

C6522353

MODEL 700™ M24

Model **5M5**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



**Remington**  
MODEL 700™ M24

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

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

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

SERIAL NO. C4522353

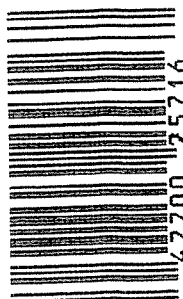
ORDER NO. 5716

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5716 C4522353

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6522353  
17 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .381083 |
| 1 TO | 2 | .507008 |
| 1 TO | 3 | .485157 |
| 1 TO | 4 | .45209  |
| 1 TO | 5 | .57205  |

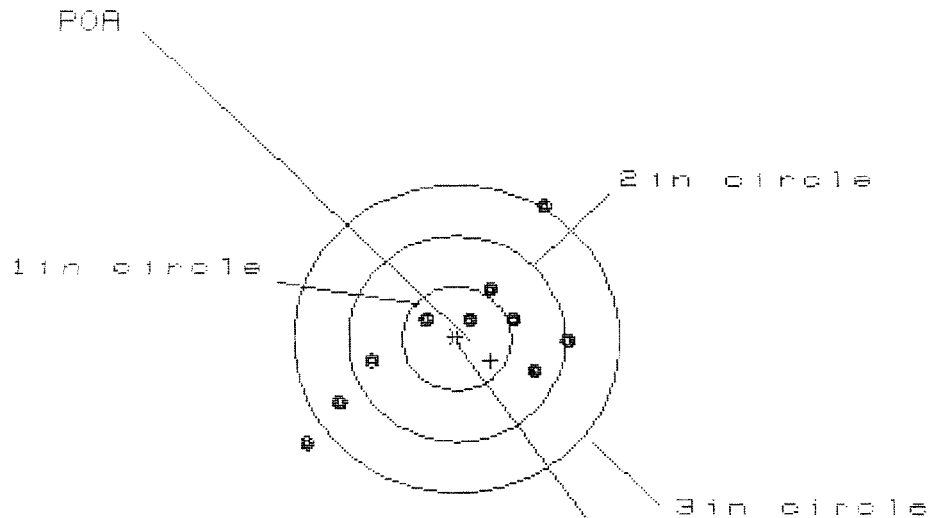
L<sub>4</sub> <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.064  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0692  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0942584  
THE AMR FOR THIS RIFLE IS: .9382

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FILE:/PATTERNING/CENTERFIRE\_PATT/06522353

## CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.378

VS= 2.373

GS= 3.241

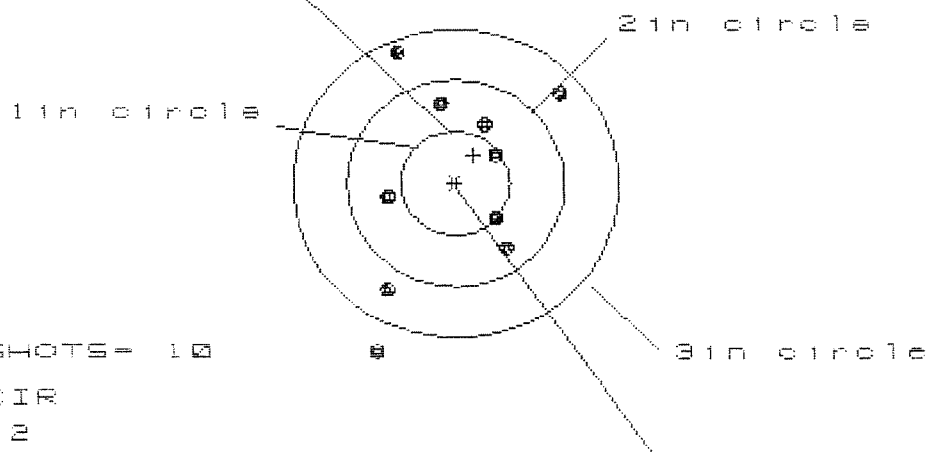
| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.015  | .864   | .951   |
| MINIMUM X                     | -1.362 | -1.202 | -1.115 |
| MAXIMUM Y                     | 1.338  | 1.223  | .498   |
| MINIMUM Y                     | -1.035 | -.746  | -.593  |
| CENTROID X                    | -.318  | -.166  | -.253  |
| CENTROID Y                    | .210   | .325   | .172   |
| POA TO CENTROID in.           | .381   | .365   | .306   |
| MIN RADIUS                    | .258   | .104   | .266   |
| MEAN RADIUS                   | .881   | .746   | .687   |
| MAX RADIUS                    | 1.711  | 1.415  | 1.263  |
| HORIZONTAL SPREAD             | 2.378  | 2.066  | 2.066  |
| VERTICAL SPREAD               | 2.373  | 1.969  | 1.091  |
| EXTREME SPREAD                | 3.241  | 2.733  | 2.150  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

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## CENTERFIRE PATTERNS # 2

POR



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 6

3 in = 9

ME = 1.6885

VS = 2.946

GS = 3.020

CENTROID #

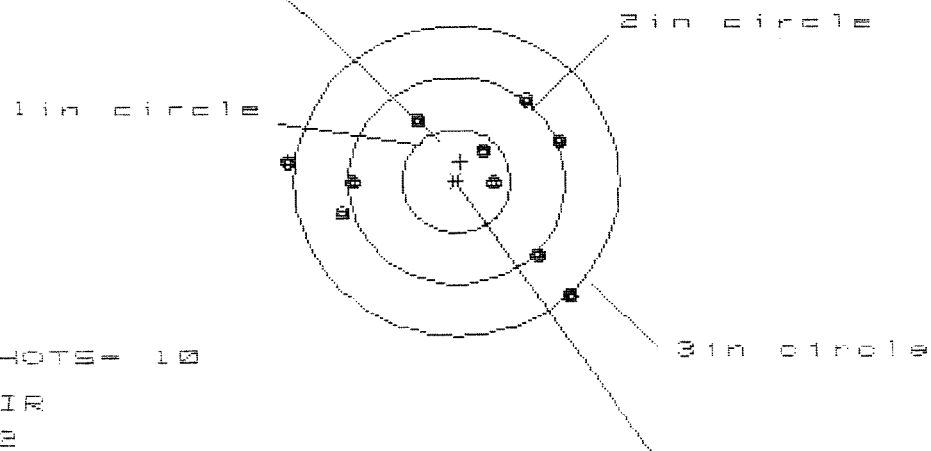
| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .969   | .889   | .816   |
| MINIMUM X                   | : | -.717  | -.710  | -.783  |
| MAXIMUM Y                   | : | 1.314  | 1.133  | .835   |
| MINIMUM Y                   | : | -1.632 | -1.256 | -1.114 |
| CENTROID X                  | : | -.167  | -.087  | -.014  |
| CENTROID Y                  | : | -.274  | -.093  | -.235  |
| POR TO CENTROID in.         | : | .321   | .127   | .235   |
| MIN RADIUS                  | : | .468   | .333   | .318   |
| MEAN RADIUS                 | : | .960   | .838   | .772   |
| MAX RADIUS                  | : | 1.782  | 1.420  | 1.336  |
| HORIZONTAL SPREAD           | : | 1.686  | 1.599  | 1.599  |
| VERTICAL SPREAD             | : | 2.946  | 2.389  | 1.949  |
| EXTREME SPREAD              | : | 3.020  | 2.491  | 2.491  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS # 3

POA



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.540

VS= 1.855

CS= 2.843

CENTROID #

| PATTERN #                     | 1      | 3      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.028  | .860   | .854   |
| MINIMUM X                     | -1.512 | -1.229 | -1.122 |
| MAXIMUM Y                     | .763   | .784   | .650   |
| MINIMUM Y                     | -1.092 | -1.071 | -.855  |
| CENTROID X                    | -.042  | .126   | .019   |
| CENTROID Y                    | -.189  | -.210  | -.076  |
| POA TO CENTROID in.           | .194   | .245   | .078   |
| MIN RADIUS                    | .348   | .180   | .241   |
| MEAN RADIUS                   | .946   | .854   | .777   |
| MAX RADIUS                    | 1.524  | 1.373  | 1.187  |
| HORIZONTAL SPREAD             | 2.540  | 2.089  | 1.976  |
| VERTICAL SPREAD               | 1.855  | 1.855  | 1.505  |
| EXTREME SPREAD                | 2.843  | 2.256  | 2.084  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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## CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.549

VS= 3.003

GS= 3.199

CENTROID #

| PATTERN #                   | : | 4      |
|-----------------------------|---|--------|
| SHOTS (BEST OF)             | : | 10     |
| MAXIMUM X                   | : | .768   |
| MINIMUM X                   | : | -.789  |
| MAXIMUM Y                   | : | 1.761  |
| MINIMUM Y                   | : | -1.242 |
| CENTROID X                  | : | .121   |
| CENTROID Y                  | : | .102   |
| POA TO CENTROID in.         | : | .159   |
| MIN RADIUS                  | : | .142   |
| MEAN RADIUS                 | : | 1.004  |
| MAX RADIUS                  | : | 1.918  |
| HORIZONTAL SPREAD           | : | 1.549  |
| VERTICAL SPREAD             | : | 3.003  |
| EXTREME SPREAD              | : | 3.199  |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |
| NUMBER IN TWO INCH CIRCLE   | = | 5      |
| NUMBER IN THREE INCH CIRCLE | = | 9      |

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## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.158

VS = 3.011

GS = 3.119

CENTROID #

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .398   | .442   | .395   |
| MINIMUM X                   | : | -.760  | -.716  | -.763  |
| MAXIMUM Y                   | : | 1.396  | 1.217  | .886   |
| MINIMUM Y                   | : | -1.615 | -1.414 | -1.262 |
| CENTROID X                  | : | .086   | .042   | .089   |
| CENTROID Y                  | : | -.195  | -.016  | -.168  |
| POA TO CENTROID in.         | : | .213   | .045   | .190   |
| MIN RADIUS                  | : | .355   | .348   | .356   |
| MEAN RADIUS                 | : | .900   | .807   | .735   |
| MAX RADIUS                  | : | 1.662  | 1.425  | 1.269  |
| HORIZONTAL SPREAD           | : | 1.158  | 1.158  | 1.158  |
| VERTICAL SPREAD             | : | 3.011  | 2.631  | 2.148  |
| EXTREME SPREAD              | : | 3.119  | 2.689  | 2.256  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| 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 06522353

DATE 8/23/90

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.34                     | 2.27                           | 2.19  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.43             | 2.37                     | 2.24                           | 2.25  |                                                                        |
| PULL #3 | 2.39             | 2.34                     | 2.24                           | 2.23  |                                                                        |
| PULL #4 | 2.39             | 2.30                     | 2.25                           | 2.21  |                                                                        |
| PULL #5 | 2.40             | 2.33                     | 2.28                           | 2.24  |                                                                        |
| TOTAL   | 12.11            | 11.73                    | 11.28                          | 11.12 |                                                                        |
| AVG.    | 2.422            | 2.346                    | 2.256                          | 2.224 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.26             | 3.36                     |  |          |
| PULL #2 | 3.12             | 3.34                     |  |          |
| PULL #3 | 3.36             | 3.40                     |  |          |
| PULL #4 | 3.35             | 3.36                     |  |          |
| PULL #5 | 3.40             | 3.34                     |  |          |
| TOTAL   | 16.49            | 16.70                    |  |          |
| AVG.    | 3.298            | 3.34                     |  |          |

|         | 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 | 4.17             | 4.26                     |                                | 4.27                                 |
| PULL #2 | 4.27             | 4.28                     |                                | 4.28                                 |
| PULL #3 | 4.28             | 4.30                     |                                | 4.26                                 |
| PULL #4 | 4.27             | 4.27                     |                                | 4.27                                 |
| PULL #5 | 4.28             | 4.28                     |                                | 4.29                                 |
| TOTAL   | 21.27            | 21.39                    |                                | 21.37                                |
| AVG.    | 4.254            | 4.278                    |                                | 4.274                                |

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522353

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>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<br>Action                                     |          | 7-17-90 | RR   |
|              | Magnaflux Bolt                                                 |          | 7-17-90 | RR   |
| 615          | Rollmark Caliber                                               |          | 7-17-90 | LS   |
| 617          | Drill and Tap Sight Holes                                      |          | 7/23/90 | LB   |
| 618          | Polish Barrel RB                                               |          | 7/24/90 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-6-90  | TS   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/8/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/8/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/8/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/8/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/23/90 | JH   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        | 4    | 4    |      |      | 8/16/90 | JH   |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 8/16/90 | JH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8/23/90 | JH   |
|              | I) Firing Pin Indent                                        | .023     | .023 | .023 |      |      | 8/16/90 | JH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8/16/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8/29/90 | JH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8/16/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8/16/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8/16/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8/16/90 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8/16/90 | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-17-90 | DH   |
|              | A) Time                                                     |          |      |      |      |      | 8-17-90 | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-17-90 | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-17-90 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-17-90 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-17-90 | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 8/29/90 | JH   |
|              | B) Trigger Pull                                             | 2.19     | 2.25 | 2.23 | 2.21 | 2.24 | 8/23/90 | JH   |
|              | C) Function                                                 |          |      |      |      |      | 8/29/90 | JH   |
| 660          | Pack                                                        |          |      |      |      |      | 9/19/90 | NF   |