

FORM

UPC



0 47700 25716 7

C6665667

CAPACITY*
*INCLUDES 1 IN CHAMBER

TM M24

5716

ORDER NO.

BARREL LENGTH

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665667

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1 91	10 1 91	RW
600	Proof	10 1 91	10 1 91	RW
607	Check Headspace	10 1 91	10 1 91	RW
610	Dis-assemble Gun	10 1 91	10 1 91	RW
612	Magnaflux Barrel Action	OCT	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	LS
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel		10/8/91	CB
620	Apply Coatings (Barrel Action)		10-22-91	TJ
	Apply Coating (Bolt)		10-22-91	TJ
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/1/91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/5/91	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/5/91	WLB
	H) Trigger Pull Test & Retainability						11/11/91	WLB
	I) Firing Pin Indent	.0215	.020	.0205			11/5/91	WLB
	J) Assemble Stock						11/5/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11/5/91	RW
	M) Iron Sight Alignment						11/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	RW
	O) Attach Scope to Rifle						11/5/91	RW
	P) Detach & Attach Scope 20 Times						11/5/91	RW
640	Gallery Target & Test						11-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-5-91	NF
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.21	2.29	2.29	2.34	2.35	11-6-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6665667
DATE 10/1/91
TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.35	2.48	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.27	2.45	2.29	
PULL #3	2.25	2.34	2.38	2.29	
PULL #4	2.38	2.39	2.40	2.34	
PULL #5	2.33	2.40	2.44	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.51		
PULL #2	3.28	3.51		
PULL #3	3.42	3.54		
PULL #4	3.39	3.60		
PULL #5	3.43	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.31		4.59
PULL #2	4.55	4.60		4.59
PULL #3	4.55	4.48		4.40
PULL #4	4.55	4.44		4.44
PULL #5	4.51	4.46		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665667
5 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.148489
1 TO	2	.263911
1 TO	3	.14368
1 TO	4	.0256125
1 TO	5	.136971

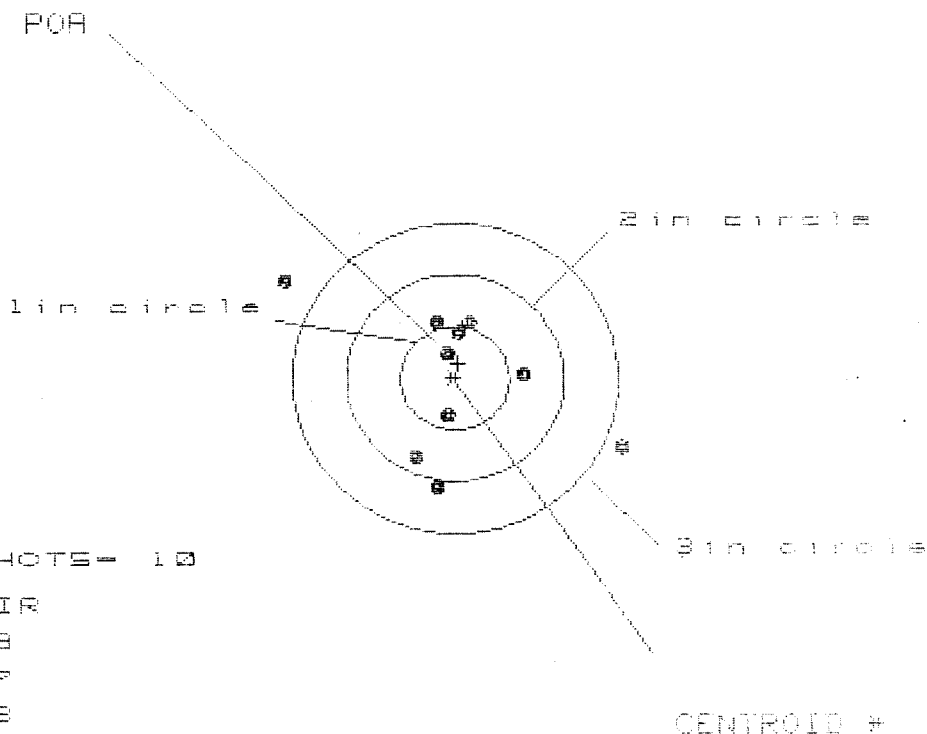
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1078
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107920
THE AMR FOR THIS RIFLE IS: 1.001

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865667

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 3.081

VS= 1.979

GS= 3.491

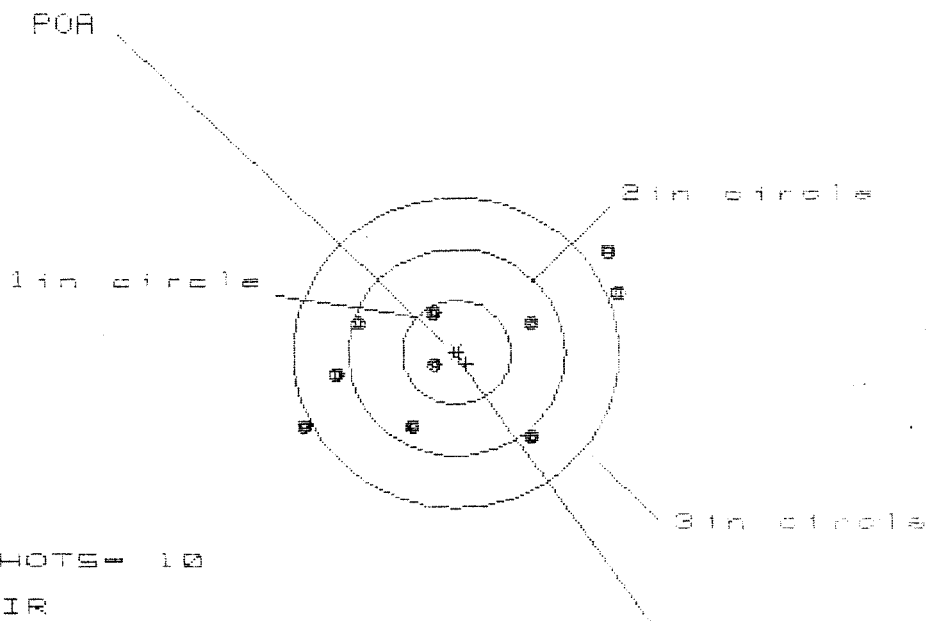
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.559	1.390	.593
MINIMUM X	-1.522	-.578	-.404
MAXIMUM Y	.963	.683	.612
MINIMUM Y	-1.016	-.909	-.980
CENTROID X	-.032	.137	-.037
CENTROID Y	-.145	-.252	-.181
POA TO CENTROID in.	.149	.287	.184
MIN RADIUS	.245	.373	.280
MEAN RADIUS	.829	.732	.604
MAX RADIUS	1.801	1.503	.993
HORIZONTAL SPREAD	3.081	1.968	.997
VERTICAL SPREAD	1.979	1.592	1.592
EXTREME SPREAD	3.491	2.148	1.627
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

5 Nov 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.881

VS= 1.716

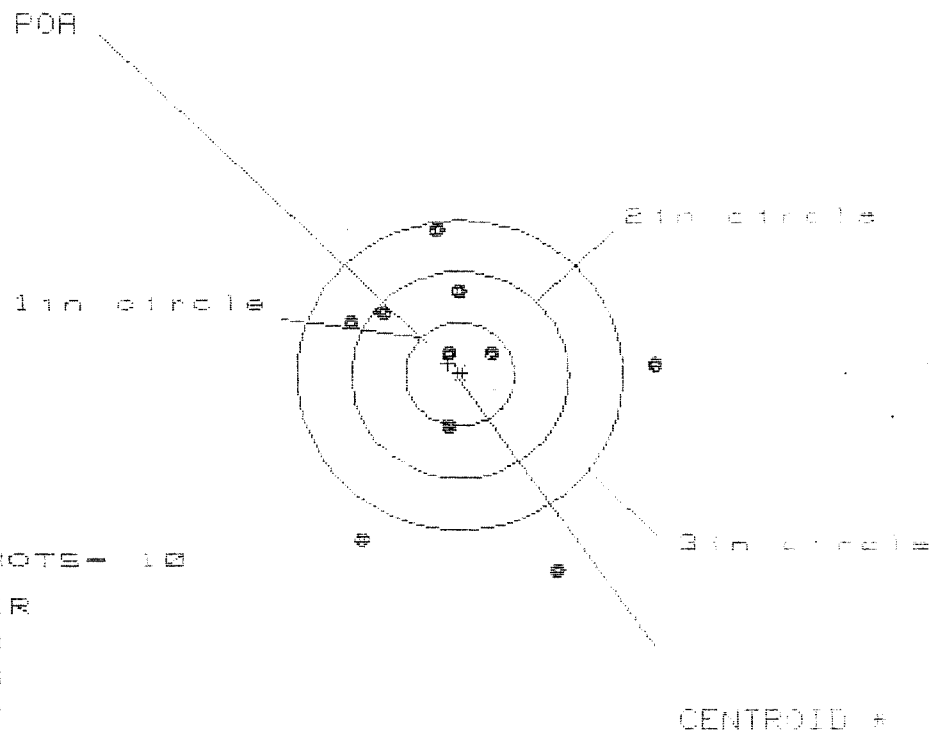
GS= 3.210

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.479	1.630	1.679
MINIMUM X	:	-1.402	-1.251	-1.047
MAXIMUM Y	:	.944	.663	.537
MINIMUM Y	:	-.772	-.667	-.584
CENTROID X	:	-.092	-.243	-.447
CENTROID Y	:	.112	.007	-.076
POA TO CENTROID in.	:	.145	.243	.453
MIN RADIUS	:	.269	.085	.136
MEAN RADIUS	:	1.017	.905	.772
MAX RADIUS	:	1.658	1.760	1.212
HORIZONTAL SPREAD	:	2.881	2.881	2.126
VERTICAL SPREAD	:	1.716	1.330	1.121
EXTREME SPREAD	:	3.210	3.139	2.353
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

5 Nov 1981

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CENTERFIRE PATTERNS # 3



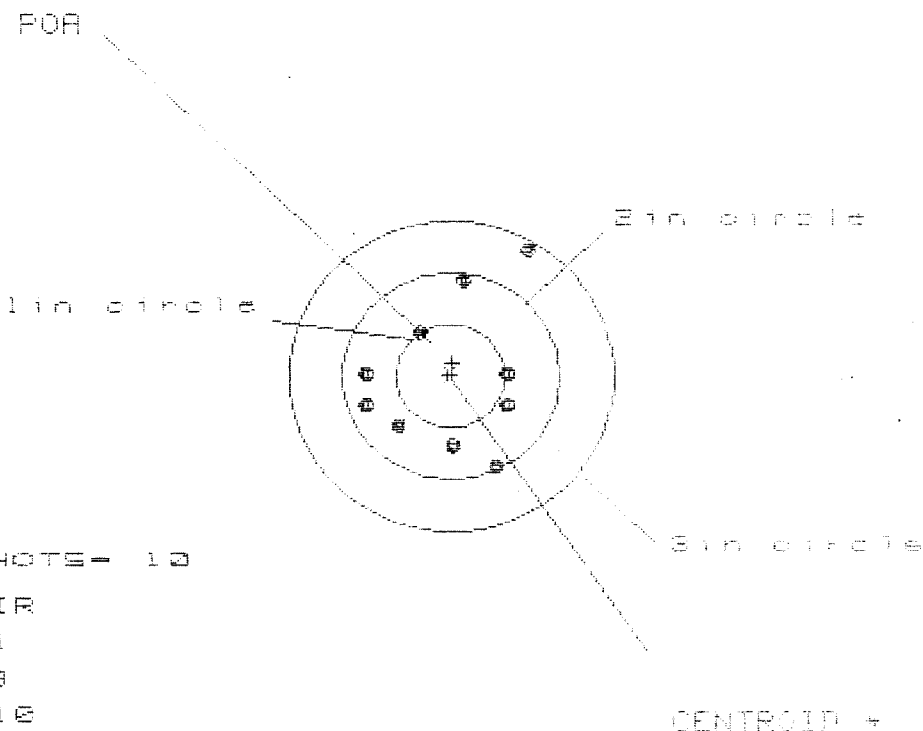
OF SHOTS - 10
 # IN CIR
 1in = 3
 2in = 5
 3in = 7
 HS = 2.849
 VS = 3.366
 GS = 3.552

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.794	1.899	.635
MINIMUM X	:	-1.054	-.950	-1.712
MAXIMUM Y	:	1.443	1.229	1.218
MINIMUM Y	:	-1.923	-1.768	-1.779
CENTROID X	:	.106	.002	-.236
CENTROID Y	:	-.105	.109	.120
POA TO CENTROID in.	:	.149	.109	.264
MIN RADIUS	:	.210	.032	.246
MEAN RADIUS	:	1.120	.948	.837
MAX RADIUS	:	2.141	1.928	1.957
HORIZONTAL SPREAD	:	2.849	2.849	1.347
VERTICAL SPREAD	:	3.366	2.997	2.997
EXTREME SPREAD	:	3.552	3.153	3.073
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.528

VS= 2.063

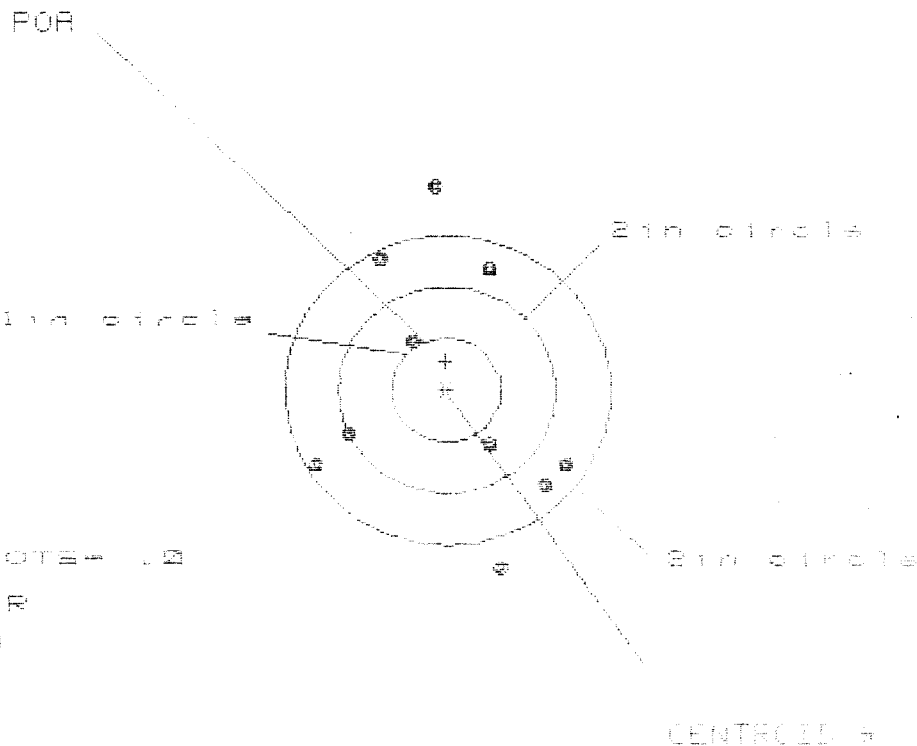
GS= 2.091

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.708	.640	.708
MINIMUM X	:	-.820	-.742	-.674
MAXIMUM Y	:	1.203	1.015	.935
MINIMUM Y	:	-.860	-.727	-.615
CENTROID X	:	-.016	-.094	-.162
CENTROID Y	:	-.125	-.258	-.168
POA TO CENTROID in.	:	.126	.275	.208
MIN RADIUS	:	.478	.492	.448
MEAN RADIUS	:	.785	.698	.667
MAX RADIUS	:	1.396	1.034	.961
HORIZONTAL SPREAD	:	1.528	1.382	1.382
VERTICAL SPREAD	:	2.063	1.742	1.540
EXTREME SPREAD	:	2.091	1.776	1.544
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Nov 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10
 # IN CIR
 1in = 0
 2in = 2
 3in = 8
 HS = 2.341
 VS = 3.675
 GS = 3.728

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.088	1.015	1.137
MINIMUM X	:	-1.253	-1.266	-1.284
MAXIMUM Y	:	1.991	1.494	1.301
MINIMUM Y	:	-1.684	-1.462	-1.885
CENTROID X	:	.008	.021	-.041
CENTROID Y	:	-.276	-.498	-.315
FOR TO CENTROID in.	:	.277	.498	.317
MIN RADIUS	:	.585	.426	.591
MEAN RADIUS	:	1.253	1.150	1.095
MAX RADIUS	:	1.995	1.597	1.404
HORIZONTAL SPREAD	:	2.341	2.341	2.341
VERTICAL SPREAD	:	3.675	2.946	2.166
EXTREME SPREAD	:	3.728	3.139	2.593
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665667

ORDER NO.

5716

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



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