

C6587677

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6587677
DATE 6-4-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.35	2.57	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.47	2.56	
PULL #3	2.39	2.52	2.59	
PULL #4	2.50	2.45	2.62	
PULL #5	2.48	2.48	2.57	
TOTAL	12.13	12.43	12.65	
AVG.	2.42	2.48	2.53	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.14	3.00	
PULL #2	3.23	2.98	
PULL #3	3.15	2.97	
PULL #4	3.14	3.04	
PULL #5	3.13	3.03	
TOTAL	15.79	15.02	
AVG.	3.15	3.00	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.02		4.16
PULL #2	4.01	4.02		4.15
PULL #3	3.96	4.04		4.13
PULL #4	3.99	4.00		4.18
PULL #5	4.00	4.03		4.15
TOTAL	20.00	20.11		20.77
AVG.	4.00	4.02		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 26587677
17 Apr 1988

CENTROIDAL DISTANCES

0 TO	1	.2278
1 TO	2	.166436
1 TO	3	.0946414
1 TO	4	.313806
1 TO	5	.0694262

-----> FOR

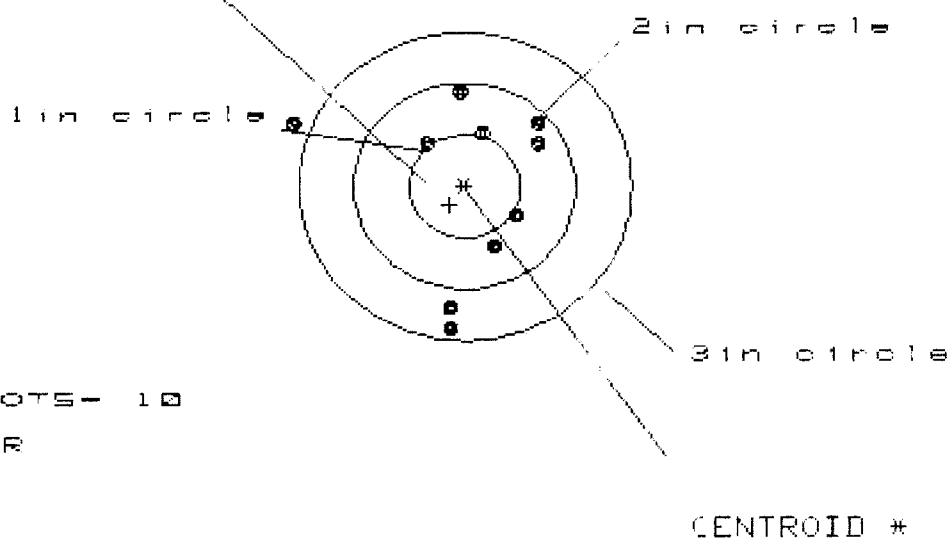
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .188
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2602
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .321011
THE AMR FOR THIS RIFLE IS: .9922

1 Apr 1968

FILE:/PATTERNING/CENTERFIRE_PATT/CS587677

CENTERFIRE PATTERNS # 1

PCA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 2.210

VS= 2.352

GS= 2.474

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.676	.505	.469
MINIMUM X	-1.534	-.501	-.537
MAXIMUM Y	.926	.993	.823
MINIMUM Y	-1.426	-1.359	-1.326
CENTROID X	.137	.308	.344
CENTROID Y	.182	.115	.285
POA TO CENTROID in.	.228	.328	.446
MIN RADIUS	.520	.373	.450
MEAN RADIUS	.910	.804	.700
MAX RADIUS	1.649	1.389	1.361
HORIZONTAL SPREAD	2.210	1.006	1.006
VERTICAL SPREAD	2.352	2.352	2.149
EXTREME SPREAD	2.474	2.354	2.150
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

Apr 900

FILE: PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.639

VS = 2.295

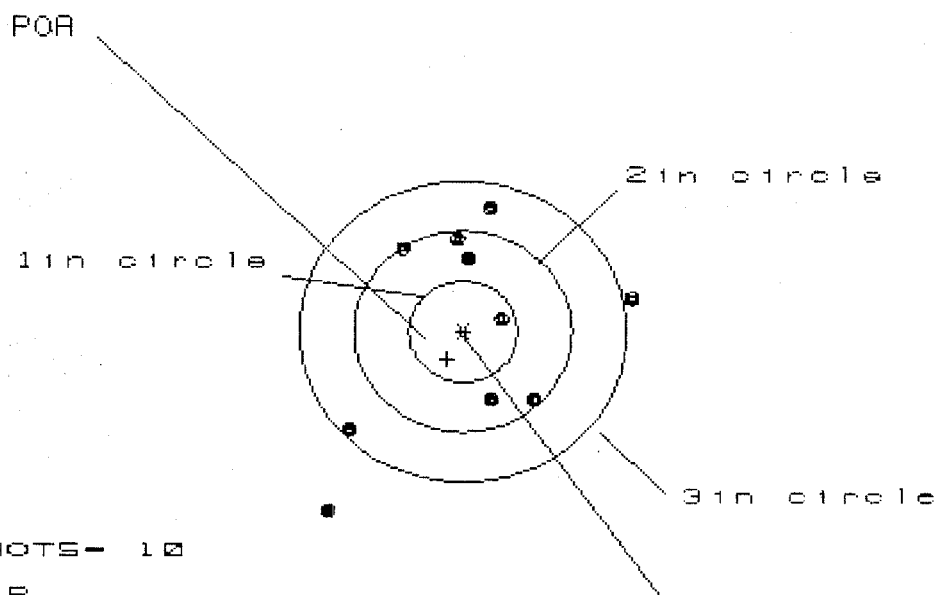
GS = 2.677

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.823	.748
MINIMUM X	:	-.725	-.623	-.698
MAXIMUM Y	:	1.048	.768	.647
MINIMUM Y	:	-1.247	-1.130	-1.251
CENTROID X	:	.288	.186	.261
CENTROID Y	:	.252	.135	.256
POA TO CENTROID in.	:	.382	.230	.366
MIN RADIUS	:	.264	.341	.247
MEAN RADIUS	:	.792	.736	.654
MAX RADIUS	:	1.391	1.140	1.264
HORIZONTAL SPREAD	:	1.639	1.446	1.446
VERTICAL SPREAD	:	2.295	1.898	1.898
EXTREME SPREAD	:	2.677	1.968	1.968
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 3



* OF SHOTS - 10

* IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.8009

VS = 3.042

GS = 3.519

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.520	1.376	.669
MINIMUM X	:	-1.289	-1.239	-1.067
MAXIMUM Y	:	1.240	1.040	1.054
MINIMUM Y	:	-1.802	-1.157	-1.143
CENTROID X	:	.148	.292	.120
CENTROID Y	:	.276	.476	.462
POA TO CENTROID in.	:	.313	.558	.477
MIN RADIUS	:	.386	.243	.405
MEAN RADIUS	:	1.118	.944	.897
MAX RADIUS	:	2.216	1.695	1.563
HORIZONTAL SPREAD	:	2.809	2.615	1.736
VERTICAL SPREAD	:	3.042	2.197	2.197
EXTREME SPREAD	:	3.519	2.909	2.568
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

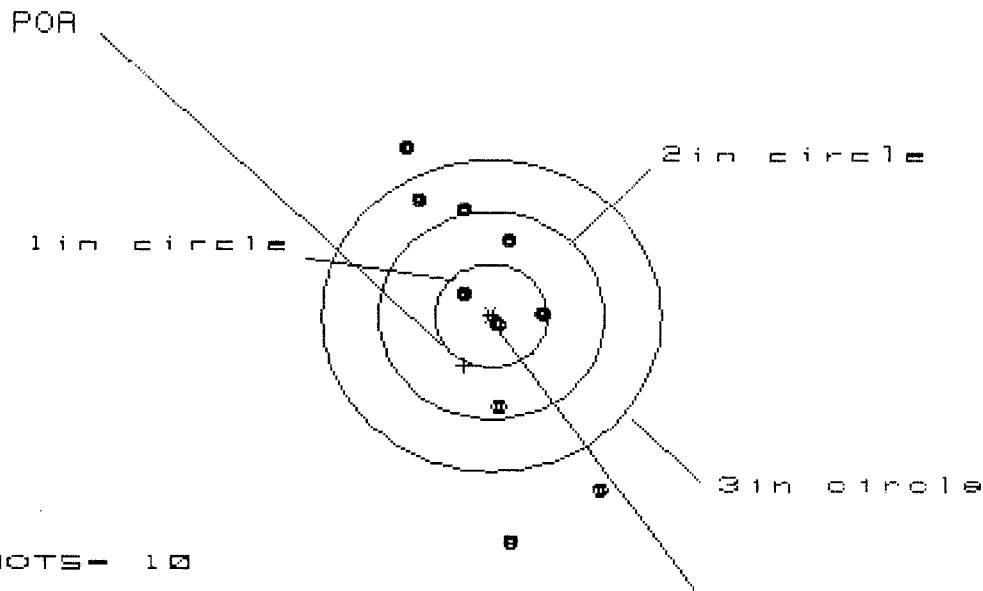
17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

BARBER - M24 0025069

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 1.688

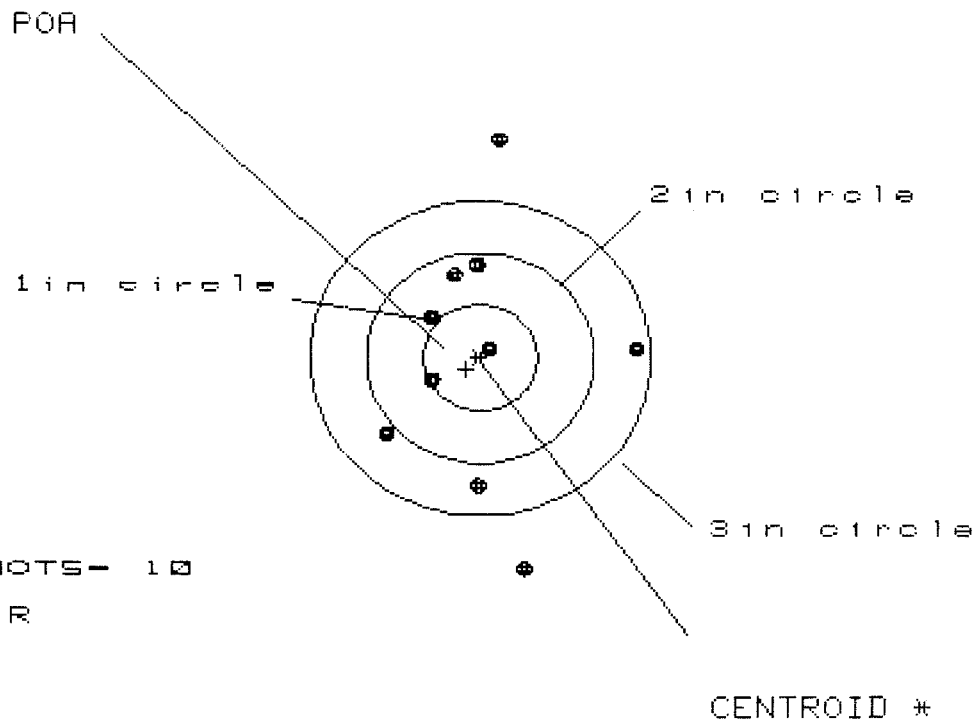
VS= 3.750

GS= 3.866

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.975	.599
MINIMUM X	:	-.736	-.713	-.591
MAXIMUM Y	:	1.582	1.341	1.105
MINIMUM Y	:	-2.168	-1.890	-1.314
CENTROID X	:	.244	.221	.099
CENTROID Y	:	.477	.718	.954
POA TO CENTROID in.	:	.536	.751	.959
MIN RADIUS	:	.118	.177	.264
MEAN RADIUS	:	1.061	.904	.738
MAX RADIUS	:	2.178	2.127	1.324
HORIZONTAL SPREAD	:	1.688	1.688	1.190
VERTICAL SPREAD	:	3.750	3.231	2.419
EXTREME SPREAD	:	3.866	3.645	2.534
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.242

VS= 4.055

GS= 4.060

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.409	1.427	1.475
MINIMUM X	:	-.833	-.815	-.767
MAXIMUM Y	:	2.046	1.161	.938
MINIMUM Y	:	-2.009	-1.781	-1.258
CENTROID X	:	.123	.105	.057
CENTROID Y	:	.114	-.114	.109
POA TO CENTROID in.	:	.167	.154	.123
MIN RADIUS	:	.113	.317	.171
MEAN RADIUS	:	1.080	.993	.833
MAX RADIUS	:	2.053	1.822	1.476
HORIZONTAL SPREAD	:	2.242	2.242	2.242
VERTICAL SPREAD	:	4.055	2.942	2.196
EXTREME SPREAD	:	4.060	2.969	2.379
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587677

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. #	BARBER - M24 0025072		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5/4	5/4	5			6/24/96	WSB
	G) Safety Off Force		3	3	3			6/24/96	WSB
	H) Trigger Pull Test & Retainability								
	I) Firing Pin Indent								
	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		2.63	2.68	2.73	2.75	2.77	6/24/96	WSB
	C) Function								
660	Pack								

Remington
MODEL 700™ M24

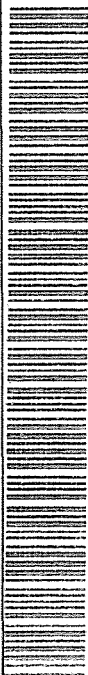
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

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

SERIAL NO. C6587677

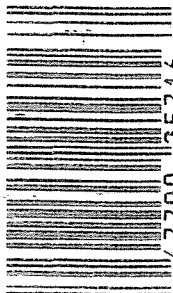
ORDER NO. 5716

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



5716 C6587677

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587677

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 5800)	Assemble Action and Stock	10 9	90	RW
B) 600	Proof	10 9	90	RW
V) 607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes		10/18/90	LB
618	Polish Barrel		10/19/90	WB
620	Apply Coatings (Barrel Action)		11-5-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/13/90	RW

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4	11/13/90	WB
	G) Safety Off Force	3	3	3	11/13/90	WB
	H) Trigger Pull Test & Retainability				11-13-90	JH
	I) Firing Pin Indent	0205	0215	021	11/13/90	WB
	J) Assemble Stock				11/13/90	RW
	K) Assemble Swivel Studs				11/13/90	J28
	L) Attach Front and Rear Sight Assemblies				11/13/90	RW
	M) Iron Sight Alignment				11/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container				11/13/90	RW
	O) Attach Scope to Rifle				11/13/90	RW
	P) Detach & Attach Scope 20 Times				11/13/90	RW
640	Gallery Target & Test				11-14-90	AC
	A) Time				11-14-90	AC
	B) Malfunctions				11-14-90	AC
	C) Pierced Primers				11-14-90	AC
	D) Optical Clarity of Scope				11-14-90	AC
645	Inspect for Live Ammo				11-14-90	AC
655	Final Inspection					
	A) Headspace				11/19/90	J28
	B) Trigger Pull	23	23	219 214	11/19/90	J28
	C) Function				11/19/90	J28
660	Pack				12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587677DATE 11-13-90TESTER gpl

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.23	2.28	2.31	MIN. SETTING,
PULL #2	2.48	2.31	2.44	2.33	NO AVG. OF 5
PULL #3	2.49	2.16	2.38	2.26	READINGS ACCEPT-
PULL #4	2.26	2.20	2.28	2.19	ABLE LESS THAN 2#
PULL #5	2.38	2.26	2.31	2.14	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.26		
PULL #2	3.15	3.21		
PULL #3	3.09	3.18		
PULL #4	3.26	3.27		
PULL #5	3.32	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.28		4.28
PULL #2	4.44	4.41		4.36
PULL #3	4.33	4.31		4.42
PULL #4	4.32	4.44		4.29
PULL #5	4.28	4.38		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 POI RIFLE # 06587677
 11 NOV 1990

CENTROIDAL DISTANCES

0 TO	1	.190263
1 TO	2	.415087
1 TO	3	.337343
1 TO	4	.0782304
1 TO	5	.244845

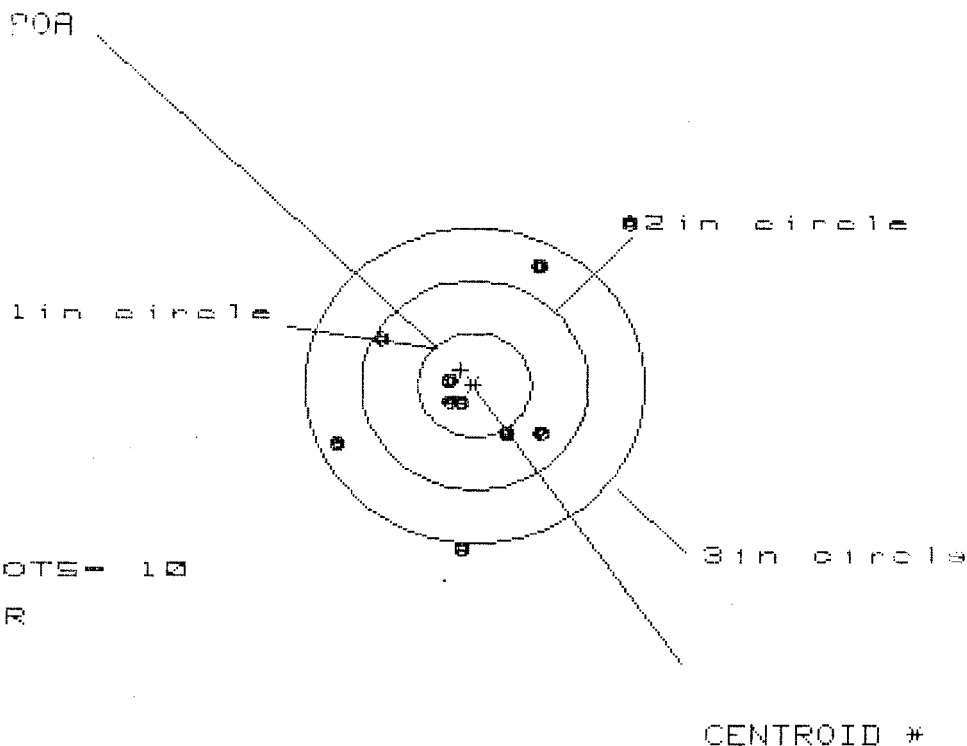
POI <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.02
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1536
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .154897
 THE AMR FOR THIS RIFLE IS: 1.049

4 Nov 1980

FILE:/PATTERNING/CENTERFIRE_PATT/08587677

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.589

VS= 3.099

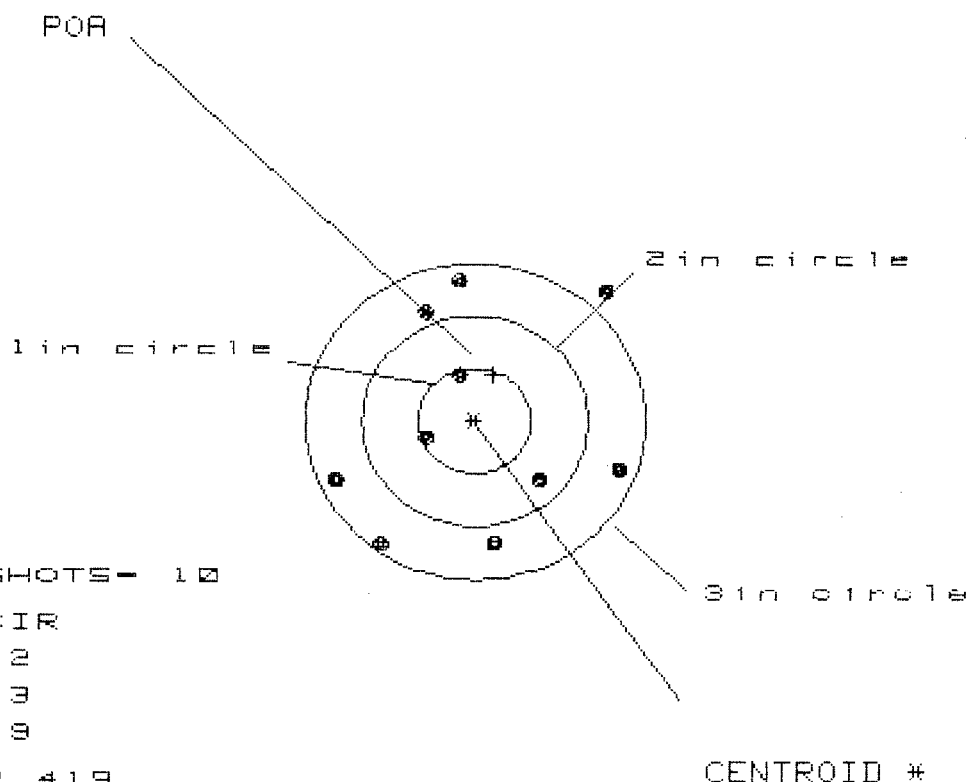
GS= 3.430

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.358	.716	.721
MINIMUM X	-1.231	-1.080	-1.075
MAXIMUM Y	1.558	1.295	1.124
MINIMUM Y	-1.541	-1.368	-.557
CENTROID X	.122	-.029	-.034
CENTROID Y	-.146	-.319	-.148
POA TO CENTROID in.	.190	.320	.152
MIN RADIUS	.184	.053	.069
MEAN RADIUS	.897	.722	.636
MAX RADIUS	2.067	1.480	1.335
HORIZONTAL SPREAD	2.589	1.796	1.796
VERTICAL SPREAD	3.099	2.663	1.681
EXTREME SPREAD	3.430	2.748	2.460
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

14 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 2

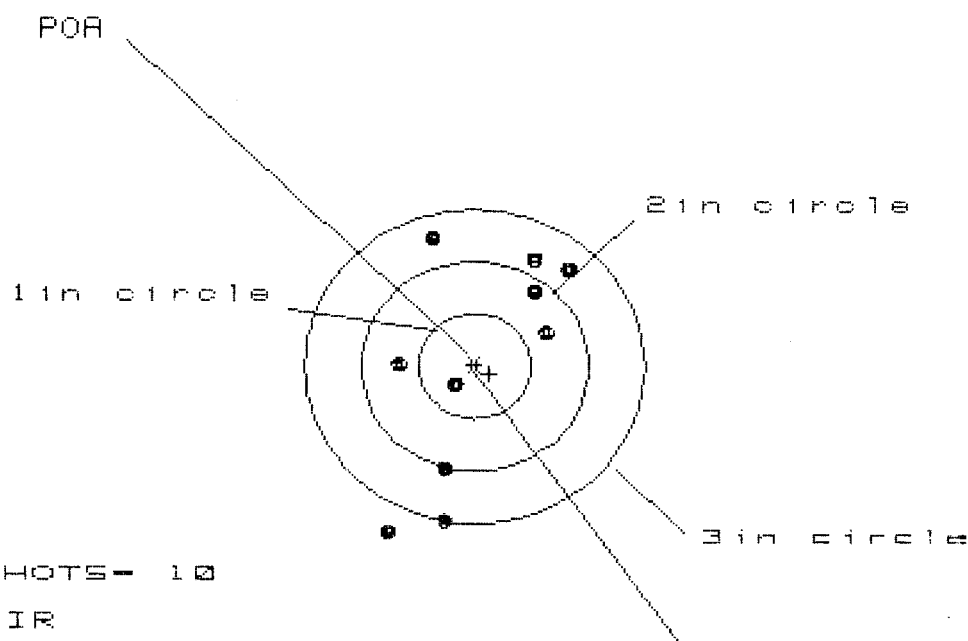


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	1.362	1.274
MINIMUM X	:	-1.186	-1.057	-1.145
MAXIMUM Y	:	1.298	1.433	1.300
MINIMUM Y	:	-1.201	-1.066	-1.171
CENTROID X	:	-.169	-.298	-.210
CENTROID Y	:	-.442	-.577	-.444
POA TO CENTROID in.	:	.473	.650	.491
MIN RADIUS	:	.459	.306	.419
MEAN RADIUS	:	1.116	1.034	.999
MAX RADIUS	:	1.684	1.433	1.360
HORIZONTAL SPREAD	:	2.419	2.419	2.419
VERTICAL SPREAD	:	2.499	2.499	2.471
EXTREME SPREAD	:	3.132	2.591	2.495
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.666

VS= 2.828

GS= 3.044

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.779	.731
MINIMUM X	-.798	-.741	-.789
MAXIMUM Y	1.217	1.038	.833
MINIMUM Y	-1.611	-1.640	-1.355
CENTROID X	-.132	-.043	.005
CENTROID Y	.076	.255	.460
POA TO CENTROID in.	.152	.259	.460
MIN RADIUS	.245	.432	.483
MEAN RADIUS	1.052	.948	.823
MAX RADIUS	1.798	1.685	1.427
HORIZONTAL SPREAD	1.666	1.520	1.520
VERTICAL SPREAD	2.828	2.678	2.188
EXTREME SPREAD	3.044	2.679	2.242
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 9

HS= 2.514

VS= 2.668

GS= 2.787

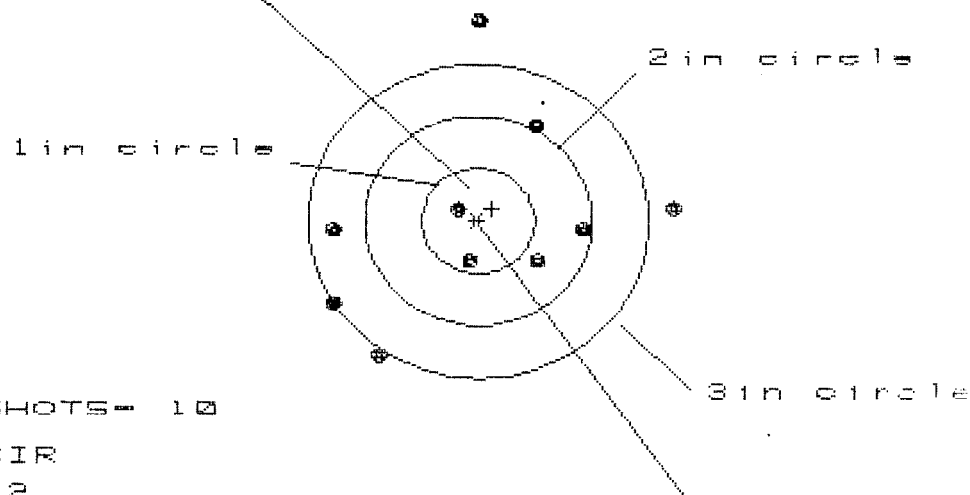
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.533
MINIMUM X	-.981
MAXIMUM Y	1.298
MINIMUM Y	-1.370
CENTROID X	.200
CENTROID Y	-.140
POA TO CENTROID in.	.244
MIN RADIUS	.195
MEAN RADIUS	1.061
MAX RADIUS	1.758
HORIZONTAL SPREAD	2.514
VERTICAL SPREAD	2.668
EXTREME SPREAD	2.787
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	9

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587677

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS = 3.000

VS = 3.181

GS = 3.290

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.716	1.713	1.111
MINIMUM X	:	-1.284	-1.287	-1.073
MAXIMUM Y	:	1.882	1.169	1.204
MINIMUM Y	:	-1.299	-1.089	-1.054
CENTROID X	:	-.121	-.118	-.332
CENTROID Y	:	-.116	-.326	-.361
POA TO CENTROID in.	:	.168	.346	.491
MIN RADIUS	:	.215	.190	.216
MEAN RADIUS	:	1.121	1.015	.924
MAX RADIUS	:	1.883	1.737	1.424
HORIZONTAL SPREAD	:	3.000	3.000	2.183
VERTICAL SPREAD	:	3.181	2.258	2.258
EXTREME SPREAD	:	3.290	3.120	2.664
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	