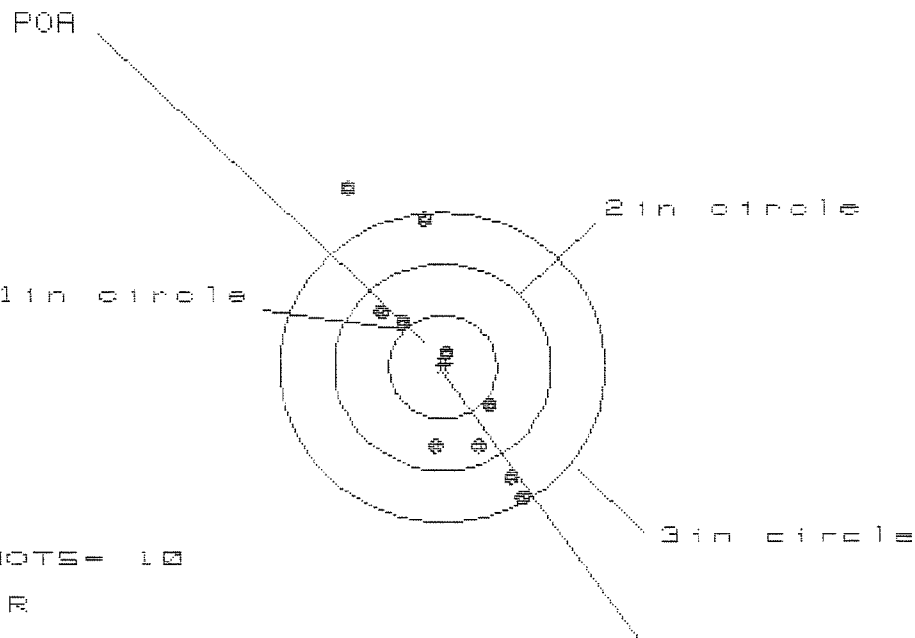
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.192	1.300
MINIMUM X	:	-1.415	-1.551	-1.402
MAXIMUM Y	:	1.052	.725	.665
MINIMUM Y	:	-.797	-.680	-.590
CENTROID X	:	-.297	-.161	-.310
CENTROID Y	:	.090	-.027	-.117
POR TO CENTROID in.	:	.311	.163	.332
MIN RADIUS	:	.431	.252	.361
MEAN RADIUS	:	1.067	.955	.925
MAX RADIUS	:	1.615	1.552	1.409
HORIZONTAL SPREAD	:	2.743	2.743	2.702
VERTICAL SPREAD	:	1.849	1.405	1.255
EXTREME SPREAD	:	2.828	2.825	2.708
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.566

VS= 2.991

GS= 3.376

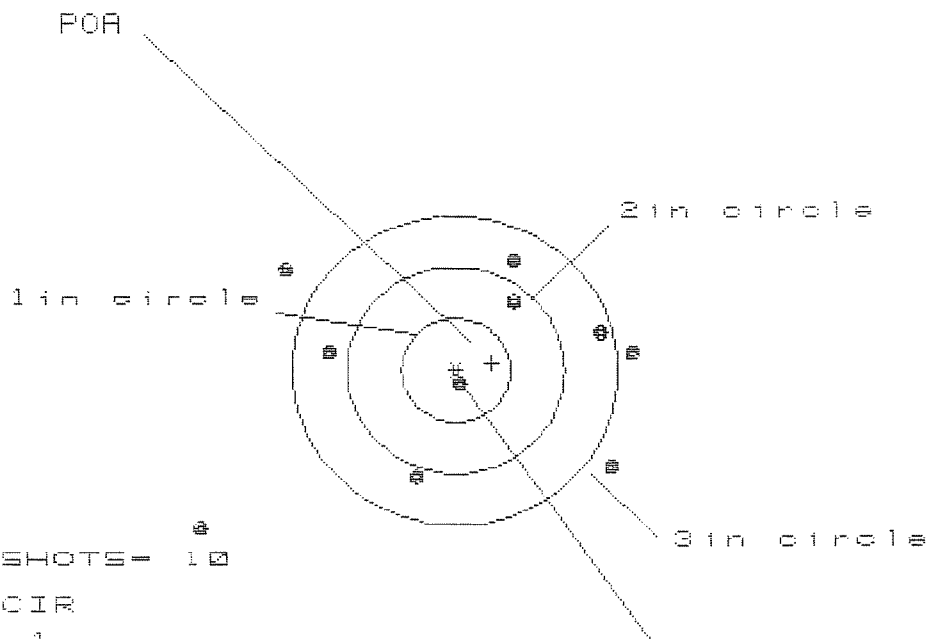
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.743	.651	.621
MINIMUM X	-.823	-.660	-.690
MAXIMUM Y	1.763	1.663	.897
MINIMUM Y	-1.228	-1.032	-.824
CENTROID X	-.029	.063	.093
CENTROID Y	-.037	-.233	-.441
POA TO CENTROID in.	.047	.241	.450
MIN RADIUS	.169	.344	.268
MEAN RADIUS	.973	.845	.707
MAX RADIUS	1.946	1.680	1.131
HORIZONTAL SPREAD	1.566	1.311	1.311
VERTICAL SPREAD	2.991	2.695	1.721
EXTREME SPREAD	3.376	2.838	2.163
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 2.963

VS= 2.585

GS= 4.315

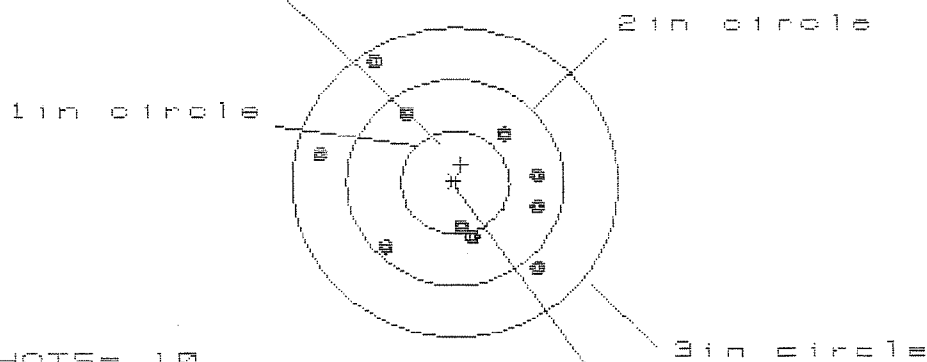
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.591	1.327	1.096
MINIMUM X	-2.372	-1.852	-1.637
MAXIMUM Y	1.084	.917	1.019
MINIMUM Y	-1.501	-1.147	-1.045
CENTROID X	-.335	-.071	.160
CENTROID Y	-.070	.097	-.005
FOR TO CENTROID in.	.342	.121	.160
MIN RADIUS	.151	.342	.452
MEAN RADIUS	1.379	1.182	1.059
MAX RADIUS	2.807	2.024	1.640
HORIZONTAL SPREAD	3.963	3.179	2.733
VERTICAL SPREAD	2.585	2.064	2.064
EXTREME SPREAD	4.315	3.599	2.827
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 2.0339

VS = 2.017

GS = 2.516

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.702	.535
MINIMUM X	:	-1.256	-1.337	-.866
MAXIMUM Y	:	1.170	.833	.879
MINIMUM Y	:	-.847	-.717	-.671
CENTROID X	:	-.056	.025	.192
CENTROID Y	:	-.174	-.304	-.350
POA TO CENTROID in.	:	.193	.305	.399
MIN RADIUS	:	.412	.271	.271
MEAN RADIUS	:	.862	.770	.656
MAX RADIUS	:	1.375	1.385	1.099
HORIZONTAL SPREAD	:	2.039	2.039	1.401
VERTICAL SPREAD	:	2.017	1.550	1.550
EXTREME SPREAD	:	2.516	2.307	1.957
NUMBER IN ONE INCH CIRCLE	=		1	
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 700TM M24

SERIAL NO.

C6522242

ORDER NO.

5716

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

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5716 C6522242

UPC



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