

06522327

MODEL 700™ M24

Model S&S™

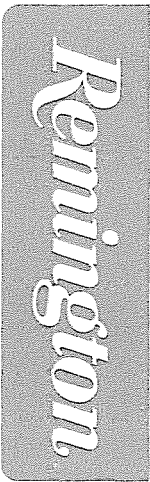
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

* Includes 1 in chamber.



Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6522322	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			
 5716 C6522322			

UPC



0 47700 25716 7

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522322
17 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.485177
1 TO	2	.444713
1 TO	3	.3245
1 TO	4	.556619
1 TO	5	.385892

1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .115
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .164198
THE AMR FOR THIS RIFLE IS: .9746

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522322.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 8

HS = 3.127

VS = 2.974

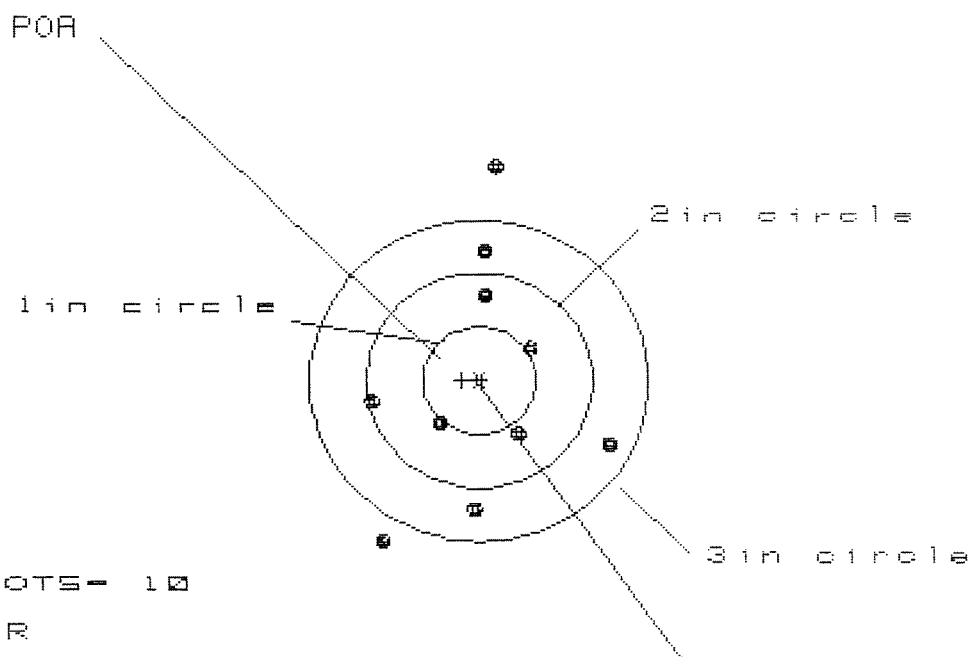
GS = 4.060

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.931	1.907	.911
MINIMUM X	:	-1.196	-.981	-.743
MAXIMUM Y	:	1.850	1.439	1.324
MINIMUM Y	:	-1.124	-.918	-.869
CENTROID X	:	.191	-.024	-.262
CENTROID Y	:	-.446	-.652	-.537
POA TO CENTROID in.	:	.485	.652	.598
MIN RADIUS	:	.478	.423	.590
MEAN RADIUS	:	1.290	1.073	.930
MAX RADIUS	:	2.675	2.117	1.547
HORIZONTAL SPREAD	:	3.127	2.888	1.654
VERTICAL SPREAD	:	2.974	2.357	2.193
EXTREME SPREAD	:	4.060	3.141	2.574
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	8		

17 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG522322.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.054

VS = 3.438

GS = 3.571

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.126	1.140	1.037
MINIMUM X	:	-.928	-.914	-1.017
MAXIMUM Y	:	1.976	1.375	1.219
MINIMUM Y	:	-1.462	-1.242	-1.110
CENTROID X	:	.152	.138	.241
CENTROID Y	:	-.003	-.223	-.067
POA TO CENTROID in.	:	.152	.262	.250
MIN RADIUS	:	.471	.329	.446
MEAN RADIUS	:	1.055	.928	.851
MAX RADIUS	:	1.980	1.491	1.222
HORIZONTAL SPREAD	:	2.054	2.054	2.054
VERTICAL SPREAD	:	3.438	2.617	2.329
EXTREME SPREAD	:	3.571	2.751	2.330
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522322.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 9

HS= 2.131

VS= 2.448

GS= 2.828

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	.603	.516
MINIMUM X	:	-.843	-.700	-.436
MAXIMUM Y	:	.836	.657	.621
MINIMUM Y	:	-1.612	-.605	-.641
CENTROID X	:	.173	.030	.117
CENTROID Y	:	-.122	.057	.093
POA TO CENTROID in.	:	.212	.064	.150
MIN RADIUS	:	.350	.268	.279
MEAN RADIUS	:	.776	.601	.573
MAX RADIUS	:	2.063	.757	.775
HORIZONTAL SPREAD	:	2.131	1.303	.952
VERTICAL SPREAD	:	2.448	1.262	1.262
EXTREME SPREAD	:	2.828	1.368	1.368
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522322.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 1.950

VS= 2.835

GS= 3.051

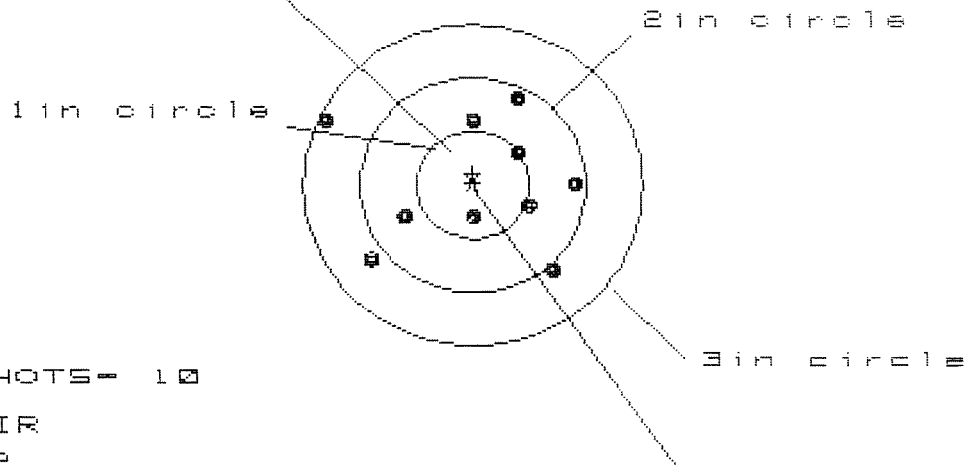
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.938	1.010	.583
MINIMUM X	:	-1.012	-.940	-.813
MAXIMUM Y	:	1.574	1.287	1.154
MINIMUM Y	:	-1.261	-1.086	-1.219
CENTROID X	:	.056	-.016	-.143
CENTROID Y	:	.094	-.081	.052
POA TO CENTROID in.	:	.110	.082	.152
MIN RADIUS	:	.264	.307	.438
MEAN RADIUS	:	.969	.875	.792
MAX RADIUS	:	1.704	1.593	1.412
HORIZONTAL SPREAD	:	1.950	1.950	1.396
VERTICAL SPREAD	:	2.835	2.373	2.373
EXTREME SPREAD	:	3.051	3.051	2.752
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522322.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.143

VS= 1.596

GS= 2.414

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.850	.706	.575
MINIMUM X	:	-1.293	-1.050	-.837
MAXIMUM Y	:	.766	.833	.752
MINIMUM Y	:	-.830	-.763	-.844
CENTROID X	:	.003	.147	.278
CENTROID Y	:	-.109	-.176	-.095
POA TO CENTROID in.	:	.109	.229	.294
MIN RADIUS	:	.254	.253	.293
MEAN RADIUS	:	.783	.688	.597
MAX RADIUS	:	1.429	1.234	.922
HORIZONTAL SPREAD	:	2.143	1.756	1.412
VERTICAL SPREAD	:	1.596	1.596	1.596
EXTREME SPREAD	:	2.414	1.972	1.616
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522322
31 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.608412
1 TO	2	.972371
1 TO	3	1.69109
1 TO	4	.744009
1 TO	5	.746545

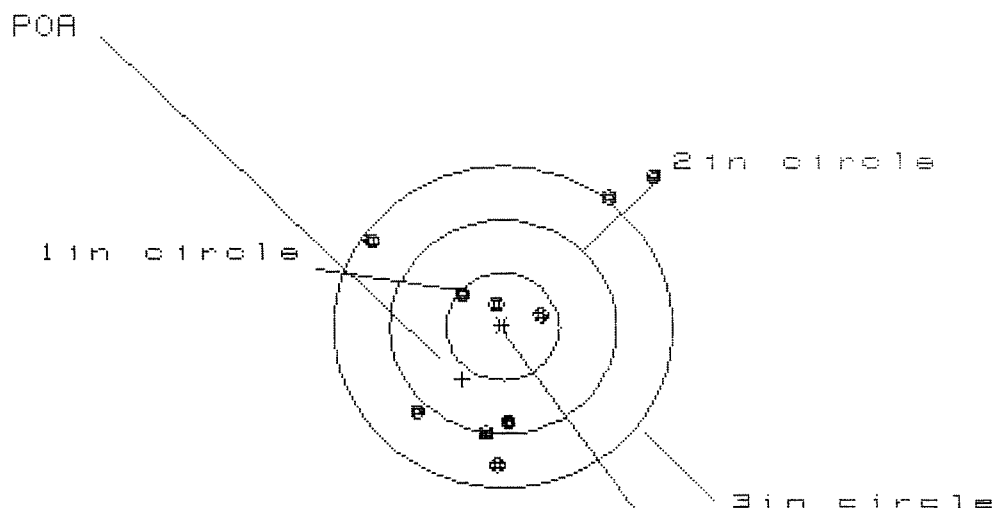
$\begin{matrix} 1 & 4 \\ + & \swarrow \searrow \\ & 2 & 3 \end{matrix}$
 -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .9976
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .163
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.01083
 THE AMR FOR THIS RIFLE IS: .8554

31 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522322

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.496

VS= 2.729

GS= 3.069

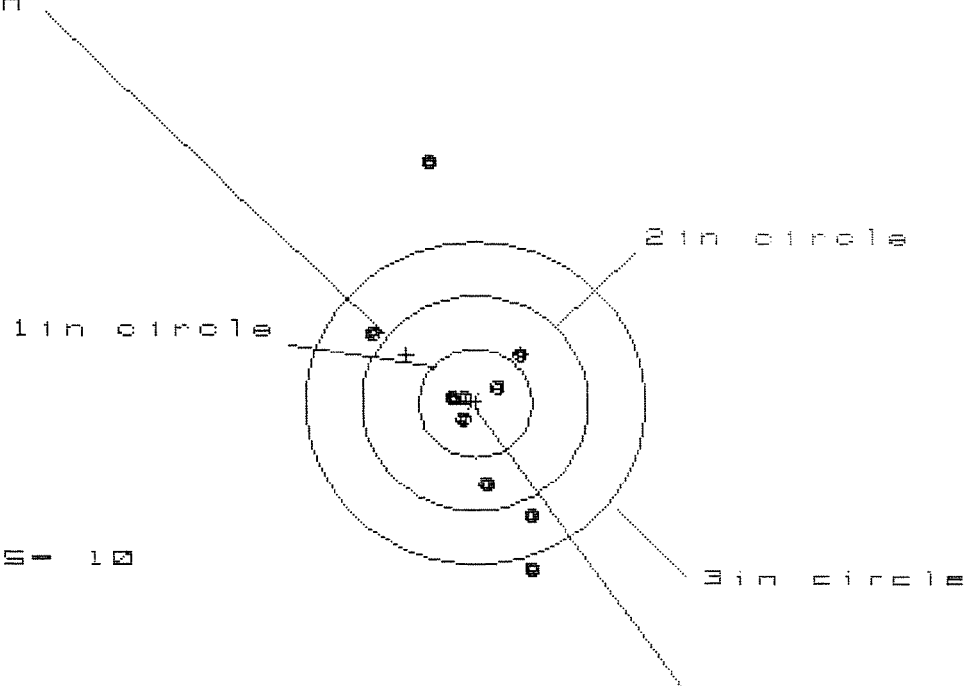
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.090	.581
MINIMUM X	:	-1.156	-1.007	-.871
MAXIMUM Y	:	1.392	1.324	1.130
MINIMUM Y	:	-1.337	-1.182	-1.017
CENTROID X	:	.362	.213	.077
CENTROID Y	:	.489	.334	.169
POA TO CENTROID in.	:	.608	.397	.186
MIN RADIUS	:	.279	.416	.594
MEAN RADIUS	:	1.021	.908	.799
MAX RADIUS	:	1.932	1.715	1.427
HORIZONTAL SPREAD	:	2.496	2.097	1.452
VERTICAL SPREAD	:	2.729	2.506	2.147
EXTREME SPREAD	:	3.069	2.700	2.408
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522322

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 1.387

VS= 3.789

GS= 3.896

CENTROID #

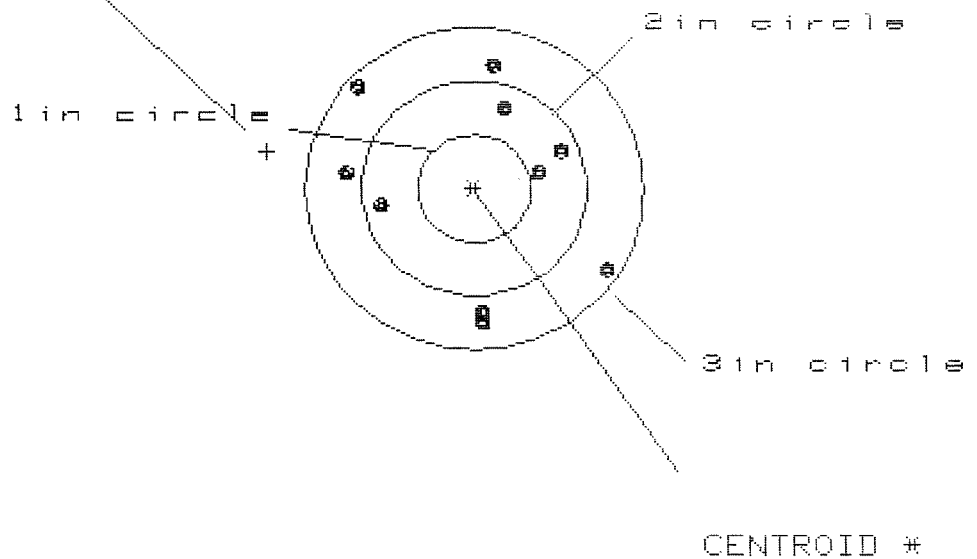
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.503	.456	.510
MINIMUM X	:	-.884	-.931	-.877
MAXIMUM Y	:	2.225	.851	.686
MINIMUM Y	:	-1.564	-1.317	-.993
CENTROID X	:	.607	.654	.600
CENTROID Y	:	-.452	-.699	-.534
POA TO CENTROID in.	:	.756	.957	.804
MIN RADIUS	:	.092	.167	.067
MEAN RADIUS	:	.817	.683	.536
MAX RADIUS	:	2.265	1.386	1.116
HORIZONTAL SPREAD	:	1.387	1.387	1.387
VERTICAL SPREAD	:	3.789	2.168	1.679
EXTREME SPREAD	:	3.896	2.561	2.178
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522322

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS = 2.313

VS = 2.339

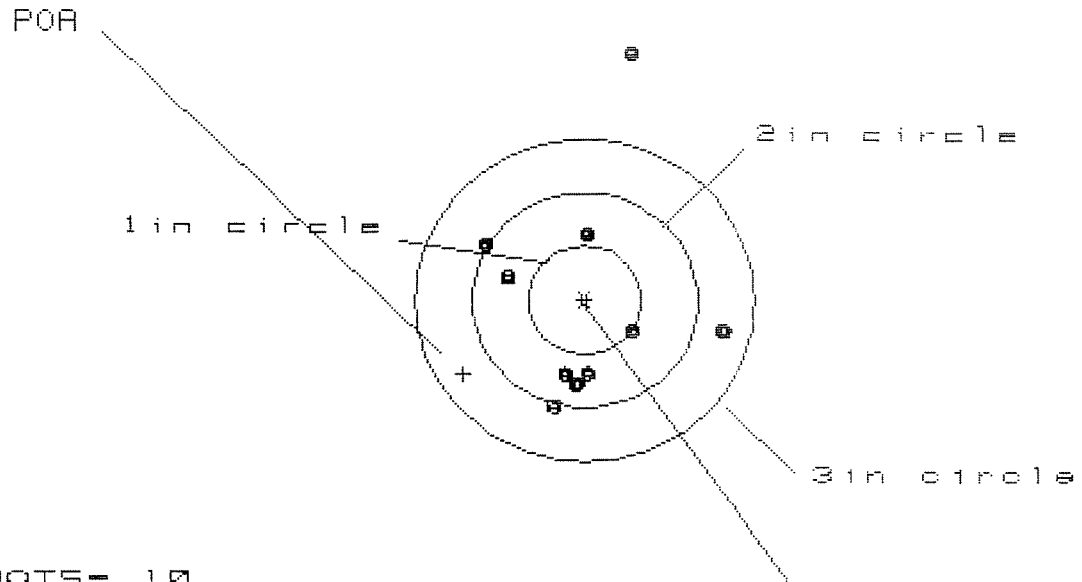
GS = 2.721

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.156	.877	.768
MINIMUM X	:	-1.157	-1.029	-1.137
MAXIMUM Y	:	1.130	1.047	1.152
MINIMUM Y	:	-1.209	-1.292	-1.187
CENTROID X	:	1.832	1.704	1.813
CENTROID Y	:	-.347	-.264	-.369
POA TO CENTROID in.	:	1.865	1.724	1.850
MIN RADIUS	:	.552	.672	.576
MEAN RADIUS	:	1.037	.993	.957
MAX RADIUS	:	1.375	1.310	1.192
HORIZONTAL SPREAD	:	2.313	1.906	1.906
VERTICAL SPREAD	:	2.339	2.339	2.339
EXTREME SPREAD	:	2.721	2.388	2.339
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			10	

31 Aug 1990

FILE: \PATTERNING\CENTERFIRE_PATT\08522322

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 8

3 in = 9

HS = 2.101

VS = 3.292

GS = 3.363

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.267	.646
MINIMUM X	:	-.881	-.834	-.676
MAXIMUM Y	:	2.349	.894	.889
MINIMUM Y	:	-.944	-.683	-.688
CENTROID X	:	1.080	1.033	.875
CENTROID Y	:	.684	.424	.429
POA TO CENTROID in.	:	1.279	1.117	.974
MIN RADIUS	:	.521	.414	.396
MEAN RADIUS	:	.965	.736	.665
MAX RADIUS	:	2.387	1.268	.990
HORIZONTAL SPREAD	:	2.101	2.101	1.322
VERTICAL SPREAD	:	3.292	1.577	1.577
EXTREME SPREAD	:	3.363	2.239	1.603
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522322

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.281

VS= 3.761

GS= 3.771

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	1.077	.946
MINIMUM X	:	-1.172	-1.204	-1.335
MAXIMUM Y	:	2.271	1.017	.882
MINIMUM Y	:	-1.490	-1.238	-1.373
CENTROID X	:	1.107	1.139	1.270
CENTROID Y	:	.441	.189	.324
POA TO CENTROID in.	:	1.191	1.154	1.311
MIN RADIUS	:	.437	.538	.481
MEAN RADIUS	:	1.154	1.030	.925
MAX RADIUS	:	2.289	1.558	1.584
HORIZONTAL SPREAD	:	2.281	2.281	2.281
VERTICAL SPREAD	:	3.761	2.255	2.255
EXTREME SPREAD	:	3.771	2.864	2.864
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522322

DATE 8/29/90

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.56	2.50	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.49	2.46	2.11	
PULL #3	2.49	2.49	2.48	2.30	
PULL #4	2.36	2.39	2.42	2.20	
PULL #5	2.45	2.49	2.40	2.29	
TOTAL	12.02	12.42	12.26	11.18	
AVG.	2.404	2.484	2.452	2.236	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.52		
PULL #2	3.30	3.43		
PULL #3	3.36	3.54		
PULL #4	3.27	3.34		
PULL #5	3.39	3.40		
TOTAL	16.80	17.23		
AVG.	3.36	3.446		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.15		4.19
PULL #2	4.13	4.21		4.15
PULL #3	4.46	4.29		4.08
PULL #4	4.14	4.27		4.10
PULL #5	4.21	4.12		4.13
TOTAL	21.37	21.04		20.65
AVG.	4.274	4.208		4.13

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522322

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7 12 90	RW
600	Proof		7 12 90	RW
607	Check Headspace		7 12 90	RW
610	Dis-assemble Gun		7 12 90	RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7/17/90	LL
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/90	SL

BARBER - M24 0005169

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/29/90	WB
	G) Safety Off Force	2	2	2			8/29/90	WB
	H) Trigger Pull Test & Retainability						8/29/90	SL
	I) Firing Pin Indent	.022 .0235	.022 .0235	.0225 .0235			8/29/90	WB
	J) Assemble Stock						8/30/90	RW
	K) Assemble Swivel Studs						9/5/90	JS
	L) Attach Front and Rear Sight Assemblies						8/30/90	RW
	M) Iron Sight Alignment						8/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/30/90	RW
	O) Attach Scope to Rifle						8/30/90	RW
	P) Detach & Attach Scope 20 Times						8/30/90	RW
640	Gallery Target & Test						8-31-90	DAH
	A) Time						8-31-90	DAH
	B) Malfunctions						8-31-90	DAH
	C) Pierced Primers						8-31-90	DAH
	D) Optical Clarity of Scope						8-31-90	DAH
645	Inspect for Live Ammo						8-31-90	DAH
655	Final Inspection							
	A) Headspace						9/5/90	JS
	B) Trigger Pull	2.28	2.11	2.30	2.20	2.29	9-4-90	SL
	C) Function						9/5/90	JS
660	Pack						9-18-90	SL

2.42

2.45

2.33

2.39

2.38