C652344

MODEL 700™ M24

Model SPS™

Action

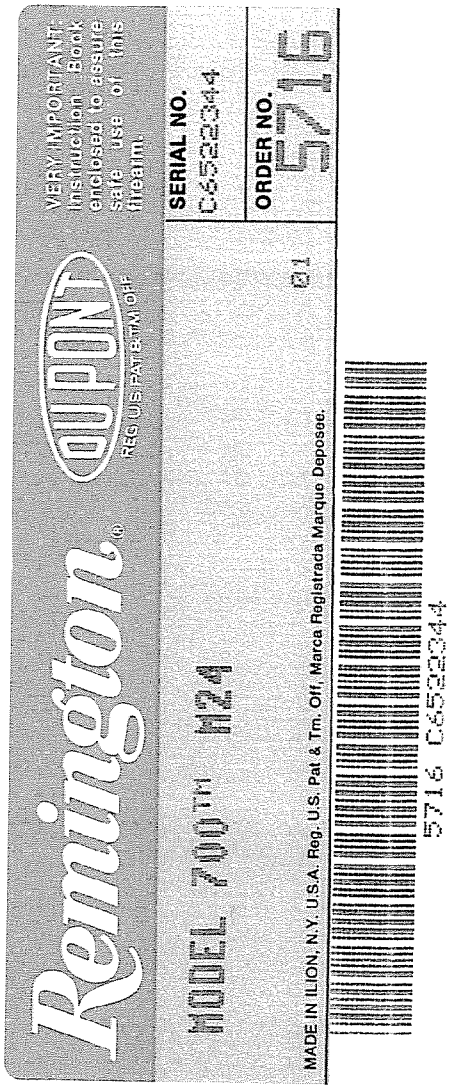
Barrel Length

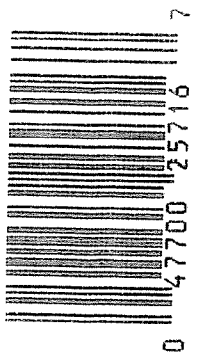
Capacity

Order No. 576

*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 TM M24
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.
01
SERIAL NO.
C6522344
ORDER NO.
5716
5716 C6522344

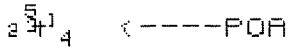

UPC
0 47700 25716 7

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522344
17 Sep 1990

CENTROIDAL DISTANCES

Ø	TO	1	.2664
1	TO	2	.715388
1	TO	3	.345774
1	TO	4	.457739
1	TO	5	.395103

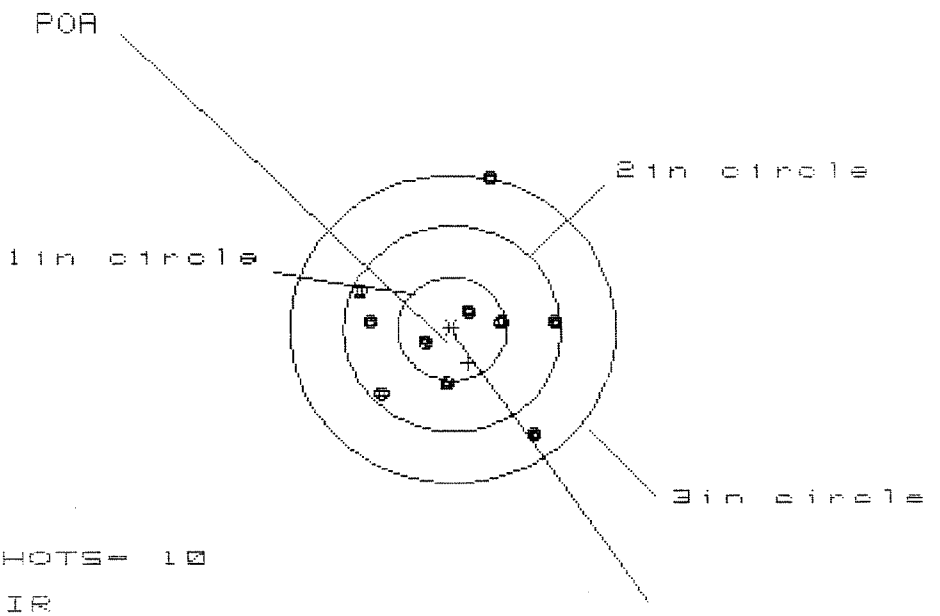


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0546
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0546033

THE AMR FOR THIS RIFLE IS: .9278

17 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522344.1.1

CENTERFIRE PATTERNS # 5

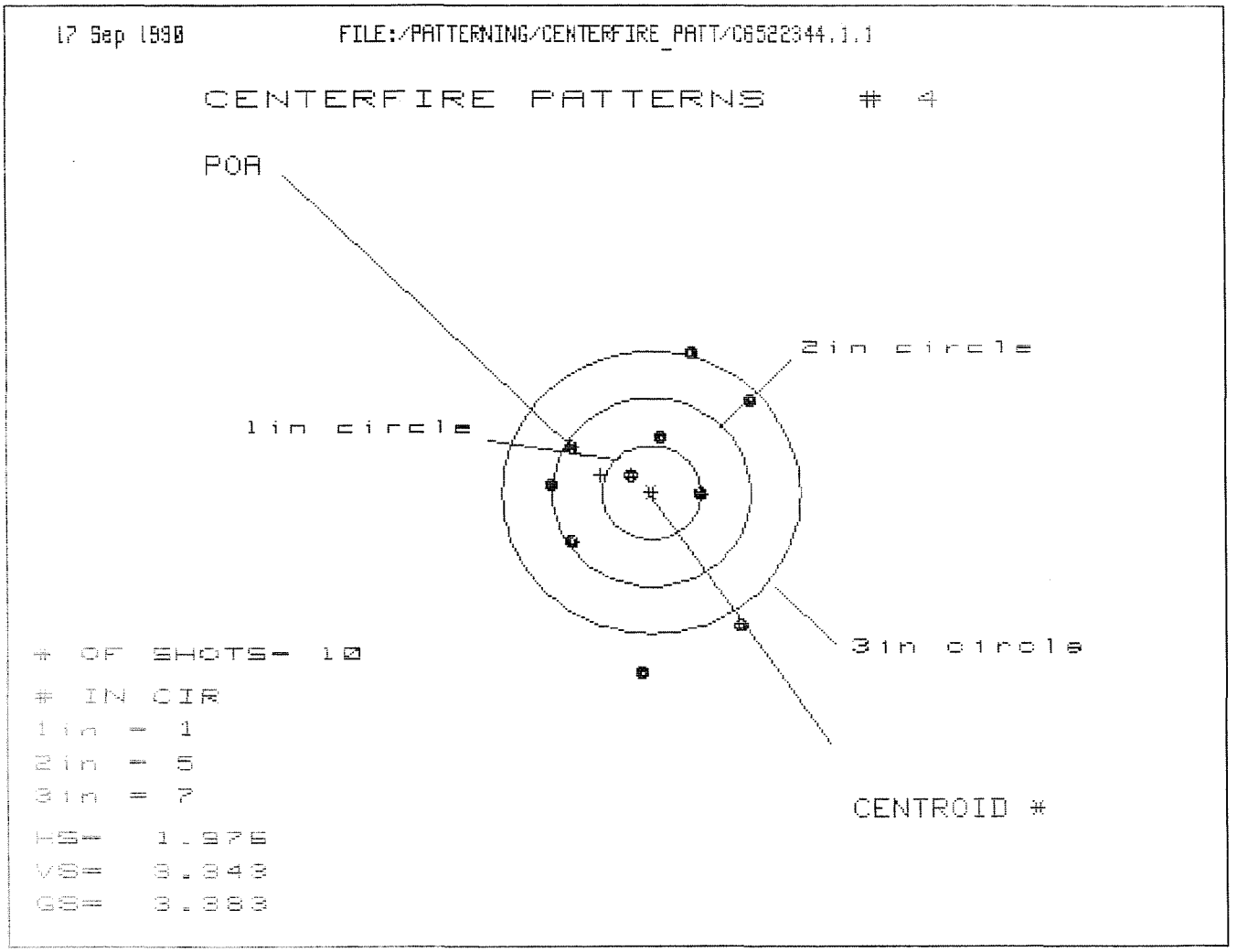


OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 9

HS= 1.760
VS= 2.576
GS= 2.596

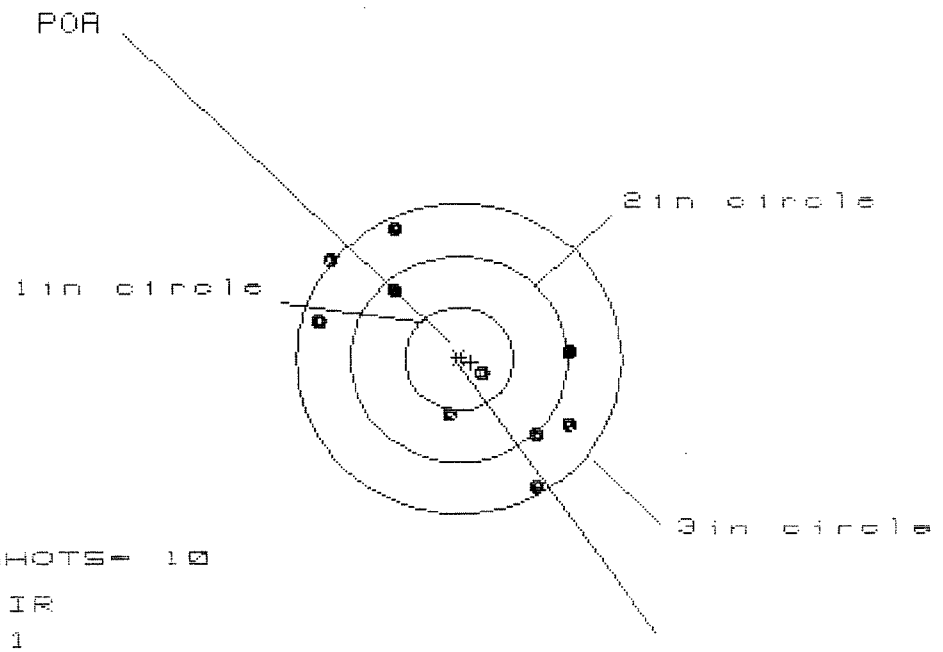
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.957	1.052
MINIMUM X	:	-.846	-.803	-.708
MAXIMUM Y	:	1.519	.516	.405
MINIMUM Y	:	-1.057	-.888	-.573
CENTROID X	:	-.146	-.189	-.284
CENTROID Y	:	.325	.156	.267
POA TO CENTROID in.	:	.356	.246	.390
MIN RADIUS	:	.254	.230	.124
MEAN RADIUS	:	.793	.694	.617
MAX RADIUS	:	1.568	1.166	1.056
HORIZONTAL SPREAD	:	1.760	1.760	1.760
VERTICAL SPREAD	:	2.576	1.404	.978
EXTREME SPREAD	:	2.596	2.097	1.787
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.946	1.061
MINIMUM X	:	-1.016	-1.030	-.915
MAXIMUM Y	:	1.463	1.254	1.052
MINIMUM Y	:	-1.880	-1.617	-.880
CENTROID X	:	.508	.522	.407
CENTROID Y	:	-.190	.019	.221
POA TO CENTROID in.	:	.542	.522	.463
MIN RADIUS	:	.299	.248	.259
MEAN RADIUS	:	1.078	.952	.813
MAX RADIUS	:	1.885	1.862	1.227
HORIZONTAL SPREAD	:	1.976	1.976	1.976
VERTICAL SPREAD	:	3.343	2.871	1.932
EXTREME SPREAD	:	3.383	2.923	2.286
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522344.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

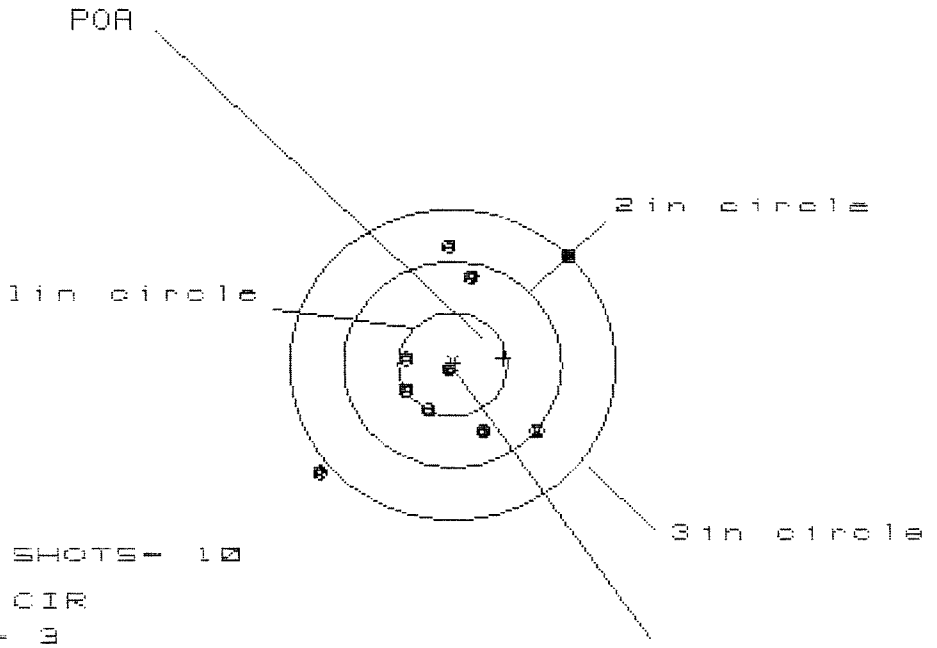
# IN CIR
1in = 1
2in = 3
3in = 9

HS= 2.330
VS= 2.538
GS= 2.949

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.906	.982
MINIMUM X	:	-1.288	-1.424	-1.348
MAXIMUM Y	:	1.270	1.375	1.229
MINIMUM Y	:	-1.268	-1.163	-.752
CENTROID X	:	-.109	.026	-.050
CENTROID Y	:	.034	-.071	.075
POA TO CENTROID in.	:	.115	.075	.090
MIN RADIUS	:	.300	.129	.285
MEAN RADIUS	:	1.071	.979	.961
MAX RADIUS	:	1.537	1.556	1.393
HORIZONTAL SPREAD	:	2.330	2.330	2.330
VERTICAL SPREAD	:	2.538	2.538	1.981
EXTREME SPREAD	:	2.949	2.867	2.534
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522344.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

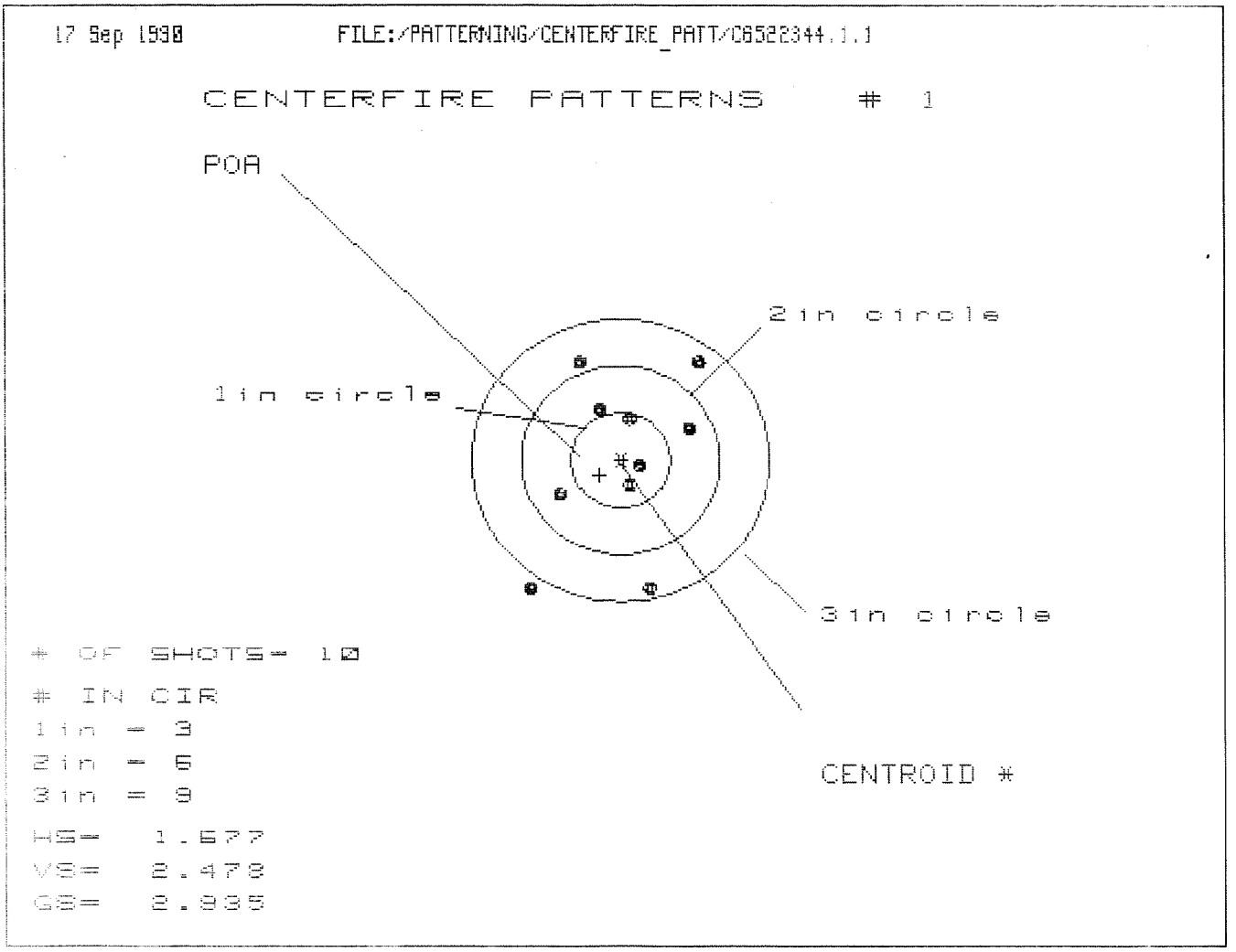
# IN CIR
1in = 3
2in = 6
3in = 8

HS= 2.283
VS= 2.164
GS= 3.119

PATTERN # : 2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.062	.926	.787
MINIMUM X	:	-1.221	-.579	-.463
MAXIMUM Y	:	1.122	1.006	1.127
MINIMUM Y	:	-1.042	-.797	-.676
CENTROID X	:	-.469	-.333	-.449
CENTROID Y	:	-.056	.060	-.061
POA TO CENTROID in.	:	.472	.338	.453
MIN RADIUS	:	.062	.239	.079
MEAN RADIUS	:	.844	.792	.669
MAX RADIUS	:	1.606	1.339	1.128
HORIZONTAL SPREAD	:	2.283	1.505	1.250
VERTICAL SPREAD	:	2.164	1.803	1.803
EXTREME SPREAD	:	3.119	2.035	1.934

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.747	.644	.664
MINIMUM X	:	-.930	-.716	-.696
MAXIMUM Y	:	1.078	.927	.733
MINIMUM Y	:	-1.401	-1.551	-.692
CENTROID X	:	.213	.316	.296
CENTROID Y	:	.160	.310	.504
POA TO CENTROID in.	:	.266	.443	.584
MIN RADIUS	:	.230	.206	.062
MEAN RADIUS	:	.853	.738	.613
MAX RADIUS	:	1.641	1.560	.981
HORIZONTAL SPREAD	:	1.677	1.360	1.360
VERTICAL SPREAD	:	2.478	2.478	1.425
EXTREME SPREAD	:	2.935	2.575	1.955
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522344
7 Aug 1990

CENTROIDAL DISTANCES

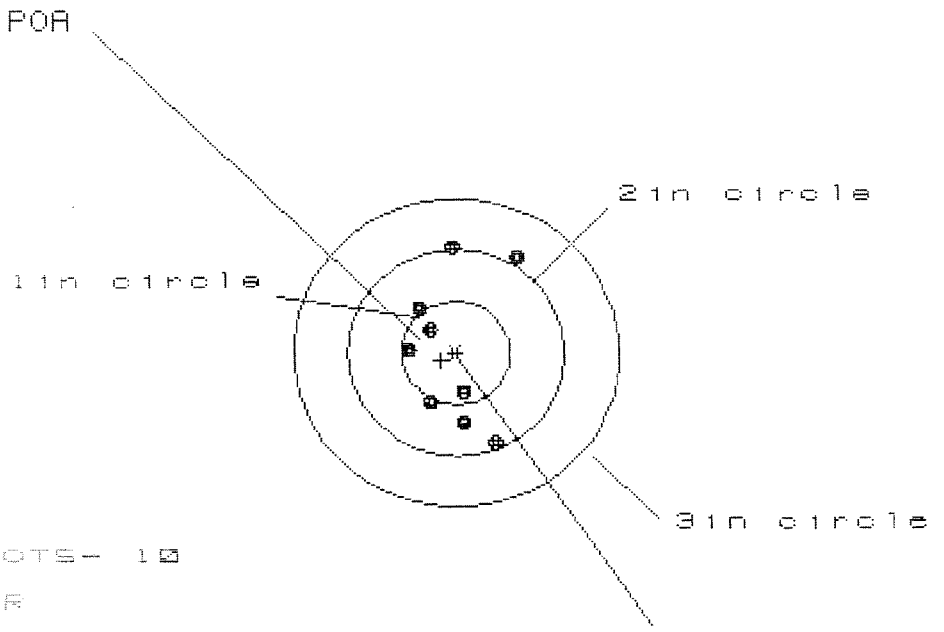
0	TO	1	.156525
1	TO	2	.0174929
1	TO	3	.218488
1	TO	4	.512149
1	TO	5	.42457

<----POA

THE AVERAGE [illegible] FOR THIS RIFLE IS: .0678
THE AVERAGE [illegible] FOR THIS RIFLE IS: .0102
[illegible] RADIUS FOR THIS RIFLE IS: .068563

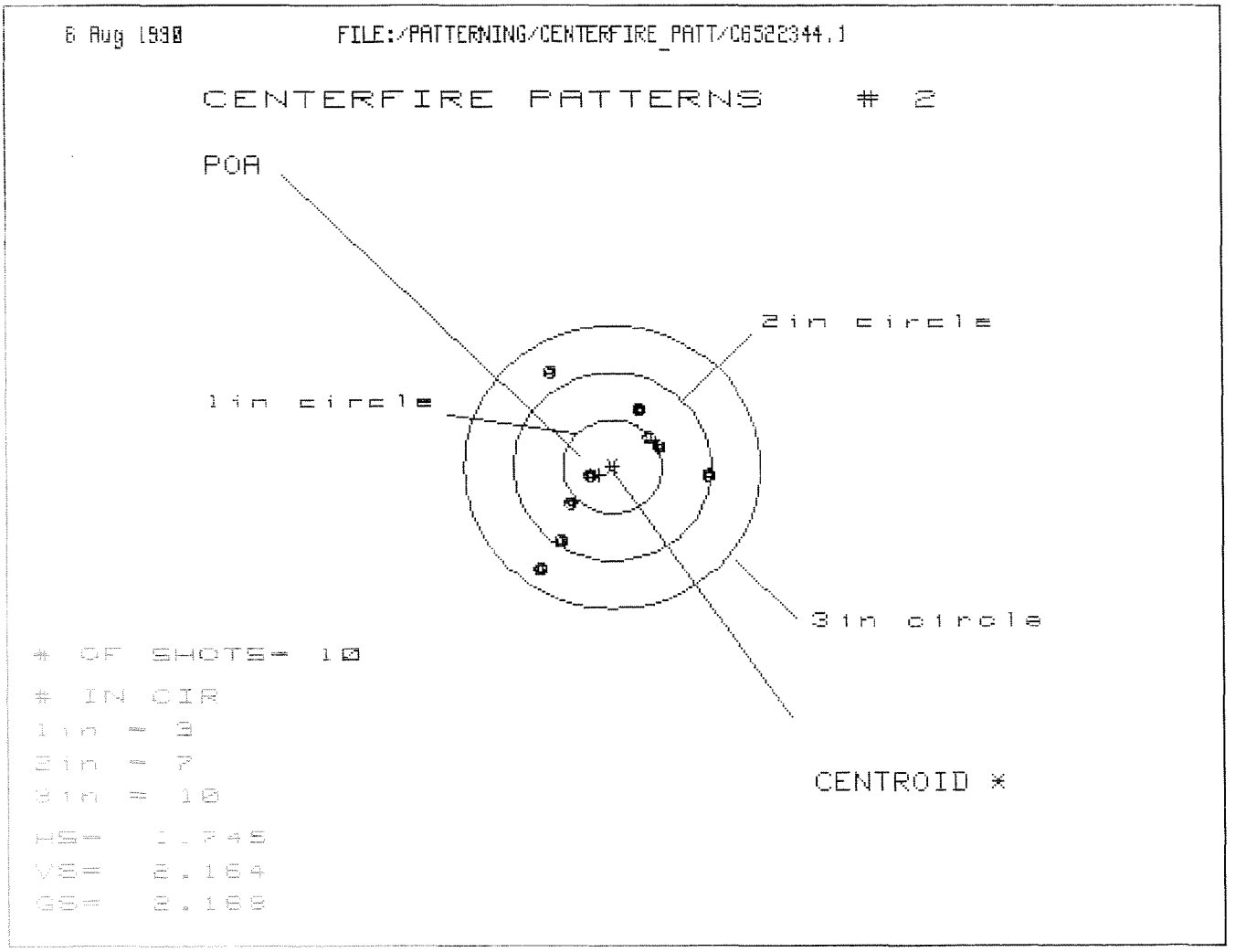
6 Aug 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6522344.1

CENTERFIRE PATTERNS # 1

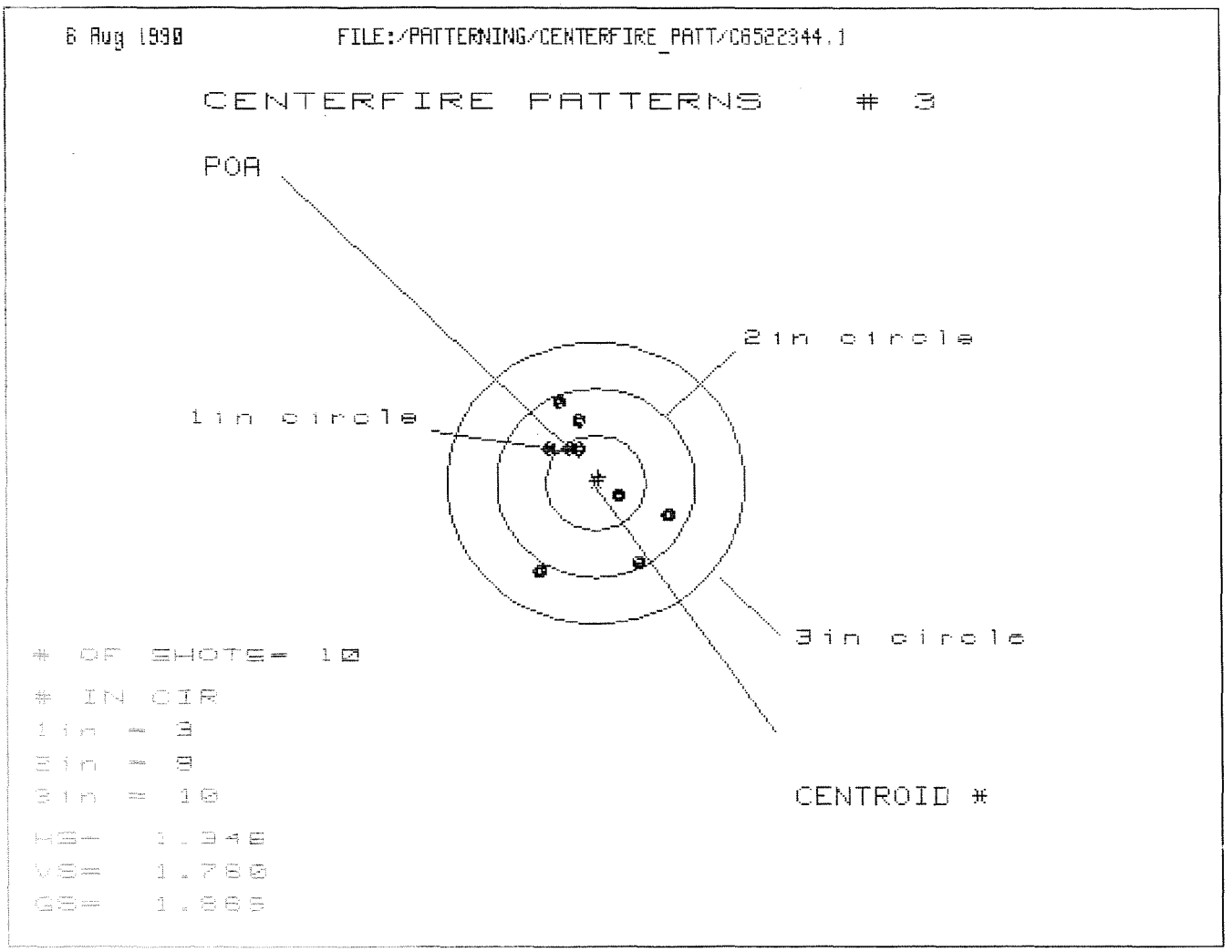


# OF SHOTS= 10
# IN CIR
11n = 5
21n = 8
31n = 10
MEAN RADIUS= 1.082
EXTREME SPREAD= 1.883
MEAN GROUP RANGE= 1.524

PATTERN #			
SHOTS (BEST UP)	10	9	8
MAXIMUM X	.605	.442	.451
MINIMUM X	-.416	-.349	-.340
MAXIMUM Y	1.027	1.136	.656
MINIMUM Y	-.861	-.752	-.610
MEAN RADIUS	.140	.073	.064
MEAN POINT OF IMPACT	.070	-.089	-.181
STANDARD DEVIATION	.157	.083	.192
EXTREME SPREAD	.319	.246	.132
MEAN GROUP RANGE	.683	.502	.420
MEAN GROUP MIDPOINT	1.150	1.138	.759
MEAN GROUP HEIGHT	1.021	.791	.791
VERTICAL EXTREME SPREAD	1.888	1.888	1.266
EXTREME SPREAD	1.924	1.924	1.451
NUMBER IN ONE 11cm CIRCLE =		5	
NUMBER IN TWO 21cm CIRCLE =		8	
NUMBER IN THREE 31cm CIRCLE =		10	



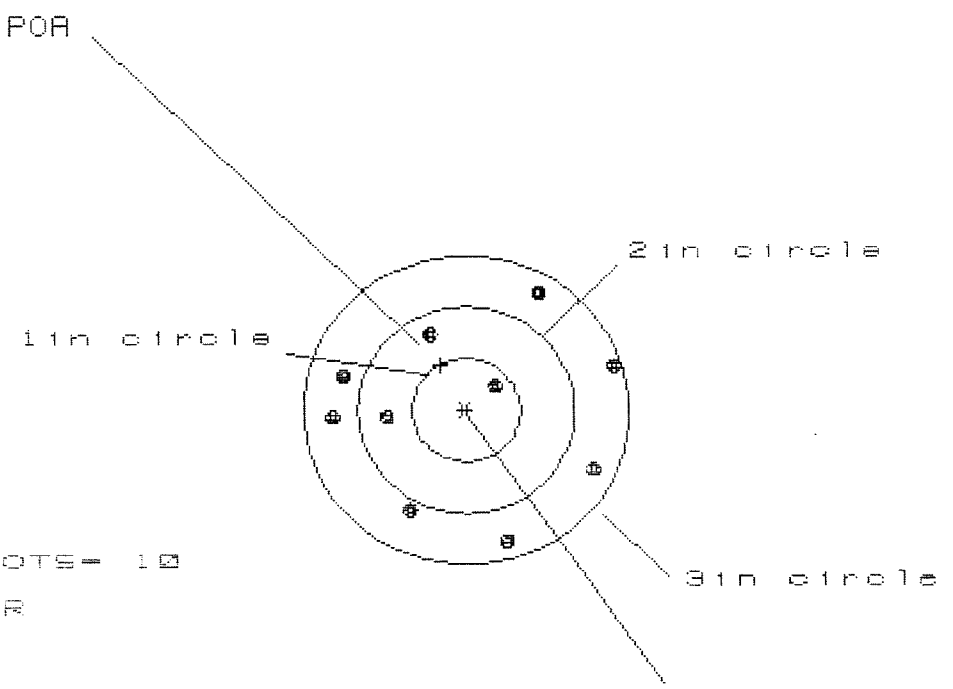
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	.929	.844
MINIMUM X	:	-.734	-.686	-.736
MAXIMUM Y	:	1.040	.916	.622
MINIMUM Y	:	-1.123	-.907	-.793
CENTROID X	:	.131	.213	.298
CENTROID Y	:	.085	.210	.096
POA TO CENTER	:	.156	.299	.313
MIN RADIUS	:	.259	.336	.347
MEAN RADIUS	:	.759	.668	.603
MR - RAD'S	:	1.342	1.144	1.082
HORIZONTAL SPREAD	:	1.745	1.615	1.580
VERTICAL SPREAD	:	2.164	1.823	1.415
EXTREME SPREAD	:	2.168	1.961	1.732
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF	:	10	9	8
MAXIMUM X	:	.756	.690	.635
MINIMUM X	:	-.590	-.538	-.593
MAXIMUM Y	:	.870	.769	.613
MINIMUM Y	:	-.910	-.899	-.803
CENTROID X	:	-.031	.035	.090
CENTROID Y	:	-.066	.035	-.061
POA TO CENTROID	:	.073	.049	.109
MIN RADIUS	:	.253	.290	.179
MEAN RADIUS	:	.697	.642	.612
MAX RADIUS	:	1.084	.987	.877
HORIZONTAL SPREAD	:	1.346	1.228	1.228
VERTICAL SPREAD	:	1.780	1.668	1.416
EXTREME SPREAD	:	1.869	1.869	1.565
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Aug 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522344.1

CENTERFIRE PATTERNS # 4

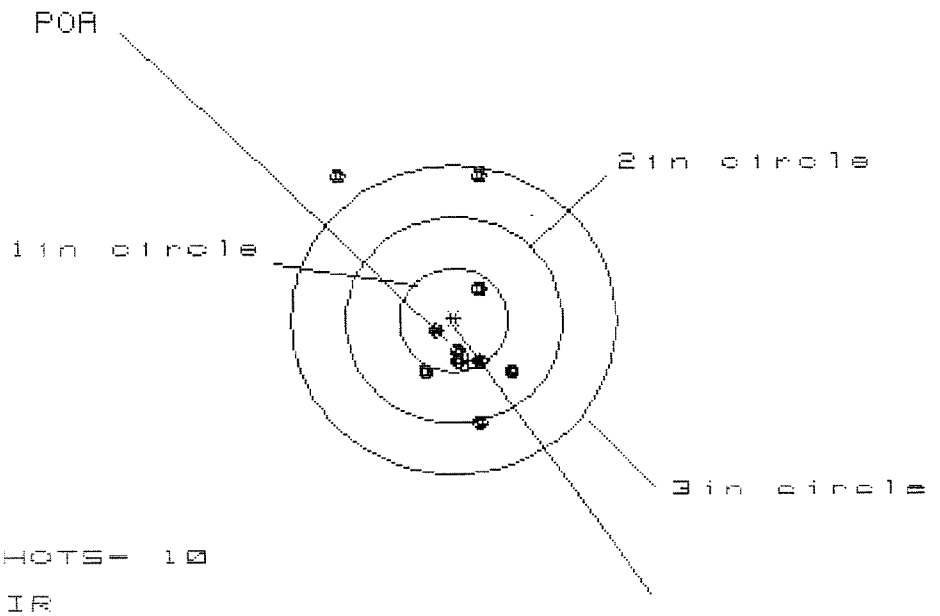


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 3
3in = 10
HS= 2.589
VS= 2.367
GS= 2.654

PATTERN #	:	4	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.383	1.279	1.385
MINIMUM X	:	-1.206	-1.052	-.946
MAXIMUM Y	:	1.142	1.196	.953
MINIMUM Y	:	-1.225	-1.171	-1.022
CENTROID X	:	.231	.077	-.029
CENTROID Y	:	-.434	-.488	-.637
POA TO CENTROID in	:	.492	.494	.638
MIN RADIUS	:	.392	.549	.512
MEAN RADIUS	:	1.080	1.022	.952
MAX RADIUS	:	1.464	1.470	1.423
HORIZONTAL SPREAD	:	2.589	2.331	2.331
VERTICAL SPREAD	:	2.367	2.367	1.975
EXTREME SPREAD	:	2.654	2.466	2.394
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Aug 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C8522344.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 5
2in = 8
3in = 9

HS= 1.553
VS= 2.411
GS= 2.721

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.548	.435	.445
MINIMUM X	:	-1.020	-.398	-.388
MAXIMUM Y	:	1.441	1.550	.687
MINIMUM Y	:	-.970	-.809	-.616
CENTROID X	:	-.132	-.019	-.029
CENTROID Y	:	.396	.235	.042
POA TO CENTROID in.	:	.417	.236	.051
MIN RADIUS	:	.189	.145	.095
MEAN RADIUS	:	.722	.546	.367
MAX RADIUS	:	1.766	1.552	.706
HORIZONTAL SPREAD	:	1.568	.833	.833
VERTICAL SPREAD	:	2.411	2.359	1.303
EXTREME SPREAD	:	2.721	2.359	1.303
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

MOD. _____ GA. _____ CAL. _____ GUN # C6522344

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Mag holds 4 Rds not 5	KS
	2nd	OK Now ADJ'D	KS
	3rd	OK	
	4th		

FUNCTION RD 6654 Rev 1

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF			
TEST			
TGT			
PROOF			
TEST			
TGT			
PROOF		ENGINEER	
TEST			
TGT			
PROOF		ENGINEER	
TEST			
TGT			

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522344

DATE 8/23/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.75	2.11	2.49	MIN. SETTING,
PULL #2	2.32	2.16	2.11	2.37	NO AVG. OF 5
PULL #3	2.14	2.10	2.49	2.45	READINGS ACCEPT-
PULL #4	2.25	2.15	2.43	2.43	ABLE LESS THAN 2#
PULL #5	2.10	2.24	2.40	2.48	
TOTAL	11.10	10.80	11.54	12.22	
AVG.	2.22	2.16	2.308	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.22		
PULL #2	3.28	3.20		
PULL #3	3.18	3.21		
PULL #4	3.17	3.14		
PULL #5	3.22	3.26		
TOTAL	16.29	16.03		
AVG.	3.258	3.206		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.21		4.11
PULL #2	4.22	4.14		4.19
PULL #3	4.19	4.25		4.19
PULL #4	4.25	4.21		4.23
PULL #5	4.25	4.20		4.26
TOTAL	21.18	21.02		20.98
AVG.	4.236	4.204		4.196

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522344

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6/24/90	KA
600	Proof		6/26/90	KA
607	Check Headspace		6/26/90	KA
610	Dis-assemble Gun		6/26/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	D.S.
617	Drill and Tap Sight Holes		7/11/90	WB
618	Polish Barrel WB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/90	KS
	C) Inspect Ejector Hole for Chamfer		8/1/90	KS
	D) Oil Firing Pin Ass'y		8/1/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/1/90	
	G) Safety Off Force	3	3	3			8/1/90	
	H) Trigger Pull Test & Retainability						8/23/90	
	I) Firing Pin Indent	.022	.022	.022			8/1/90	
	J) Assemble Stock						8/2/90	KS
	K) Assemble Swivel Studs						8/24/90	
	L) Attach Front and Rear Sight Assemblies						8/2/90	KS
	M) Iron Sight Alignment						8/2/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/2/90	KS
	O) Attach Scope to Rifle						8/2/90	KS
	P) Detach & Attach Scope 20 Times						8/2/90	KS
640	Gallery Target & Test						8-6-90	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clearity of Scope							KJ
645	Inspect for Live Ammo						8-6-90	KJ
655	Final Inspection A) Headspace						8/24/90	
	B) Trigger Pull	2.49	2.37	2.45	2.43	2.48	8/23/90	
	C) Function						8/24/90	
660	Pack						9-18-90	

2.39
2.38
2.39
2.39
2.39