

C6498845

MODEL 780™ M24

Model **SMS**™

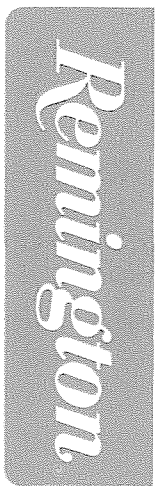
Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



**Remington**  
MODEL 700<sup>TH</sup> M24

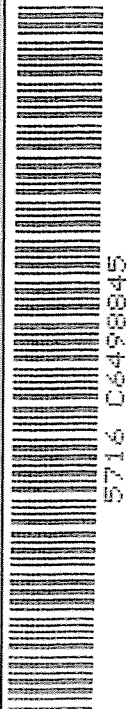
**DU PONT**  
REG. U.S. PAT. & TM. OFF.

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

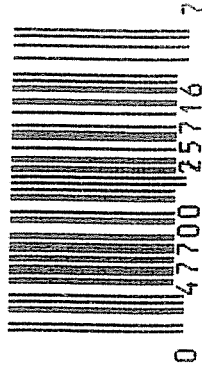
SERIAL NO.  
C6498845

ORDER NO.  
5716

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



UPC



CENTROIDAL DISTANCE CALCULATIONS  
 FOR RIFLE # 06498845  
 24 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .851826 |
| 1 TO | 2 | .93602  |
| 1 TO | 3 | .910486 |
| 1 TO | 4 | .424355 |
| 1 TO | 5 | .518499 |

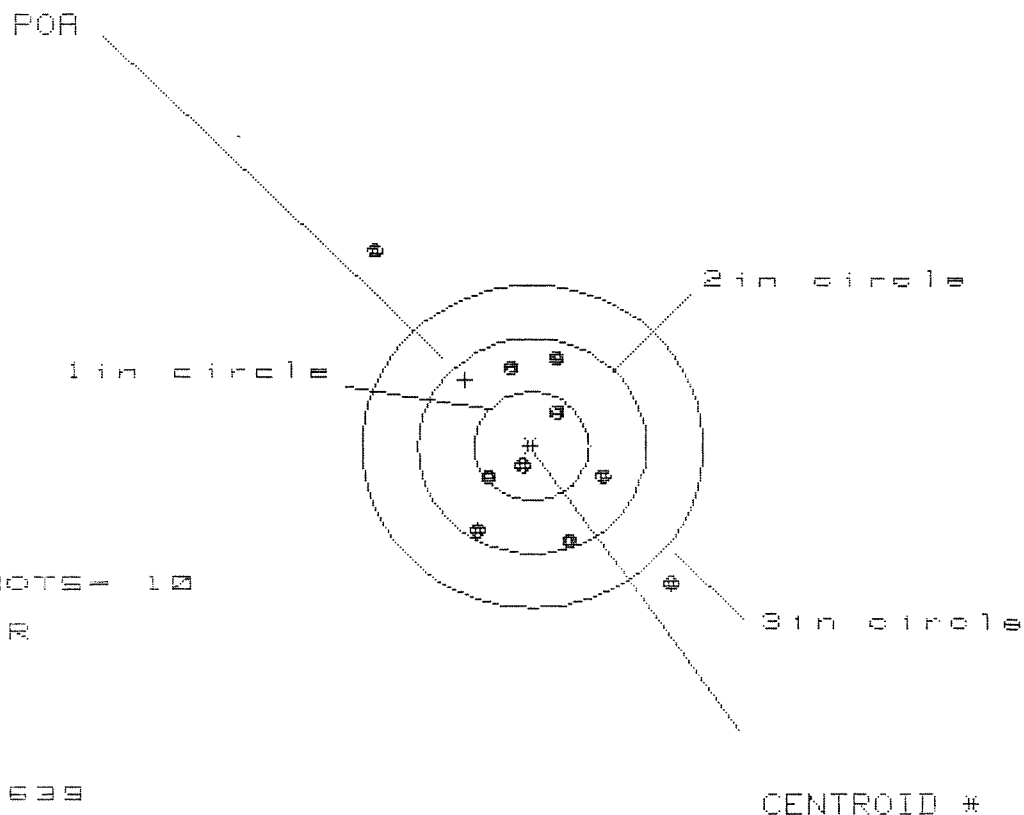
$\begin{matrix} 2^+ \\ 3 \end{matrix} \begin{matrix} 4 \\ 1 \end{matrix}$ 
 $\leftarrow$ ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1264  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3732  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .394024  
 THE AMR FOR THIS RIFLE IS: .8526

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/08438845

## CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 8

3 in = 8

HE = 2.639

VS = 3.076

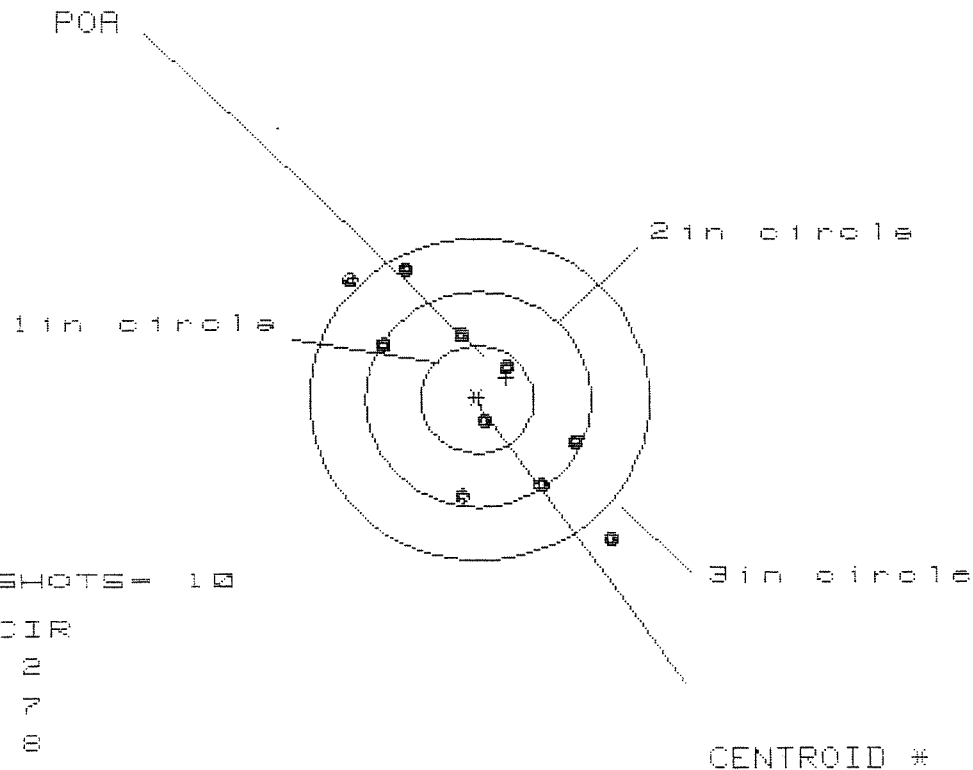
GS = 4.053

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.249  | 1.095  | .562  |
| MINIMUM X                     | -1.390 | -.588  | -.452 |
| MAXIMUM Y                     | 1.819  | 1.023  | .891  |
| MINIMUM Y                     | -1.257 | -1.054 | -.765 |
| CENTROID X                    | .582   | .736   | .600  |
| CENTROID Y                    | -.622  | -.825  | -.693 |
| POA TO CENTROID in.           | .852   | 1.105  | .916  |
| MIN RADIUS                    | .208   | .225   | .153  |
| MEAN RADIUS                   | .906   | .740   | .618  |
| MAX RADIUS                    | 2.290  | 1.520  | .912  |
| HORIZONTAL SPREAD             | 2.639  | 1.683  | 1.014 |
| VERTICAL SPREAD               | 3.076  | 2.077  | 1.656 |
| EXTREME SPREAD                | 4.053  | 2.432  | 1.722 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.337

VS = 2.560

GS = 3.374

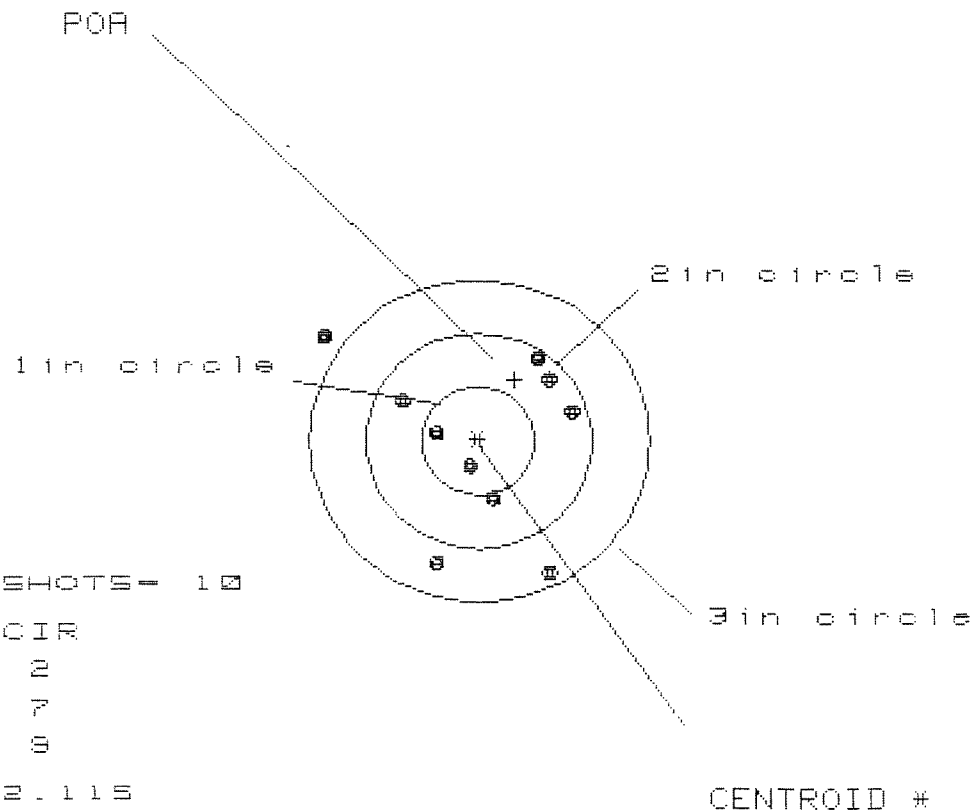
CENTROID #

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.189  | .975   | .848  |
| MINIMUM X                   | : | -1.148 | -1.016 | -.846 |
| MAXIMUM Y                   | : | 1.220  | 1.071  | 1.189 |
| MINIMUM Y                   | : | -1.340 | -1.069 | -.951 |
| CENTROID X                  | : | -.256  | -.388  | -.261 |
| CENTROID Y                  | : | -.205  | -.056  | -.174 |
| POA TO CENTROID in.         | : | .328   | .392   | .314  |
| MIN RADIUS                  | : | .211   | .385   | .242  |
| MEAN RADIUS                 | : | .977   | .883   | .800  |
| MAX RADIUS                  | : | 1.792  | 1.387  | 1.337 |
| HORIZONTAL SPREAD           | : | 2.337  | 1.991  | 1.694 |
| VERTICAL SPREAD             | : | 2.560  | 2.140  | 2.140 |
| EXTREME SPREAD              | : | 3.374  | 2.567  | 2.346 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.115

VS = 2.203

GS = 2.843

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .787   | .640   | .699   |
| MINIMUM X                   | : | -1.328 | -.778  | -.719  |
| MAXIMUM Y                   | : | .942   | .905   | .760   |
| MINIMUM Y                   | : | -1.261 | -1.156 | -1.137 |
| CENTROID X                  | : | -.327  | -.180  | -.239  |
| CENTROID Y                  | : | -.570  | -.675  | -.530  |
| POA TO CENTROID in.         | : | .658   | .699   | .582   |
| MIN RADIUS                  | : | .267   | .290   | .345   |
| MEAN RADIUS                 | : | .882   | .795   | .727   |
| MAX RADIUS                  | : | 1.628  | 1.250  | 1.213  |
| HORIZONTAL SPREAD           | : | 2.115  | 1.418  | 1.418  |
| VERTICAL SPREAD             | : | 2.203  | 2.061  | 1.897  |
| EXTREME SPREAD              | : | 2.943  | 2.099  | 2.099  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.284

VS= 2.752

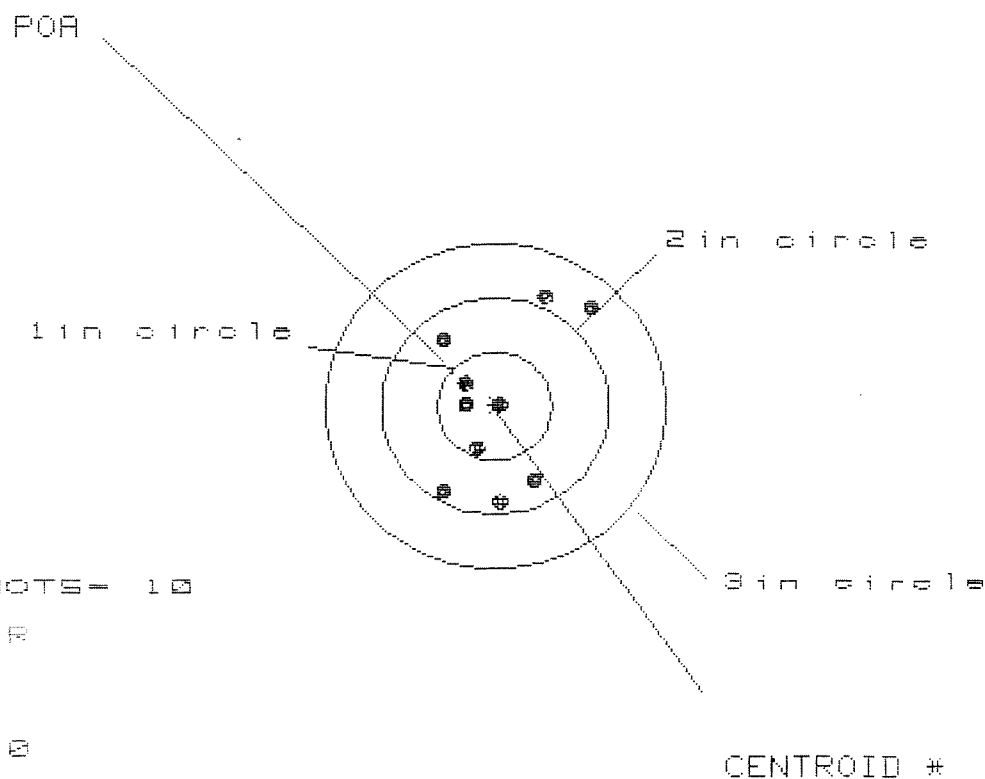
GS= 2.754

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .724   | .691   | .662   |
| MINIMUM X                   | : | -.560  | -.593  | -.622  |
| MAXIMUM Y                   | : | 1.376  | .834   | .681   |
| MINIMUM Y                   | : | -1.376 | -1.223 | -1.131 |
| CENTROID X                  | : | .376   | .409   | .438   |
| CENTROID Y                  | : | -.251  | -.404  | -.251  |
| POA TO CENTROID in.         | : | .452   | .575   | .505   |
| MIN RADIUS                  | : | .343   | .256   | .380   |
| MEAN RADIUS                 | : | .815   | .752   | .664   |
| MAX RADIUS                  | : | 1.407  | 1.245  | 1.140  |
| HORIZONTAL SPREAD           | : | 1.284  | 1.284  | 1.284  |
| VERTICAL SPREAD             | : | 2.752  | 2.057  | 1.812  |
| EXTREME SPREAD              | : | 2.754  | 2.089  | 1.965  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

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## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.324

VS= 1.857

GS= 2.207

| PATTERN #                   | : | 5     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .832  | .539  | .535  |
| MINIMUM X                   | : | -.492 | -.400 | -.333 |
| MAXIMUM Y                   | : | .974  | 1.081 | .867  |
| MINIMUM Y                   | : | -.883 | -.776 | -.641 |
| CENTROID X                  | : | .257  | .164  | .097  |
| CENTROID Y                  | : | -.218 | -.325 | -.460 |
| POA TO CENTROID in.         | : | .336  | .364  | .470  |
| MIN RADIUS                  | : | .019  | .133  | .180  |
| MEAN RADIUS                 | : | .683  | .600  | .517  |
| MAX RADIUS                  | : | 1.275 | 1.208 | .929  |
| HORIZONTAL SPREAD           | : | 1.324 | .939  | .868  |
| VERTICAL SPREAD             | : | 1.857 | 1.857 | 1.508 |
| EXTREME SPREAD              | : | 2.207 | 2.007 | 1.607 |
| 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. C6498845

DATE 8/21/90

TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.20             | 2.16                     | 2.60                           | 2.33  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.15             | 2.10                     | 2.52                           | 2.54  |                                                                        |
| PULL #3 | 2.16             | 2.20                     | 2.50                           | 2.57  |                                                                        |
| PULL #4 | 2.11             | 2.22                     | 2.59                           | 2.60  |                                                                        |
| PULL #5 | 2.14             | 2.23                     | 2.54                           | 2.25  |                                                                        |
| TOTAL   | 10.76            | 10.91                    | 12.75                          | 12.51 |                                                                        |
| AVG.    | 2.15             | 2.18                     | 2.53                           | 2.502 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.07             | 3.17                     |  |          |
| PULL #2 | 3.06             | 3.20                     |  |          |
| PULL #3 | 3.08             | 3.26                     |  |          |
| PULL #4 | 3.05             | 3.08                     |  |          |
| PULL #5 | 3.13             | 3.16                     |  |          |
| TOTAL   | 15.39            | 15.87                    |  |          |
| AVG.    | 3.07             | 3.17                     |  |          |

|         | 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 | 4.20             | 4.10                     |                                | 4.13                                 |
| PULL #2 | 4.21             | 4.15                     |                                | 4.13                                 |
| PULL #3 | 4.11             | 4.07                     |                                | 4.07                                 |
| PULL #4 | 4.17             | 4.15                     |                                | 4.28                                 |
| PULL #5 | 4.05             | 4.10                     |                                | 4.25                                 |
| TOTAL   | 20.74            | 20.57                    |                                | 20.86                                |
| AVG.    | 4.14             | 4.11                     |                                | 4.17                                 |

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498845

| 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 | KR   |
|              | Magnaflux Bolt                                                 |          | 7-17-90 | KR   |
| 615          | Rollmark Caliber                                               |          | 7-17-90 | GL   |
| 617          | Drill and Tap Sight Holes                                      |          | 7/23/90 | LB   |
| 618          | Polish Barrel RB                                               |          | 7/24/90 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-26-90 | HA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly                                                 |          |         |      |
|              | A) Clean inside of<br>Bolt Assembly                            |          |         |      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          |         |      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          |         |      |
|              | D) Oil Firing Pin Ass'y                                        |          |         |      |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/22/90 | AC   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/4    | 4 1/4 | 4 1/4 |      |      | 8/22/90 | WB   |
|              | G) Safety Off Force                                         | 2 1/4    | 2 1/4 | 2 1/4 |      |      | 8/22/90 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/22/90 | AC   |
|              | I) Firing Pin Indent                                        | .023     | .023  | .023  |      |      | 8/22/90 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 8/22/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8/31/90 | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/22/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/22/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/22/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/22/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/22/90 | KS   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8/23/90 | KJ   |
|              | A) Time                                                     |          |       |       |      |      | 8/23/90 | KJ   |
|              | B) Malfunctions                                             |          |       |       |      |      | 8/23/90 | KJ   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 8/23/90 | KJ   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 8/23/90 | KZ   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8/23/90 | KZ   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 8/31/90 | JS   |
|              | B) Trigger Pull                                             | 2.55     | 2.54  | 2.57  | 2.60 | 2.25 | 8/31/90 | JS   |
|              | C) Function                                                 |          |       |       |      |      | 8/31/90 | JS   |
| 660          | Pack                                                        |          |       |       |      |      | 9/20/90 | NF   |