

C6523316

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ M24

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

SERIAL NO.
C6523316

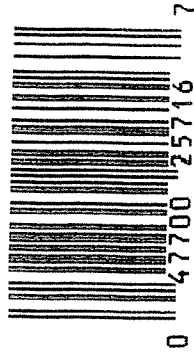
ORDER NO.
5716

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

Ø1



LPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523316
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.110309
1 TO	2	.122102
1 TO	3	.355376
1 TO	4	.189552
1 TO	5	.157762

~~4~~⁵ <----POB

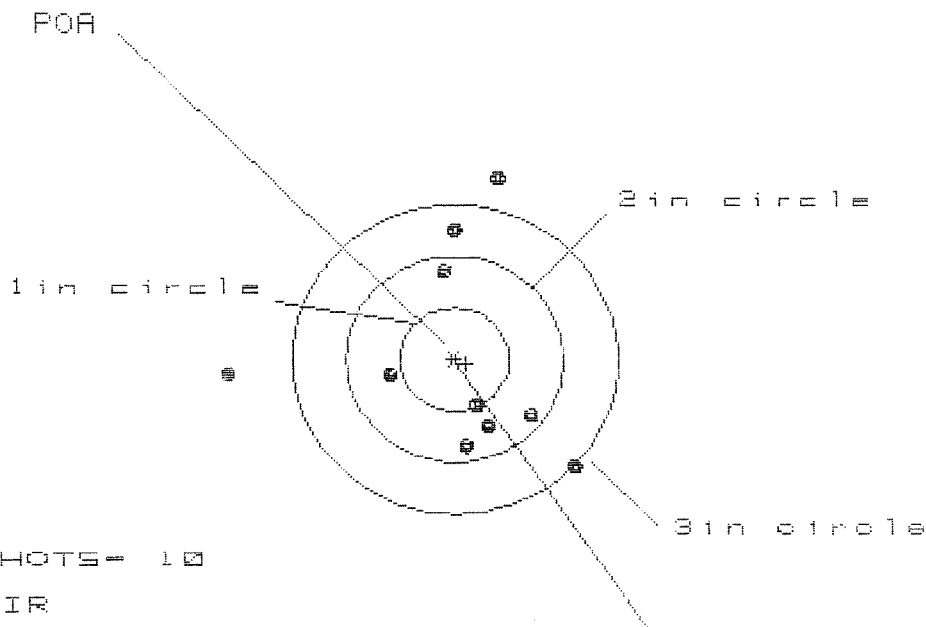
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .04245

THE AMR FOR THIS RIFLE IS: .8692

13 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523316

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.219

VS= 2.849

GS= 3.341

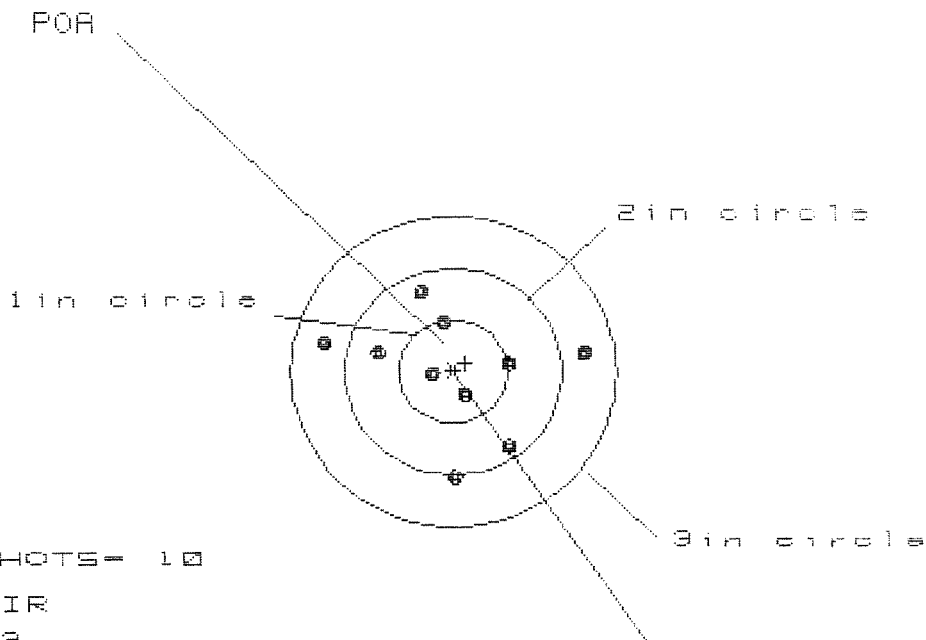
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	.875	.900
MINIMUM X	:	-2.110	-.879	-.853
MAXIMUM Y	:	1.780	1.760	1.459
MINIMUM Y	:	-1.069	-1.089	-.868
CENTROID X	:	-.102	.132	.106
CENTROID Y	:	.042	.062	-.158
POA TO CENTROID in.	:	.111	.146	.191
MIN RADIUS	:	.481	.444	.224
MEAN RADIUS	:	1.118	.991	.822
MAX RADIUS	:	2.117	1.772	1.480
HORIZONTAL SPREAD	:	3.219	1.754	1.754
VERTICAL SPREAD	:	2.849	2.849	2.328
EXTREME SPREAD	:	3.341	2.926	2.595
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.412

VS= 1.821

GS= 2.414

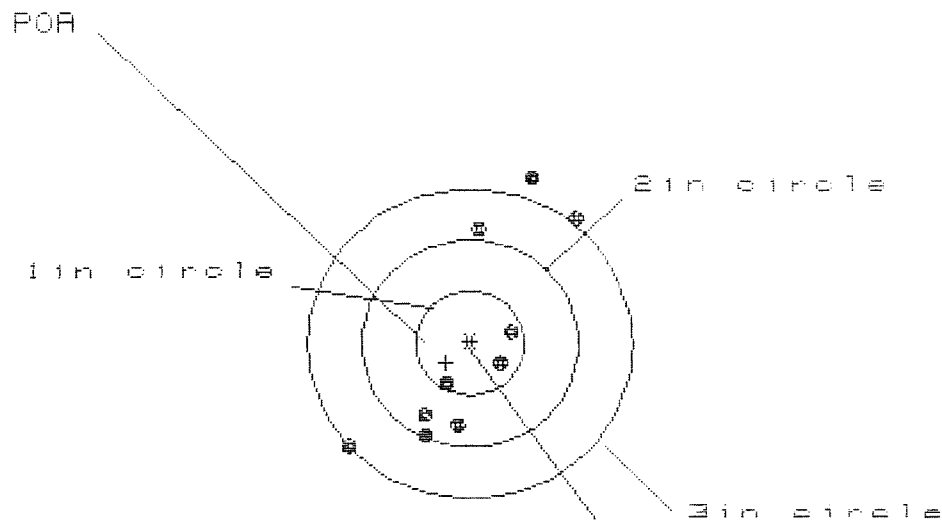
CENTROID #

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.228	.667	.536
MINIMUM X	-1.184	-1.047	-.693
MAXIMUM Y	.782	.799	.833
MINIMUM Y	-1.039	-1.022	-.988
CENTROID X	-.107	-.244	-.113
CENTROID Y	-.080	-.097	-.131
POA TO CENTROID in.	.134	.263	.173
MIN RADIUS	.158	.050	.170
MEAN RADIUS	.733	.668	.611
MAX RADIUS	1.238	1.081	.989
HORIZONTAL SPREAD	2.412	1.714	1.229
VERTICAL SPREAD	1.821	1.821	1.821
EXTREME SPREAD	2.414	1.946	1.842
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 2.157

VS= 2.634

GS= 3.144

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	1.079	.600
MINIMUM X	:	-1.142	-1.078	-.944
MAXIMUM Y	:	1.624	1.372	1.442
MINIMUM Y	:	-1.010	-.829	-.658
CENTROID X	:	.222	.158	.024
CENTROID Y	:	.188	.007	-.164
POA TO CENTROID in.	:	.291	.159	.166
MIN RADIUS	:	.321	.262	.064
MEAN RADIUS	:	.967	.836	.665
MAX RADIUS	:	1.723	1.745	1.462
HORIZONTAL SPREAD	:	2.157	2.157	1.544
VERTICAL SPREAD	:	2.634	2.201	2.100
EXTREME SPREAD	:	3.144	3.082	2.410
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

CENTROID *

HS= 2.556

VS= 2.033

GS= 2.809

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.204	.736
MINIMUM X	:	-1.217	-1.085	-.935
MAXIMUM Y	:	1.103	1.000	.953
MINIMUM Y	:	-.930	-.907	-.954
CENTROID X	:	.029	.164	.014
CENTROID Y	:	-.095	.008	.055
POA TO CENTROID in.	:	.099	.165	.057
MIN RADIUS	:	.292	.172	.161
MEAN RADIUS	:	.870	.768	.685
MAX RADIUS	:	1.532	1.261	1.204
HORIZONTAL SPREAD	:	2.556	2.289	1.671
VERTICAL SPREAD	:	2.033	1.907	1.907
EXTREME SPREAD	:	2.809	2.384	2.322
NUMBER IN ONE INCH CIRCLE	=		3	
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 = 8

3in = 10

HS= 1.733

VS= 1.865

GS= 2.228

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.930	.865	.447
MINIMUM X	:	-.803	-.868	-.760
MAXIMUM Y	:	.696	.566	.608
MINIMUM Y	:	-1.169	-1.074	-1.032
CENTROID X	:	.013	.078	-.030
CENTROID Y	:	.150	.280	.238
POA TO CENTROID in.	:	.150	.290	.240
MIN RADIUS	:	.154	.202	.113
MEAN RADIUS	:	.658	.562	.516
MAX RADIUS	:	1.306	1.074	1.036
HORIZONTAL SPREAD	:	1.733	1.733	1.207
VERTICAL SPREAD	:	1.865	1.640	1.640
EXTREME SPREAD	:	2.228	1.800	1.645
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
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. C6523316

DATE 9/11/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.36	2.32	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.57	2.31	2.25	
PULL #3	2.46	2.55	2.25	2.18	
PULL #4	2.47	2.61	2.23	2.21	
PULL #5	2.49	2.57	2.20	2.18	
TOTAL	12.35	12.86	11.31	11.06	
AVG.	2.47	2.57	2.36	2.212	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.29		
PULL #2	3.09	3.16		
PULL #3	3.13	3.20		
PULL #4	3.14	3.28		
PULL #5	3.09	3.24		
TOTAL	15.64	16.17		
AVG.	3.13	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.39		3.95
PULL #2	4.29	4.36		4.05
PULL #3	4.14	4.16		4.01
PULL #4	4.24	4.31		4.03
PULL #5	4.07	4.29		3.95
TOTAL	20.92	21.51		19.99
AVG.	4.18	4.30		4.00

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523314

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCD
	Magnaflux Bolt		8/22/90	KCD
615	Rollmark Caliber		8/22/90	GS
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-22-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/90	W.B.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4 1/2			9/11/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/11/90	WB
	H) Trigger Pull Test & Retainability						9/11/90	WB
	I) Firing Pin Indent	.0225	.023	.023			9/11/90	WB
	J) Assemble Stock						9/11/90	RW
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						9/11/90	RW
	M) Iron Sight Alignment						9/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/90	RW
	O) Attach Scope to Rifle						9/11/90	RW
	P) Detach & Attach Scope 20 Times						9/11/90	RW
640	Gallery Target & Test						9-13-90	NF
	A) Time						9-13-90	NF
	B) Malfunctions						9-13-90	NF
	C) Pierced Primers						9-13-90	NF
	D) Optical Clarity of Scope						9-13-90	NF
645	Inspect for Live Ammo						9-13-90	NF
655	Final Inspection							
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.24	2.25	2.18	2.21	2.18	9-15-90	JS
	C) Function						9/15/90	JS
660	Pack						9/19/90	NF