

C6522333

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

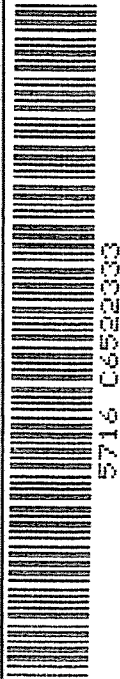
MODEL 700™ H24

SERIAL NO.
C6522333

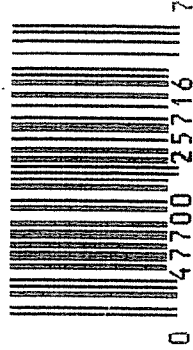
ORDER NO.
5716

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

Ø1



UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522333
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.225577
1 TO	2	.792316
1 TO	3	.605688
1 TO	4	.26556
1 TO	5	.18333

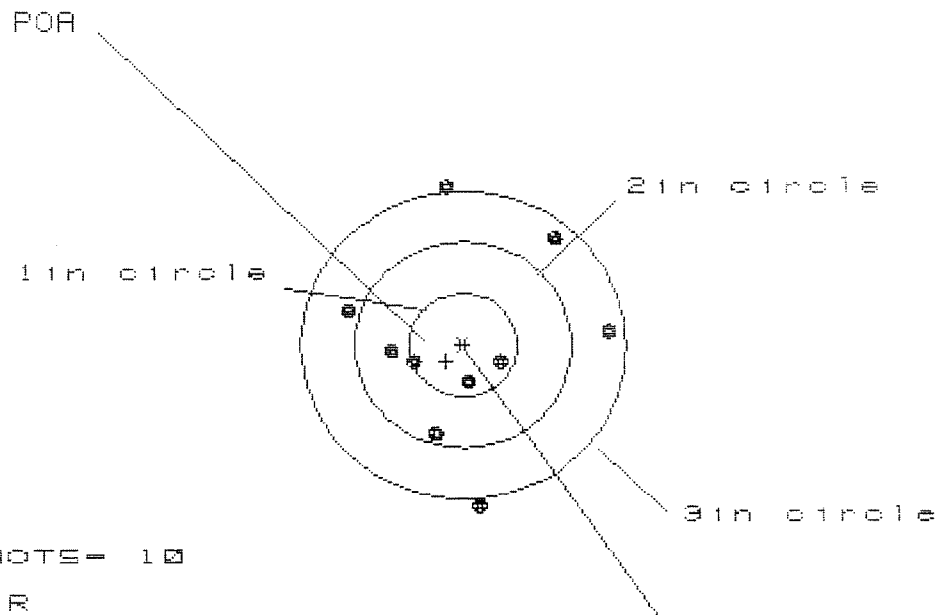
2 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.181
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1284
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .221918
THE AMR FOR THIS RIFLE IS: .9376

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522333

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.377

VS= 3.072

GS= 3.090

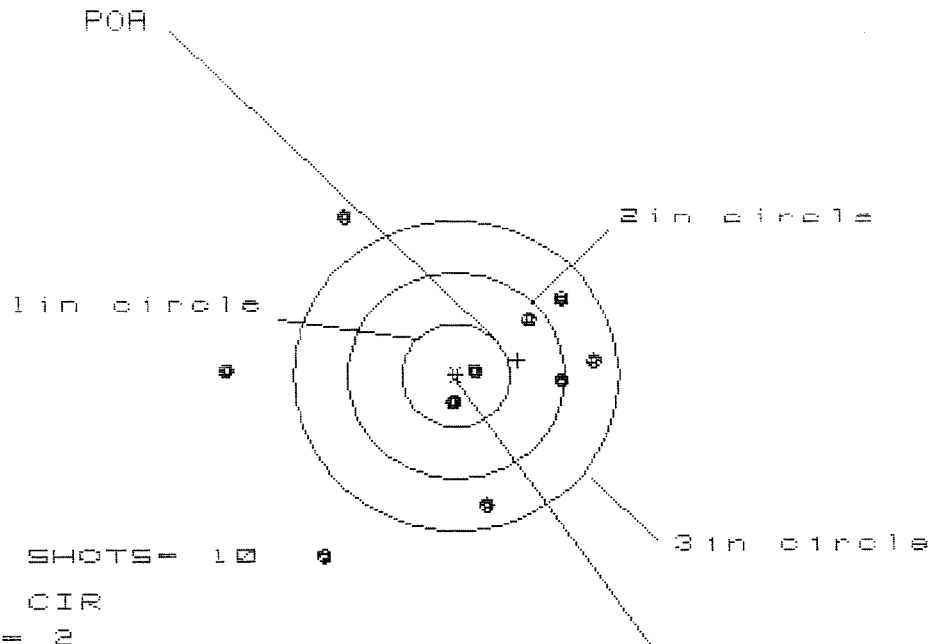
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.295	1.274	1.289
MINIMUM X	:	-1.082	-1.103	-1.088
MAXIMUM Y	:	1.548	1.193	1.024
MINIMUM Y	:	-1.524	-1.352	-.898
CENTROID X	:	.158	.179	.164
CENTROID Y	:	.161	-.011	.158
POA TO CENTROID in.	:	.226	.180	.228
MIN RADIUS	:	.339	.170	.333
MEAN RADIUS	:	.960	.860	.813
MAX RADIUS	:	1.560	1.443	1.317
HORIZONTAL SPREAD	:	2.377	2.377	2.377
VERTICAL SPREAD	:	3.072	2.545	1.922
EXTREME SPREAD	:	3.090	2.637	2.385
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.408

VS= 3.286

GS= 3.409

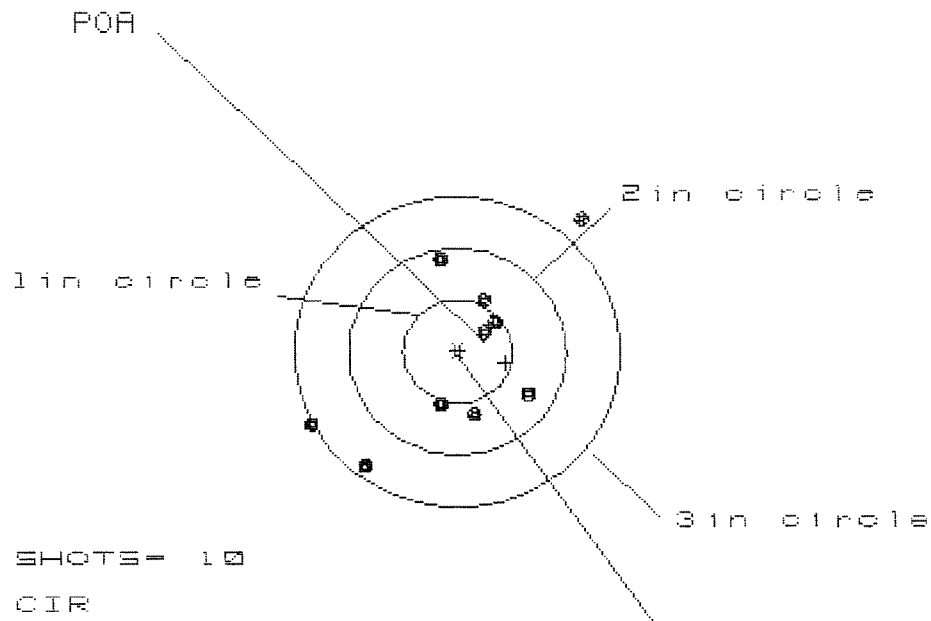
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.300	1.066	.882
MINIMUM X	:	-2.108	-1.470	-1.424
MAXIMUM Y	:	1.581	1.590	1.377
MINIMUM Y	:	-1.705	-1.696	-1.411
CENTROID X	:	-.572	-.338	-.154
CENTROID Y	:	-.147	-.156	.056
POA TO CENTROID in.	:	.591	.372	.164
MIN RADIUS	:	.129	.119	.339
MEAN RADIUS	:	1.211	1.061	.886
MAX RADIUS	:	2.109	2.245	1.981
HORIZONTAL SPREAD	:	3.408	2.536	2.306
VERTICAL SPREAD	:	3.286	3.286	2.788
EXTREME SPREAD	:	3.409	3.294	3.086
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.431

VS= 2.414

GS= 3.132

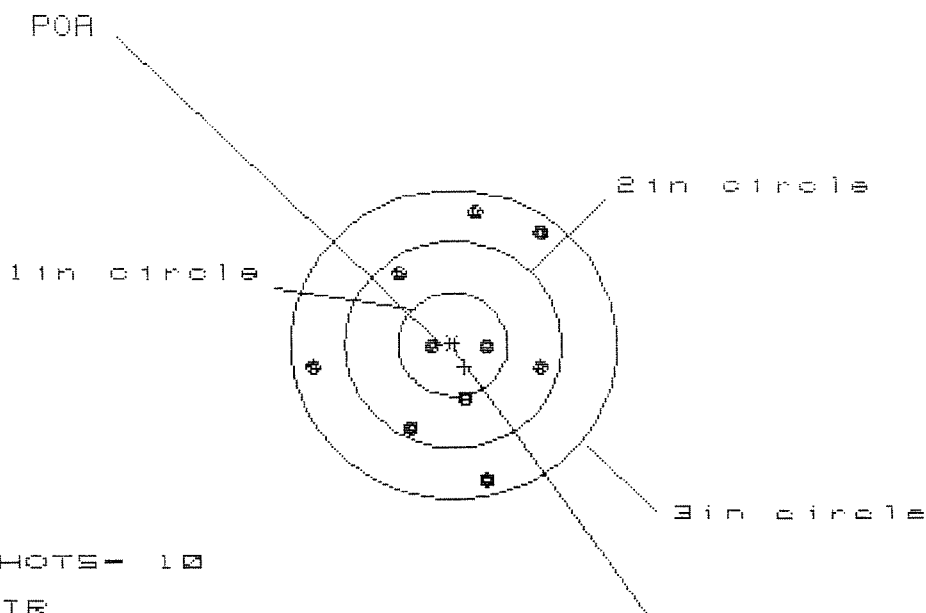
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.102	.769	.618
MINIMUM X	:	-1.329	-1.206	-.917
MAXIMUM Y	:	1.275	1.051	.982
MINIMUM Y	:	-1.139	-.998	-1.067
CENTROID X	:	-.445	-.568	-.417
CENTROID Y	:	.104	-.037	.033
POA TO CENTROID in.:	:	.457	.569	.418
MIN RADIUS	:	.308	.331	.340
MEAN RADIUS	:	.877	.799	.696
MAX RADIUS	:	1.685	1.329	1.407
HORIZONTAL SPREAD	:	2.431	1.975	1.535
VERTICAL SPREAD	:	2.414	2.049	2.049
EXTREME SPREAD	:	3.132	2.162	2.162
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.162

VS= 2.614

GS= 2.616

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.829	.680	.696
MINIMUM X	:	-1.333	-.680	-.664
MAXIMUM Y	:	1.294	1.267	1.099
MINIMUM Y	:	-1.320	-1.347	-.963
CENTROID X	:	-.103	.046	.030
CENTROID Y	:	.210	.237	.406
POA TO CENTROID in.	:	.234	.241	.407
MIN RADIUS	:	.188	.132	.232
MEAN RADIUS	:	.885	.824	.773
MAX RADIUS	:	1.355	1.353	1.104
HORIZONTAL SPREAD	:	2.162	1.360	1.360
VERTICAL SPREAD	:	2.614	2.614	2.061
EXTREME SPREAD	:	2.616	2.616	2.175
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.998

VS= 1.681

GS= 3.098

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.523	.693	.544
MINIMUM X	:	-1.357	-1.188	-.809
MAXIMUM Y	:	.892	.970	.925
MINIMUM Y	:	-.789	-.711	-.756
CENTROID X	:	.057	-.112	.037
CENTROID Y	:	.314	.236	.281
POA TO CENTROID in.	:	.319	.261	.283
MIN RADIUS	:	.079	.257	.102
MEAN RADIUS	:	.755	.670	.559
MAX RADIUS	:	1.678	1.241	.951
HORIZONTAL SPREAD	:	2.880	1.881	1.353
VERTICAL SPREAD	:	1.681	1.681	1.681
EXTREME SPREAD	:	3.098	2.044	1.686
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6522333DATE 8/17/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.39	2.30	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.36	2.36	2.27	
PULL #3	2.44	2.27	2.33	2.26	
PULL #4	2.40	2.33	2.25	2.29	
PULL #5	2.39	2.37	2.30	2.26	
TOTAL	12.03	11.72	11.54	11.32	
AVG.	2.406	2.344	2.308	2.264	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.52		
PULL #2	3.37	3.26		
PULL #3	3.17	3.38		
PULL #4	3.29	3.35		
PULL #5	3.45	3.34		
TOTAL	16.59	16.85		
AVG.	3.318	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.29		4.28
PULL #2	4.35	4.41		4.44
PULL #3	4.34	4.40		4.39
PULL #4	4.30	4.42		4.29
PULL #5	4.39	4.38		4.35
TOTAL	21.69	21.90		21.75
AVG.	4.338	4.38		4.35

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522333

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	5 28	90	RW
610	Dis-assemble Gun	3 20	80	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	LS
617	Drill and Tap Sight Holes		7/13/90	KB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/12/90	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/9/90	JK
	G) Safety Off Force	3	3	3			8/9/90	JK
	H) Trigger Pull Test & Retainability						8/17/90	JK
	I) Firing Pin Indent	.0225	.0225	.0225			8/9/90	JK
	J) Assemble Stock						8/20/90	RW
	K) Assemble Swivel Studs						9/16/90	JS
	L) Attach Front and Rear Sight Assemblies						8/20/90	RW
	M) Iron Sight Alignment						8/20/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	RW
	O) Attach Scope to Rifle						8/20/90	RW
	P) Detach & Attach Scope 20 Times						8/20/90	RW
640	Gallery Target & Test						8/20/90	KJ
	A) Time						8/20/90	KJ
	B) Malfunctions						8/20/90	KJ
	C) Pierced Primers						8-20/90	KJ
	D) Optical Clarity of Scope						8-20/90	KJ
645	Inspect for Live Ammo						8-20/90	KJ
655	Final Inspection							
	A) Headspace						9/16/90	JS
	B) Trigger Pull	2.24	2.27	2.26	2.29	2.26	8/22/90	JK
	C) Function						9/16/90	JS
660	Pack						8/20/90	NF