

C6522203

MODEL 760™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington[®]


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

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

MODEL 700TM M24

SERIAL NO.
C6522203

ORDER NO.
5716

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

01


5716 C6522203

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522203
31 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.559709
1 TO	2	.450884
1 TO	3	1.25172
1 TO	4	1.05743
1 TO	5	1.37946

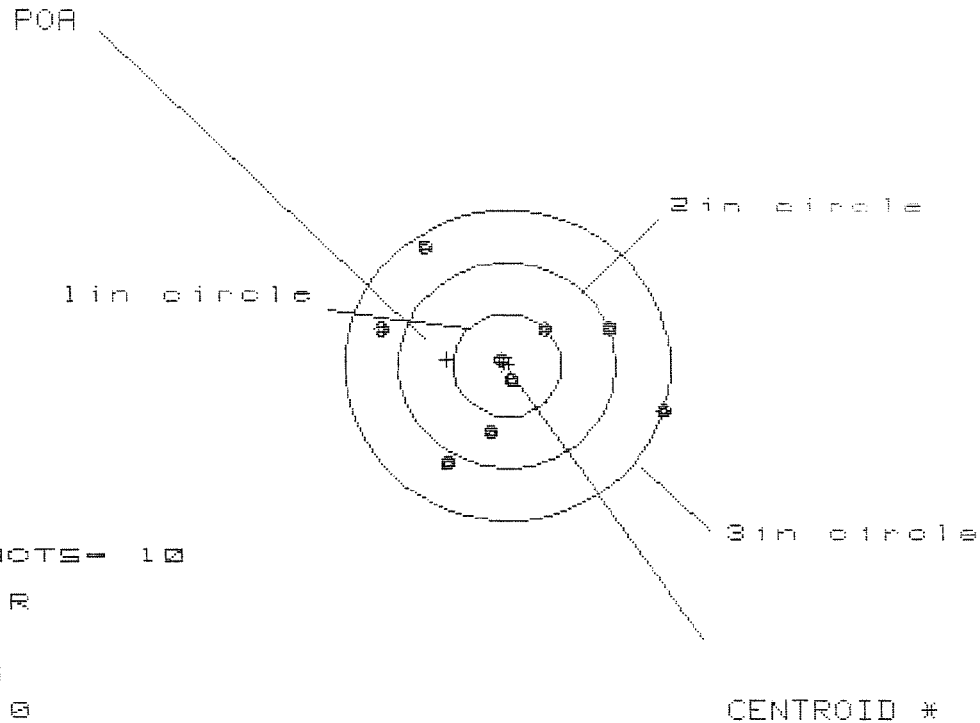
$$\frac{5}{4+1} \times \frac{2}{3} \times \text{POA}$$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1448
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .059
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156359
 THE AMR FOR THIS RIFLE IS: .784

30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522203

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS = 2.541

VS = 2.044

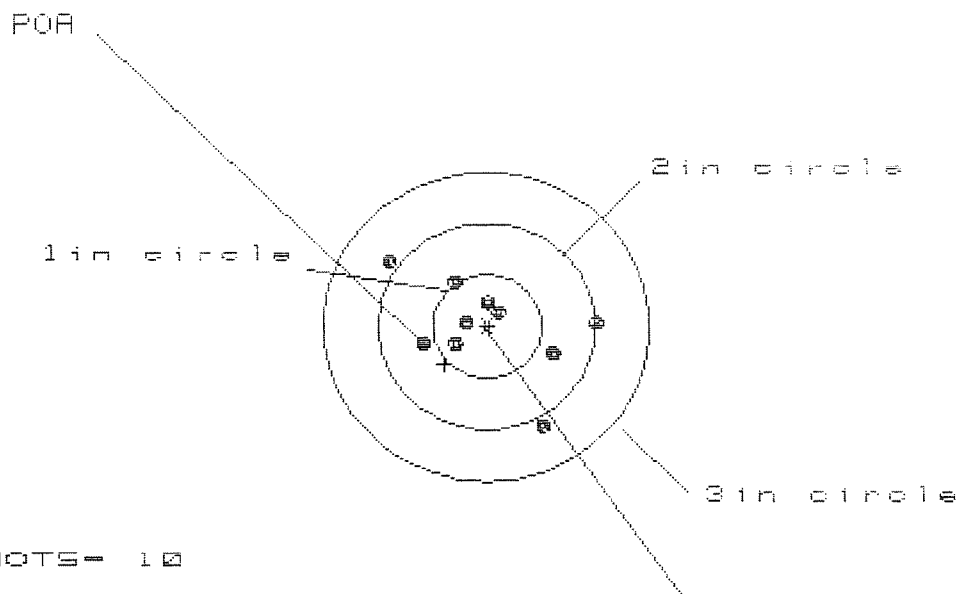
GS = 2.694

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.078	1.001
MINIMUM X	-1.148	-.993	-1.070
MAXIMUM Y	1.128	1.075	.415
MINIMUM Y	-.916	-.969	-.835
CENTROID X	.557	.402	.479
CENTROID Y	-.055	-.002	-.136
POA TO CENTROID in.	.560	.402	.498
MIN RADIUS	.089	.062	.105
MEAN RADIUS	.760	.687	.600
MAX RADIUS	1.474	1.237	1.147
HORIZONTAL SPREAD	2.541	2.071	2.071
VERTICAL SPREAD	2.044	2.044	1.250
EXTREME SPREAD	2.694	2.071	2.071
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

30 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.935

VS= 1.563

GS= 2.098

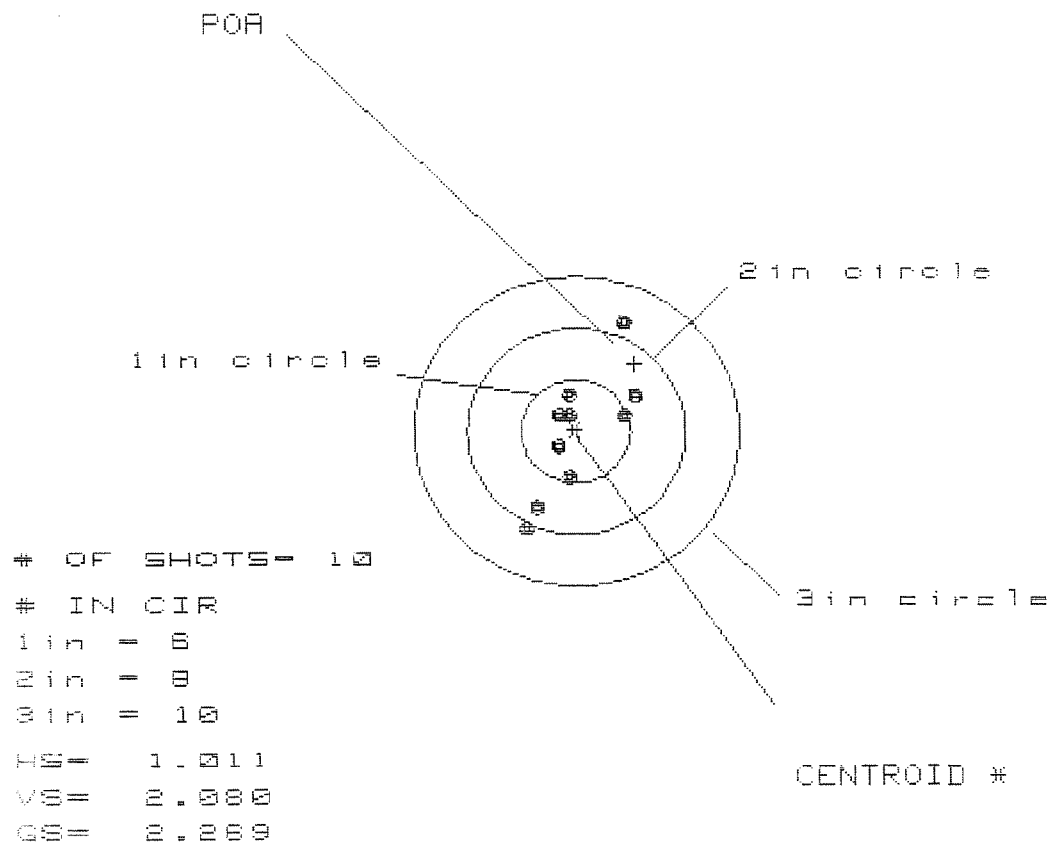
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.035	.935	.985
MINIMUM X	:	-.900	-.643	-.593
MAXIMUM Y	:	.640	.506	.400
MINIMUM Y	:	-.923	-.852	-.319
CENTROID X	:	.393	.493	.443
CENTROID Y	:	.365	.294	.401
POA TO CENTROID in.	:	.536	.574	.597
MIN RADIUS	:	.127	.166	.068
MEAN RADIUS	:	.585	.551	.462
MAX RADIUS	:	1.104	.941	.986
HORIZONTAL SPREAD	:	1.935	1.578	1.578
VERTICAL SPREAD	:	1.563	1.358	.718
EXTREME SPREAD	:	2.098	1.584	1.584
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



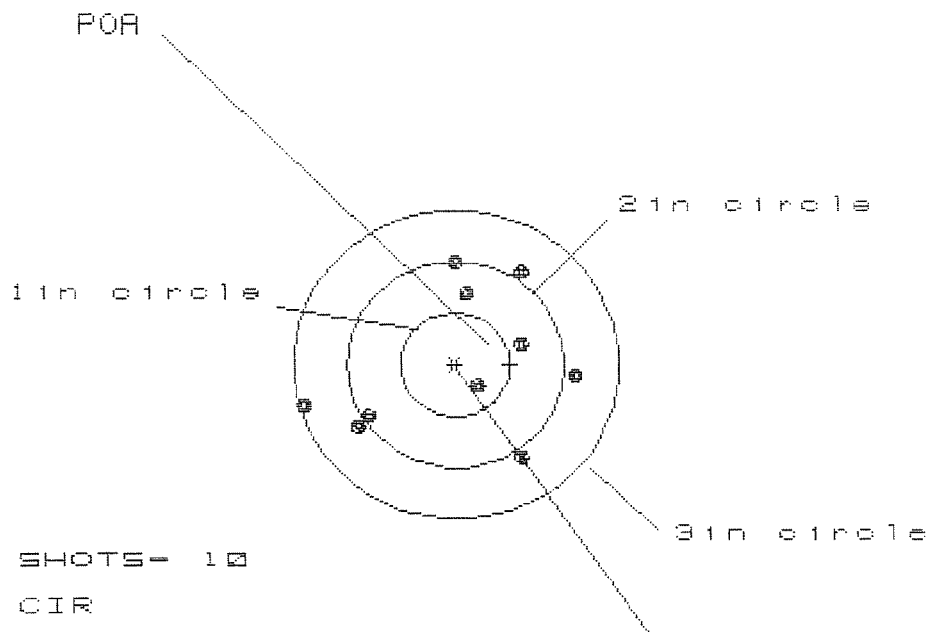
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.518	.564	.588
MINIMUM X	:	-.493	-.447	-.343
MAXIMUM Y	:	1.105	.482	.376
MINIMUM Y	:	-.975	-.853	-.689
CENTROID X	:	-.541	-.587	-.531
CENTROID Y	:	-.656	-.779	-.673
POA TO CENTROID in.	:	.851	.975	.857
MIN RADIUS	:	.175	.072	.170
MEAN RADIUS	:	.559	.492	.418
MAX RADIUS	:	1.179	.963	.770
HORIZONTAL SPREAD	:	1.011	1.011	.851
VERTICAL SPREAD	:	2.080	1.335	1.065
EXTREME SPREAD	:	2.269	1.657	1.346
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

08 Aug 1998

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.463

VS= 1.927

GS= 2.483

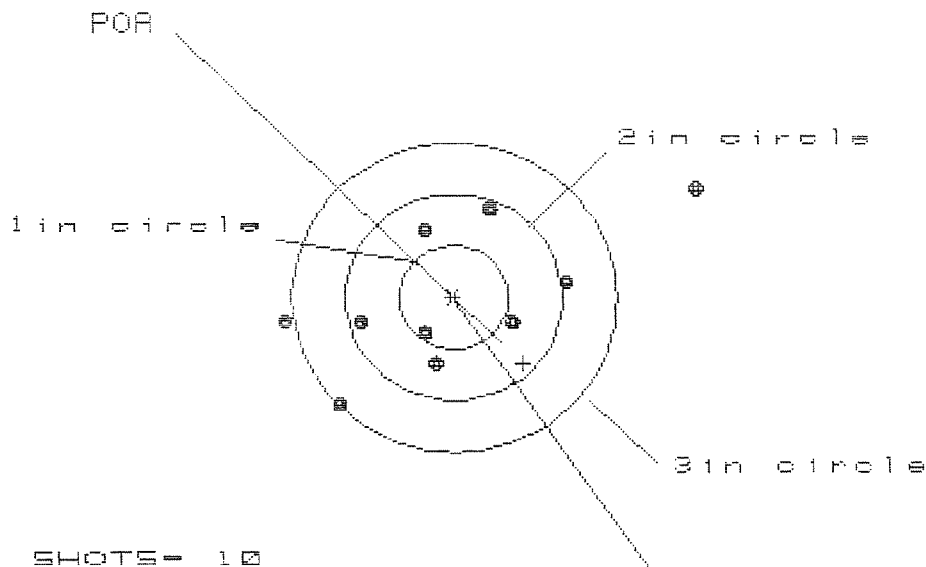
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	.908	.771
MINIMUM X	:	-1.400	-1.095	-1.064
MAXIMUM Y	:	1.023	.978	.901
MINIMUM Y	:	-.904	-.949	-1.026
CENTROID X	:	-.499	-.344	-.207
CENTROID Y	:	-.000	.045	.122
POA TO CENTROID in.	:	.499	.346	.240
MIN RADIUS	:	.329	.294	.318
MEAN RADIUS	:	.931	.843	.763
MAX RADIUS	:	1.457	1.257	1.244
HORIZONTAL SPREAD	:	2.463	2.003	1.835
VERTICAL SPREAD	:	1.927	1.927	1.927
EXTREME SPREAD	:	2.483	2.064	2.039
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 3.871

VS= 2.050

GS= 4.074

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.260
MINIMUM X	-1.611
MAXIMUM Y	1.038
MINIMUM Y	-1.012
CENTROID X	-.634
CENTROID Y	.641
POA TO CENTROID in.	.901
MIN RADIUS	.460
MEAN RADIUS	1.085
MAX RADIUS	2.487
HORIZONTAL SPREAD	3.871
VERTICAL SPREAD	2.050
EXTREME SPREAD	4.074
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	6
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. 06522203

DATE 8/28/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.42	2.40	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.41	2.42	2.10	
PULL #3	2.43	2.45	2.41	2.23	
PULL #4	2.43	2.42	2.35	2.25	
PULL #5	2.33	2.39	2.30	2.25	
TOTAL	12.20	12.09	11.88	10.93	
AVG.	2.44	2.418	2.376	2.186	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.39		
PULL #2	3.48	3.33		
PULL #3	3.35	3.39		
PULL #4	3.34	3.32		
PULL #5	3.40	3.30		
TOTAL	16.98	16.73		
AVG.	3.396	3.346		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.36		4.38
PULL #2	4.43	4.38		4.41
PULL #3	4.42	4.50		4.43
PULL #4	4.38	4.50		4.46
PULL #5	4.42	4.46		4.39
TOTAL	22.00	22.20		22.07
AVG.	4.4	4.44		4.414

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522203

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT 8 2	90	RW
600	Proof		90	RW
607	Check Headspace		90	RW
610	Dis-assemble Gun		90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	JS
617	Drill and Tap Sight Holes		8/10/90	EB
618	Polish Barrel RB		8/14/90	W/B
620	Apply Coatings (Barrel Action)		8-22-90	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/24/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	RW
	C) Inspect Ejector Hole for Chamfer		8/24/90	RW
	D) Oil Firing Pin Ass'y		8/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/28/90	WB
	G) Safety Off Force	2	2	2			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	JK
	I) Firing Pin Indent	.024	.023	.023			8/28/90	WB
	J) Assemble Stock						8/28/90	RW
	K) Assemble Swivel Studs						9/5/90	JS
	L) Attach Front and Rear Sight Assemblies						8/28/90	RW
	M) Iron Sight Alignment						8/28/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/90	RW
	O) Attach Scope to Rifle						8/28/90	RW
	P) Detach & Attach Scope 20 Times						8/28/90	RW
640	Gallery Target & Test						8-30-90	DH
	A) Time						8-30-90	DH
	B) Malfunctions						8-30-90	DH
	C) Pierced Primers						8-30-90	DH
	D) Optical Clarity of Scope						8-30-90	DH
645	Inspect for Live Ammo						8-30-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	JS
	B) Trigger Pull	2.20	2.10	2.23	2.15	2.25	9/1/90	JK
	C) Function						9/5/90	JS
660	Pack						9/20/90	LF