

C6522126

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6522126*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	<i>8/1/90</i>	<i>KS</i>
600	Proof		<i>8/1/90</i>	<i>KS</i>
607	Check Headspace		<i>8/1/90</i>	<i>KS</i>
610	Dis-assemble Gun		<i>8/1/90</i>	<i>KS</i>
612	Magnaflux Barrel Action		<i>8/6/90</i>	<i>KR</i>
	Magnaflux Bolt		<i>8/6/90</i>	<i>KR</i>
615	Rollmark Caliber		<i>8/6/90</i>	<i>LS</i>
617	Drill and Tap Sight Holes		<i>8/10/90</i>	<i>LB</i>
618	Polish Barrel <i>RB</i>		<i>8/14/90</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>8/22/90</i>	<i>TJA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		<i>9/6/90</i>	<i>WB</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>9/6/90</i>	<i>WB</i>
	C) Inspect Ejector Hole for Chamfer		<i>9/6/90</i>	<i>WB</i>
	D) Oil Firing Pin Ass'y		<i>9/6/90</i>	<i>WB</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>9/6/90</i>	<i>WB</i>

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	9/6/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	9/6/90	WB		
	H) Trigger Pull Test & Retainability				9/6/90	WB		
	I) Firing Pin Indent	.025	.025	.025	9/6/90	WB		
	J) Assemble Stock				9/6/90	KS		
	K) Assemble Swivel Studs				9/9/90	JS		
	L) Attach Front and Rear Sight Assemblies				9/6/90	KS		
	M) Iron Sight Alignment				9/6/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				9/6/90	KS		
	O) Attach Scope to Rifle				9/6/90	KS		
	P) Detach & Attach Scope 20 Times				9/6/90	KS		
640	Gallery Target & Test				9-8-90	AC		
	A) Time				9-8-90	AC		
	B) Malfunctions				9-8-90	AC		
	C) Pierced Primers				9-8-90	AC		
	D) Optical Clarity of Scope				9-8-90	AC		
645	Inspect for Live Ammo				9-8-90	AC		
655	Final Inspection							
	A) Headspace				9/9/90	JS		
	B) Trigger Pull	241	238	235	241	243	9/9/90	JS
	C) Function						9/9/90	JS
660	Pack						9/20/90	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6522126
DATE 9/6/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.73	2.14	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.15	2.20	2.38	
PULL #3	2.50	2.19	2.15	2.35	
PULL #4	2.40	2.19	2.19	2.41	
PULL #5	2.21	2.15	2.19	2.43	
TOTAL	12.06	10.91	10.87		
AVG.	2.41	2.18	2.17		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.21		
PULL #2	3.19	3.12		
PULL #3	3.03	3.04		
PULL #4	3.18	3.10		
PULL #5	3.05	3.00		
TOTAL	15.62	15.47		
AVG.	3.12	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.17		4.14
PULL #2	4.04	4.24		4.18
PULL #3	4.01	4.14		4.21
PULL #4	4.13	4.10		4.10
PULL #5	4.09	4.14		4.05
TOTAL	20.50	20.79		20.68
AVG.	4.10	4.16		4.13

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522126
8 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	.578613
1 TO 2	.101045
1 TO 3	1.17892
1 TO 4	.925285
1 TO 5	.508869

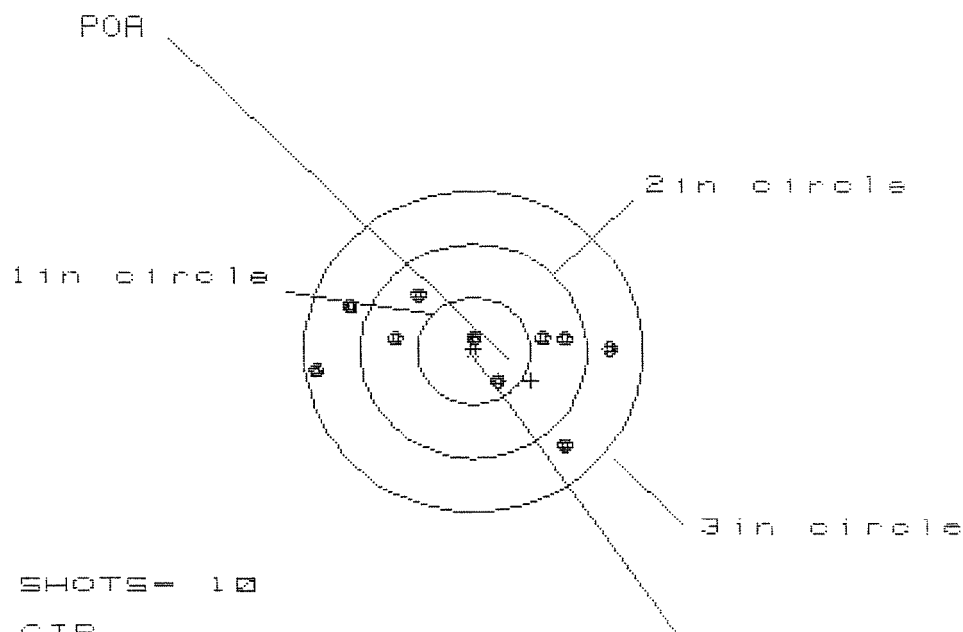
2 3 <----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1094
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0096
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .10982
THE AMR FOR THIS RIFLE IS: .9384

8 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522126

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.548

VS= 1.380

GS= 2.553

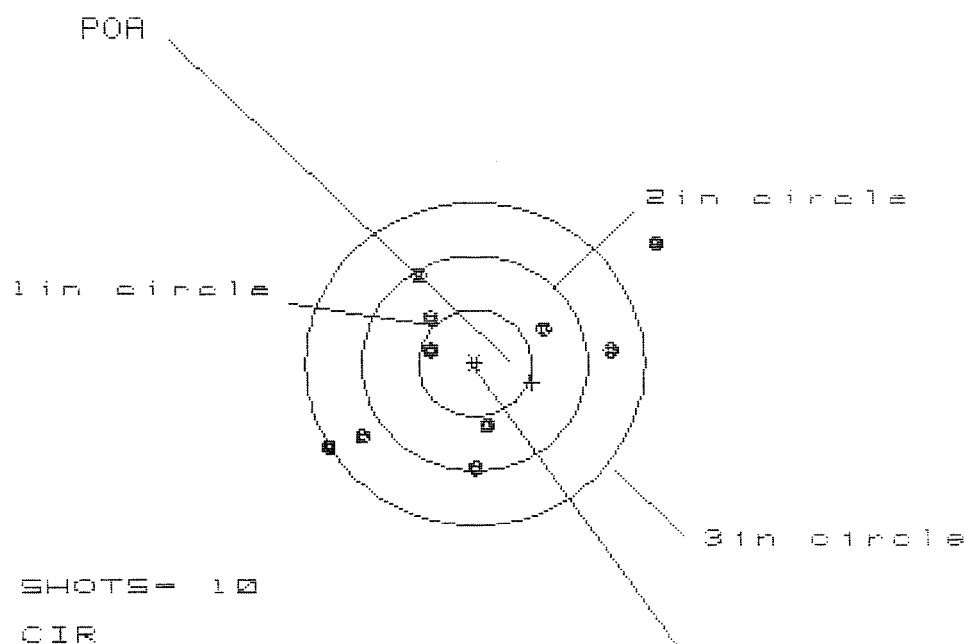
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.194	1.044	1.131
MINIMUM X	:	-1.354	-1.273	-1.185
MAXIMUM Y	:	.529	.509	.400
MINIMUM Y	:	-.851	-.871	-.400
CENTROID X	:	-.508	-.358	-.445
CENTROID Y	:	.277	.297	.406
POA TO CENTROID in.	:	.579	.465	.603
MIN RADIUS	:	.119	.193	.079
MEAN RADIUS	:	.821	.748	.693
MAX RADIUS	:	1.365	1.326	1.214
HORIZONTAL SPREAD	:	2.548	2.317	2.317
VERTICAL SPREAD	:	1.380	1.380	.800
EXTREME SPREAD	:	2.553	2.351	2.351
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.891

VS = 2.012

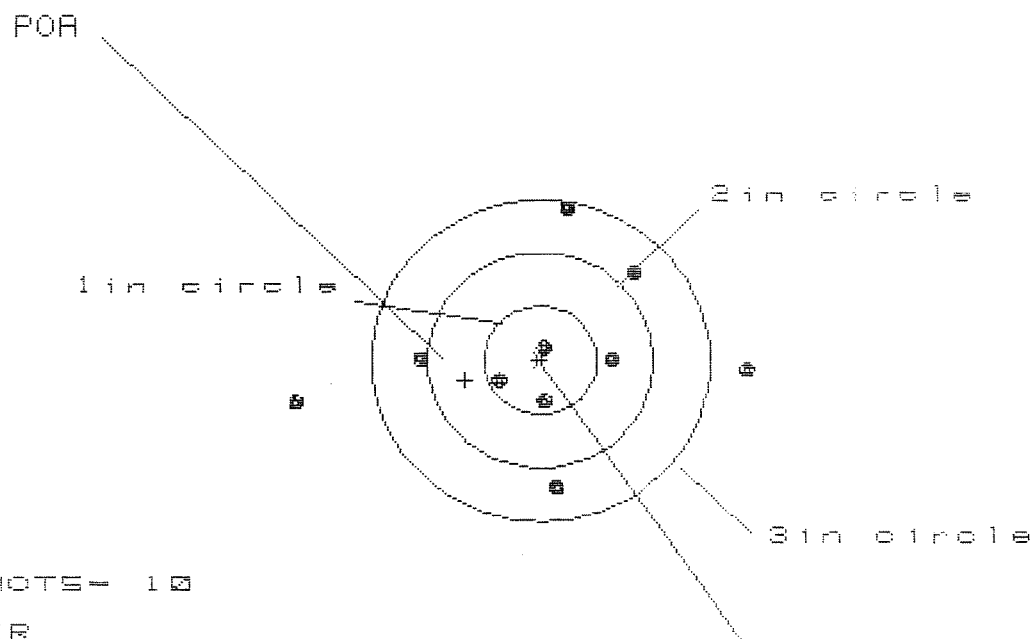
GS = 3.433

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.642	1.368	1.235
MINIMUM X	:	-1.249	-1.067	-0.985
MAXIMUM Y	:	1.075	.981	.898
MINIMUM Y	:	-.937	-.817	-.899
CENTROID X	:	-.505	-.687	-.554
CENTROID Y	:	.176	.056	.139
POA TO CENTROID in.	:	.534	.689	.571
MIN RADIUS	:	.408	.343	.382
MEAN RADIUS	:	.993	.864	.808
MAX RADIUS	:	1.962	1.383	1.241
HORIZONTAL SPREAD	:	2.891	2.435	2.220
VERTICAL SPREAD	:	2.012	1.798	1.798
EXTREME SPREAD	:	3.433	2.582	2.333
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 3.991

VS= 2.590

GS= 4.002

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.848	1.610	.762
MINIMUM X	:	-2.143	-1.289	-1.088
MAXIMUM Y	:	1.369	1.324	1.304
MINIMUM Y	:	-1.222	-1.266	-1.286
CENTROID X	:	.667	.905	.704
CENTROID Y	:	.181	.226	.246
POA TO CENTROID in.	:	.691	.933	.745
MIN RADIUS	:	.114	.215	.045
MEAN RADIUS	:	1.034	.908	.787
MAX RADIUS	:	2.180	1.618	1.312
HORIZONTAL SPREAD	:	3.991	2.899	1.850
VERTICAL SPREAD	:	2.590	2.590	2.590
EXTREME SPREAD	:	4.002	2.901	2.592
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 1.927

VS = 3.053

GS = 3.079

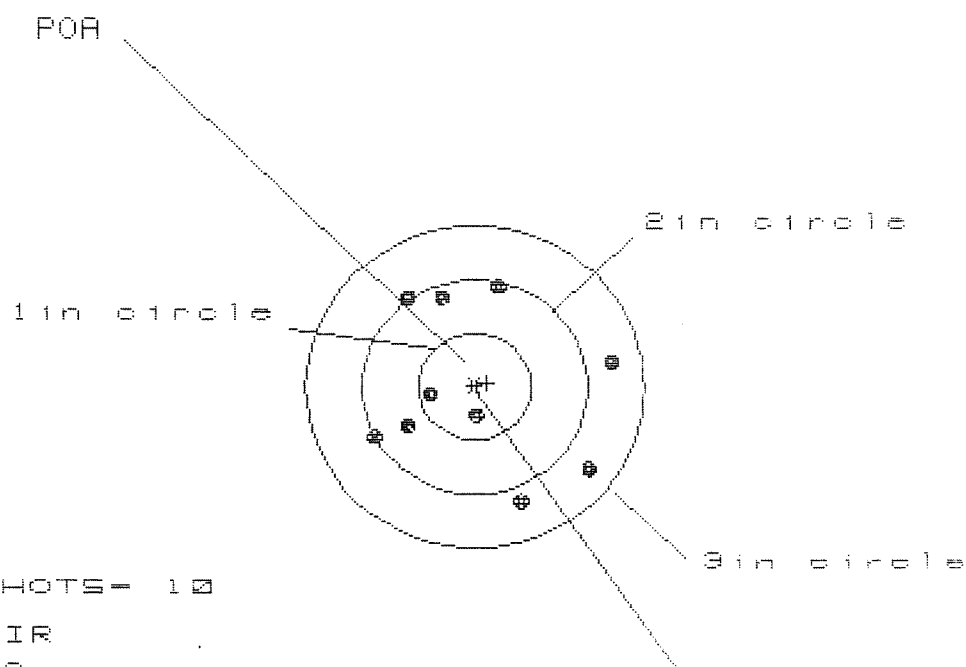
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.041	1.014	.839
MINIMUM X	:	-.886	-.913	-.787
MAXIMUM Y	:	1.696	1.130	1.035
MINIMUM Y	:	-1.357	-1.169	-1.264
CENTROID X	:	-.095	-.068	-.194
CENTROID Y	:	-.551	-.739	-.644
POA TO CENTROID in.	:	.559	.742	.672
MIN RADIUS	:	.149	.206	.047
MEAN RADIUS	:	.968	.892	.814
MAX RADIUS	:	1.714	1.269	1.288
HORIZONTAL SPREAD	:	1.927	1.927	1.626
VERTICAL SPREAD	:	3.053	2.299	2.299
EXTREME SPREAD	:	3.079	2.358	2.353
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.054

VS= 2.040

GS= 2.218

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.177	1.284	.631
MINIMUM X	-.877	-.770	-.609
MAXIMUM Y	.938	.859	.880
MINIMUM Y	-1.102	-1.181	-1.160
CENTROID X	-.106	-.213	-.374
CENTROID Y	-.035	.044	.023
POA TO CENTROID in.	.111	.218	.375
MIN RADIUS	.229	.261	.116
MEAN RADIUS	.876	.822	.729
MAX RADIUS	1.206	1.295	1.321
HORIZONTAL SPREAD	2.054	2.054	1.240
VERTICAL SPREAD	2.040	2.040	2.040
EXTREME SPREAD	2.218	2.187	2.180
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6522126

ORDER NO.
5716

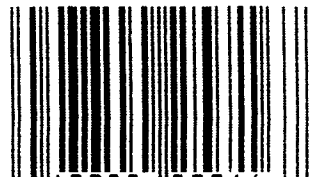
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5716 C6522126

UPC



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