

C6225361

MODEL 700™ M24

Model ~~700~~ M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

00299

5091

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225361*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>1/22</i>	<i>FB</i>
600	PROOF	<i>1/28/88</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>2/15/88</i>	<i>P/C.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>P/C.</i>
620	COATING	<i>2/11/88</i>	<i>JA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225361

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/25/88	AW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/25/88	AW
	C) Inspect Ejector Hole for Chamfer		8/25/88	AW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/25/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		25aug88	JH + JS
	F) Safety on Force	5.5 5.5 5	25aug88	JH + JS
	G) Safety off Force	3 3 3	25aug88	JH + JS
	H) Trigger Pull Test & Retainabilty		25aug88	JH + JS
	I) Firing Pin Indent	.0215 .022 .0215	25aug88	JH + JS
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-6-88	JS
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10-1-88	RW
	P) Detach & Attach Scope 20 times		10-1-88	JS
640	Gallery Target & Test	59R 96L	9/4/88	W.B.
	A) Optical Clarity of Scope		9/4/88	W.B.
645	Inspect for Live Ammo		9/4/88	W.B.
655	Final Inspection			
	A) Headspace		10-6-88	JS
	B) Trigger Pull		10-6-88	JS
	C) Function		10-6-88	JS
660	Pack		10-21-88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225361

DATE 25 Aug. 88

TESTER J. U. + L. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.83	2.62	2.93	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.43	2.52	2.92	
PULL #3	2.46	2.44	2.55	2.90	
PULL #4	2.49	2.90	2.52	2.88	
PULL #5	2.50	2.55	2.50	2.90	
TOTAL	12.56	13.15	12.71	14.53	
AVG.	2.512	2.63	2.542	2.90	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.97		
PULL #2	3.04	3.25		
PULL #3	2.99	3.05		
PULL #4	3.07	3.03		
PULL #5	3.09	3.09		
TOTAL	15.19	15.39		
AVG.	3.038	3.078		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.32		4.36
PULL #2	4.38	4.33		4.36
PULL #3	4.40	4.41		4.27
PULL #4	4.35	4.32		4.39
PULL #5	4.39	4.42		4.41
TOTAL	21.88	21.80		21.79
AVG.	4.376	4.36		4.358

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225361

CENTROIDAL DISTANCES

0 TO	1	1.87704
1 TO	2	.25262
1 TO	3	.340635
1 TO	4	.642511
1 TO	5	1.11801

+ 5 $\frac{1}{4}$ ---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.5668
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.57074
THE AMR FOR THIS RIFLE IS: .9954

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FILE:/PATTERNING/CENTERFIRE_PATT/06225361

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

IS- .2.258

VS= 3.169

GS= 3.202

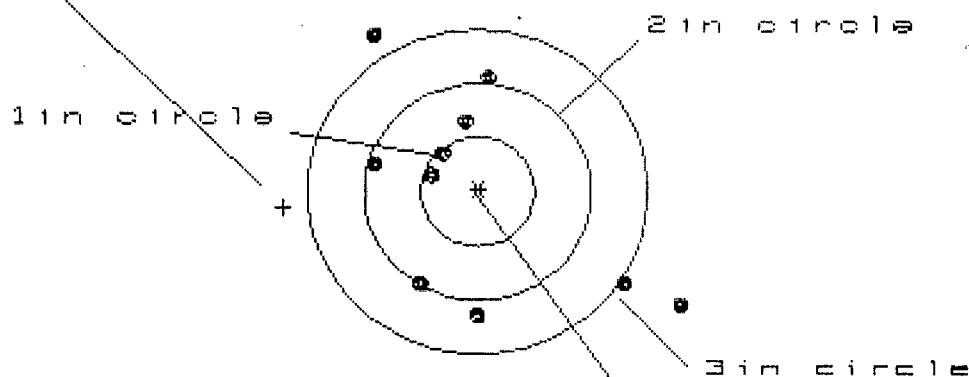
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.558	1.590	.546
MINIMUM X	-.700	-.668	-.469
MAXIMUM Y	2.173	.868	.849
MINIMUM Y	-.996	-.755	-.774
CENTROID X	1.842	1.810	1.611
CENTROID Y	.361	.120	.139
POA TO CENTROID in.	1.877	1.814	1.617
MIN RADIUS	.164	.403	.477
MEAN RADIUS	.967	.819	.706
MAX RADIUS	2.192	1.597	.879
HORIZONTAL SPREAD	2.258	2.258	1.015
VERTICAL SPREAD	3.169	1.623	1.623
EXTREME SPREAD	3.202	2.357	1.632
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.770

VS= 2.580

GS= 3.633

CENTROID *

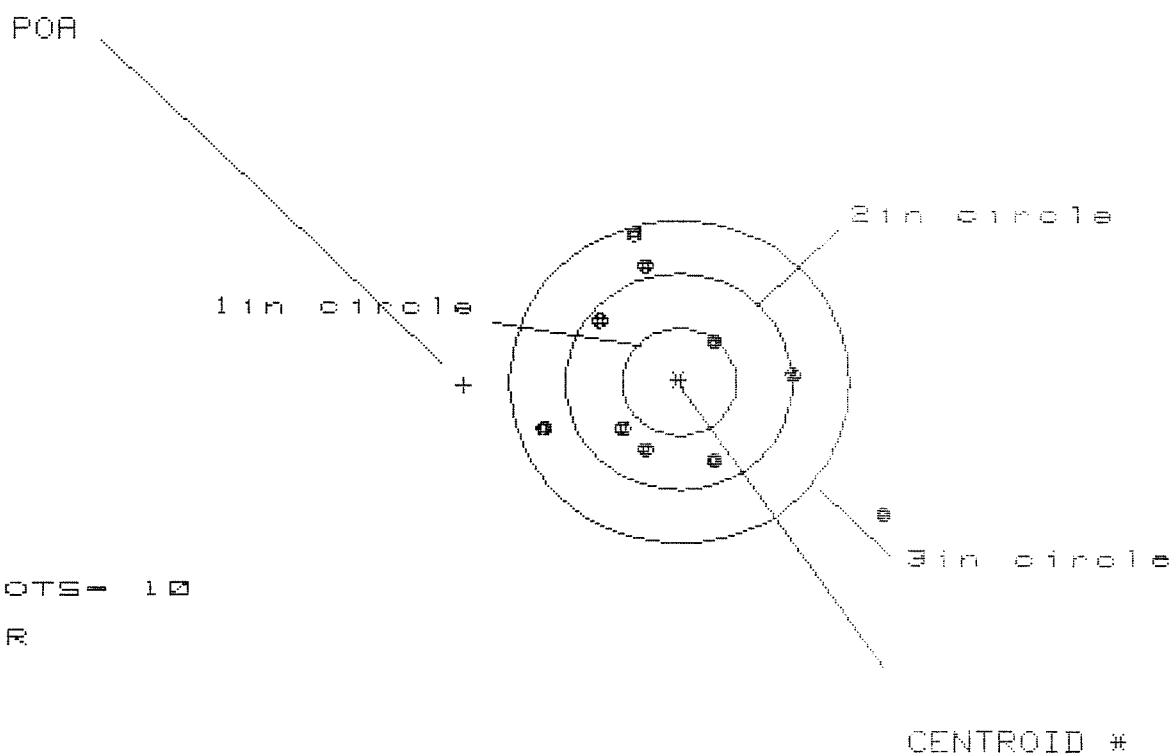
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM -X	-1.810	-1.473	-1.338
MINIMUM X	-.957	-.756	-.841
MAXIMUM Y	1.405	1.291	1.071
MINIMUM Y	-1.175	-1.289	-1.128
CENTROID X	1.711	1.510	1.595
CENTROID Y	.145	.259	.098
POA TO CENTROID in.	1.717	1.532	1.598
MIN RADIUS	.453	.227	.382
MEAN RADIUS	1.106	.925	.896
MAX RADIUS	2.084	1.747	1.591
HORIZONTAL SPREAD	2.770	2.229	2.229
VERTICAL SPREAD	2.580	2.580	2.199
EXTREME SPREAD	3.633	3.102	2.458
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 3.045

VS= 2.639

GS= 3.442

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.837	1.195	1.173
MINIMUM X	-1.208	-1.004	-1.025
MAXIMUM Y	1.396	1.258	1.064
MINIMUM Y	-1.243	-.851	-.694
CENTROID X	1.898	1.694	1.715
CENTROID Y	.025	.163	.006
POA TO CENTROID in.	1.899	1.702	1.716
MIN RADIUS	.448	.516	.518
MEAN RADIUS	1.051	.903	.840
MAX RADIUS	2.218	1.269	1.179
HORIZONTAL SPREAD	3.045	2.199	2.199
VERTICAL SPREAD	2.639	2.109	1.758
EXTREME SPREAD	3.442	2.256	2.256
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

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.079

VS = 2.177

GS = 2.198

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.178

1.109

1.187

MINIMUM X

:

-.901

-.970

-.892

MAXIMUM Y

:

1.202

1.098

.538

MINIMUM Y

:

-.975

-.841

-.704

CENTROID X

:

1.656

1.725

1.647

CENTROID Y

:

-.254

-.388

-.525

POA TO CENTROID in.

:

1.676

1.768

1.729

MIN RADIUS

:

.269

.241

.121

MEAN RADIUS

:

.791

.709

.601

MAX RADIUS

:

1.351

1.262

1.204

HORIZONTAL SPREAD

:

2.079

2.079

2.079

VERTICAL SPREAD

:

2.177

1.939

1.242

EXTREME SPREAD

:

2.198

2.190

2.081

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

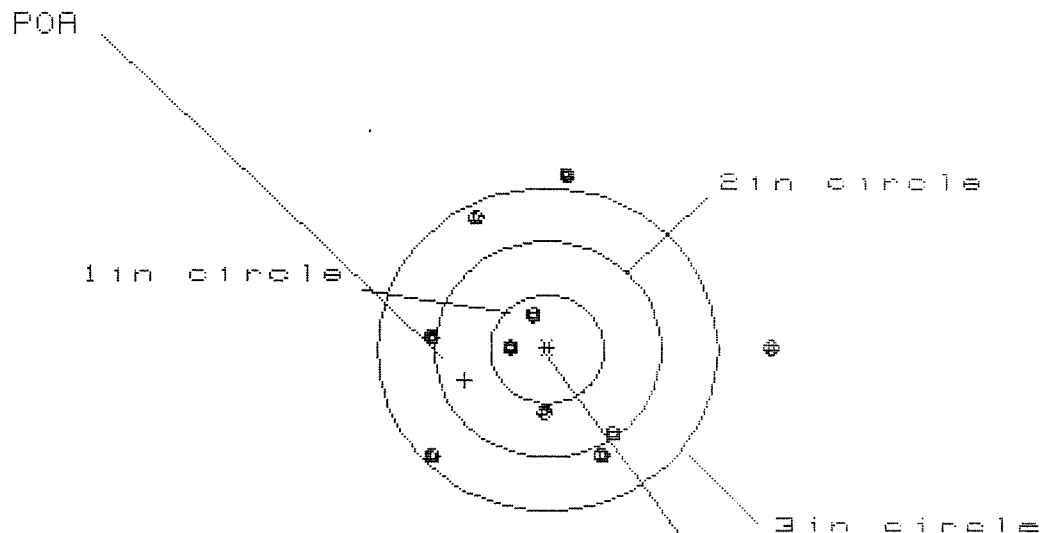
NUMBER IN THREE INCH CIRCLE =

10

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.947

VS= 2.622

GS= 3.101

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.952	.767	.809
MINIMUM X	:	-.995	-.778	-.736
MAXIMUM Y	:	1.606	1.609	1.429
MINIMUM Y	:	-1.016	-1.013	-.812
CENTROID X	:	.727	.510	.468
CENTROID Y	:	.279	.276	.075
POA TO CENTROID in.	:	.779	.580	.474
MIN RADIUS	:	.289	.073	.220
MEAN RADIUS	:	1.062	.922	.827
MAX RADIUS	:	1.952	1.644	1.484
HORIZONTAL SPREAD	:	2.947	1.545	1.545
VERTICAL SPREAD	:	2.622	2.622	2.241
EXTREME SPREAD	:	3.101	2.813	2.514
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	