

C6587661

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

BARBER - M24 M2400024766

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06587661DATE 3-11-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.64	2.58	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.45	2.64	
PULL #3	2.60	2.56	2.48	
PULL #4	2.56	2.43	2.43	
PULL #5	2.41	2.66	2.51	
TOTAL	12.84	12.68	12.54	
AVG.	2.56	2.53	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.07	3.02	
PULL #2	3.10	2.94	
PULL #3	3.06	2.94	
PULL #4	3.10	3.00	
PULL #5	3.04	3.00	
TOTAL	15.37	14.90	
AVG.	3.07	2.98	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.13		4.27
PULL #2	4.28	4.21		4.25
PULL #3	4.17	4.18		4.21
PULL #4	4.20	4.20		4.29
PULL #5	4.20	4.21		4.25
TOTAL	21.08	20.93		21.27
AVG.	4.21	4.18		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587761
22 Jan 1900

CENTROIDAL DISTANCES

0 TO 1	.917576
1 TO 2	.372759
1 TO 3	.545367
1 TO 4	.443005
1 TO 5	.915492

1.4
2
+5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3566
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .5908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .690078

THE AMR FOR THIS RIFLE IS: .948

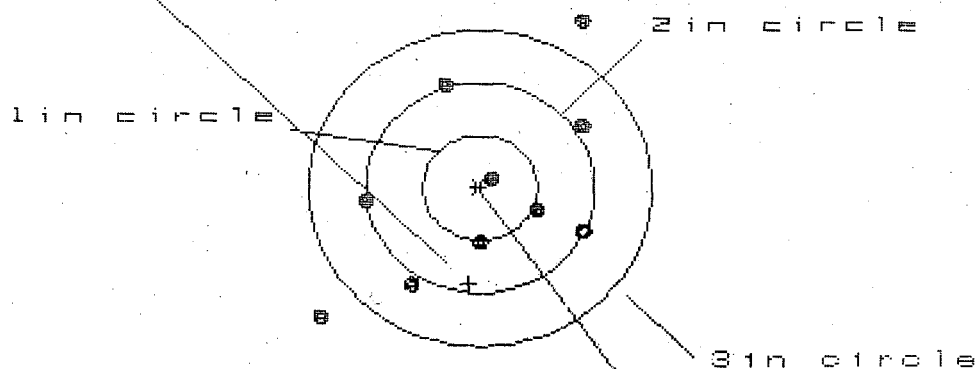
22 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6587761

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 2.340

VS= 2.749

GS= 3.607

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.946

.791

.890

MINIMUM X

-1.394

-1.120

-1.021

MAXIMUM Y

1.551

1.418

.996

MINIMUM Y

-1.198

-1.051

-.873

CENTROID X

.101

.256

.157

CENTROID Y

.912

1.045

.867

POA TO CENTROID in.

.917

1.076

.882

MIN RADIUS

.144

.093

.174

MEAN RADIUS

.994

.887

.778

MAX RADIUS

1.838

1.622

1.084

HORIZONTAL SPREAD

2.340

1.911

1.911

VERTICAL SPREAD

2.749

2.469

1.869

EXTREME SPREAD

3.607

2.903

2.126

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

4

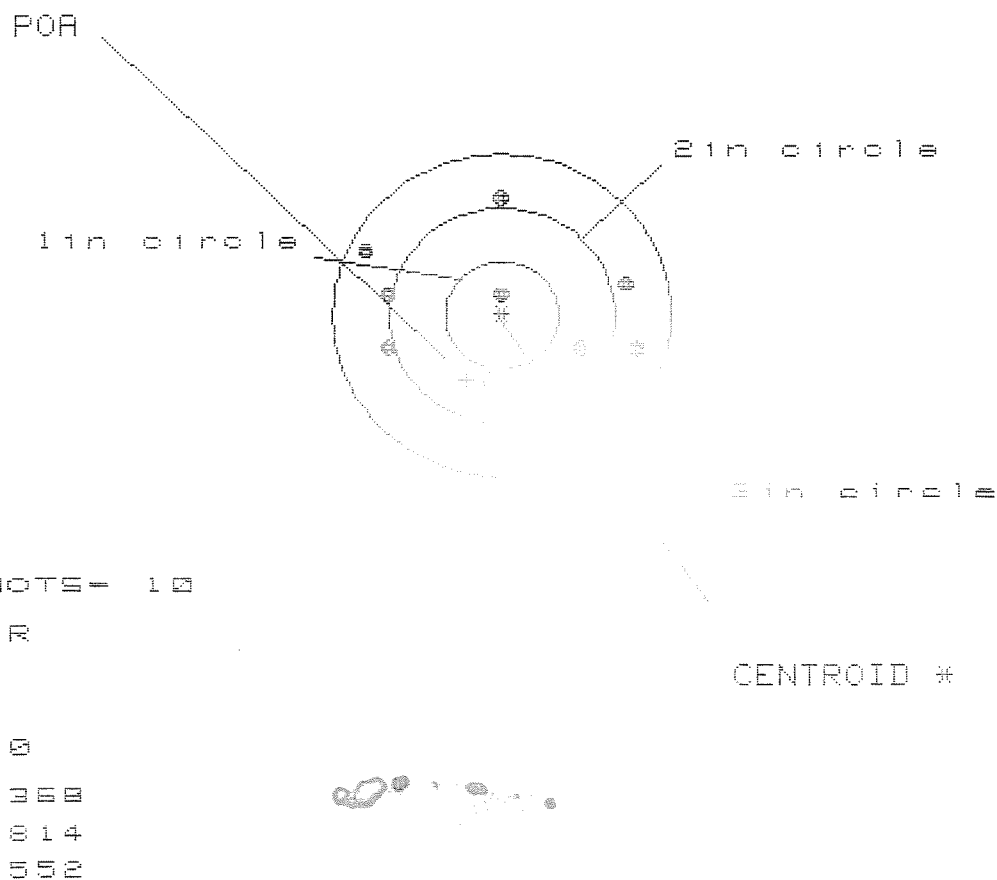
NUMBER IN THREE INCH CIRCLE =

8

22 Jan 1988

FILE: \PATTERNING\CENTERFIRE_PATT\C6587761

CENTERFIRE PATTERNS # 2

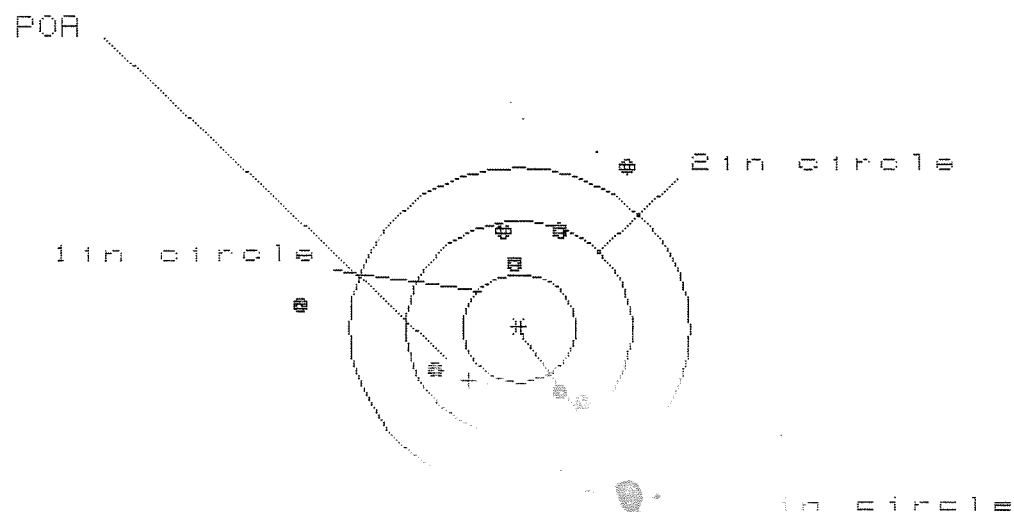


PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.202	1.073	1.123
MINIMUM X	:	-1.166	-1.161	-1.027
MAXIMUM Y	:	1.051	1.119	1.086
MINIMUM Y	:	-0.763	-0.695	-0.728
CENTROID X	:	.308	.437	.303
CENTROID Y	:	.602	.534	.567
POA TO CENTROID in.	:	.676	.690	.643
MIN RADIUS	:	.164	.274	.199
MEAN RADIUS	:	.918	.864	.826
MAX RADIUS	:	1.319	1.183	1.183
HORIZONTAL SPREAD	:	2.368	2.234	2.150
VERTICAL SPREAD	:	1.814	1.814	1.814
EXTREME SPREAD	:	2.552	2.241	2.241
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

22 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587761

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 2.895

VS= 2.799

GS= 3.159

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.984	.772	.468
MINIMUM X	:	-1.911	-1.003	-.907
MAXIMUM Y	:	1.481	1.505	1.154
MINIMUM Y	:	-1.318	-1.294	-1.106
CENTROID X	:	.444	.656	.560
CENTROID Y	:	.488	.464	.276
POA TO CENTROID in.	:	.660	.804	.624
MIN RADIUS	:	.594	.587	.467
MEAN RADIUS	:	1.128	1.023	.916
MAX RADIUS	:	1.923	1.691	1.175
HORIZONTAL SPREAD	:	2.895	1.775	1.375
VERTICAL SPREAD	:	2.799	2.799	2.268
EXTREME SPREAD	:	3.159	2.941	2.268
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

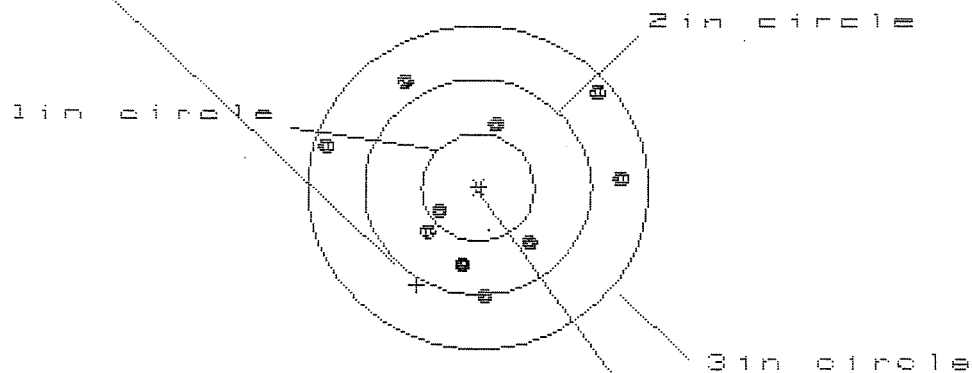
22 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8587761

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.576

VS= 2.042

GS= 2.585

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.:

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

.221

-.689

1.151

-.891

.574

.760

.952

.327

.777

1.341

1.910

2.042

2.164

1

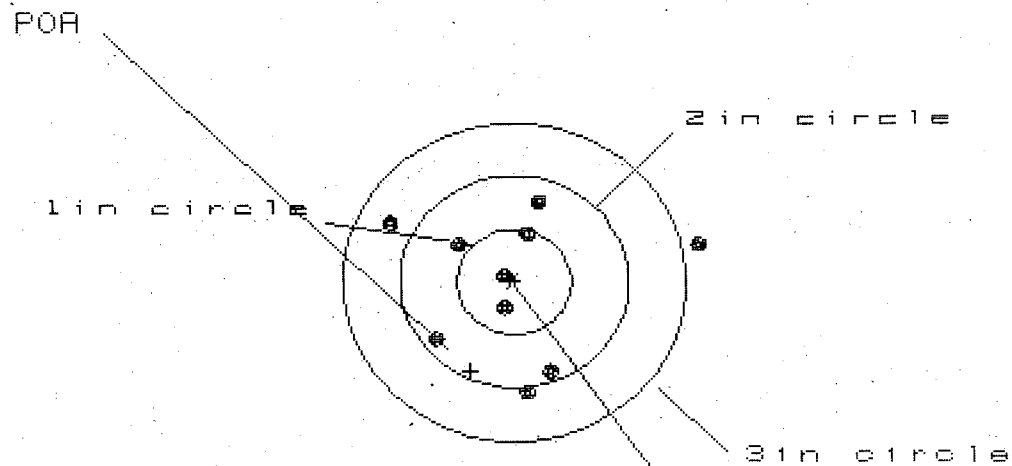
5

10

22 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587761

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.686

VS= 1.816

GS= 2.694

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X	1.079	.379
MINIMUM X	-1.079	-.595
MAXIMUM Y	.773	.810
MINIMUM Y	-1.043	-1.006
CENTROID X	.386	.209
CENTROID Y	.042	.005
POA TO CENTROID in.	.926	.831
MIN RADIUS	.108	.178
MEAN RADIUS	.780	.674
MAX RADIUS	1.626	1.086
HORIZONTAL SPREAD	2.686	1.412
VERTICAL SPREAD	1.816	1.816
EXTREME SPREAD	2.694	2.013
NUMBER IN ONE INCH CIRCLE	=	3
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587661

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

op. #	OP. NAME	READINGS					DATE	INITIALS
625 cont.	F) Safety On Force	9	9	9			5/4/96	9
	G) Safety Off Force	4	4	4			5/4/96	9
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.0235	.022			5/4/96	9
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.48	2.47	2.68	2.68	2.68	5/4/96	9
	C) Function							
660	Pack							

Remington®

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

enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6587661

ORDER NO.
5716

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

20



5716 C6587661

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587661

OP. #	OP. NAME	READINGS	DATE	IN
575 & 580	Assemble Action and Stock	1019	90	/
600	Proof	1019	90	/
607	Check Headspace	1019	90	/
610	Dis-assemble Gun	1019	90	/
612	Magnaflux Barrel Action		10/23/90	K
	Magnaflux Bolt		10/23/90	K
615	Rollmark Caliber		10/23/90	Z
617	Drill and Tap Sight Holes		10/26/90	F
618	Polish Barrel RB		10/28/90	C
620	Apply Coatings (Barrel Action)		11-7-90	A
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	A
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	A
	C) Inspect Ejector Hole for Chamfer		11/12/90	A
	D) Oil Firing Pin Ass'y		11/12/90	A
	E) Adjust Trigger Pull to Min Setting and Stake		11/26/90	9

op. #	OP. NAME	READINGS					DATE	INI
625 cont.	F) Safety On Force	3.50	3.25	3.50			11/29/90	K
	G) Safety Off Force	2.50	2.50	2.50			11/29/90	K
	H) Trigger Pull Test & Retainability						11/24/90	D
	I) Firing Pin Indent	.021	.021	.021			11/29/90	K
	J) Assemble Stock						12/6/90	K
	K) Assemble Swivel Studs						12-7-90	Q
	L) Attach Front and Rear Sight Assemblies						12/6/90	K
	M) Iron Sight Alignment						12/6/90	K
	N) Detach Front & Rear Sights & place in numbered container						12/6/90	K
	O) Attach Scope to Rifle						12/6/90	K
	P) Detach & Attach Scope 20 Times						12/6/90	K
640	Gallery Target & Test						12-6-90	A
	A) Time						12-6-90	A
	B) Malfunctions						12-6-90	A
	C) Pierced Primers						12-6-90	A
	D) Optical Clarity of Scope						12-6-90	A
645	Inspect for Live Ammo						12-6-90	A
655	Final Inspection							
	A) Headspace						12-7-90	Q
	B) Trigger Pull	208	228	252	246	205	12-7-90	Q
	C) Function						12-7-90	Q
660	Pack						12-7-90	Q

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 26587661

DATE 11/27/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.41	2.25	208	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.41	2.22	228	
PULL #3	2.36	2.30	2.12	252	
PULL #4	2.47	2.21	2.15	246	
PULL #5	2.45	2.16	2.20	203	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.27		
PULL #2	3.24	3.18		
PULL #3	3.25	3.21		
PULL #4	3.24	3.30		
PULL #5	3.25	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.45		4.25
PULL #2	4.16	4.26		4.18
PULL #3	4.29	4.44		4.17
PULL #4	4.15	4.47		4.21
PULL #5	4.39	4.26		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587661
6 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.241812
1 TO	2	.070214
1 TO	3	.0640078
1 TO	4	.666108
1 TO	5	.2228

4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0457121
THE AMR FOR THIS RIFLE IS: 1.007

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587661

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 2.310

VS= 3.394

GS= 3.631

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.035	.998	1.062
MINIMUM X	:	-1.275	-1.160	-1.096
MAXIMUM Y	:	1.605	1.409	1.208
MINIMUM Y	:	-1.789	-1.611	-1.487
CENTROID X	:	.048	-.067	-.131
CENTROID Y	:	.237	.059	.260
POA TO CENTROID in.	:	.242	.089	.291
MIN RADIUS	:	.296	.185	.380
MEAN RADIUS	:	1.154	1.078	.974
MAX RADIUS	:	1.910	1.692	1.640
HORIZONTAL SPREAD	:	2.310	2.158	2.158
VERTICAL SPREAD	:	3.394	3.020	2.695
EXTREME SPREAD	:	3.631	3.099	2.918
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587661

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.375

VS= 2.719

GS= 2.762

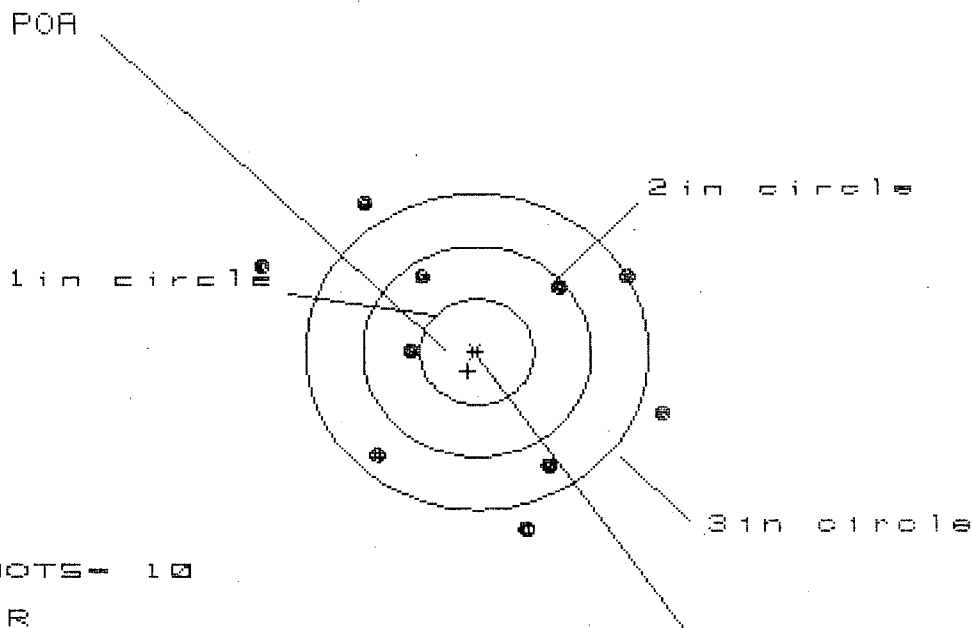
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.733
MINIMUM X	-.642
MAXIMUM Y	1.002
MINIMUM Y	-1.717
CENTROID X	.017
CENTROID Y	.174
POA TO CENTROID in.	.175
MIN RADIUS	.260
MEAN RADIUS	.745
MAX RADIUS	1.718
HORIZONTAL SPREAD	1.375
VERTICAL SPREAD	2.719
EXTREME SPREAD	2.762
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587661

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.500

VS= 3.101

GS= 3.752

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.618	1.489	1.441
MINIMUM X	:	-1.882	-1.185	-1.153
MAXIMUM Y	:	1.429	1.519	1.322
MINIMUM Y	:	-1.672	-1.582	-1.152
CENTROID X	:	.079	.288	.256
CENTROID Y	:	.181	.091	.288
POA TO CENTROID in.	:	.197	.302	.386
MIN RADIUS	:	.531	.744	.719
MEAN RADIUS	:	1.355	1.272	1.212
MAX RADIUS	:	2.050	1.927	1.754
HORIZONTAL SPREAD	:	3.500	2.594	2.594
VERTICAL SPREAD	:	3.101	3.101	2.474
EXTREME SPREAD	:	3.752	3.419	3.257
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587661

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.790

VS= 1.889

GS= 2.301

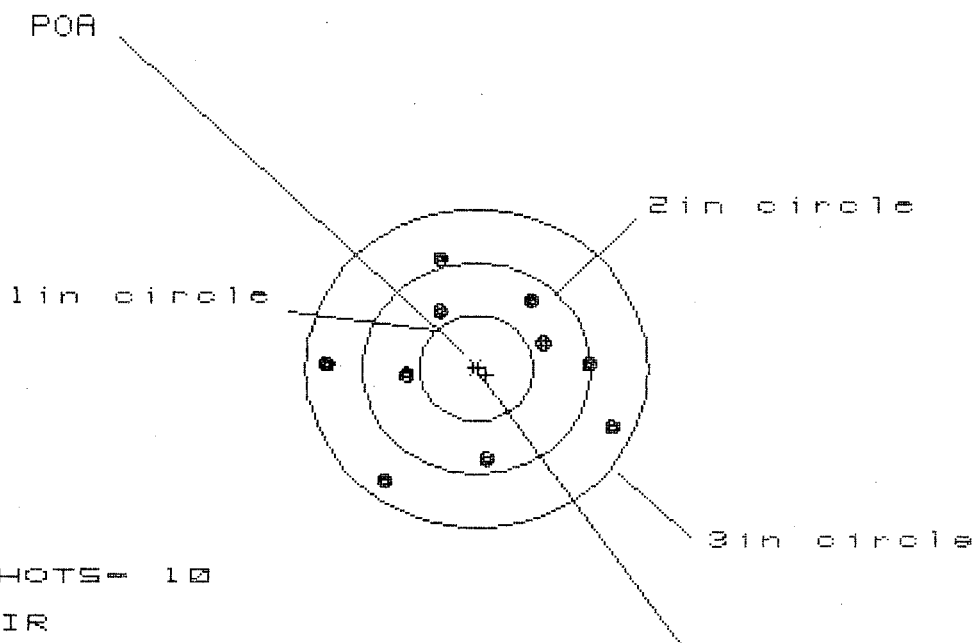
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.062	1.178	1.239
MINIMUM X	:	-.728	-.612	-.551
MAXIMUM Y	:	1.040	.963	.942
MINIMUM Y	:	-.849	-.926	-.806
CENTROID X	:	-.042	-.158	-.219
CENTROID Y	:	-.423	-.346	-.466
POA TO CENTROID in.	:	.425	.380	.515
MIN RADIUS	:	.183	.219	.193
MEAN RADIUS	:	.837	.774	.729
MAX RADIUS	:	1.254	1.180	1.240
HORIZONTAL SPREAD	:	1.790	1.790	1.790
VERTICAL SPREAD	:	1.889	1.889	1.748
EXTREME SPREAD	:	2.301	2.118	1.902
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587661

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.455

VS = 2.118

GS = 2.527

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.162	1.071	1.032
MINIMUM X	:	-1.293	-1.384	-1.250
MAXIMUM Y	:	1.058	.941	.854
MINIMUM Y	:	-1.060	-.946	-1.033
CENTROID X	:	-.086	.005	-.129
CENTROID Y	:	.059	.176	.263
POA TO CENTROID in.	:	.104	.177	.293
MIN RADIUS	:	.585	.489	.399
MEAN RADIUS	:	.946	.882	.818
MAX RADIUS	:	1.339	1.387	1.263
HORIZONTAL SPREAD	:	2.455	2.455	2.282
VERTICAL SPREAD	:	2.118	1.887	1.887
EXTREME SPREAD	:	2.527	2.527	2.282
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		