

06522348

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

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

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

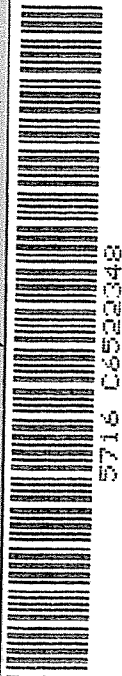
**MODEL 700<sup>TM</sup> M24**

**SERIAL NO.**  
C6522348

**ORDER NO.**  
5716

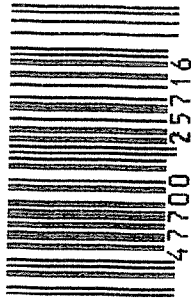
**Ø1**

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



5716 C6522348

UPC



0 47700 25716 7

100

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06522348  
16 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .968618 |
| 1 TO | 2 | .75018  |
| 1 TO | 3 | .931271 |
| 1 TO | 4 | .826736 |
| 1 TO | 5 | .647324 |

5#

<----FOR

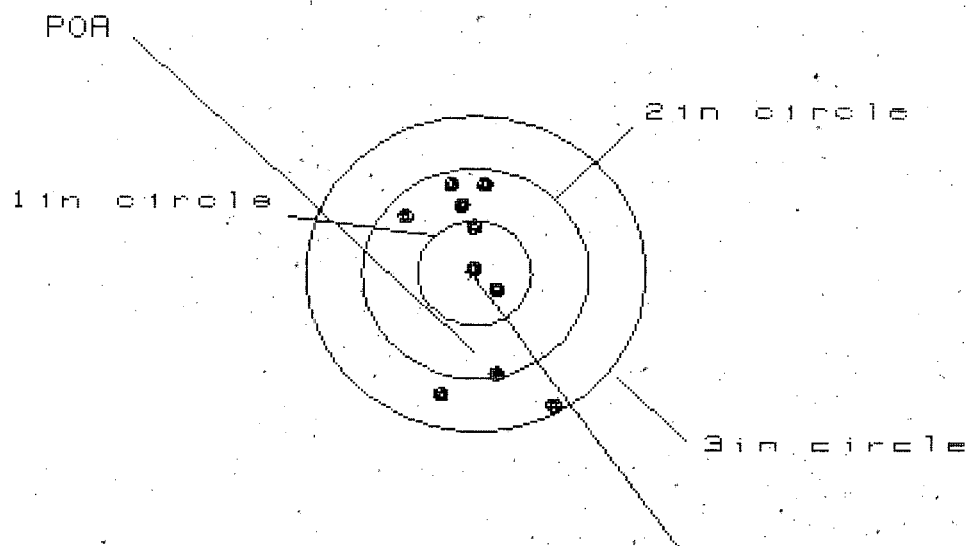
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.215  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3342  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .397385

THE AMR FOR THIS RIFLE IS: .97

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522348

## CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.258

VS = 2.108

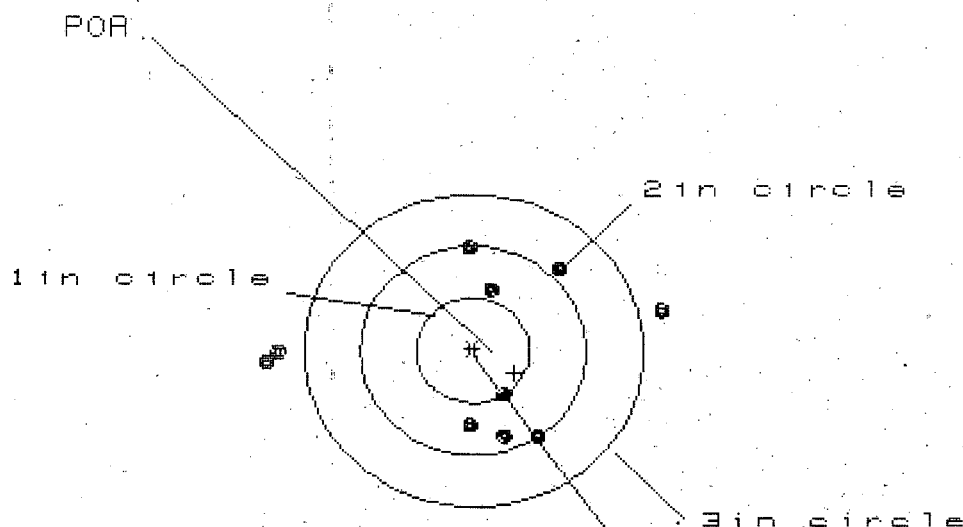
GS = 2.279

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .647   | .279   | .255   |
| MINIMUM X                     | -.621  | -.549  | -.573  |
| MAXIMUM Y                     | .882   | .745   | .582   |
| MINIMUM Y                     | -1.226 | -1.305 | -1.256 |
| CENTROID X                    | -.189  | -.261  | -.237  |
| CENTROID Y                    | .950   | 1.087  | 1.250  |
| POA TO CENTROID in.           | .969   | 1.118  | 1.272  |
| MIN RADIUS                    | .072   | .095   | .216   |
| MEAN RADIUS                   | .764   | .669   | .550   |
| MAX RADIUS                    | 1.387  | 1.319  | 1.276  |
| HORIZONTAL SPREAD             | 1.268  | .828   | .828   |
| VERTICAL SPREAD               | 2.108  | 2.050  | 1.838  |
| EXTREME SPREAD                | 2.279  | 2.051  | 1.881  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522348

## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in - 1

2in - 5

3in = 7

HS- 3.564

VS= 1.847

GS= 3.588

CENTROID \*

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.691  | 1.483  | .720   |
| MINIMUM X                     | -1.873 | -1.917 | -1.732 |
| MAXIMUM Y                     | 1.009  | 1.002  | 1.045  |
| MINIMUM Y                     | -.838  | -.845  | -.802  |
| CENTROID X                    | -.366  | -.158  | -.343  |
| CENTROID Y                    | .211   | .218   | .175   |
| POA TO CENTROID in.           | .422   | .269   | .385   |
| MIN RADIUS                    | .442   | .384   | .399   |
| MEAN RADIUS                   | 1.102  | .985   | .920   |
| MAX RADIUS                    | 1.874  | 1.917  | 1.733  |
| HORIZONTAL SPREAD             | 3.564  | 3.400  | 2.452  |
| VERTICAL SPREAD               | 1.847  | 1.847  | 1.847  |
| EXTREME SPREAD                | 3.588  | 3.417  | 2.568  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522348

## CENTERFIRE PATTERNS

# 3

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS - 10

# IN CIR

1 in - 1

2 in - 6

3 in - 9

HS= 2.290

VS= 1.898

GS= 2.747

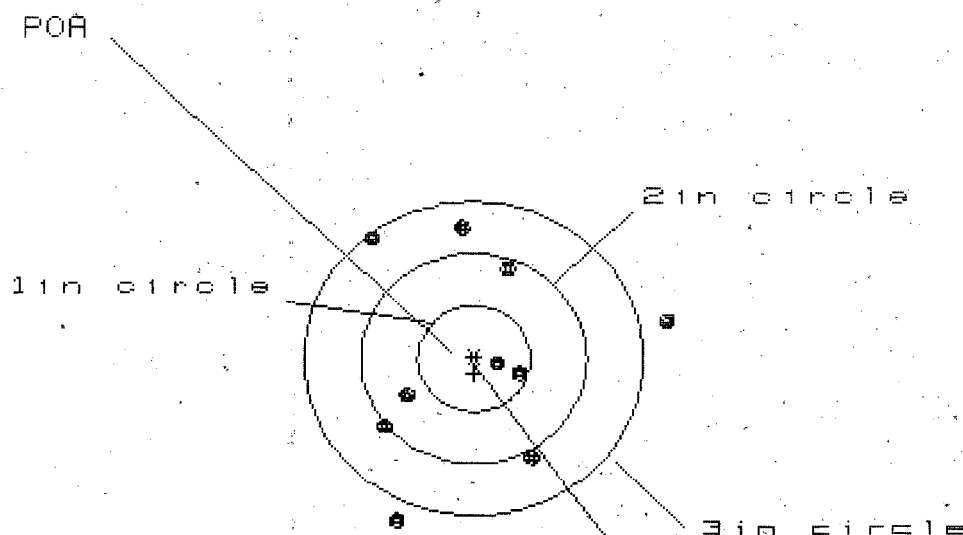
CENTROID #

| PATTERN #                   | : | 10     | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.040  | 1.089  | .947  |
| MINIMUM X                   | : | -1.250 | -1.134 | -.958 |
| MAXIMUM Y                   | : | 1.158  | 1.121  | 1.092 |
| MINIMUM Y                   | : | -.740  | -.611  | -.640 |
| CENTROID X                  | : | -.124  | -.240  | -.098 |
| CENTROID Y                  | : | .021   | -.108  | -.079 |
| POA TO CENTROID in.         | : | .126   | .263   | .126  |
| MIN RADIUS                  | : | .346   | .233   | .368  |
| MEAN RADIUS                 | : | .908   | .819   | .766  |
| MAX RADIUS                  | : | 1.557  | 1.205  | 1.239 |
| HORIZONTAL SPREAD           | : | 2.290  | 2.223  | 1.905 |
| VERTICAL SPREAD             | : | 1.898  | 1.732  | 1.732 |
| EXTREME SPREAD              | : | 2.747  | 2.227  | 2.138 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE | = | 9      |        |       |

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/06522348

## CENTERFIRE PATTERNS # 4



# OF SHOTS - 10

# IN CIR

1 in - 2

2 in - 4

3 in - 7

HS - 2.618

VS - 2.773

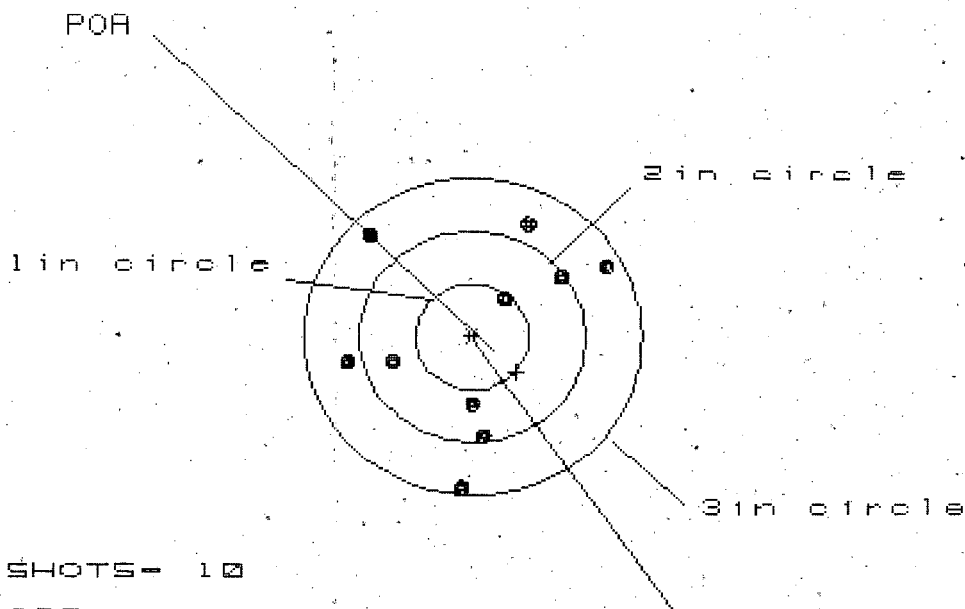
GS - 3.057

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.705  | .679   | .612   |
| MINIMUM X                     | -.913  | -.723  | -.790  |
| MAXIMUM Y                     | 1.277  | 1.318  | 1.136  |
| MINIMUM Y                     | -1.496 | -1.455 | -1.087 |
| CENTROID X                    | -.005  | -.195  | -.128  |
| CENTROID Y                    | .144   | .103   | .285   |
| POA TO CENTROID in.           | .144   | .220   | .313   |
| MIN RADIUS                    | .195   | .373   | .372   |
| MEAN RADIUS                   | 1.057  | .985   | .911   |
| MAX RADIUS                    | 1.743  | 1.550  | 1.321  |
| HORIZONTAL SPREAD             | 2.618  | 1.402  | 1.402  |
| VERTICAL SPREAD               | 2.773  | 2.773  | 2.223  |
| EXTREME SPREAD                | 3.057  | 2.845  | 2.563  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

16 Aug. 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522348

## CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1 in - 1

2 in - 5

3 in = 10

HS= 2.300

VS= 2.424

GS= 2.541

CENTROID \*

| PATTERN #                     | 5      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.212  | 1.202  | .907   |
| MINIMUM X                     | -1.088 | -1.098 | -.948  |
| MAXIMUM Y                     | 1.022  | .867   | .931   |
| MINIMUM Y                     | -1.402 | -1.139 | -1.075 |
| CENTROID X                    | -.391  | -.381  | -.531  |
| CENTROID Y                    | .335   | .490   | .426   |
| POA TO CENTROID in.           | .514   | .621   | .681   |
| MIN RADIUS                    | .460   | .349   | .510   |
| MEAN RADIUS                   | 1.019  | .967   | .921   |
| MAX RADIUS                    | 1.404  | 1.307  | 1.189  |
| HORIZONTAL SPREAD             | 2.300  | 2.300  | 1.855  |
| VERTICAL SPREAD               | 2.424  | 2.006  | 2.006  |
| EXTREME SPREAD                | 2.541  | 2.472  | 2.205  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| 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 06522348

DATE 9-18-90

TESTER JR

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.32             | 2.31                     | 2.40                           | 2.21  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.12             | 2.32                     | 2.28                           | 2.11  |                                                                        |
| PULL #3 | 2.41             | 2.40                     | 2.36                           | 2.36  |                                                                        |
| PULL #4 | 2.34             | 2.36                     | 2.51                           | 2.43  |                                                                        |
| PULL #5 | 2.24             | 2.28                     | 2.34                           | 2.56  |                                                                        |
| TOTAL   | 11.43            | 11.67                    | 11.89                          | 11.61 |                                                                        |
| AVG.    | 2.286            | 2.334                    | 2.378                          | 2.322 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.48             | 3.20                     |  |          |
| PULL #2 | 3.36             | 3.35                     |  |          |
| PULL #3 | 3.39             | 3.27                     |  |          |
| PULL #4 | 3.50             | 3.18                     |  |          |
| PULL #5 | 3.45             | 3.35                     |  |          |
| TOTAL   | 17.18            | 16.35                    |  |          |
| AVG.    | 3.436            | 3.27                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.26             | 4.38                     |                                | 4.52                                 |
| PULL #2 | 4.39             | 4.25                     |                                | 4.41                                 |
| PULL #3 | 4.28             | 4.36                     |                                | 4.40                                 |
| PULL #4 | 4.50             | 4.40                     |                                | 4.43                                 |
| PULL #5 | 4.11             | 4.44                     |                                | 4.46                                 |
| TOTAL   | 21.54            | 21.83                    |                                | 22.22                                |
| AVG.    | 4.308            | 4.366                    |                                | 4.444                                |

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522348

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 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                                           |          | 7/14/90 | KR   |
| 615       | Rollmark Caliber                                         |          | 7/18/90 | G.S. |
| 617       | Drill and Tap Sight Holes                                |          | 7/11/90 | FB   |
| 618       | Polish Barrel RB                                         |          | 7/13/90 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 7-23-90 | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          | 8/13/90 | KS   |
|           | A) Clean inside of Bolt Assembly                         |          |         |      |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 8/13/90 | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 8/13/90 | KS   |
|           | D) Oil Firing Pin Ass'y                                  |          | 8/13/90 | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 9-14-90 | SL   |

| op. #        | OP. NAME                                                    | READINGS |      |       |      |       | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|-------|------|-------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        |      | 4     |      | 4     | 8/8/90  | JS   |
|              | G) Safety Off Force                                         | 2        |      | 2     |      | 2     | 8/8/90  | JS   |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |      |       | 9-14/90 | JS   |
|              | I) Firing Pin Indent                                        | .0225    |      | .0225 |      | .0225 | 8/8/90  | JS   |
|              | J) Assemble Stock                                           |          |      |       |      |       | 8/14/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |       |      |       | 9/15/90 | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |      |       | 8/14/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |       |      |       | 8/14/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |      |       | 8/14/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |       |      |       | 8/14/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |      |       | 8/14/90 | KS   |
| 640          | Gallery Target & Test                                       |          |      |       |      |       | 8/15/90 | AF   |
|              | A) Time                                                     |          |      |       |      |       | 8/15/90 | AF   |
|              | B) Malfunctions                                             |          |      |       |      |       | 8/15/90 | AF   |
|              | C) Pierced Primers                                          |          |      |       |      |       | 8/15/90 | AF   |
|              | D) Optical Clarity of Scope                                 |          |      |       |      |       | 8/15/90 | AF   |
| 645          | Inspect for Live Ammo                                       |          |      |       |      |       | 8/15/90 | AF   |
| 655          | Final Inspection                                            |          |      |       |      |       |         |      |
|              | A) Headspace                                                |          |      |       |      |       | 9/15/90 | JS   |
|              | B) Trigger Pull                                             | 2.21     | 2.11 | 2.36  | 2.43 | 2.60  | 9-14-90 | JS   |
|              | C) Function                                                 |          |      |       |      |       | 9/15/90 | JS   |
| 660          | Pack                                                        |          |      |       |      |       | 9/20/90 | AF   |