

C6522188

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington[®]

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

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

MODEL 700TM M24

SERIAL NO.
C6522188

ORDER NO.
5716

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

01


5716 C6522188

UPC


0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522188
9 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.341459
1 TO	2	.396062
1 TO	3	.319453
1 TO	4	.324575
1 TO	5	.411798

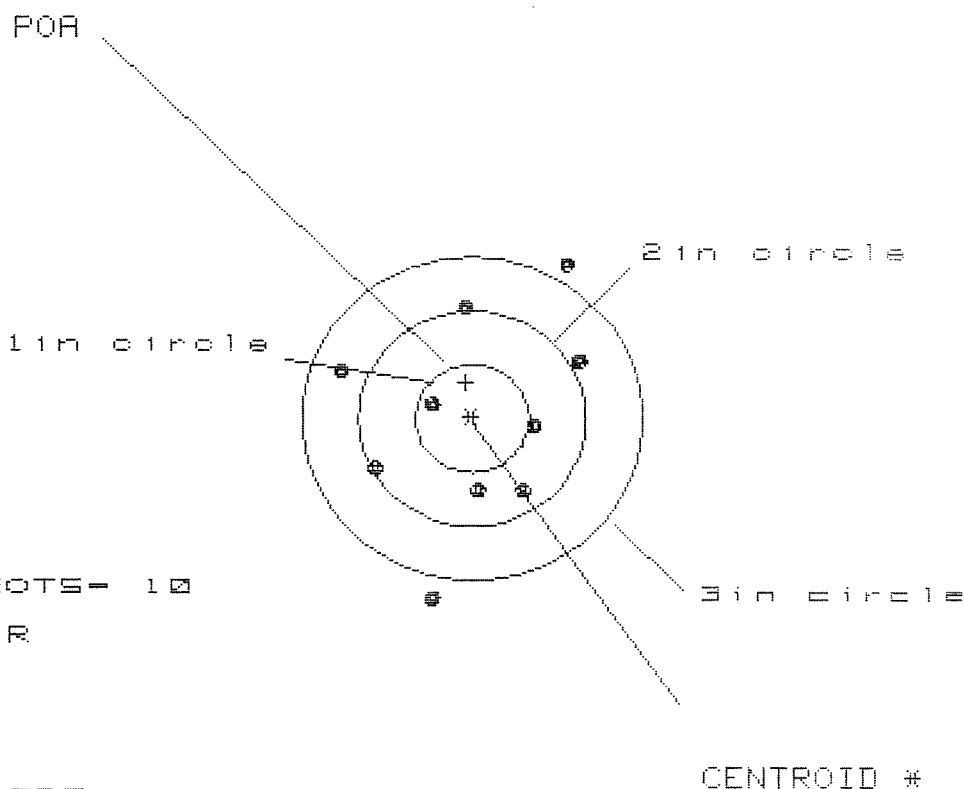
$\frac{1}{3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2802
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.385
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .476169
THE AMR FOR THIS RIFLE IS: .85

9 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522188

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.000

VS= 3.062

GS= 3.302

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.910	.871	.977
MINIMUM X	-1.170	-1.209	-1.103
MAXIMUM Y	1.412	1.228	.978
MINIMUM Y	-1.650	-.824	-.670
CENTROID X	.055	.094	-.012
CENTROID Y	-.337	-.153	-.307
POR TO CENTROID in.	.341	.180	.307
MIN RADIUS	.375	.389	.301
MEAN RADIUS	1.001	.926	.831
MAX RADIUS	1.687	1.493	1.177
HORIZONTAL SPREAD	2.080	2.080	2.080
VERTICAL SPREAD	3.062	2.052	1.648
EXTREME SPREAD	3.302	2.599	2.081
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.050

VS= 2.104

GS= 2.304

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	.239	.191
MINIMUM X	:	-.706	-.556	-.527
MAXIMUM Y	:	.816	.741	.571
MINIMUM Y	:	-1.288	-1.363	-1.024
CENTROID X	:	.363	.213	.184
CENTROID Y	:	-.088	-.013	.157
POA TO CENTROID in.	:	.373	.214	.242
MIN RADIUS	:	.033	.152	.181
MEAN RADIUS	:	.706	.597	.463
MAX RADIUS	:	1.504	1.384	1.025
HORIZONTAL SPREAD	:	2.050	.795	.718
VERTICAL SPREAD	:	2.104	2.104	1.595
EXTREME SPREAD	:	2.304	2.163	1.609
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.679

VS = 2.436

GS = 2.735

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.858	.655	.690
MINIMUM X	:	-1.821	-.618	-.583
MAXIMUM Y	:	1.157	1.179	1.022
MINIMUM Y	:	-1.279	-1.257	-.921
CENTROID X	:	.162	.365	.330
CENTROID Y	:	-.638	-.660	-.502
POA TO CENTROID in.	:	.658	.754	.601
MIN RADIUS	:	.192	.375	.224
MEAN RADIUS	:	.860	.732	.641
MAX RADIUS	:	1.832	1.288	1.089
HORIZONTAL SPREAD	:	2.679	1.273	1.273
VERTICAL SPREAD	:	2.436	2.436	1.942
EXTREME SPREAD	:	2.735	2.460	2.019
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.909

VS= 2.884

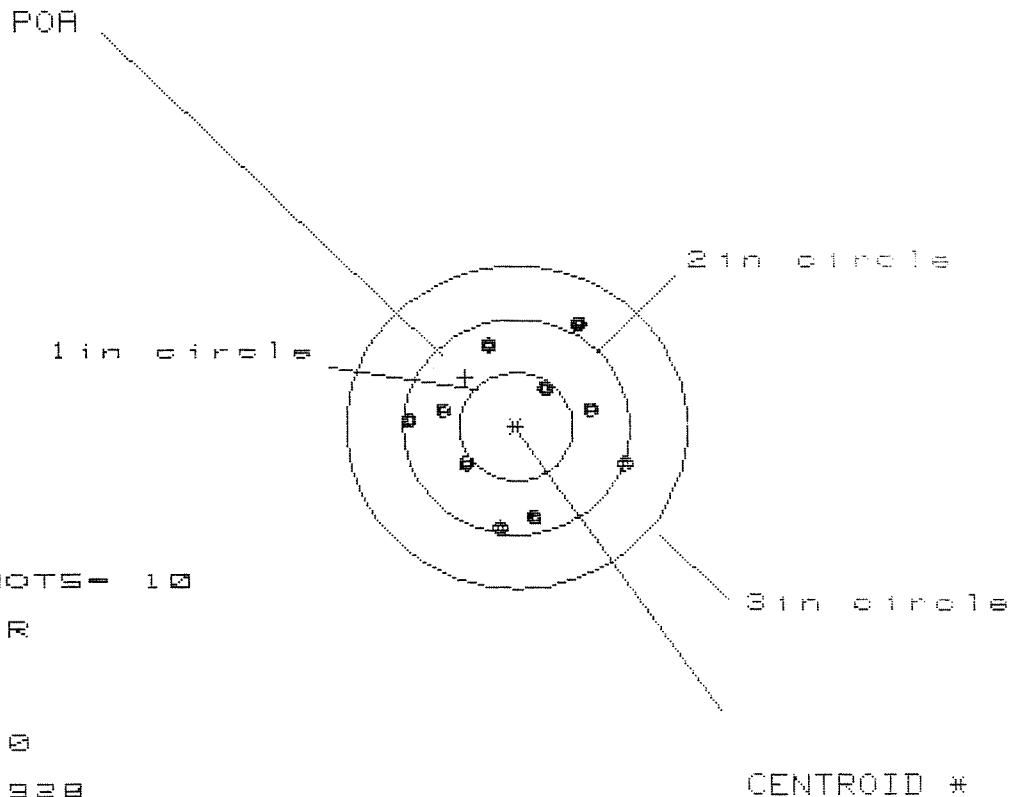
GS= 2.914

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	.387	.435
MINIMUM X	:	-.712	-.579	-.530
MAXIMUM Y	:	1.505	1.365	.824
MINIMUM Y	:	-1.379	-1.519	-1.348
CENTROID X	:	.373	.240	.191
CENTROID Y	:	-.402	-.262	-.433
POA TO CENTROID in.	:	.548	.355	.473
MIN RADIUS	:	.305	.142	.318
MEAN RADIUS	:	.885	.739	.672
MAX RADIUS	:	1.733	1.523	1.358
HORIZONTAL SPREAD	:	1.909	.966	.965
VERTICAL SPREAD	:	2.884	2.884	2.172
EXTREME SPREAD	:	2.914	2.897	2.188
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 1.928

VS= 1.900

GS= 2.052

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.946	1.010	.823
MINIMUM X	-.982	-.918	-.792
MAXIMUM Y	.983	.882	.852
MINIMUM Y	-.917	-.808	-.838
CENTROID X	.448	.384	.258
CENTROID Y	-.460	-.569	-.539
POA TO CENTROID in.	.643	.687	.597
MIN RADIUS	.404	.429	.347
MEAN RADIUS	.798	.752	.699
MAX RADIUS	1.141	1.039	.864
HORIZONTAL SPREAD	1.928	1.928	1.615
VERTICAL SPREAD	1.900	1.690	1.690
EXTREME SPREAD	2.052	1.970	1.692
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522188

DATE 9/6/90

TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.26	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.29	2.24	2.46	
PULL #3	2.40	2.24	2.26	2.45	
PULL #4	2.37	2.16	2.23	2.37	
PULL #5	2.24	2.18	2.21	2.43	
TOTAL	11.81	11.26	11.20	12.17	
AVG.	2.36	2.25	2.24	2.434	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.13		
PULL #2	3.08	3.10		
PULL #3	3.11	3.13		
PULL #4	3.10	3.00		
PULL #5	3.13	3.08		
TOTAL	15.51	15.44		
AVG.	3.10	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.00		4.16
PULL #2	4.11	4.03		4.17
PULL #3	4.10	4.08		4.03
PULL #4	4.11	4.09		4.16
PULL #5	4.12	4.13		4.19
TOTAL	20.59	20.33		20.71
AVG.	4.12	4.07		4.14

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522188

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	SS
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel <i>RB</i>		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 ³ / ₄	5			9/6/90	WB
	G) Safety Off Force	2	2	2			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/6/90	WB
	I) Firing Pin Indent	.025	.025	.025			9/6/90	WB
	J) Assemble Stock						9/6/90	KS
	K) Assemble Swivel Studs						9/16/90	JS
	L) Attach Front and Rear Sight Assemblies						9/6/90	KS
	M) Iron Sight Alignment						9/6/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/6/90	KS
	O) Attach Scope to Rifle						9/6/90	KS
	P) Detach & Attach Scope 20 Times						9/6/90	KS
640	Gallery Target & Test						9-9-90	DH
	A) Time						9-9-90	DH
	B) Malfunctions						9-9-90	DH
	C) Pierced Primers						9-9-90	DH
	D) Optical Clarity of Scope						9-9-90	DH
645	Inspect for Live Ammo						9-9-90	DH
655	Final Inspection							
	A) Headspace						9/16/90	JS
	B) Trigger Pull	2.46	2.46	2.45	2.37	2.43	9-16-90	JS
	C) Function						9/16/90	JS
660	Pack						9-19-90	DH