

C6523368

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523368
1 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.487231
1 TO 2	.445785
1 TO 3	.644845
1 TO 4	.396879
1 TO 5	.43115

$\frac{1}{5}$ <----POA

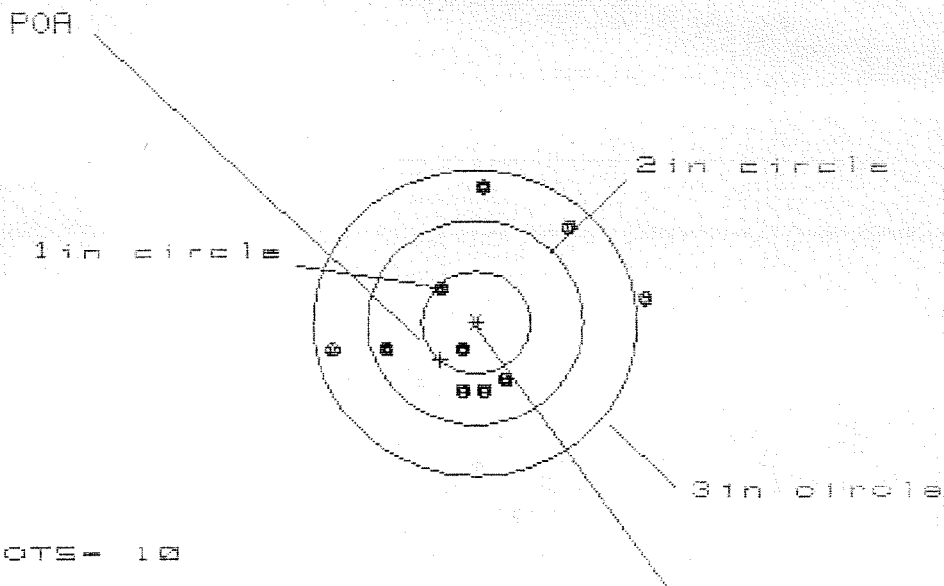
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .153
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0782
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .171826

THE AMR FOR THIS RIFLE IS: .8886

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523368

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.893

VS= 2.028

GS= 2.937

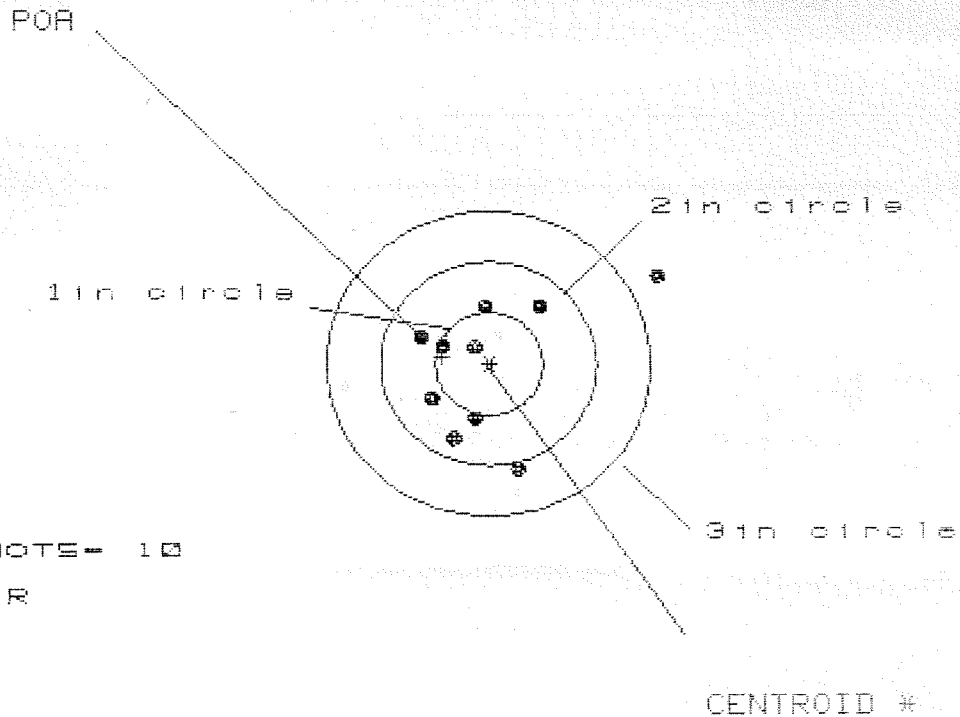
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.533	1.048	.899
MINIMUM X	-1.360	-1.190	-.779
MAXIMUM Y	1.337	1.359	1.324
MINIMUM Y	-.692	-.669	-.704
CENTROID X	.325	.155	.304
CENTROID Y	.363	.341	.376
POA TO CENTROID in.	.488	.374	.483
MIN RADIUS	.312	.245	.313
MEAN RADIUS	.910	.810	.769
MAX RADIUS	1.546	1.394	1.328
HORIZONTAL SPREAD	2.893	2.238	1.678
VERTICAL SPREAD	2.028	2.028	2.028
EXTREME SPREAD	2.937	2.540	2.043
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523368

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 9

HS = 2.200

VS = 1.870

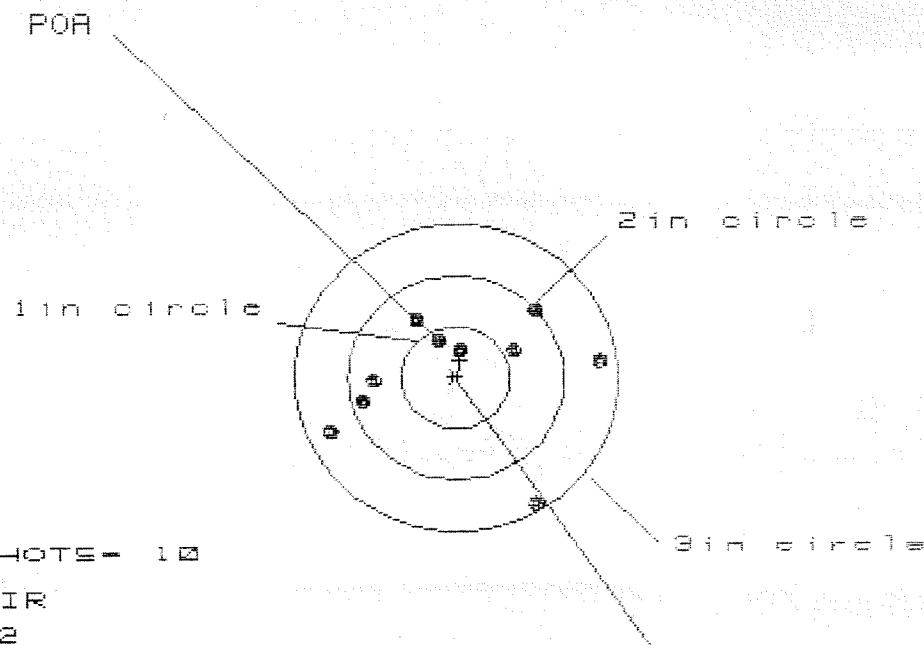
GS = 2.492

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.531	.606	.666
MINIMUM X	-.677	-.507	-.447
MAXIMUM Y	.868	.699	.586
MINIMUM Y	-1.002	-.906	-.762
CENTROID X	.435	.265	.205
CENTROID Y	-.069	-.165	-.052
POA TO CENTROID in.	.440	.312	.212
MIN RADIUS	.225	.295	.211
MEAN RADIUS	.757	.610	.536
MAX RADIUS	1.760	1.023	.887
HORIZONTAL SPREAD	2.200	1.113	1.113
VERTICAL SPREAD	1.870	1.605	1.348
EXTREME SPREAD	2.492	1.610	1.570
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

1 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523368

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.455

VS= 1.886

GS= 2.566

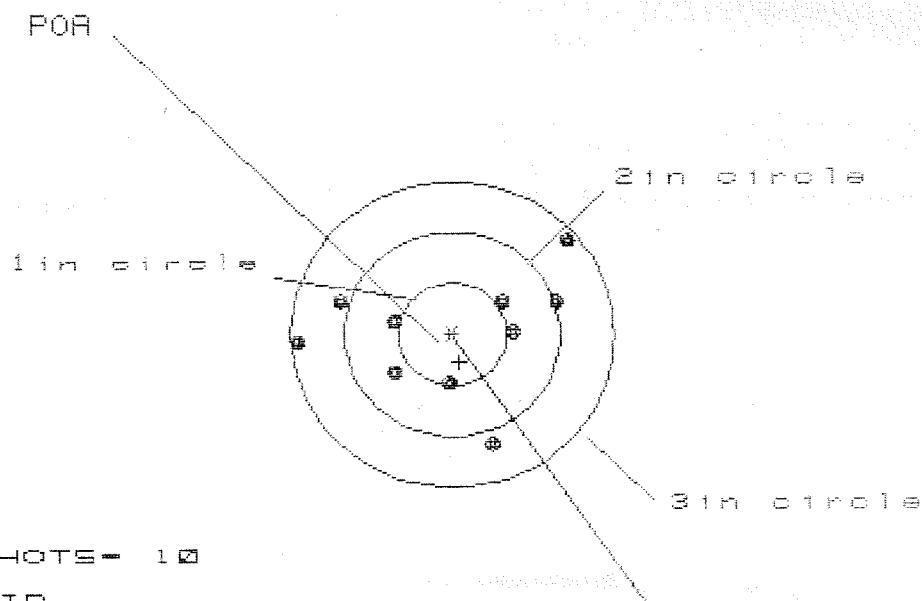
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	1.374	1.239
MINIMUM X	-1.168	-1.081	-.946
MAXIMUM Y	.637	.498	.408
MINIMUM Y	-1.249	-.716	-.493
CENTROID X	-.035	-.122	.013
CENTROID Y	-.172	-.033	.057
POA TO CENTROID in.	.175	.126	.058
MIN RADIUS	.236	.153	.010
MEAN RADIUS	.855	.742	.646
MAX RADIUS	1.474	1.374	1.240
HORIZONTAL SPREAD	2.455	2.455	2.185
VERTICAL SPREAD	1.886	1.214	.901
EXTREME SPREAD	2.566	2.566	2.227
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523368

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 10

HS= 2.491

VS= 1.993

GS= 2.663

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.103	1.120	.962
MINIMUM X	-1.388	-1.265	-1.066
MAXIMUM Y	.886	.451	.456
MINIMUM Y	-1.107	-1.008	-1.003
CENTROID X	-.062	-.185	-.026
CENTROID Y	.275	.176	.171
POA TO CENTROID in.	.282	.255	.173
MIN RADIUS	.446	.357	.348
MEAN RADIUS	.888	.815	.751
MAX RADIUS	1.415	1.266	1.134
HORIZONTAL SPREAD	2.491	2.385	2.027
VERTICAL SPREAD	1.993	1.459	1.459
EXTREME SPREAD	2.663	2.419	2.028
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

1 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523368

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.593

VS= 2.736

GS= 3.770

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.078	1.102	.928
MINIMUM X	-1.515	-1.395	-.873
MAXIMUM Y	1.615	1.461	1.343
MINIMUM Y	-1.121	-.942	-.808
CENTROID X	.102	-.018	.156
CENTROID Y	-.006	-.185	-.067
POA TO CENTROID in.	.102	.186	.170
MIN RADIUS	.364	.318	.285
MEAN RADIUS	1.033	.902	.798
MAX RADIUS	1.941	1.683	1.345
HORIZONTAL SPREAD	2.593	2.497	1.801
VERTICAL SPREAD	2.736	2.403	2.151
EXTREME SPREAD	3.770	2.832	2.157
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523368DATE 10/30/90TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.34	2.25	200	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.20	2.20	205	
PULL #3	2.16	2.25	2.15	201	
PULL #4	2.27	2.11	2.35	204	
PULL #5	2.21	2.28	2.30	201	
TOTAL	11.15	11.18	11.25		
AVG.	2.23	2.236	2.25		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.39		
PULL #2	3.29	3.41		
PULL #3	3.36	3.37		
PULL #4	3.39	3.39		
PULL #5	3.36	3.40		
TOTAL	16.71	16.96		
AVG.	3.342	3.392		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.50		4.40
PULL #2	4.48	4.47		4.44
PULL #3	4.39	4.44		4.44
PULL #4	4.43	4.42		4.29
PULL #5	4.10	4.42		4.42
TOTAL	21.87	22.25		21.99
AVG.	4.374	4.45		4.398

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523368

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	SS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/90	JL

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4		10/30/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4		10/30/90	WB
	H) Trigger Pull Test & Retainability					10/30/90	JS
	I) Firing Pin Indent	.023	.0225	.023		10/30/90	WB
	J) Assemble Stock					10/30/90	RW
	K) Assemble Swivel Studs					11/19/90	JS
	L) Attach Front and Rear Sight Assemblies					10/30/90	RW
	M) Iron Sight Alignment					10/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container					10/30/90	RW
	O) Attach Scope to Rifle					10/30/90	RW
	P) Detach & Attach Scope 20 Times					10/30/90	RW
640	Gallery Target & Test					10-31-90	DA
	A) Time					10-31-90	DA
	B) Malfunctions					10-31-90	DA
	C) Pierced Primers					10-31-90	DA
	D) Optical Clarity of Scope					10-31-90	DA
645	Inspect for Live Ammo					10-31-90	DA
655	Final Inspection						
	A) Headspace					11/19/90	JS
	B) Trigger Pull	200	205	201	204	201	11/19/90
	C) Function					11/19/90	JS
660	Pack					12/18/90	VF

Remington
MODEL 700™ H24

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

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

SERIAL NO.
06523368

ORDER NO.
5716

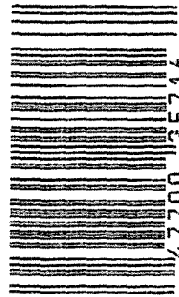
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 06523368

LPC



0 47700 25716 7

BARBER - M24 ~~0026896~~ **M2400026845**

SWS TRIGGER PULL TEST

New Trigger Assy

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523368DATE 2/12/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.53	2.42		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.43	2.20		
PULL #3	2.48	2.31	2.39		
PULL #4	2.43	2.38	2.35		
PULL #5	2.46	2.36	2.37		
TOTAL	12.41	12.01	11.73		
AVG.	2.48	2.40	2.35		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.14		
PULL #2	3.20	3.14		
PULL #3	3.10	3.13		
PULL #4	3.14	3.18		
PULL #5	3.17	3.11		
TOTAL	15.83	15.70		
AVG.	3.17	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.23		4.02
PULL #2	4.03	4.08		4.05
PULL #3	4.09	4.12		4.15
PULL #4	4.05	4.00		4.08
PULL #5	4.04	4.07		4.17
TOTAL	20.25	20.50		20.47
AVG.	4.05	4.10		4.09

GFM

CONTRACT # DAAA21-87-C-0086

*Repair*GUN SERIAL # *C6523368*

OP. #	OP. NAME	READINGS	DATE	INIT
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		<i>2/12/93</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>2/12/93</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>2/12/93</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>2/12/93</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>2/12/93</i>	<i>RW</i>

op. #	BARBER - M24 0026809 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/12/93	RW
	G) Safety Off Force	2.5	2.5	2.5			2/12/93	RW
	H) Trigger Pull Test & Retainability						2/12/93	RW
	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						2/12/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection							
	A) Headspace						3/3/93	RW
	B) Trigger Pull	2.66	2.59	2.55	2.58	2.56	3/3/93	RW
	C) Function						3/3/93	RW
660	Pack							

