

C6636331

MODEL 760™ M24

Model **SMS**™

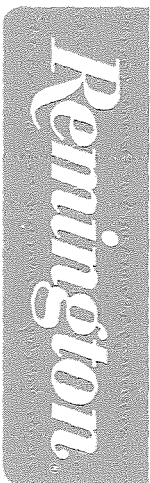
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100RB short OK 73491 DH	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 633

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
		7/29	Shave BRASS	RW
		2nd		
		7/31/91	Reamed Ejector hole & Polish Ejector	RW
		3rd		
		4th		
			FUNCTION	

Remington®

MODEL 700™ M24

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

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

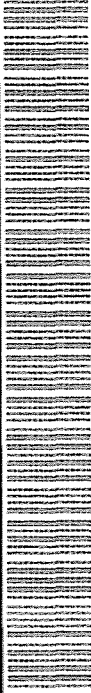


REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6636331

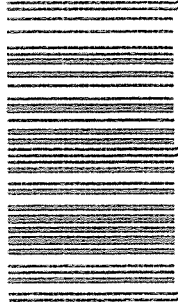
ORDER NO.
5716

20



5716 C6636331

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400033166

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636331

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 0		KCK
	Magnaflux Bolt	5 6 91		KCK
615	Rollmark Caliber	5 6 9		CS
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-20-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/19	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/19	RW
	C) Inspect Ejector Hole for Chamfer		7/19	RW
	D) Oil Firing Pin Ass'y		7/19	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6		6		6	7-18-91	JH
	G) Safety Off Force	4		4		4	7-18-91	JH
	H) Trigger Pull Test & Retainability						7-18-91	JH
	I) Firing Pin Indent	10225		10225		10225	7-18-91	JH
	J) Assemble Stock						7/20/91	
	K) Assemble Swivel Studs						8/4/91	DH
	L) Attach Front and Rear Sight Assemblies						7/20	RW
	M) Iron Sight Alignment						7/20	RW
	N) Detach Front & Rear Sights & place in numbered container						7/20	RW
	O) Attach Scope to Rifle						7/20	RW
	P) Detach & Attach Scope 20 Times						7/20	RW
640	Gallery Target & Test						7/29	AC
	A) Time						7/29	AC
	B) Malfunctions						7/29	AC
	C) Pierced Primers						7/29	AC
	D) Optical Clarity of Scope						7/29	AC
645	Inspect for Live Ammo						7/29	DH
655	Final Inspection							
	A) Headspace						8-5-91	A
	B) Trigger Pull	2.30	2.29	2.35	2.33	2.39	8-5-91	JH
	C) Function						8-5-91	AC
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636331

DATE 7-18-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.47	2.48	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.50	2.46	2.29	
PULL #3	2.52	2.49	2.50	2.35	
PULL #4	2.53	2.46	2.50	2.33	
PULL #5	2.48	2.50	2.48	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.47		
PULL #2	3.47	3.57		
PULL #3	3.45	3.52		
PULL #4	3.45	3.48		
PULL #5	3.52	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	4.32	4.20		4.22
PULL #2	4.52	4.27		4.24
PULL #3	4.60	4.26		4.27
PULL #4	4.20	4.30		4.20
PULL #5	4.20	4.20		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636331
29 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.187043
1 TO	2	.304015
1 TO	3	.344819
1 TO	4	.327416
1 TO	5	.295513

3
4
5 <----POA

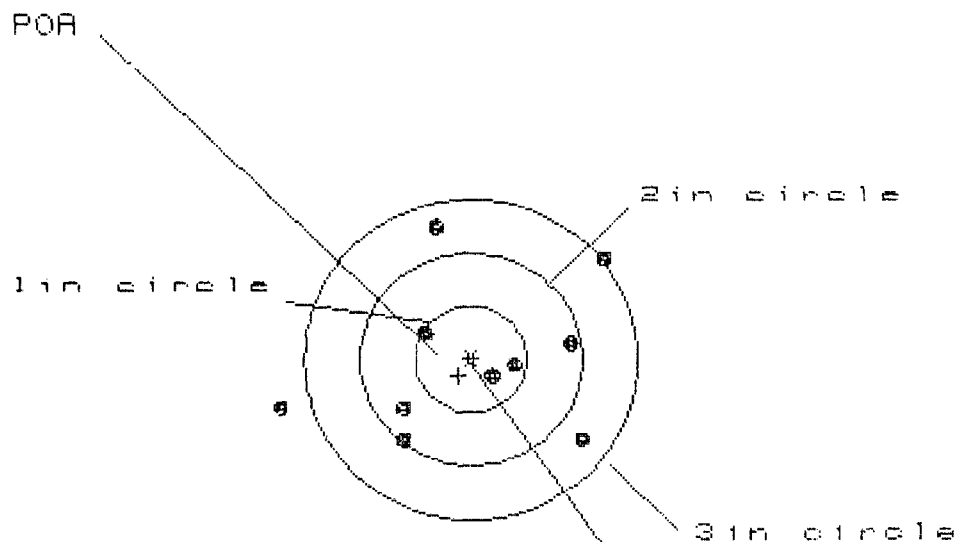
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0944
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1614
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .186979

THE AMR FOR THIS RIFLE IS: .9092

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.911

VS= 2.027

GS= 3.198

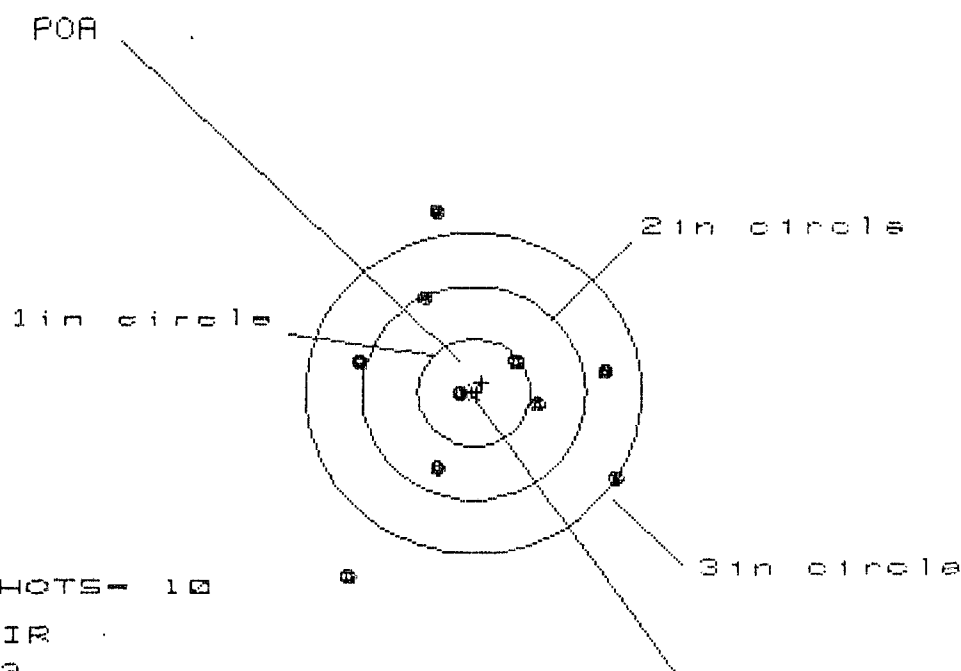
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.184	.992	.909
MINIMUM X	:	-1.727	-.812	-.688
MAXIMUM Y	:	1.251	1.205	1.314
MINIMUM Y	:	-.776	-.822	-.714
CENTROID X	:	.109	.301	.177
CENTROID Y	:	.152	.198	.090
POA TO CENTROID in.	:	.187	.360	.199
MIN RADIUS	:	.193	.161	.102
MEAN RADIUS	:	.946	.836	.759
MAX RADIUS	:	1.776	1.316	1.355
HORIZONTAL SPREAD	:	2.911	1.804	1.597
VERTICAL SPREAD	:	2.027	2.027	2.027
EXTREME SPREAD	:	3.198	2.431	2.374
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.403

VS= 3.441

GS= 3.534

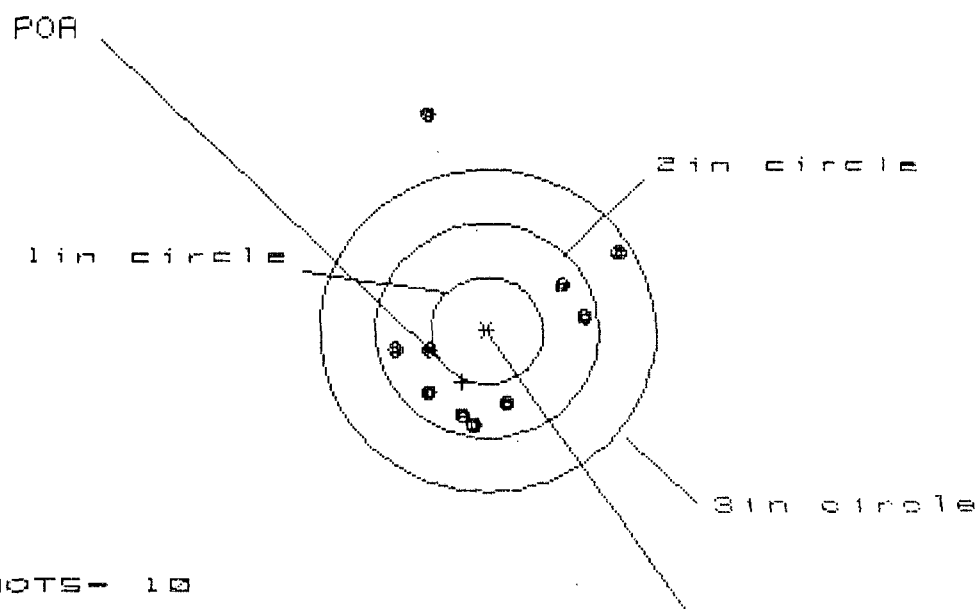
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.245	1.117	1.056
MINIMUM X	:	-1.158	-1.124	-1.185
MAXIMUM Y	:	1.716	1.524	.856
MINIMUM Y	:	-1.726	-.982	-.792
CENTROID X	:	-.071	.057	.118
CENTROID Y	:	-.093	.099	-.091
POA TO CENTROID in.	:	.117	.115	.149
MIN RADIUS	:	.137	.263	.322
MEAN RADIUS	:	1.043	.915	.814
MAX RADIUS	:	2.078	1.598	1.320
HORIZONTAL SPREAD	:	2.403	2.241	2.241
VERTICAL SPREAD	:	3.441	2.506	1.648
EXTREME SPREAD	:	3.534	2.973	2.475
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 8

3 in - 9

HS- 1.962

VS- 2.848

GS- 2.868

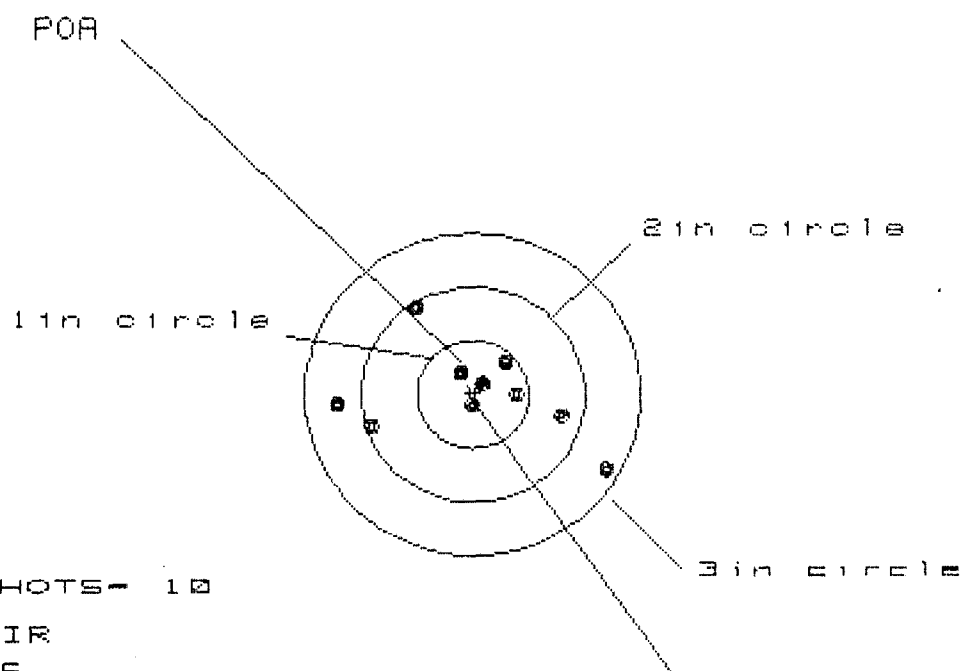
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.145	1.089	.945
MINIMUM X	:	-.817	-.873	-.737
MAXIMUM Y	:	1.974	.940	.724
MINIMUM Y	:	-.874	-.655	-.537
CENTROID X	:	.227	.283	.147
CENTROID Y	:	.476	.257	.139
POA TO CENTROID in.	:	.527	.382	.202
MIN RADIUS	:	.547	.463	.411
MEAN RADIUS	:	.955	.787	.653
MAX RADIUS	:	2.038	1.439	1.065
HORIZONTAL SPREAD	:	1.962	1.962	1.682
VERTICAL SPREAD	:	2.848	1.595	1.261
EXTREME SPREAD	:	2.868	2.173	1.722
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.366

VS= 1.489

GS= 2.429

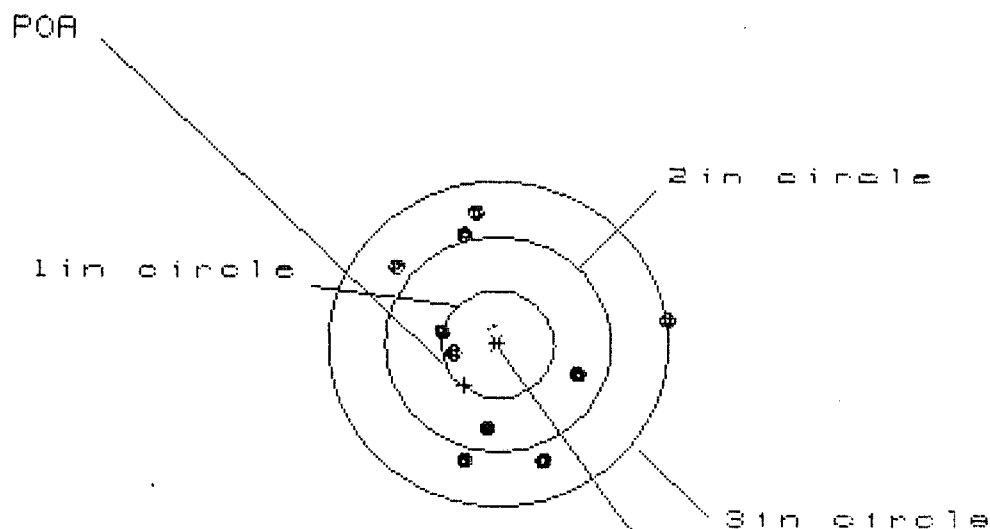
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.194	.892	.762
MINIMUM X	:	-1.172	-1.040	-.926
MAXIMUM Y	:	.828	.754	.731
MINIMUM Y	:	-.661	-.339	-.362
CENTROID X	:	-.090	-.222	-.092
CENTROID Y	:	-.108	-.034	-.011
POA TO CENTROID in.	:	.140	.225	.093
MIN RADIUS	:	.115	.112	.123
MEAN RADIUS	:	.656	.588	.494
MAX RADIUS	:	1.365	1.056	.995
HORIZONTAL SPREAD	:	2.366	1.932	1.689
VERTICAL SPREAD	:	1.489	1.093	1.093
EXTREME SPREAD	:	2.429	1.936	1.689
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.306

VS= 2.296

GS= 2.377

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.457	.861	.934
MINIMUM X	:	-.849	-.687	-.614
MAXIMUM Y	:	1.175	1.194	1.056
MINIMUM Y	:	-1.121	-1.102	-1.166
CENTROID X	:	.297	.135	.062
CENTROID Y	:	.380	.361	.499
POA TO CENTROID in.	:	.482	.385	.502
MIN RADIUS	:	.395	.231	.232
MEAN RADIUS	:	.946	.854	.787
MAX RADIUS	:	1.468	1.248	1.166
HORIZONTAL SPREAD	:	2.306	1.548	1.548
VERTICAL SPREAD	:	2.296	2.296	2.222
EXTREME SPREAD	:	2.377	2.374	2.223
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636331
14 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.149091
1 TO 2	.167287
1 TO 3	.225428
1 TO 4	.12037
1 TO 5	.106042

4 <----POB

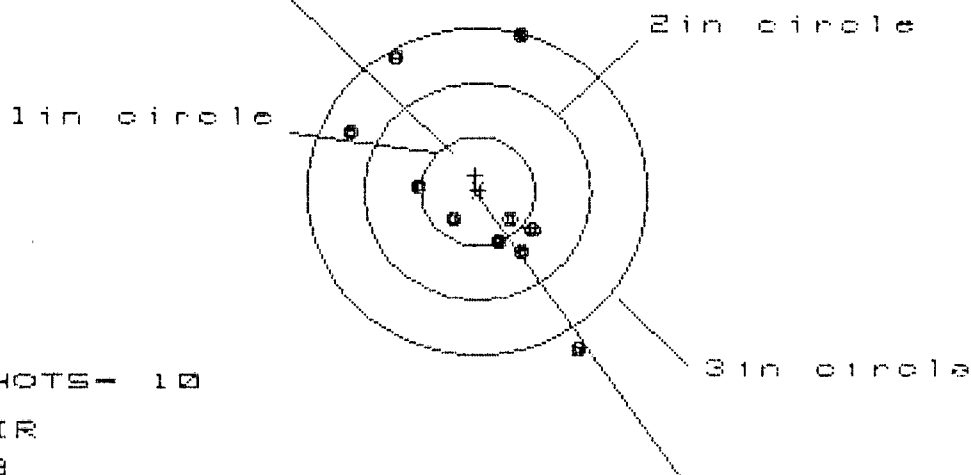
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0538
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0856
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101103
THE AMR FOR THIS RIFLE IS: 1.023

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331.1

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.037

VS= 2.914

GS= 3.109

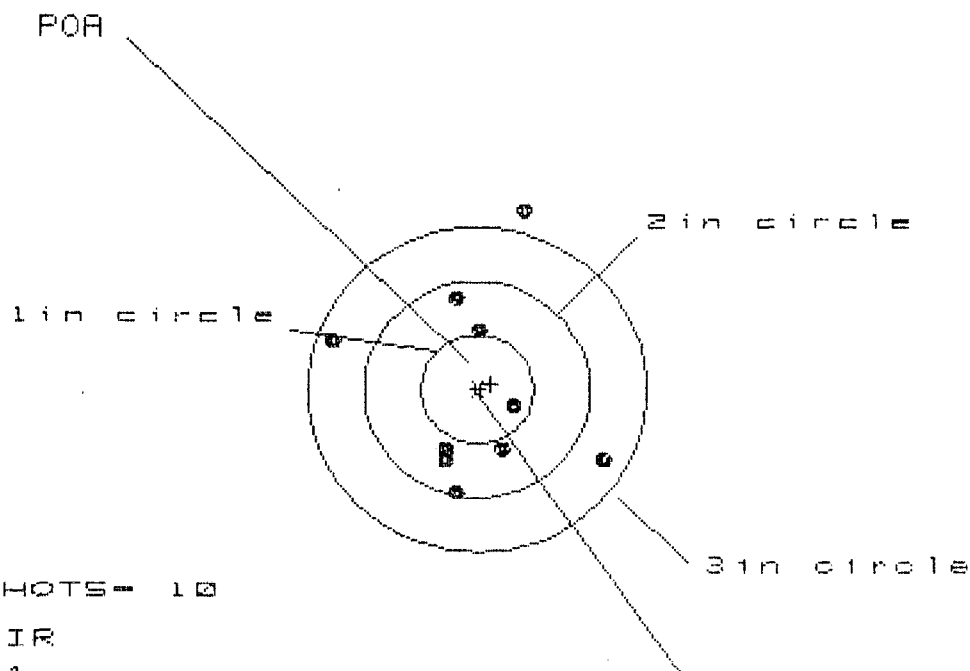
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.885	.543	.607
MINIMUM X	:	-1.152	-1.054	-.990
MAXIMUM Y	:	1.491	1.333	1.240
MINIMUM Y	:	-1.423	-.742	-.576
CENTROID X	:	.018	-.080	-.144
CENTROID Y	:	-.148	.010	-.156
POA TO CENTROID in.	:	.149	.081	.213
MIN RADIUS	:	.344	.393	.280
MEAN RADIUS	:	.895	.839	.714
MAX RADIUS	:	1.676	1.429	1.365
HORIZONTAL SPREAD	:	2.037	1.597	1.597
VERTICAL SPREAD	:	2.914	2.075	1.816
EXTREME SPREAD	:	3.109	2.147	2.147
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636331.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 2

HS= 2.430

VS= 2.673

GS= 2.743

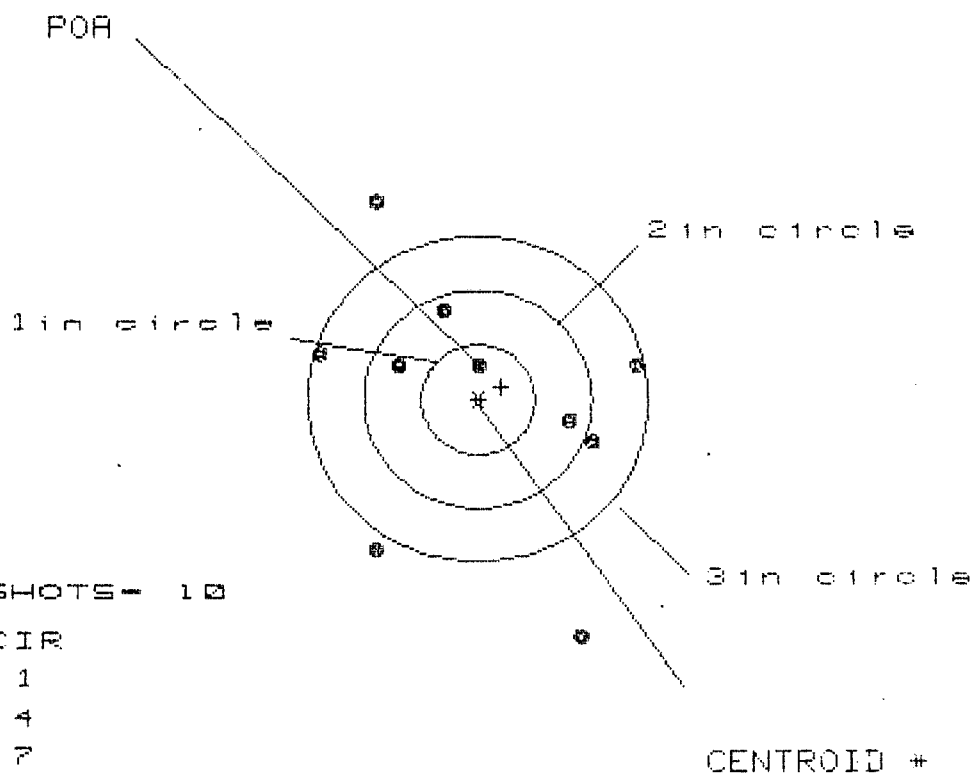
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.155	1.205	1.052
MINIMUM X	:	-1.275	-1.225	-.412
MAXIMUM Y	:	1.689	1.068	1.142
MINIMUM Y	:	-.984	-.796	-.722
CENTROID X	:	-.119	-.169	-.016
CENTROID Y	:	-.052	-.240	-.314
POA TO CENTROID in.	:	.130	.293	.314
MIN RADIUS	:	.325	.341	.218
MEAN RADIUS	:	.912	.783	.682
MAX RADIUS	:	1.748	1.361	1.168
HORIZONTAL SPREAD	:	2.430	2.430	1.464
VERTICAL SPREAD	:	2.673	1.864	1.864
EXTREME SPREAD	:	2.743	2.648	2.003
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.766

VS= 3.917

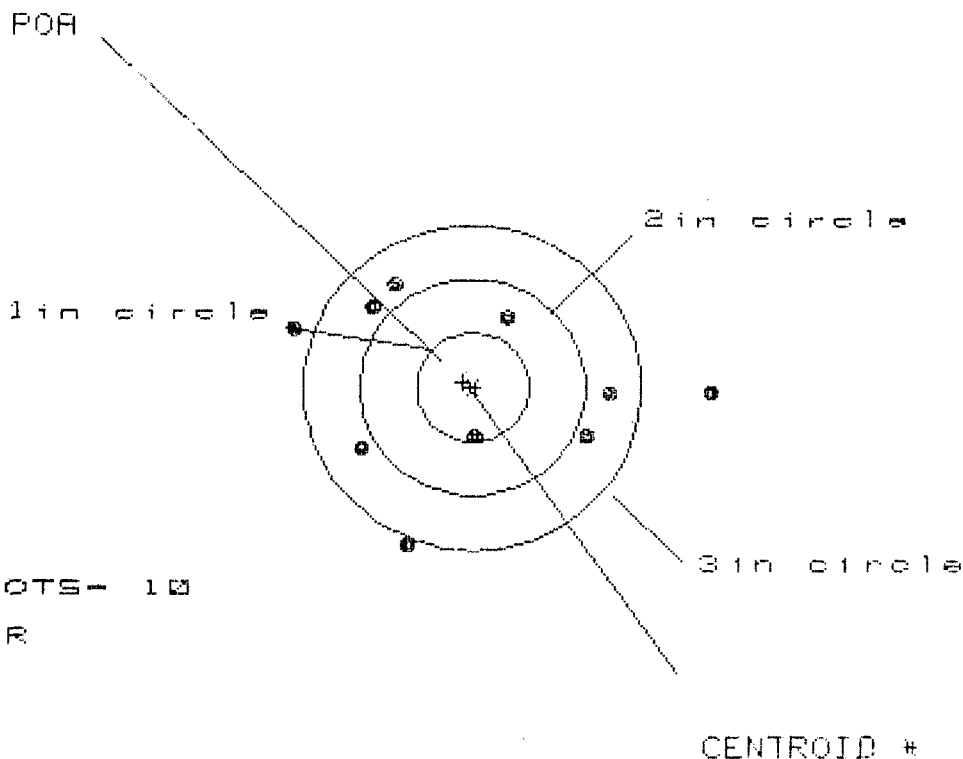
GS= 4.331

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.418	1.523	1.424
MINIMUM X	:	-1.348	-1.243	-1.342
MAXIMUM Y	:	1.770	1.532	.800
MINIMUM Y	:	-2.147	-1.581	-1.390
CENTROID X	:	-.205	-.310	-.211
CENTROID Y	:	-.115	.123	-.068
POA TO CENTROID in.	:	.235	.334	.221
MIN RADIUS	:	.350	.139	.303
MEAN RADIUS	:	1.270	1.098	1.037
MAX RADIUS	:	2.346	1.786	1.673
HORIZONTAL SPREAD	:	2.766	2.766	2.766
VERTICAL SPREAD	:	3.917	3.113	2.190
EXTREME SPREAD	:	4.331	3.113	2.870
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635331.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 3.720

VS= 2.407

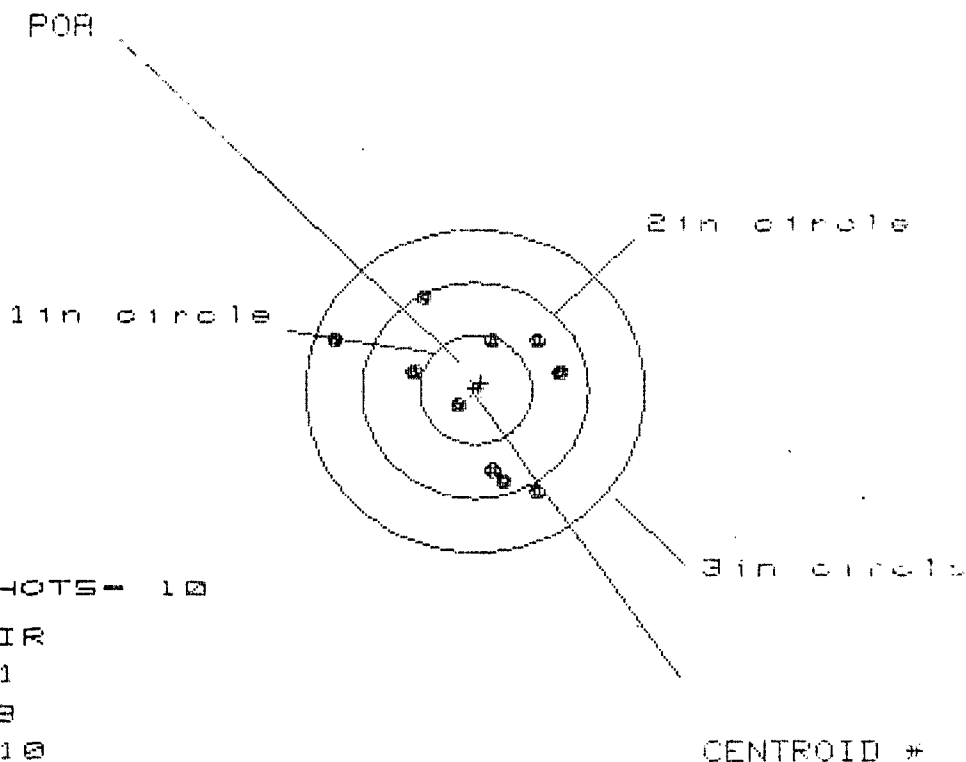
GS= 3.777

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.151	1.484	1.317
MINIMUM X	:	-1.569	-1.330	-.920
MAXIMUM Y	:	.993	.985	1.056
MINIMUM Y	:	-1.414	-1.422	-1.351
CENTROID X	:	.085	-.154	.013
CENTROID Y	:	-.048	-.040	-.112
POA TO CENTROID in.	:	.098	.159	.112
MIN RADIUS	:	.440	.510	.384
MEAN RADIUS	:	1.249	1.133	1.079
MAX RADIUS	:	2.152	1.485	1.441
HORIZONTAL SPREAD	:	3.720	2.814	2.237
VERTICAL SPREAD	:	2.407	2.407	2.407
EXTREME SPREAD	:	3.777	2.883	2.411
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636331.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.029

VS= 1.840

GS= 2.265

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.625	.671
MINIMUM X	:	-1.264	-.738	-.692
MAXIMUM Y	:	.880	.930	.816
MINIMUM Y	:	-.960	-.910	-.900
CENTROID X	:	-.048	.092	.046
CENTROID Y	:	-.065	-.115	-.001
POA TO CENTROID in.	:	.081	.147	.046
MIN RADIUS	:	.173	.267	.285
MEAN RADIUS	:	.790	.723	.681
MAX RADIUS	:	1.341	1.093	.972
HORIZONTAL SPREAD	:	2.029	1.363	1.363
VERTICAL SPREAD	:	1.840	1.840	1.716
EXTREME SPREAD	:	2.265	2.068	1.864
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	