

C6523382

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

SERIAL NO. C6523382DATE 4-11-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.40	2.33		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.40	2.32		
PULL #3	2.52	2.38	2.52		
PULL #4	2.53	2.21	2.57		
PULL #5	2.48	2.31	2.55		
TOTAL	12.63	11.70	12.29		
AVG.	2.52	2.34	2.45		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	2.96		
PULL #2	3.03	2.91		
PULL #3	2.92	2.71		
PULL #4	2.93	2.89		
PULL #5	2.87	2.74		
TOTAL	14.95	14.21		
AVG.	2.99	2.84		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.27		4.13
PULL #2	4.30	4.34		4.06
PULL #3	4.13	4.15		4.00
PULL #4	4.09	4.04		4.00
PULL #5	4.12	4.11		4.02
TOTAL	20.89	20.91		20.21
AVG.	4.17	4.18		4.04

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523382
11 Mar 1900

CENTROIDAL DISTANCES

0	TO	1	.541867
1	TO	2	.341855
1	TO	3	.475085
1	TO	4	.367838
1	TO	5	.468364

3
2
4 1 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2684

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2766

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .385417

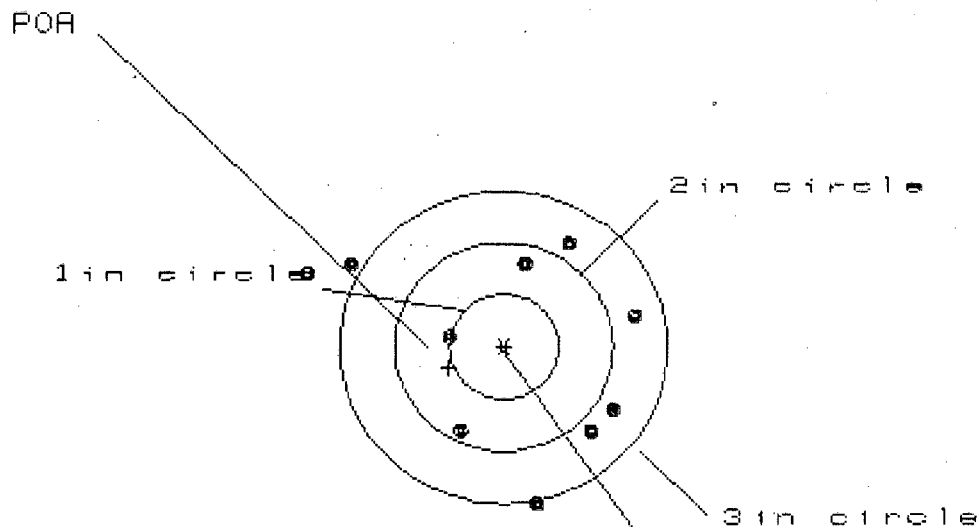
THE AMR FOR THIS RIFLE IS: .9968

11 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6523382

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.982

VS= 2.480

GS= 3.096

CENTROID *

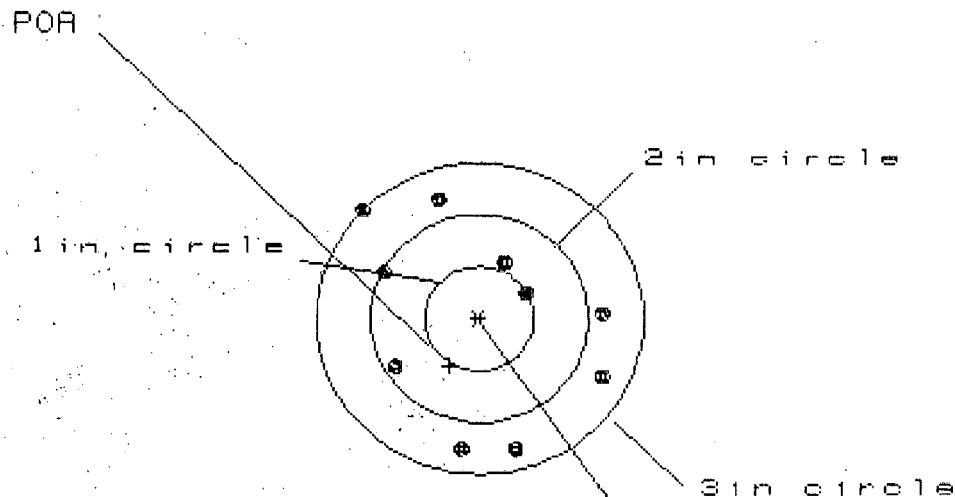
PATTERN # : 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.184	.984	.780
MINIMUM X	-1.798	-1.632	-.906
MAXIMUM Y	1.005	1.081	1.194
MINIMUM Y	-1.475	-1.399	-1.286
CENTROID X	.502	.702	.906
CENTROID Y	.204	.128	.015
POA TO CENTROID in.	.542	.714	.906
MIN RADIUS	.509	.720	.748
MEAN RADIUS	1.210	1.112	.991
MAX RADIUS	1.923	1.868	1.288
HORIZONTAL SPREAD	2.982	2.616	1.686
VERTICAL SPREAD	2.480	2.480	2.480
EXTREME SPREAD	3.096	2.908	2.489
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

11 MAR 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8523382

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 9

HS- 2.151

VS- 2.403

GS- 2.725

CENTROID *

PATTERN #

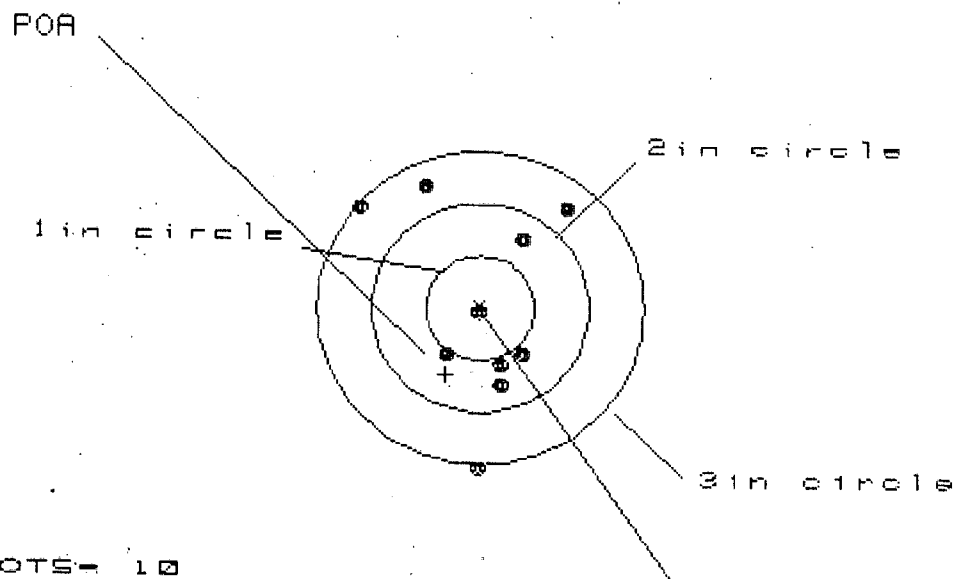
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.113	.998	1.025
MINIMUM X	:	-1.038	-.993	-.966
MAXIMUM Y	:	1.134	1.255	1.111
MINIMUM Y	:	-1.269	-1.148	-1.262
CENTROID X	:	.271	.386	.359
CENTROID Y	:	.456	.335	.479
POA TO CENTROID in.	:	.530	.511	.599
MIN RADIUS	:	.552	.541	.466
MEAN RADIUS	:	1.056	1.000	.957
MAX RADIUS	:	1.504	1.330	1.299
HORIZONTAL SPREAD	:	2.151	1.991	1.991
VERTICAL SPREAD	:	2.403	2.403	2.373
EXTREME SPREAD	:	2.725	2.491	2.375
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6523382

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 1.907

VS- 2.750

GS- 2.789

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.807	.800	.662
MINIMUM X	-1.100	-1.107	-.673
MAXIMUM Y	1.208	1.036	1.133
MINIMUM Y	-1.542	-.924	-.827
CENTROID X	.311	.318	.456
CENTROID Y	.639	.811	.714
POA TO CENTROID in.	.711	.871	.847
MIN RADIUS	.067	.236	.218
MEAN RADIUS	.891	.846	.750
MAX RADIUS	1.543	1.350	1.318
HORIZONTAL SPREAD	1.907	1.907	1.335
VERTICAL SPREAD	2.750	1.960	1.960
EXTREME SPREAD	2.789	2.157	2.103
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

11 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B2

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS = 2.459

VS = 2.870

GS = 2.927

CENTROID *

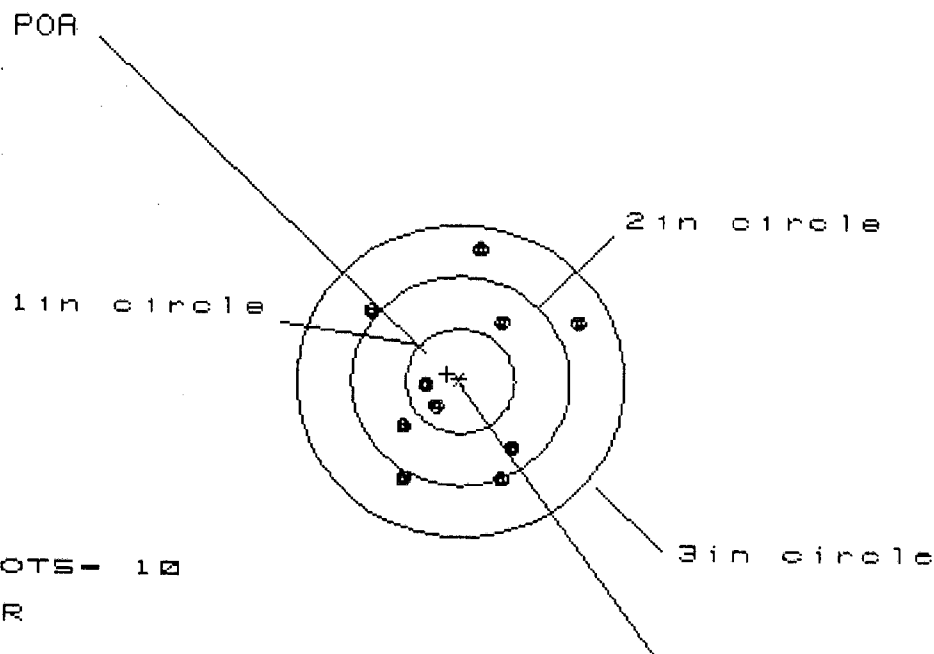
PATTERN #	:	340		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.435	.934	.872
MINIMUM X	:	-1.024	-.864	-.926
MAXIMUM Y	:	1.446	1.357	1.167
MINIMUM Y	:	-1.424	-1.513	-1.192
CENTROID X	:	.138	-.022	.041
CENTROID Y	:	.151	.240	.430
POA TO CENTROID in.	:	.204	.241	.432
MIN RADIUS	:	.243	.099	.284
MEAN RADIUS	:	.981	.901	.817
MAX RADIUS	:	1.645	1.594	1.326
HORIZONTAL SPREAD	:	2.459	1.798	1.798
VERTICAL SPREAD	:	2.870	2.870	2.359
EXTREME SPREAD	:	2.927	2.879	2.371
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Mar 1908

FILE: PATTERNING/CENTERFIRE_PATT/C6523382

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

CENTROID *

HS= 1.861

VS= 2.256

GS= 2.352

PATTERN #	:	5	:	8
SHOTS (BEST OF)	:	10	:	8
MAXIMUM X	:	1.083	:	1.098
MINIMUM X	:	-.778	:	-.763
MAXIMUM Y	:	1.304	:	.807
MINIMUM Y	:	-.952	:	-.807
CENTROID X	:	.120	:	.105
CENTROID Y	:	-.067	:	-.212
POA TO CENTROID in.	:	.137	:	.236
MIN RADIUS	:	.297	:	.219
MEAN RADIUS	:	.846	:	.771
MAX RADIUS	:	1.311	:	1.305
HORIZONTAL SPREAD	:	1.861	:	1.861
VERTICAL SPREAD	:	2.256	:	1.614
EXTREME SPREAD	:	2.352	:	2.211
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6523382

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 0027076 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/30/96	AC
	G) Safety Off Force	4	4	4			5/30/96	AC
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.022	.022	.023			5/30/96	AC
	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	2.90	2.94	2.83	2.98	2.89	5/30/96	WS
	C) Function							
660	Pack							

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

MODEL 700™ M24

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

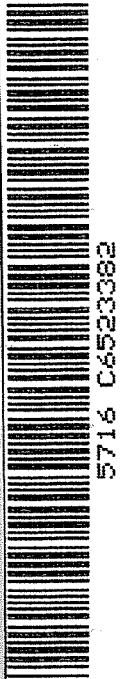
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6523382

ORDER NO.
5716

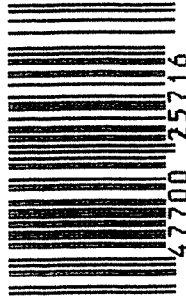
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



5716 C6523382

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523382

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	LB
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel AB		7/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	DA
	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		10/14/90	DL

op. #	OP. NAME	READINGS					DATE	INIT
635 nt.	F) Safety On Force	4	4	4			10/24/90	WB
	G) Safety Off Force	2	2	2			10/24/90	WB
	H) Trigger Pull Test & Retainability						10/29/90	JH
	I) Firing Pin Indent	.020	.0205	.0205			10/24/90	WB
	J) Assemble Stock						10/25/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						10/25/90	RW
	M) Iron Sight Alignment						10/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/25/90	RW
	O) Attach Scope to Rifle						10/25/90	RW
	P) Detach & Attach Scope 20 Times						10/25/90	RW
640	Gallery Target & Test						10-26-90	NF
	A) Time						10-26-90	NF
	B) Malfunctions						10-26-90	NF
	C) Pierced Primers						10-26-90	NF
	D) Optical Clarity of Scope						10-26-90	NF
645	Inspect for Live Ammo						10-26-90	NF
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	265	275	263	265	269	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523382DATE 10/19/90TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.17	2.26	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.15	2.33	275	
PULL #3	2.32	2.24	2.23	263	
PULL #4	2.27	2.27	2.28	265	
PULL #5	2.30	2.18	2.29	269	
TOTAL	11.44	11.01	11.39		
AVG.	2.288	2.202	2.278		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.13		
PULL #2	3.34	3.39		
PULL #3	3.21	3.45		
PULL #4	3.30	3.38		
PULL #5	3.22	3.48		
TOTAL	16.52	16.83		
AVG.	3.304	3.366		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.29		4.36
PULL #2	4.27	4.29		4.36
PULL #3	4.22	4.30		4.19
PULL #4	4.33	4.15		4.21
PULL #5	4.31	4.27		4.33
TOTAL	21.44	21.3		21.45
AVG.	4.288	4.26		4.29

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523382
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.112614
1 TO	2	.39245
1 TO	3	.250801
1 TO	4	.211026
1 TO	5	.123843

2.8 3 <----POA

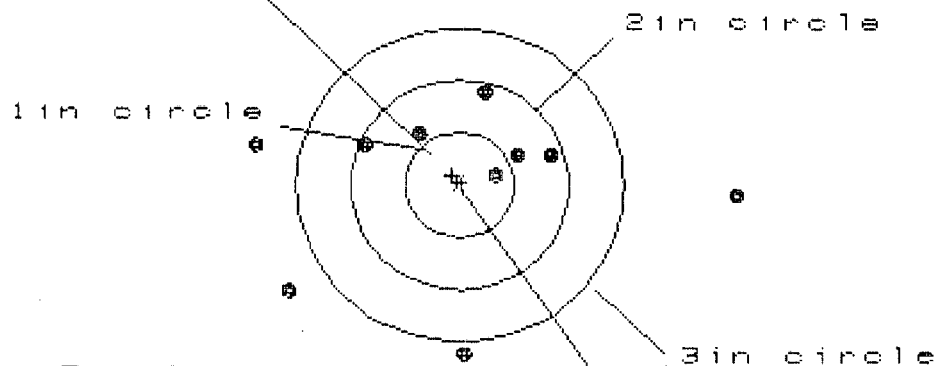
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0416293
THE AMR FOR THIS RIFLE IS: 1.063

26 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B2

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 4.466

VS= 2.473

GS= 4.492

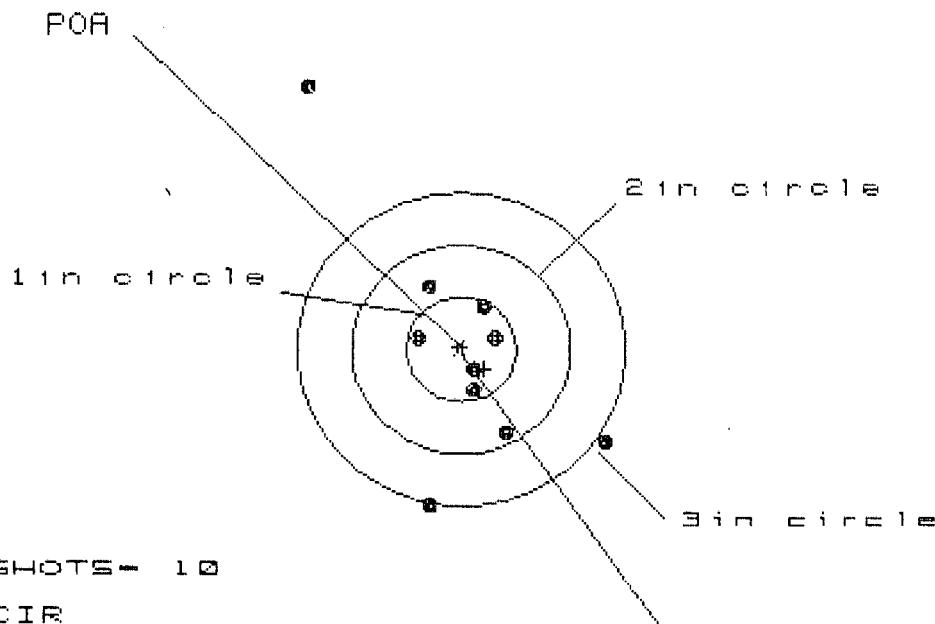
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.569	1.163	.961
MINIMUM X	:	-1.897	-1.612	-1.463
MAXIMUM Y	:	.852	.844	.894
MINIMUM Y	:	-1.621	-1.629	-1.579
CENTROID X	:	.069	-.217	-.015
CENTROID Y	:	-.089	-.081	-.131
POA TO CENTROID in.	:	.113	.232	.132
MIN RADIUS	:	.351	.442	.444
MEAN RADIUS	:	1.232	1.094	.995
MAX RADIUS	:	2.570	1.665	1.764
HORIZONTAL SPREAD	:	4.466	2.775	2.424
VERTICAL SPREAD	:	2.473	2.473	2.473
EXTREME SPREAD	:	4.492	2.820	2.740
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	3		

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523362

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 8

HS= 2.720

VS= 3.957

GS= 4.367

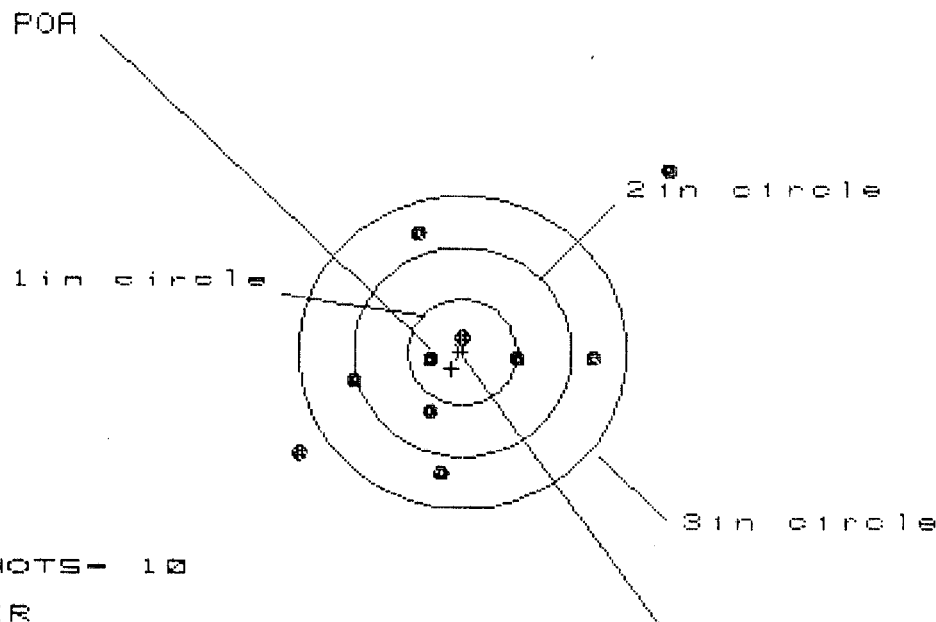
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.129	.431
MINIMUM X	:	-1.432	-.535	-.393
MAXIMUM Y	:	2.512	.857	.778
MINIMUM Y	:	-1.445	-1.166	-1.244
CENTROID X	:	-.207	-.048	-.190
CENTROID Y	:	.190	-.089	-.010
POA TO CENTROID in.	:	.282	.101	.190
MIN RADIUS	:	.182	.139	.081
MEAN RADIUS	:	.925	.681	.586
MAX RADIUS	:	2.891	1.291	1.275
HORIZONTAL SPREAD	:	2.720	1.664	.825
VERTICAL SPREAD	:	3.957	2.023	2.023
EXTREME SPREAD	:	4.367	2.182	2.024
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B2

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 3.379

VS= 2.882

GS= 4.299

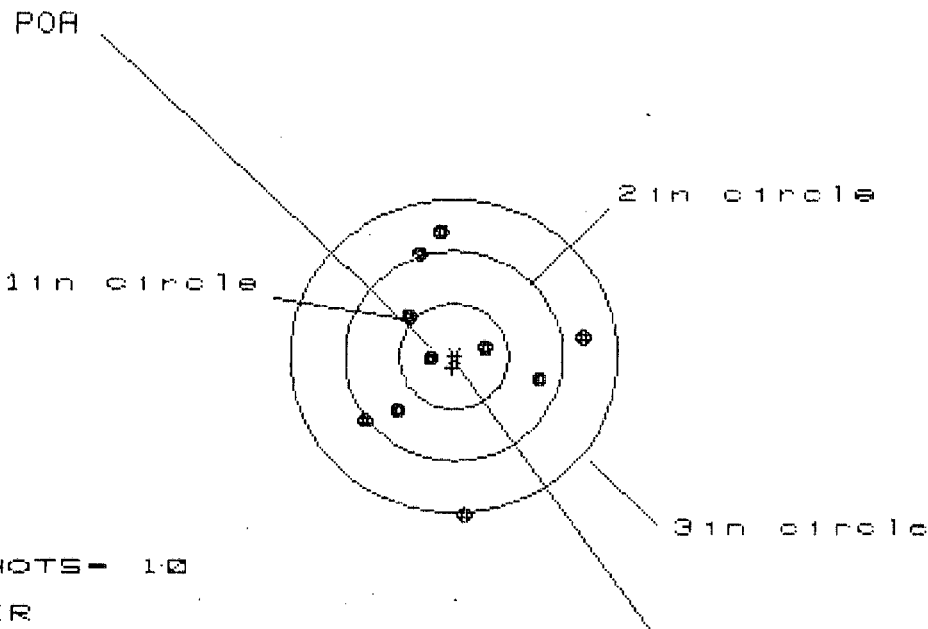
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.905	1.390	1.232
MINIMUM X	:	-1.474	-1.263	-.924
MAXIMUM Y	:	1.747	1.384	1.294
MINIMUM Y	:	-1.135	-.940	-1.030
CENTROID X	:	.099	-.112	.046
CENTROID Y	:	.160	-.035	.055
POA TO CENTROID in.	:	.188	.117	.072
MIN RADIUS	:	.181	.145	.251
MEAN RADIUS	:	1.051	.847	.767
MAX RADIUS	:	2.585	1.452	1.330
HORIZONTAL SPREAD	:	3.379	2.653	2.156
VERTICAL SPREAD	:	2.882	2.324	2.324
EXTREME SPREAD	:	4.299	2.781	2.329
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B2

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.997

VS= 2.714

GS= 2.724

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.217	1.200
MINIMUM X	:	-.789	-.780	-.797
MAXIMUM Y	:	1.218	1.052	.979
MINIMUM Y	:	-1.496	-.763	-.632
CENTROID X	:	.015	.006	.024
CENTROID Y	:	.115	.281	.150
POA TO CENTROID in.	:	.116	.282	.152
MIN RADIUS	:	.172	.245	.187
MEAN RADIUS	:	.865	.789	.740
MAX RADIUS	:	1.499	1.217	1.205
HORIZONTAL SPREAD	:	1.997	1.997	1.997
VERTICAL SPREAD	:	2.714	1.815	1.611
EXTREME SPREAD	:	2.724	2.131	2.131
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B2

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 2.355

VS= 3.716

GS= 3.744

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.444	1.416	1.438
MINIMUM X	-.912	-.939	-.917
MAXIMUM Y	1.637	1.406	1.224
MINIMUM Y	-2.079	-1.847	-1.671
CENTROID X	-.022	.006	-.016
CENTROID Y	-.173	.058	-.117
POA TO CENTROID in.	.174	.059	.119
MIN RADIUS	.286	.468	.323
MEAN RADIUS	1.243	1.131	1.086
MAX RADIUS	2.094	1.847	1.672
HORIZONTAL SPREAD	2.355	2.355	2.355
VERTICAL SPREAD	3.716	3.253	2.895
EXTREME SPREAD	3.744	3.258	3.044
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 5		