

C6498776

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*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™ M24

SERIAL NO.
C6498776

ORDER NO.
5716

Ø1

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



5716 C6498776

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498776
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.238416
1 TO	2	.193023
1 TO	3	.229976
1 TO	4	.411433
1 TO	5	.129522

$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .127
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0222
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128926
THE AMR FOR THIS RIFLE IS: .9322

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498776

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.193

VS= 2.627

GS= 3.294

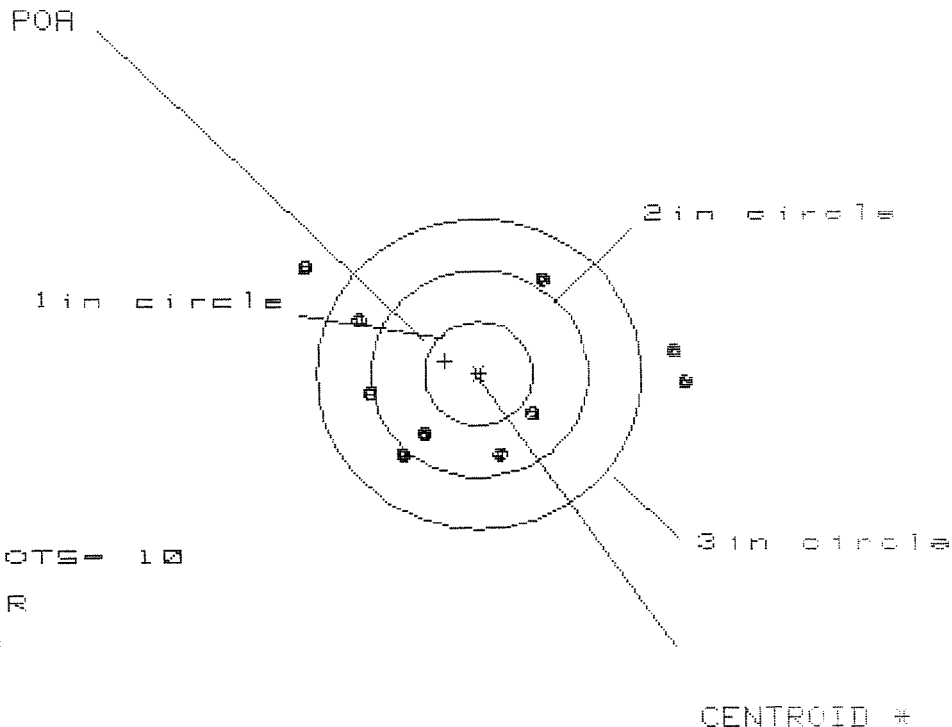
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.900	.998	1.077
MINIMUM X	:	-1.293	-1.082	-1.003
MAXIMUM Y	:	1.514	1.562	1.323
MINIMUM Y	:	-1.113	-1.065	-0.870
CENTROID X	:	.231	.020	-.059
CENTROID Y	:	.059	.011	-.184
POA TO CENTROID in.	:	.239	.023	.194
MIN RADIUS	:	.158	.272	.297
MEAN RADIUS	:	1.049	.931	.788
MAX RADIUS	:	1.948	1.687	1.706
HORIZONTAL SPREAD	:	3.193	2.080	2.080
VERTICAL SPREAD	:	2.627	2.627	2.193
EXTREME SPREAD	:	3.294	2.812	2.584
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.485

VS= 1.789

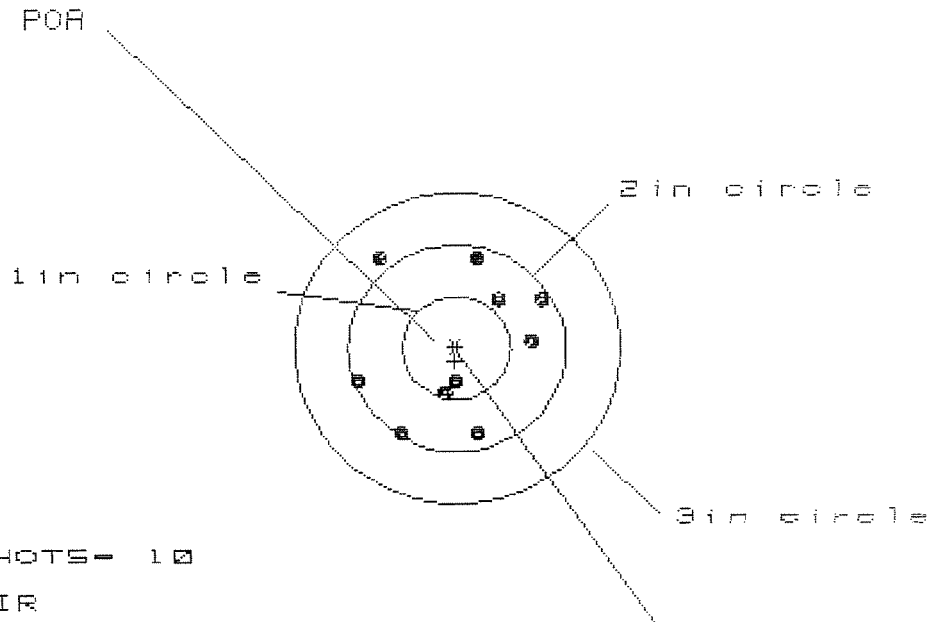
GS= 3.649

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.901	1.957	1.785
MINIMUM X	:	-1.584	-1.373	-1.040
MAXIMUM Y	:	1.026	1.020	1.065
MINIMUM Y	:	-.763	-.769	-.642
CENTROID X	:	.308	.097	.269
CENTROID Y	:	-.118	-.112	-.239
POA TO CENTROID in.	:	.330	.148	.360
MIN RADIUS	:	.645	.678	.609
MEAN RADIUS	:	1.217	1.118	1.021
MAX RADIUS	:	1.902	1.974	1.827
HORIZONTAL SPREAD	:	3.485	3.330	2.825
VERTICAL SPREAD	:	1.789	1.789	1.707
EXTREME SPREAD	:	3.649	3.416	2.840
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.637

VS= 1.690

GS= 1.915

CENTROID *

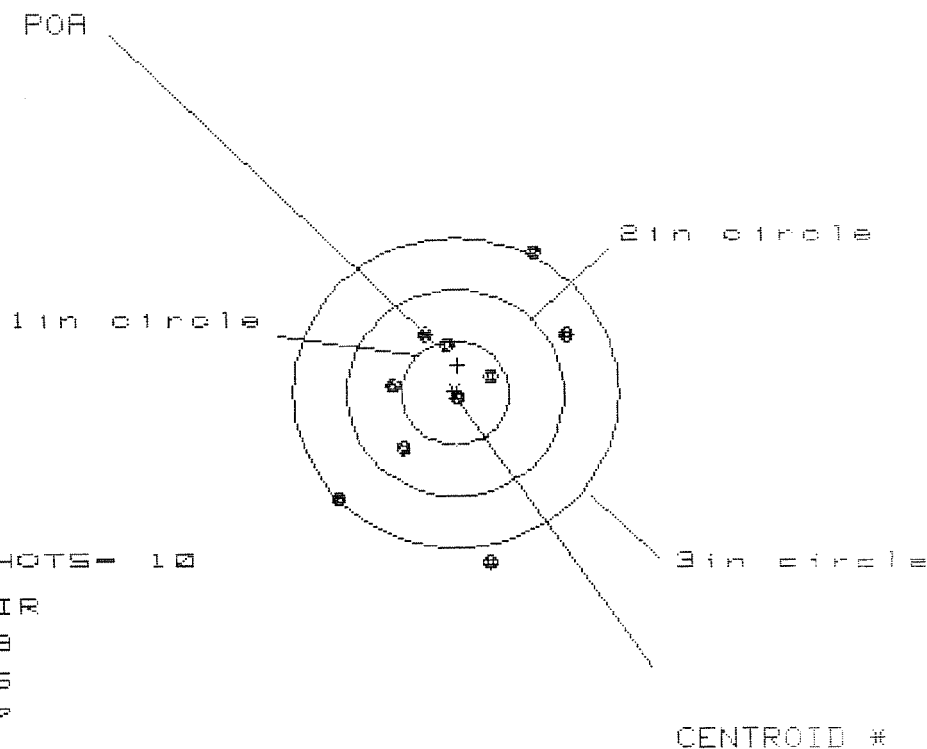
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.687	.568
MINIMUM X	:	-.872	-.950	-.679
MAXIMUM Y	:	.895	.941	.907
MINIMUM Y	:	-.795	-.696	-.730
CENTROID X	:	.011	.089	.208
CENTROID Y	:	.126	.027	.061
POA TO CENTROID in.	:	.126	.093	.216
MIN RADIUS	:	.377	.306	.400
MEAN RADIUS	:	.766	.703	.662
MAX RADIUS	:	1.140	.989	.984
HORIZONTAL SPREAD	:	1.637	1.637	1.247
VERTICAL SPREAD	:	1.690	1.637	1.637
EXTREME SPREAD	:	1.915	1.840	1.761
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.125

VS= 3.011

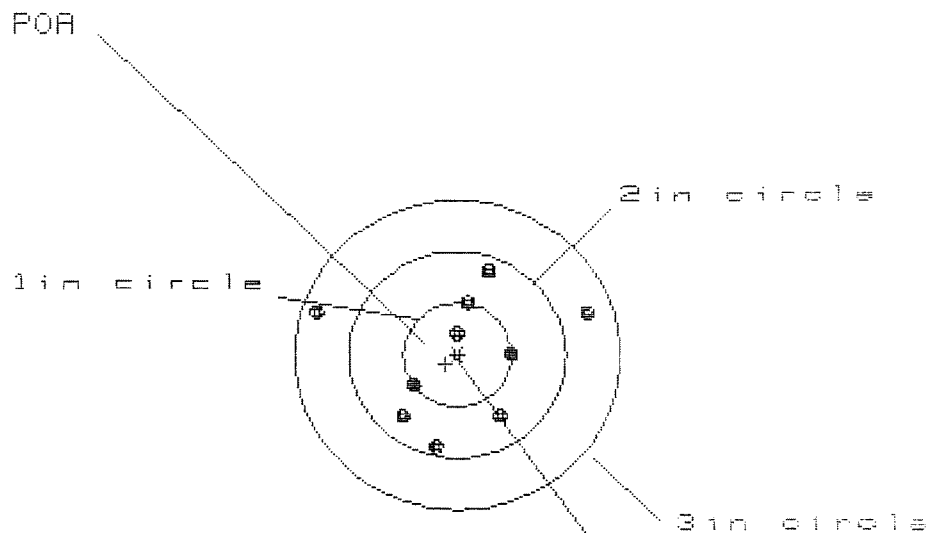
GS= 3.041

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	1.088	1.169
MINIMUM X	:	-1.083	-1.045	-.956
MAXIMUM Y	:	1.397	1.218	.587
MINIMUM Y	:	-1.614	-1.258	-1.106
CENTROID X	:	-.020	-.057	-.146
CENTROID Y	:	-.267	-.088	-.240
POA TO CENTROID in.	:	.268	.104	.281
MIN RADIUS	:	.024	.190	.112
MEAN RADIUS	:	.872	.767	.685
MAX RADIUS	:	1.648	1.636	1.462
HORIZONTAL SPREAD	:	2.125	2.125	2.125
VERTICAL SPREAD	:	3.011	2.476	1.693
EXTREME SPREAD	:	3.041	3.041	2.717
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.548

VS= 1.683

GS= 2.548

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.206	1.057	.457
MINIMUM X	-1.342	-.657	-.525
MAXIMUM Y	.789	.836	.896
MINIMUM Y	-.894	-.847	-.787
CENTROID X	.105	.254	.122
CENTROID Y	.089	.042	-.018
POA TO CENTROID in.	.138	.258	.123
MIN RADIUS	.239	.325	.347
MEAN RADIUS	.757	.680	.611
MAX RADIUS	1.407	1.161	.925
HORIZONTAL SPREAD	2.548	1.714	.982
VERTICAL SPREAD	1.683	1.683	1.683
EXTREME SPREAD	2.548	1.987	1.730
NUMBER IN ONE INCH CIRCLE =		4	
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. C6498776DATE 8/18/90TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.29	2.36	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.29	2.30	2.34	
PULL #3	2.25	2.31	2.35	2.38	
PULL #4	2.34	2.31	2.32	2.39	
PULL #5	2.31	2.21	2.32	2.36	
TOTAL	11.55	11.41	11.65	11.74	
AVG.	2.31	2.282	2.33	2.348	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.37		
PULL #2	3.31	3.34		
PULL #3	3.30	3.36		
PULL #4	3.34	3.26		
PULL #5	3.29	3.30		
TOTAL	16.60	16.63		
AVG.	3.32	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.49		4.42
PULL #2	4.29	4.48		4.49
PULL #3	4.41	4.42		4.43
PULL #4	4.39	4.46		4.51
PULL #5	4.46	4.47		4.50
TOTAL	21.93	22.32		22.35
AVG.	4.386	4.464		4.47

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498776

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun		90	RW
612	Magnaflux Barrel Action		7/12/90	KR
	Magnaflux Bolt		7/12/90	KR
615	Rollmark Caliber		7/12/90	ZL
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/18/90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/10/90	921
	G) Safety Off Force	3	3	3			8/10/90	921
	H) Trigger Pull Test & Retainability						8/18/90	922
	I) Firing Pin Indent	.022	.022	.022			8/10/90	921
	J) Assemble Stock						8/21/90	RW
	K) Assemble Swivel Studs						8/24/90	923
	L) Attach Front and Rear Sight Assemblies						8/21/90	RW
	M) Iron Sight Alignment						8/21/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/90	RW
	O) Attach Scope to Rifle						8/21/90	RW
	P) Detach & Attach Scope 20 Times						8/21/90	RW
640	Gallery Target & Test						8/21/90	NF
	A) Time						8/21/90	NF
	B) Malfunctions						8/21/90	NF
	C) Pierced Primers						8/21/90	NF
	D) Optical Clarity of Scope						8/21/90	NF
645	Inspect for Live Ammo						8/21/90	NF
655	Final Inspection							
	A) Headspace						8/24/90	928
	B) Trigger Pull	2.27	2.34	2.38	2.39	2.36	8/22/90	921
	C) Function						8/29/90	928
660	Pack						9/20/90	NF