

C6523320

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523320
8 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.238411
1 TO	2	.26414
1 TO	3	.519362
1 TO	4	.251859
1 TO	5	.356931

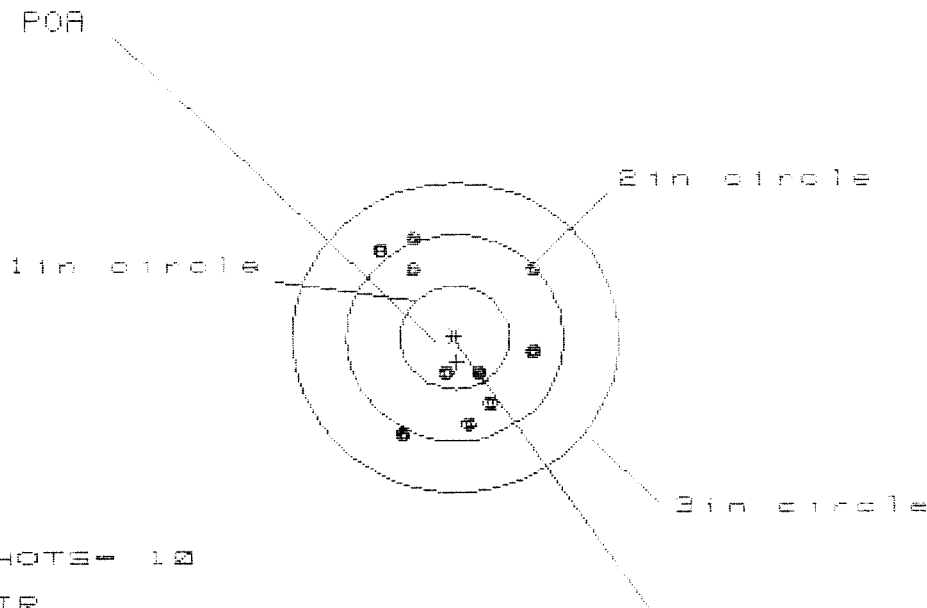
←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1078
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0010
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107815
THE AMR FOR THIS RIFLE IS: .7752

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523320

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.348

VS = 1.891

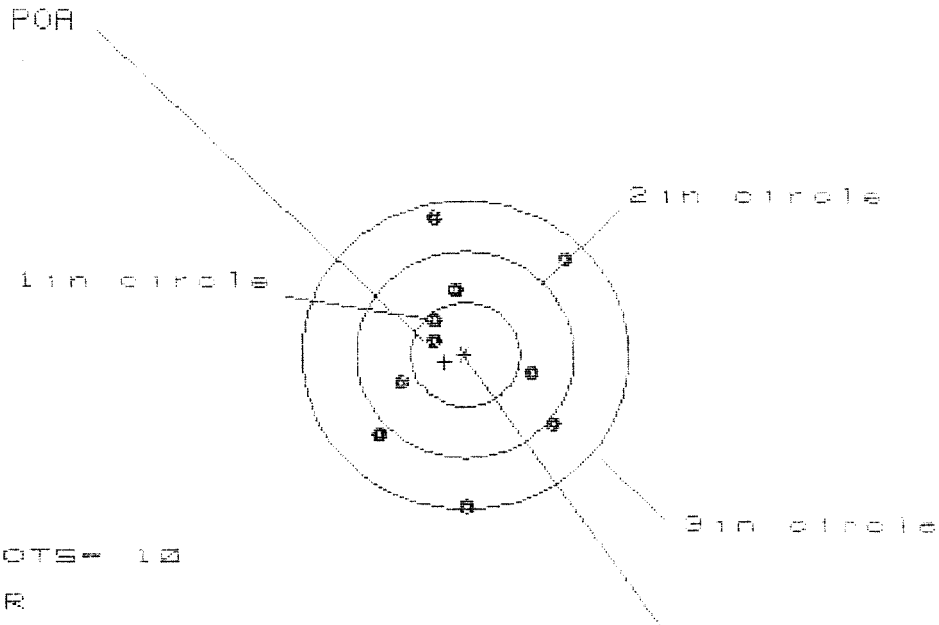
GS = 1.968

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.704	.632	.558
MINIMUM X	-.644	-.595	-.554
MAXIMUM Y	.956	1.056	.952
MINIMUM Y	-.935	-.835	-.808
CENTROID X	-.014	.058	.132
CENTROID Y	.238	.138	.242
POA TO CENTROID in.	.238	.149	.276
MIN RADIUS	.329	.276	.337
MEAN RADIUS	.785	.720	.692
MAX RADIUS	1.107	1.136	1.072
HORIZONTAL SPREAD	1.348	1.227	1.112
VERTICAL SPREAD	1.891	1.891	1.760
EXTREME SPREAD	1.968	1.968	1.812
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

6 May 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.720

VS = 2.809

GS = 2.827

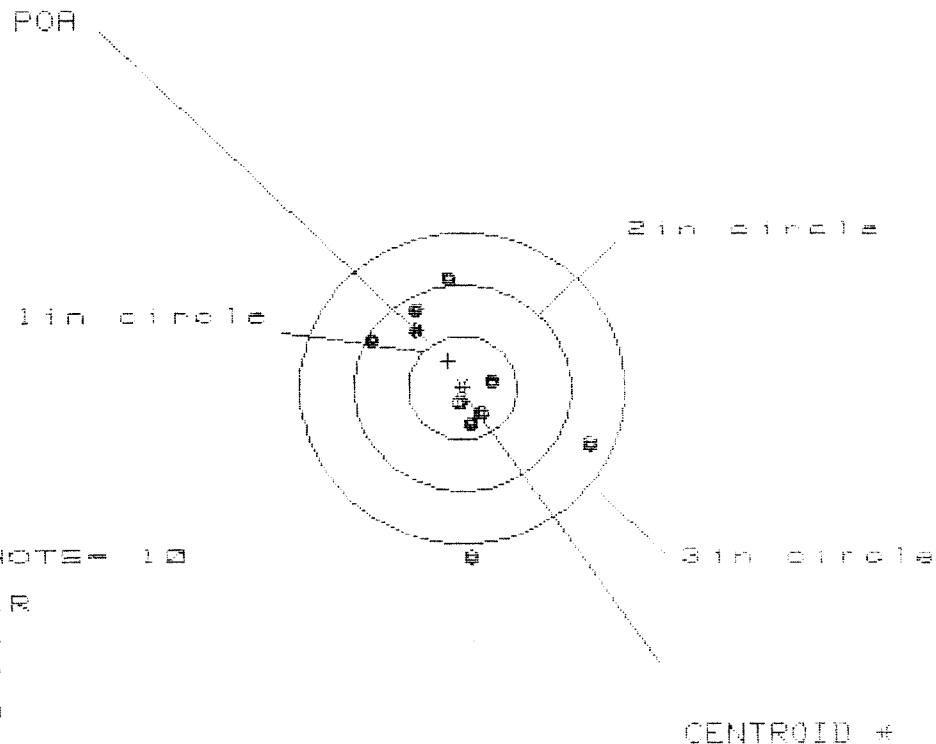
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.936	.937	.898
MINIMUM X	:	-.784	-.783	-.822
MAXIMUM Y	:	1.319	1.154	.932
MINIMUM Y	:	-1.490	-.940	-.796
CENTROID X	:	.189	.188	.227
CENTROID Y	:	.069	.234	.090
POA TO CENTROID in.	:	.201	.301	.244
MIN RADIUS	:	.299	.260	.324
MEAN RADIUS	:	.891	.801	.760
MAX RADIUS	:	1.490	1.224	1.294
HORIZONTAL SPREAD	:	1.720	1.720	1.720
VERTICAL SPREAD	:	2.809	2.094	1.720
EXTREME SPREAD	:	2.827	2.438	2.438
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.043

VS = 2.667

GS = 2.675

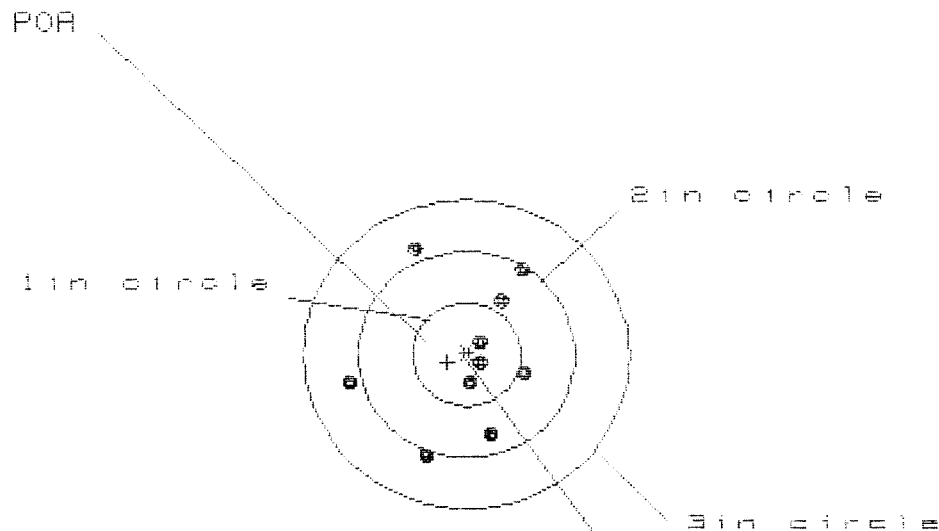
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.227	.454
MINIMUM X	:	-.827	-.816	-.663
MAXIMUM Y	:	1.042	.862	.776
MINIMUM Y	:	-1.625	-.685	-.596
CENTROID X	:	.130	.119	-.034
CENTROID Y	:	-.261	-.081	.005
POA TO CENTROID in.	:	.292	.144	.035
MIN RADIUS	:	.151	.329	.414
MEAN RADIUS	:	.764	.678	.583
MAX RADIUS	:	1.628	1.405	.778
HORIZONTAL SPREAD	:	2.043	2.043	1.117
VERTICAL SPREAD	:	2.667	1.547	1.372
EXTREME SPREAD	:	2.675	2.243	1.379
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.566

VS = 1.982

GS = 2.021

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.530	.478	.342
MINIMUM X	:	-1.036	-1.088	-1.598
MAXIMUM Y	:	1.013	.940	.919
MINIMUM Y	:	-.969	-.857	-.878
CENTROID X	:	.178	.230	.366
CENTROID Y	:	.075	-.037	-.016
POA TO CENTROID in.	:	.193	.233	.366
MIN RADIUS	:	.162	.086	.053
MEAN RADIUS	:	.682	.611	.531
MAX RADIUS	:	1.114	1.101	1.062
HORIZONTAL SPREAD	:	1.566	1.566	.940
VERTICAL SPREAD	:	1.982	1.797	1.797
EXTREME SPREAD	:	2.021	2.021	2.021
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.657

VS = 1.858

GS = 1.868

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.788	.752	.639
MINIMUM X	-.877	-.905	-.594
MAXIMUM Y	1.124	.859	.798
MINIMUM Y	-.734	-.609	-.670
CENTROID X	.056	.084	.197
CENTROID Y	-.112	-.237	-.176
POA TO CENTROID in.	.125	.252	.264
MIN RADIUS	.269	.244	.121
MEAN RADIUS	.754	.691	.631
MAX RADIUS	1.153	1.030	.995
HORIZONTAL SPREAD	1.657	1.657	1.233
VERTICAL SPREAD	1.858	1.468	1.468
EXTREME SPREAD	1.906	1.904	1.596
NUMBER IN ONE INCH CIRCLE =		2	
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 C6523320

DATE 1-6-90

TESTER JLF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.26	2.34	292	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.39	2.27	285	
PULL #3	2.26	2.28	2.28	291	
PULL #4	2.42	2.25	2.39	292	
PULL #5	2.32	2.28	2.32	290	
TOTAL	11.42	11.46	11.60		
AVG.	2.284	2.292	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.34		
PULL #2	3.17	3.31		
PULL #3	3.46	3.30		
PULL #4	3.41	3.30		
PULL #5	3.40	3.17		
TOTAL	16.71	16.42		
AVG.	3.342	3.284		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.30		4.18
PULL #2	4.50	4.33		4.22
PULL #3	4.19	4.32		4.23
PULL #4	4.52	4.30		4.17
PULL #5	4.41	4.31		4.22
TOTAL	22.10	21.62		21.02
AVG.	4.42	4.324		4.204

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523320

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KH
600	Proof		10/4/90	KH
607	Check Headspace		10/4/90	KH
610	Dis-assemble Gun		10/4/90	KH
612	Magnaflux Barrel Action		10/4/90	KR
	Magnaflux Bolt		10/4/90	KR
615	Rollmark Caliber		10/9/90	SL
617	Drill and Tap Sight Holes		10/6/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/19/90	WB
	C) Inspect Ejector Hole for Chamfer		10/19/90	WB
	D) Oil Firing Pin Ass'y		10/19/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	TH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3.5	3.0	3.0	11-2-90	KT
	G) Safety Off Force	2.0	2.0	2.0	11-2-90	KT
	H) Trigger Pull Test & Retainability				11-6-90	JH
	I) Firing Pin Indent	.026	.027	.026	11-2-90	KT
	J) Assemble Stock				11-6-90	KS
	K) Assemble Swivel Studs				11-20-90	JS
	L) Attach Front and Rear Sight Assemblies				11-6-90	KS
	M) Iron Sight Alignment				11-6-90	KS
	N) Detach Front & Rear Sights & place in numbered container				11-6-90	KS
	O) Attach Scope to Rifle				11-6-90	KS
	P) Detach & Attach Scope 20 Times				11-6-90	KS
640	Gallery Target & Test				11-8-90	AC
	A) Time				11-8-90	AC
	B) Malfunctions				11-8-90	AC
	C) Pierced Primers				11-8-90	AC
	D) Optical Clarity of Scope				11-8-90	AC
645	Inspect for Live Ammo				11-8-90	AC
655	Final Inspection				11-20-90	JS
	A) Headspace				11-20-90	JS
	B) Trigger Pull	292	285	291	11-20-90	JS
	C) Function				11-20-90	JS
660	Pack				12/18/90	W



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

MODEL 700™ M24	SERIAL NO. C6523320
01	ORDER NO. 5716

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



5716 C6523320

UPC



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