

C6522324

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

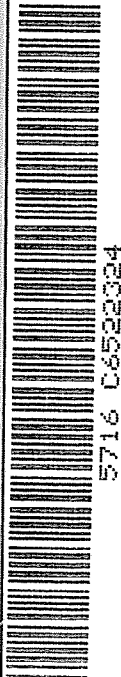
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6522324

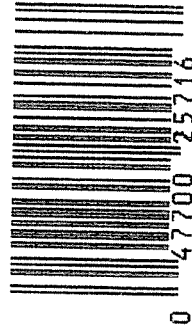
ORDER NO.
5716

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



5716 C6522324

LPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522324
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.357246
1 TO	2	.230653
1 TO	3	.234696
1 TO	4	.11908
1 TO	5	.434687

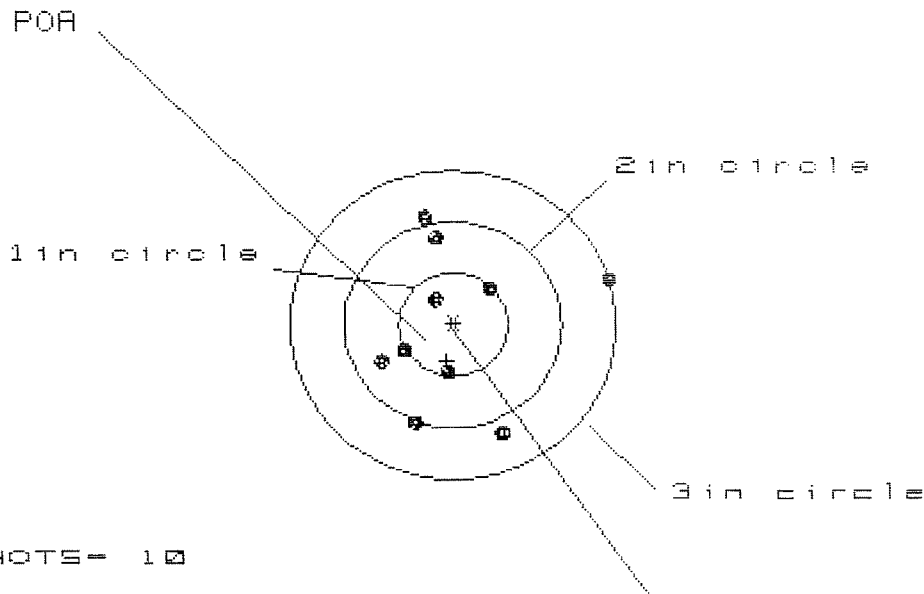
SP <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0194
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .168
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169116
THE AMR FOR THIS RIFLE IS: .6646

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522324

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.060

VS= 2.118

GS= 2.264

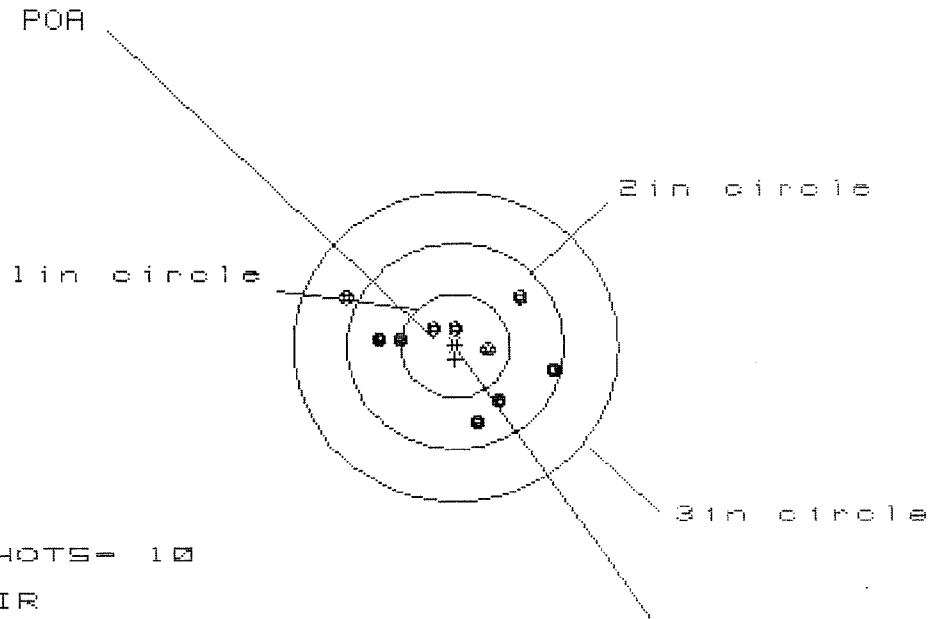
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.405	.595	.531
MINIMUM X	:	-.655	-.499	-.425
MAXIMUM Y	:	1.080	1.129	1.006
MINIMUM Y	:	-1.038	-.989	-1.056
CENTROID X	:	.061	-.095	-.169
CENTROID Y	:	.352	.303	.426
POA TO CENTROID in.	:	.358	.317	.458
MIN RADIUS	:	.297	.299	.187
MEAN RADIUS	:	.810	.710	.643
MAX RADIUS	:	1.475	1.154	1.063
HORIZONTAL SPREAD	:	2.060	1.094	.956
VERTICAL SPREAD	:	2.118	2.118	2.062
EXTREME SPREAD	:	2.264	2.224	2.065
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.967

VS= 1.175

GS= 2.104

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.829	.583
MINIMUM X	:	-1.025	-.832	-.729
MAXIMUM Y	:	.487	.539	.513
MINIMUM Y	:	-.688	-.633	-.659
CENTROID X	:	.006	.119	.016
CENTROID Y	:	.128	.073	.099
POA TO CENTROID in.	:	.128	.140	.100
MIN RADIUS	:	.179	.146	.205
MEAN RADIUS	:	.616	.554	.509
MAX RADIUS	:	1.135	.854	.777
HORIZONTAL SPREAD	:	1.967	1.661	1.312
VERTICAL SPREAD	:	1.175	1.172	1.172
EXTREME SPREAD	:	2.104	1.697	1.370
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 10

3 in = 10

HS= 1.672

VS= 1.086

GS= 1.861

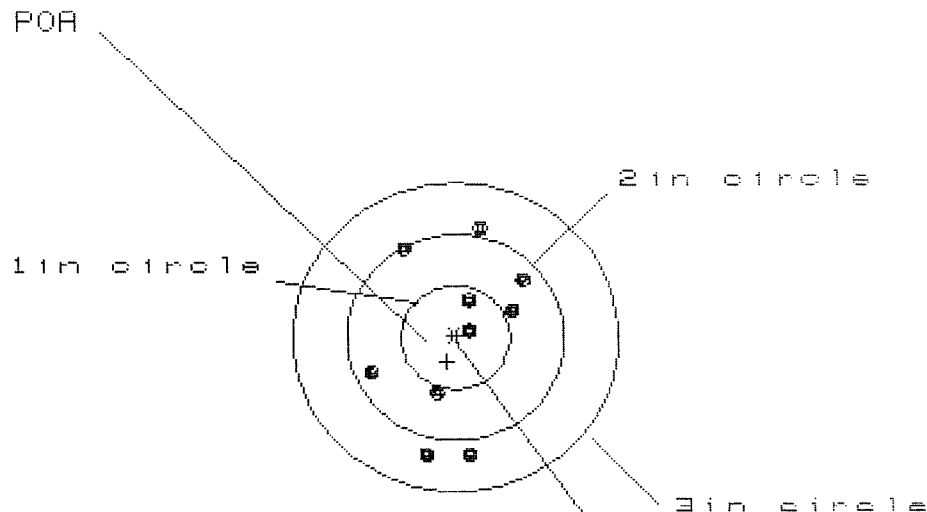
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.503	.419
MINIMUM X	:	-.772	-.672	-.370
MAXIMUM Y	:	.585	.620	.562
MINIMUM Y	:	-.501	-.466	-.475
CENTROID X	:	.140	.040	.124
CENTROID Y	:	.131	.096	.154
POA TO CENTROID in.	:	.192	.104	.198
MIN RADIUS	:	.279	.173	.275
MEAN RADIUS	:	.551	.499	.455
MAX RADIUS	:	.954	.818	.620
HORIZONTAL SPREAD	:	1.672	1.175	.789
VERTICAL SPREAD	:	1.086	1.086	1.037
EXTREME SPREAD	:	1.861	1.488	1.214
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.461

VS= 2.205

GS= 2.273

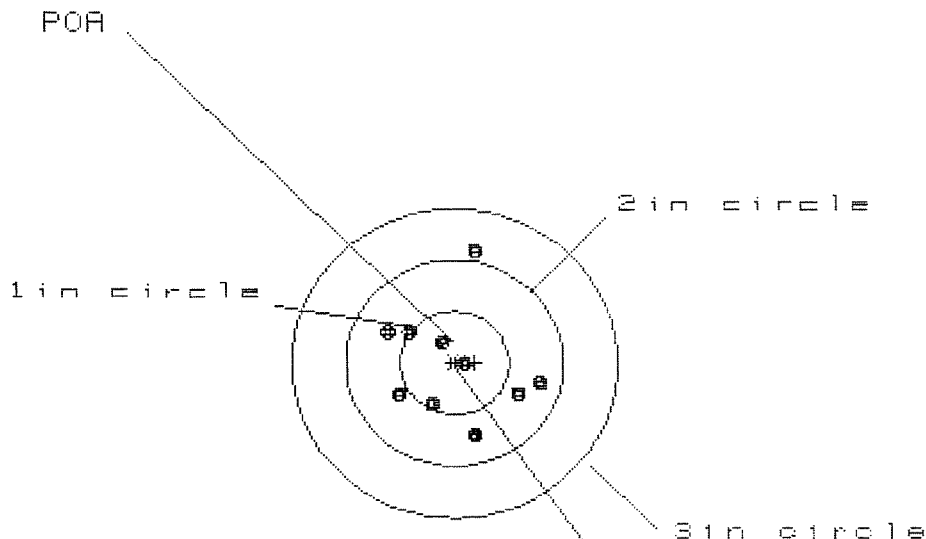
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.664	.629	.638
MINIMUM X	:	-.797	-.832	-.823
MAXIMUM Y	:	1.048	.919	.761
MINIMUM Y	:	-1.157	-1.261	-.780
CENTROID X	:	.077	.112	.103
CENTROID Y	:	.234	.363	.521
POA TO CENTROID in.	:	.247	.380	.531
MIN RADIUS	:	.147	.128	.145
MEAN RADIUS	:	.772	.701	.616
MAX RADIUS	:	1.200	1.263	1.021
HORIZONTAL SPREAD	:	1.461	1.461	1.461
VERTICAL SPREAD	:	2.205	2.180	1.541
EXTREME SPREAD	:	2.273	2.183	1.711
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.419

VS= 1.779

GS= 1.780

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.806
MINIMUM X	-.613
MAXIMUM Y	1.099
MINIMUM Y	-.679
CENTROID X	-.187
CENTROID Y	-.005
POA TO CENTROID in.	.187
MIN RADIUS	.071
MEAN RADIUS	.574
MAX RADIUS	1.112
HORIZONTAL SPREAD	1.419
VERTICAL SPREAD	1.779
EXTREME SPREAD	1.780
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	9
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. 06522324

DATE 8/30/90

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.37	2.21	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.43	2.20	2.43	
PULL #3	2.42	2.44	2.22	2.42	
PULL #4	2.45	2.47	2.19	2.42	
PULL #5	2.45	2.35	2.22	2.44	
TOTAL	11.97	12.06	11.04		
AVG.	2.394	2.412	2.21		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.39	3.49		
PULL #3	3.44	3.42		
PULL #4	3.42	3.43		
PULL #5	3.40	3.39		
TOTAL	17.03	17.14		
AVG.	3.406	3.428		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.23		4.08
PULL #2	4.14	4.12		4.09
PULL #3	4.24	4.21		4.07
PULL #4	4.20	4.21		4.07
PULL #5	4.22	4.16		4.05
TOTAL	21.04	20.93		20.36
AVG.	4.208	4.19		4.07

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522324

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	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	KP
	Magnaflux Bolt		7-17-90	KP
615	Rollmark Caliber		7-17-90	GL
617	Drill and Tap Sight Holes		7/27/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/6/90	JS
	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		8/30/90	JO

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			8/30/90	WB
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄			8/30/90	WB
	H) Trigger Pull Test & Retainability						8/30/90	fu
	I) Firing Pin Indent	.022	.022	.022			8/30/90	WB
	J) Assemble Stock						9/4/90	RW
	K) Assemble Swivel Studs						9/9/90	JS
	L) Attach Front and Rear Sight Assemblies						9/4/90	RW
	M) Iron Sight Alignment						9/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	RW
	O) Attach Scope to Rifle						9/4/90	RW
	P) Detach & Attach Scope 20 Times						9/4/90	RW
640	Gallery Target & Test						9-7-90	DH
	A) Time						9-7-90	DH
	B) Malfunctions						9-7-90	DH
	C) Pierced Primers						9-7-90	DH
	D) Optical Clarity of Scope						9-7-90	DH
645	Inspect for Live Ammo						9-7-90	DH
655	Final Inspection							
	A) Headspace						9/9/90	JS
	B) Trigger Pull	246	243	242	242	244	9/9/90	JS
	C) Function						9/9/90	JS
660	Pack						9/19-90	DH