

C65222206

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

Remington®

REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

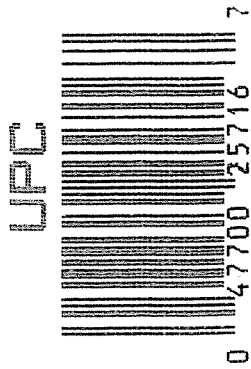
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6522206

ORDER NO.
5716

01

5716 C6522206



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522206
12 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	.487052
1 TO 2	.425146
1 TO 3	.350271
1 TO 4	.156157
1 TO 5	.898809

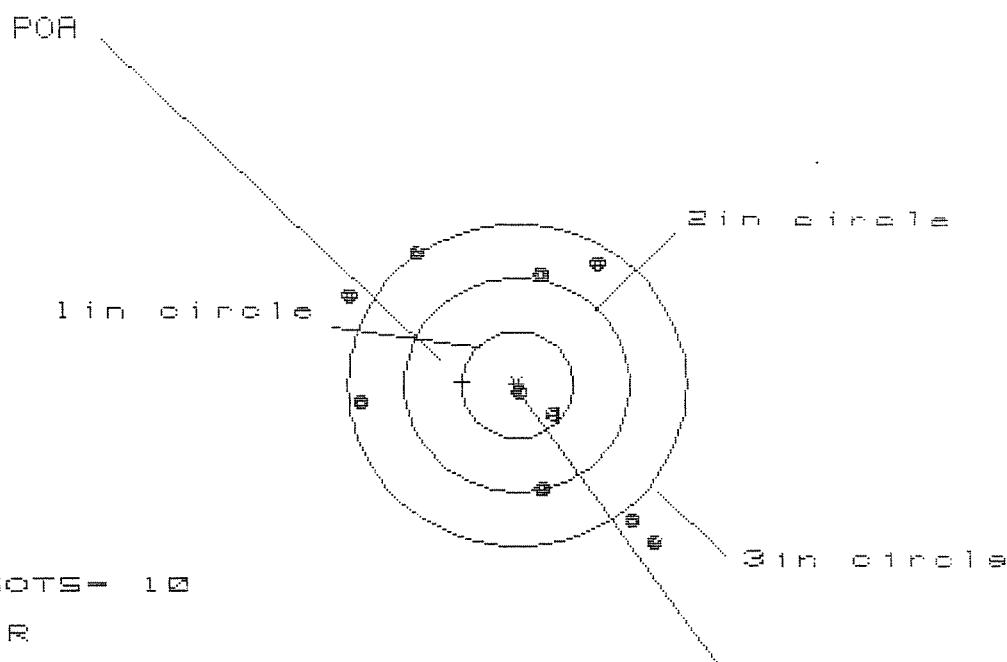
$\sum_{i=1}^5 t_i^2$ < ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .305
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0712
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3132
THE AMR FOR THIS RIFLE IS: .9892

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522286.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 2

3in = 6

HS= 2.768

VS= 2.687

GS= 3.560

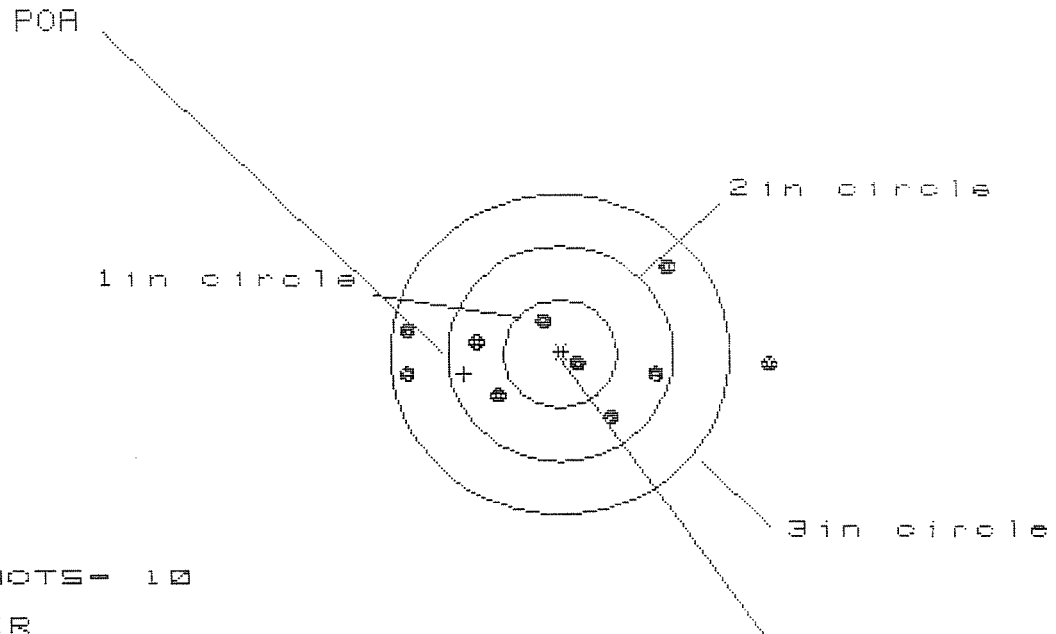
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	1.117	.943
MINIMUM X	-1.533	-1.396	-1.464
MAXIMUM Y	1.243	1.083	1.162
MINIMUM Y	-1.444	-1.429	-1.350
CENTROID X	.486	.349	.523
CENTROID Y	-.032	.128	.049
POA TO CENTROID in.	.487	.372	.526
MIN RADIUS	.048	.259	.119
MEAN RADIUS	1.212	1.153	1.067
MAX RADIUS	1.900	1.814	1.646
HORIZONTAL SPREAD	2.768	2.513	2.407
VERTICAL SPREAD	2.687	2.512	2.512
EXTREME SPREAD	3.560	3.252	3.111
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522286.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 3.245

VS = 1.442

GS = 3.265

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.856	1.184	1.036
MINIMUM X	:	-1.389	-1.182	-1.325
MAXIMUM Y	:	.842	.829	.859
MINIMUM Y	:	-.600	-.613	-.583
CENTROID X	:	.851	.644	.792
CENTROID Y	:	.186	.199	.169
POA TO CENTROID in.	:	.871	.674	.810
MIN RADIUS	:	.144	.335	.186
MEAN RADIUS	:	.951	.839	.780
MAX RADIUS	:	1.860	1.445	1.345
HORIZONTAL SPREAD	:	3.245	2.366	2.361
VERTICAL SPREAD	:	1.442	1.442	1.442
EXTREME SPREAD	:	3.265	2.568	2.568
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522206.1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.608

VS= 2.245

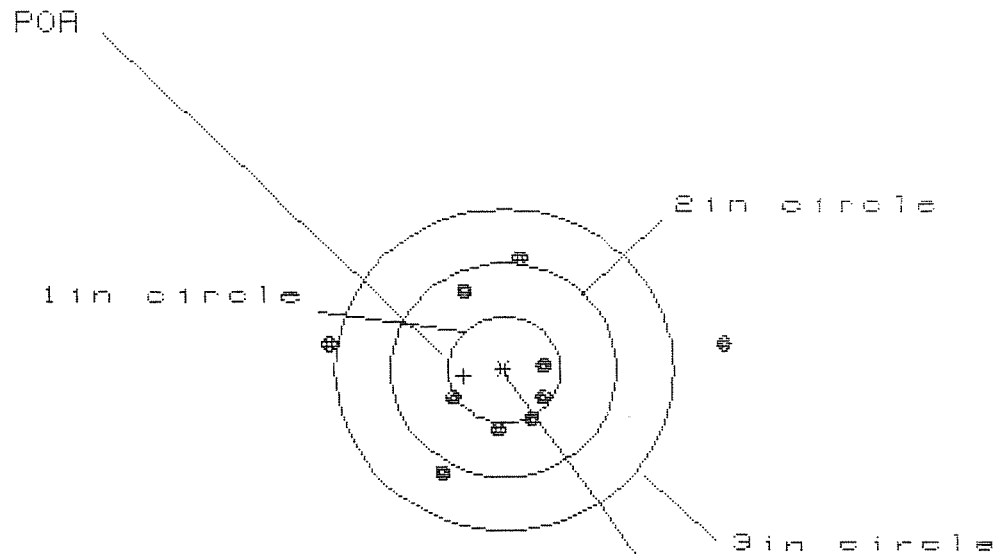
GS= 2.790

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.256	1.105	1.022
MINIMUM X	:	-1.353	-1.177	-1.039
MAXIMUM Y	:	1.241	1.189	1.247
MINIMUM Y	:	-1.004	-1.056	-0.998
CENTROID X	:	.169	.320	.182
CENTROID Y	:	-.181	-.129	-.187
POA TO CENTROID in.	:	.248	.345	.261
MIN RADIUS	:	.617	.482	.605
MEAN RADIUS	:	1.044	.977	.955
MAX RADIUS	:	1.433	1.446	1.311
HORIZONTAL SPREAD	:	2.608	2.282	2.061
VERTICAL SPREAD	:	2.245	2.245	2.245
EXTREME SPREAD	:	2.790	2.587	2.379
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522286.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.460

VS= 1.999

GS= 3.460

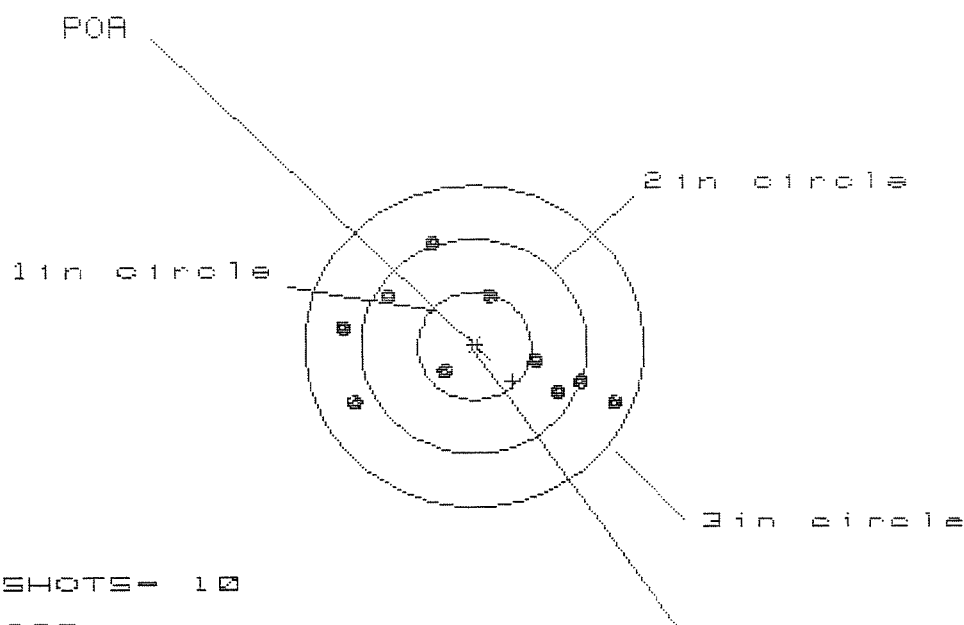
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.949	.541	.379
MINIMUM X	:	-1.511	-1.294	-.476
MAXIMUM Y	:	1.032	1.062	1.096
MINIMUM Y	:	-.967	-.937	-.903
CENTROID X	:	.357	.140	.302
CENTROID Y	:	.056	.026	-.008
POA TO CENTROID in.	:	.361	.143	.302
MIN RADIUS	:	.323	.325	.385
MEAN RADIUS	:	.874	.755	.649
MAX RADIUS	:	1.968	1.322	1.107
HORIZONTAL SPREAD	:	3.460	1.835	.855
VERTICAL SPREAD	:	1.999	1.999	1.999
EXTREME SPREAD	:	3.460	2.097	2.097
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522286.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.347

VS= 1.536

GS= 2.440

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.233	1.043	.933
MINIMUM X	-1.114	-.977	-1.087
MAXIMUM Y	1.002	.948	.874
MINIMUM Y	-.534	-.588	-.586
CENTROID X	-.338	-.475	-.365
CENTROID Y	.327	.381	.455
POA TO CENTROID in.	.470	.609	.583
MIN RADIUS	.321	.288	.370
MEAN RADIUS	.865	.806	.765
MAX RADIUS	1.327	1.101	1.088
HORIZONTAL SPREAD	2.347	2.020	2.020
VERTICAL SPREAD	1.536	1.536	1.460
EXTREME SPREAD	2.440	2.076	2.076
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522206
11 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.271155
1 TO	2	.352881
1 TO	3	.681224
1 TO	4	.141439
1 TO	5	.822052

$\bar{x}$ $\frac{d}{d}$ <----POA

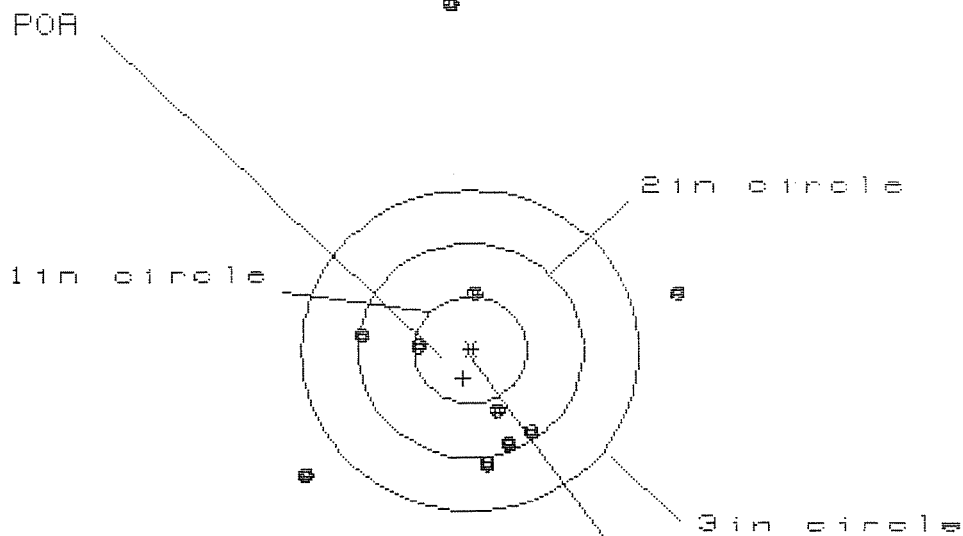
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.268
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .341589

THE AMR FOR THIS RIFLE IS: 1.36

01 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08528200

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.311

VS= 4.472

GS= 4.646

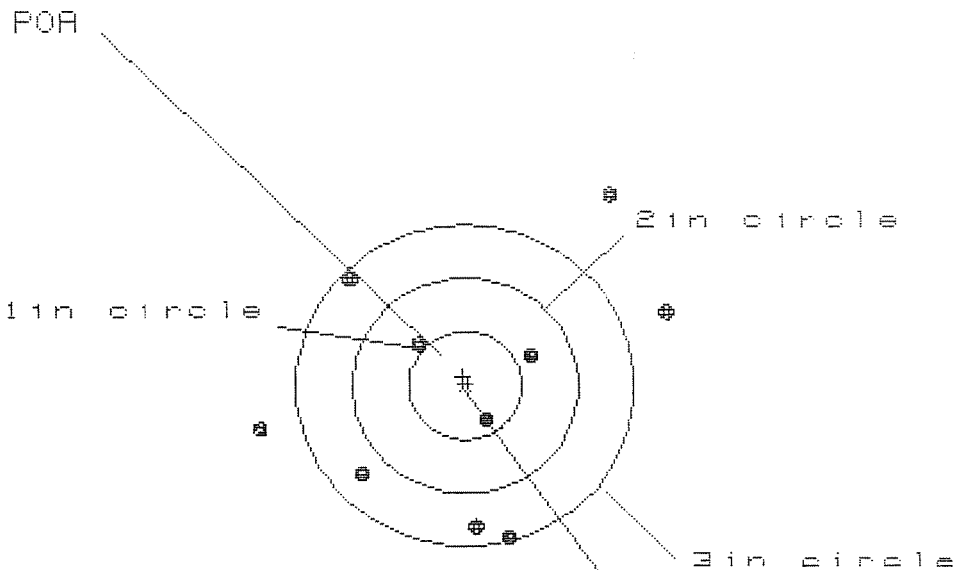
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.870	1.850	.735
MINIMUM X	-1.441	-1.461	-1.230
MAXIMUM Y	3.284	.933	1.023
MINIMUM Y	-1.188	-.823	-.706
CENTROID X	.066	.086	-.145
CENTROID Y	.263	-.102	-.219
POA TO CENTROID in.	.271	.133	.263
MIN RADIUS	.505	.292	.447
MEAN RADIUS	1.280	.973	.836
MAX RADIUS	3.289	2.072	1.418
HORIZONTAL SPREAD	3.311	3.311	1.965
VEPTICAL SPREAD	4.472	1.756	1.729
EXTREME SPREAD	4.646	3.748	2.301
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

11 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522206

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.585

VS= 3.243

GS= 3.882

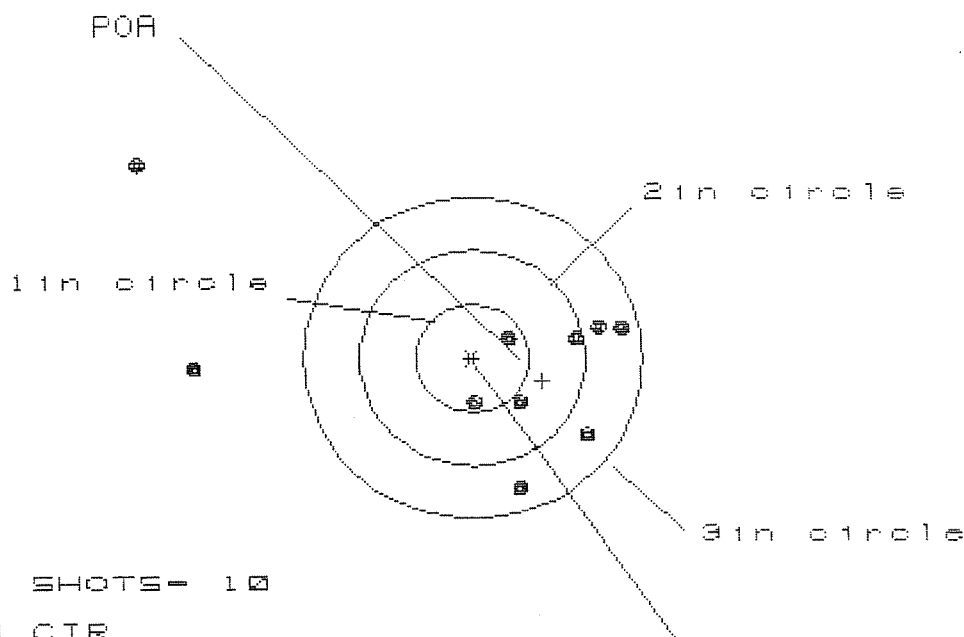
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.729	1.871	1.657
MINIMUM X	:	-1.856	-1.714	-1.133
MAXIMUM Y	:	1.787	1.220	1.199
MINIMUM Y	:	-1.456	-1.258	-1.279
CENTROID X	:	.021	-.121	.093
CENTROID Y	:	-.087	-.285	-.264
POA TO CENTROID in.	:	.089	.310	.280
MIN RADIUS	:	.313	.293	.123
MEAN RADIUS	:	1.295	1.177	1.084
MAX RADIUS	:	2.195	2.062	1.860
HORIZONTAL SPREAD	:	3.585	3.585	2.790
VERTICAL SPREAD	:	3.243	2.478	2.478
EXTREME SPREAD	:	3.882	3.733	3.051
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522206

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 4.339

VS = 3.020

GS = 4.731

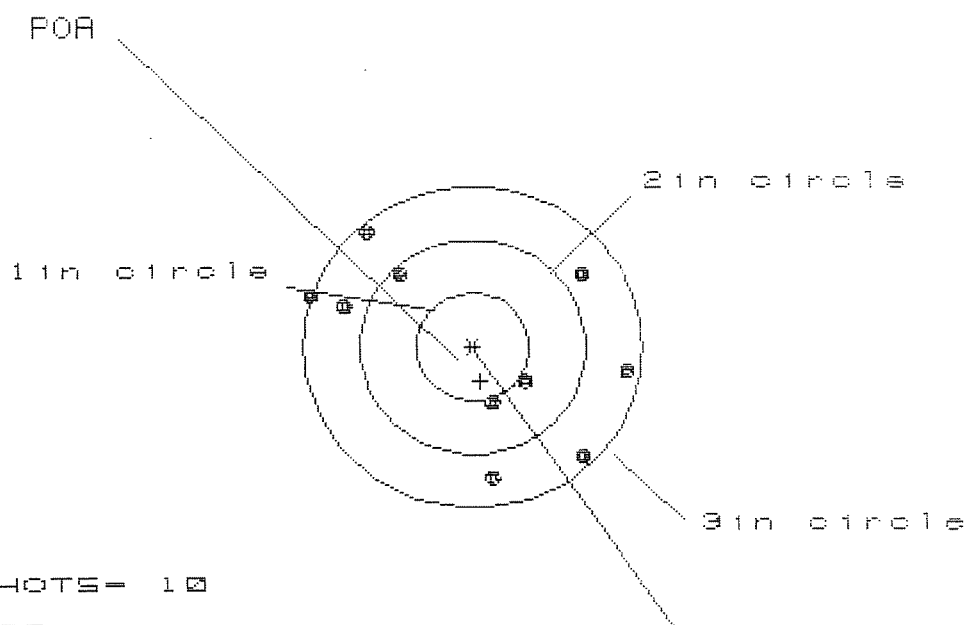
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	.993	.644
MINIMUM X	:	-3.012	-2.791	-.663
MAXIMUM Y	:	1.824	.539	.548
MINIMUM Y	:	-1.196	-.994	-.985
CENTROID X	:	-.613	-.279	.070
CENTROID Y	:	.208	.005	-.004
POR TO CENTROID in.	:	.648	.279	.070
MIN RADIUS	:	.341	.200	.302
MEAN RADIUS	:	1.327	.931	.645
MAX RADIUS	:	3.521	2.792	1.024
HORIZONTAL SPREAD	:	4.339	3.784	1.307
VERTICAL SPREAD	:	3.020	1.533	1.533
EXTREME SPREAD	:	4.731	3.812	1.790
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522206

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.782

VS= 2.300

GS= 2.865

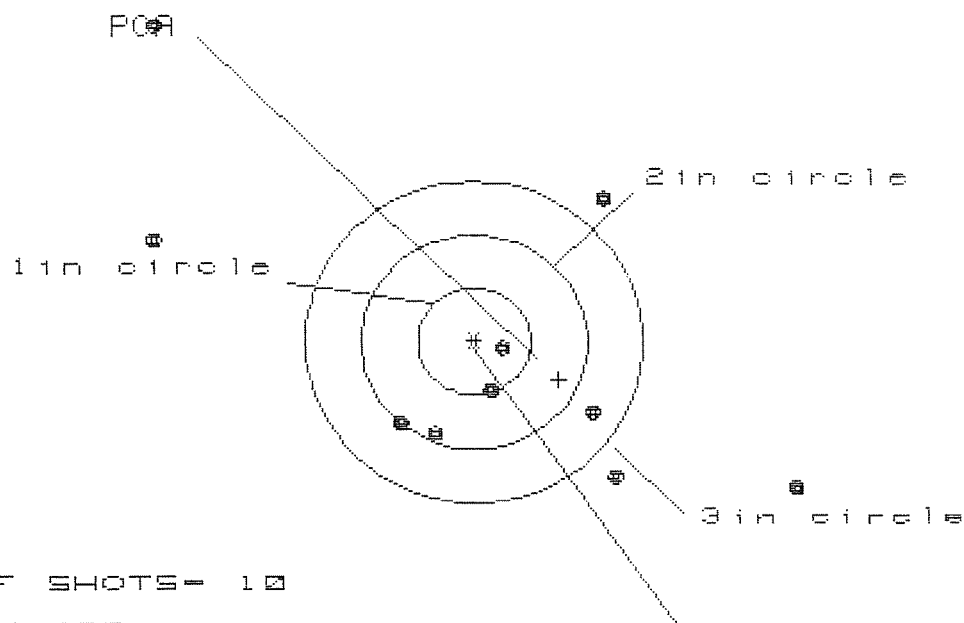
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.172	1.032
MINIMUM X	:	-1.449	-1.280	-1.420
MAXIMUM Y	:	1.049	1.102	.874
MINIMUM Y	:	-1.251	-1.198	-1.060
CENTROID X	:	-.063	.098	.238
CENTROID Y	:	.321	.268	.130
POA TO CENTROID in.:	:	.327	.285	.271
MIN RADIUS	:	.570	.408	.214
MEAN RADIUS	:	1.140	1.069	.955
MAX RADIUS	:	1.525	1.569	1.546
HORIZONTAL SPREAD	:	2.782	2.452	2.452
VERTICAL SPREAD	:	2.300	2.300	1.934
EXTREME SPREAD	:	2.865	2.836	2.557
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522286

CENTERFIRE PATTERNS # 5



PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.850	2.537	1.263
MINIMUM X	-2.841	-3.154	-2.837
MAXIMUM Y	2.957	1.679	1.555
MINIMUM Y	-1.324	-.996	-1.007
CENTROID X	-.751	-.438	-.755
CENTROID Y	.354	.026	.150
POA TO CENTROID in.	.830	.439	.770
MIN RADIUS	.240	.223	.297
MEAN RADIUS	1.760	1.389	1.240
MAX RADIUS	4.083	3.403	3.063
HORIZONTAL SPREAD	5.691	5.691	4.100
VERTICAL SPREAD	4.281	2.675	2.562
EXTREME SPREAD	7.101	6.129	4.635
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		5	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522206

DATE 8/31/90

TESTER 84

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.42	2.50	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.42	2.37	2.22	
PULL #3	2.54	2.47	2.48	2.28	
PULL #4	2.42	2.45	2.45	2.29	
PULL #5	2.26	2.52	2.50	2.27	
TOTAL	11.90	12.28	12.44	11.33	
AVG.	2.38	2.456	2.488	2.266	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.33		
PULL #2	3.22	3.30		
PULL #3	3.30	3.25		
PULL #4	3.31	3.32		
PULL #5	3.25	3.39		
TOTAL	16.46	16.69		
AVG.	3.292	3.338		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.26		4.33
PULL #2	4.43	4.34		4.30
PULL #3	4.34	4.32		4.30
PULL #4	4.32	4.30		4.30
PULL #5	4.31	4.31		4.29
TOTAL	21.51	21.53		21.51
AVG.	4.302	4.306		4.302

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522206

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/1/90	J.S.
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RB		8/14/90	WS
620	Apply Coatings (Barrel Action)		8/24/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	RU

BARBER - M24 0003051

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/5/90	WB
	G) Safety Off Force	2	2	2			9/5/90	WB
	H) Trigger Pull Test & Retainability						8/31/90	JF
	I) Firing Pin Indent	.0225	.0225	.0225			9/5/90	WB
	J) Assemble Stock						9/10/90	RW
	K) Assemble Swivel Studs						9/15/90	Q28
	L) Attach Front and Rear Sight Assemblies						9/10/90	RW
	M) Iron Sight Alignment						9/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	RW
	O) Attach Scope to Rifle						9/10/90	RW
	P) Detach & Attach Scope 20 Times						9/10/90	RW
640	Gallery Target & Test						9/11/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/11/90	NF
655	Final Inspection							
	A) Headspace						9/15/90	Q28
	B) Trigger Pull	2.27	2.27	2.28	2.29	2.27	9-15-90	JF
	C) Function						9/15/90	Q28
660	Pack						9/19/90	NF