

C6523524

MODEL 760<sup>TM</sup> M24

Model **SMS** <sup>TM</sup>

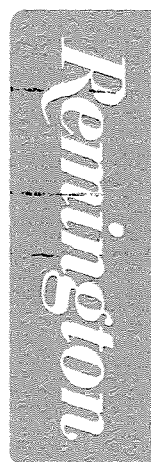
Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



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

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

**MODEL 700™ M24**

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

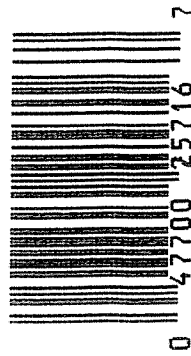
|                               |                          |
|-------------------------------|--------------------------|
| <b>SERIAL NO.</b><br>C6523524 | <b>ORDER NO.</b><br>5716 |
|-------------------------------|--------------------------|

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



5716 C6523524

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523524  
12 Sep 1990

CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .759234 |
| 1 | TO | 2 | 1.30848 |
| 1 | TO | 3 | 1.76936 |
| 1 | TO | 4 | .338009 |
| 1 | TO | 5 | .149375 |

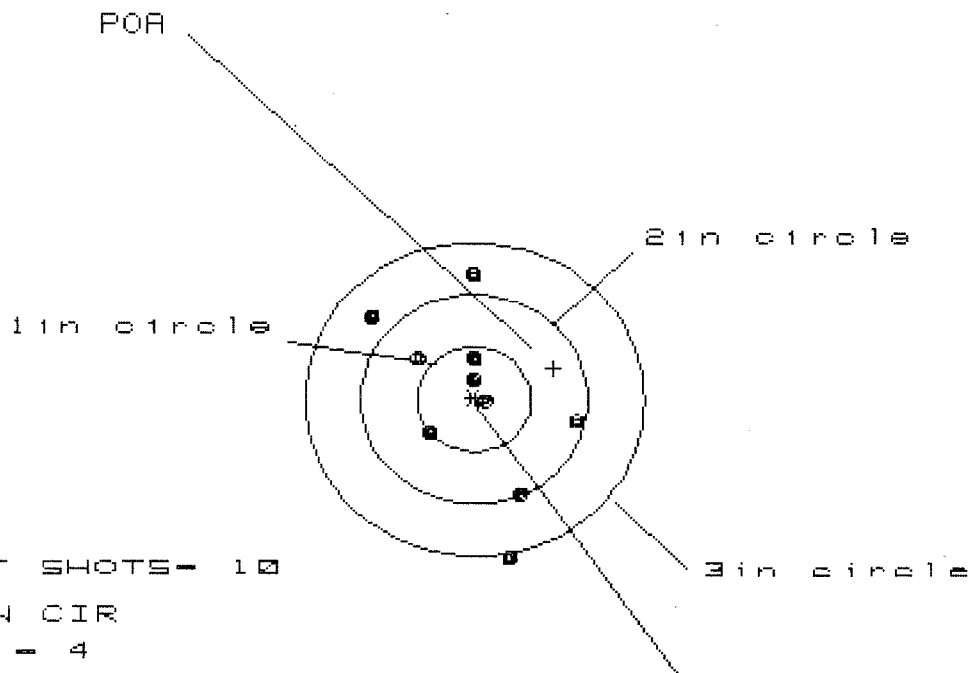
4.5 + 2.3 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1294  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1964  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .235196  
THE AMR FOR THIS RIFLE IS: .8684

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6523524

## CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 1.840

VS = 2.735

GS = 2.757

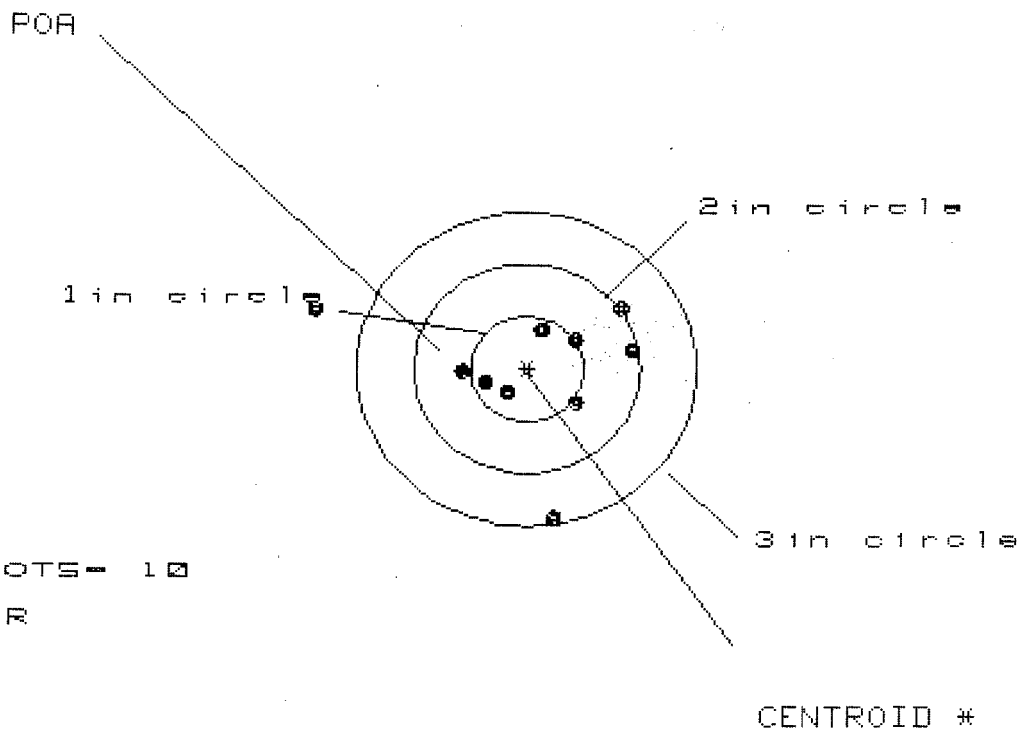
CENTROID \*

| PATTERN #                   | : | 1      | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .898   | .937   | .824  |
| MINIMUM X                   | : | -.942  | -.903  | -.525 |
| MAXIMUM Y                   | : | 1.191  | 1.020  | 1.102 |
| MINIMUM Y                   | : | -1.544 | -1.079 | -.997 |
| CENTROID X                  | : | -.700  | -.739  | -.626 |
| CENTROID Y                  | : | -.294  | -.123  | -.205 |
| POA TO CENTROID in.         | : | .759   | .749   | .659  |
| MIN RADIUS                  | : | .091   | .066   | .061  |
| MEAN RADIUS                 | : | .768   | .647   | .587  |
| MAX RADIUS                  | : | 1.583  | 1.156  | 1.105 |
| HORIZONTAL SPREAD           | : | 1.840  | 1.840  | 1.349 |
| VERTICAL SPREAD             | : | 2.735  | 2.099  | 2.099 |
| EXTREME SPREAD              | : | 2.757  | 2.183  | 2.132 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.858

VS = 2.057

GS = 2.932

| PATTERN #                     | 2      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .963   | .752   | .751  |
| MINIMUM X                     | -1.905 | -.771  | -.772 |
| MAXIMUM Y                     | .591   | .655   | .480  |
| MINIMUM Y                     | -1.466 | -1.402 | -.424 |
| CENTROID X                    | .570   | .781   | .782  |
| CENTROID Y                    | .021   | -.043  | .132  |
| POA TO CENTROID in.           | .570   | .782   | .793  |
| MIN RADIUS                    | .269   | .303   | .321  |
| MEAN RADIUS                   | .818   | .680   | .569  |
| MAX RADIUS                    | 1.988  | 1.402  | .805  |
| HORIZONTAL SPREAD             | 2.868  | 1.523  | 1.523 |
| VERTICAL SPREAD               | 2.057  | 2.057  | .904  |
| EXTREME SPREAD                | 2.932  | 2.159  | 1.534 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |       |

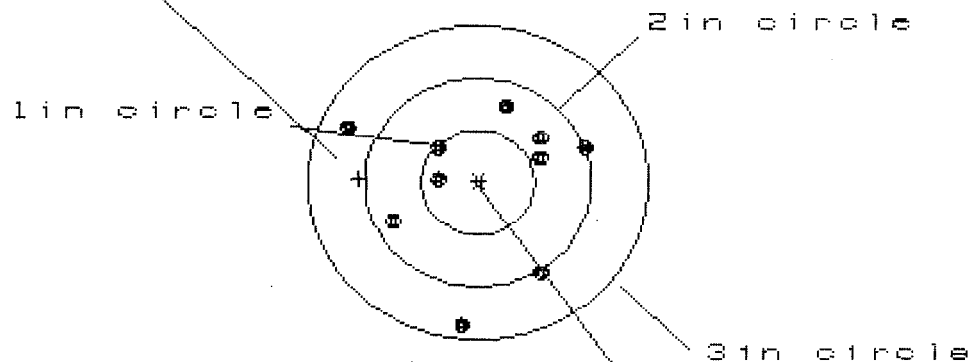
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## CENTERFIRE PATTERNS

# 3

POR



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.146

VS= 2.123

GS= 2.233

CENTROID #

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .962   | .943   | .792   |
| MINIMUM X                   | : | -1.184 | -1.203 | -.892  |
| MAXIMUM Y                   | : | .723   | .568   | .618   |
| MINIMUM Y                   | : | -1.400 | -1.054 | -1.004 |
| CENTROID X                  | : | 1.050  | 1.069  | 1.220  |
| CENTROID Y                  | : | -.033  | .122   | .072   |
| POR TO CENTROID in.         | : | 1.050  | 1.076  | 1.222  |
| MIN RADIUS                  | : | .373   | .403   | .372   |
| MEAN RADIUS                 | : | .853   | .766   | .696   |
| MAX RADIUS                  | : | 1.411  | 1.269  | 1.060  |
| HORIZONTAL SPREAD           | : | 2.146  | 2.146  | 1.684  |
| VERTICAL SPREAD             | : | 2.123  | 1.622  | 1.622  |
| EXTREME SPREAD              | : | 2.233  | 2.233  | 1.850  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

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## CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.049

VS = 2.536

GS = 3.092

CENTROID #

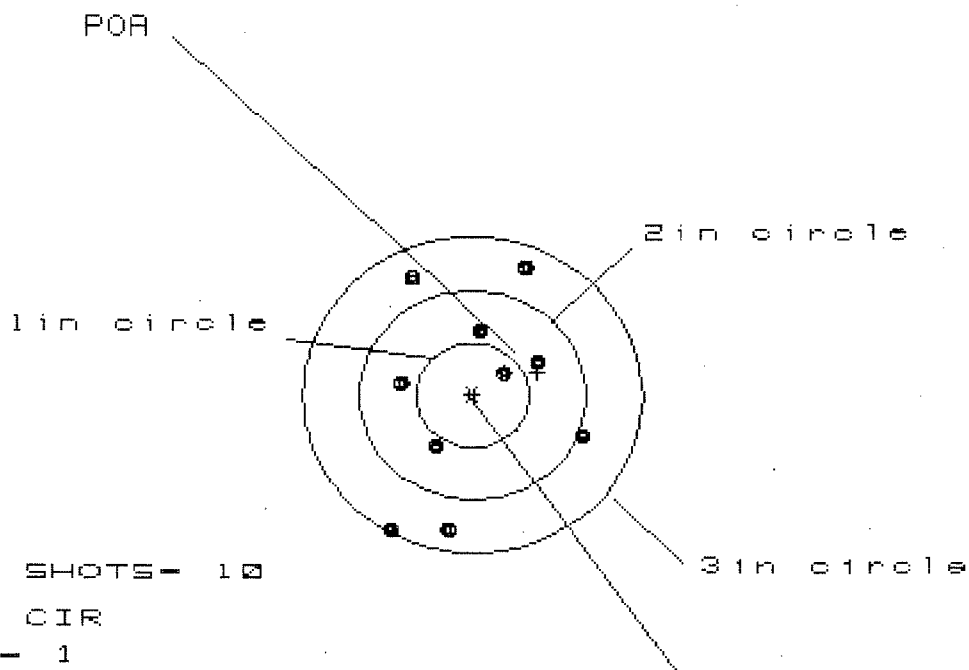
| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.003  | .887   | .778   |
| MINIMUM X                   | : | -1.046 | -1.136 | -1.026 |
| MAXIMUM Y                   | : | 1.222  | .961   | .841   |
| MINIMUM Y                   | : | -1.314 | -1.178 | -1.298 |
| CENTROID X                  | : | -.995  | -.879  | -.990  |
| CENTROID Y                  | : | -.459  | -.595  | -.475  |
| POA TO CENTROID in.         | : | 1.096  | 1.061  | 1.098  |
| MIN RADIUS                  | : | .256   | .380   | .268   |
| MEAN RADIUS                 | : | .982   | .901   | .841   |
| MAX RADIUS                  | : | 1.608  | 1.454  | 1.311  |
| HORIZONTAL SPREAD           | : | 2.049  | 2.023  | 1.803  |
| VERTICAL SPREAD             | : | 2.536  | 2.139  | 2.139  |
| EXTREME SPREAD              | : | 3.092  | 2.751  | 2.342  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS

# 5



# OF SHOTS - 10

# IN CIR

1 in - 1

2 in - 5

3 in - 8

HS= 1.685

VS= 2.574

GS= 2.841

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .961   | .881   | .930   |
| MINIMUM X                   | : | -.724  | -.669  | -.620  |
| MAXIMUM Y                   | : | 1.249  | 1.102  | 1.064  |
| MINIMUM Y                   | : | -1.325 | -1.453 | -1.316 |
| CENTROID X                  | : | -.572  | -.492  | -.541  |
| CENTROID Y                  | : | -.217  | -.070  | -.207  |
| POA TO CENTROID in.         | : | .612   | .496   | .580   |
| MIN RADIUS                  | : | .359   | .224   | .328   |
| MEAN RADIUS                 | : | .921   | .824   | .792   |
| MAX RADIUS                  | : | 1.510  | 1.486  | 1.341  |
| HORIZONTAL SPREAD           | : | 1.685  | 1.550  | 1.550  |
| VERTICAL SPREAD             | : | 2.574  | 2.555  | 2.380  |
| EXTREME SPREAD              | : | 2.841  | 2.652  | 2.398  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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

SERIAL NO. C6523524  
DATE 9/8/90  
TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.33             | 2.37                     | 2.25                           | 2.27  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.36             | 2.41                     | 2.10                           | 2.31  |                                                                        |
| PULL #3 | 2.37             | 2.27                     | 2.17                           | 2.31  |                                                                        |
| PULL #4 | 2.22             | 2.40                     | 2.17                           | 2.32  |                                                                        |
| PULL #5 | 2.27             | 2.56                     | 2.25                           | 2.32  |                                                                        |
| TOTAL   | 11.55            | 12.01                    | 10.94                          | 11.53 |                                                                        |
| AVG.    | 2.31             | 2.40                     | 2.19                           | 2.306 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.19             | 3.19                     |  |          |
| PULL #2 | 3.14             | 3.05                     |  |          |
| PULL #3 | 3.01             | 3.00                     |  |          |
| PULL #4 | 3.07             | 3.08                     |  |          |
| PULL #5 | 3.08             | 3.07                     |  |          |
| TOTAL   | 15.49            | 15.39                    |  |          |
| AVG.    | 3.10             | 3.08                     |  |          |

|         | 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 | 4.01             | 4.11                     |                                | 4.02                                 |
| PULL #2 | 4.03             | 4.10                     |                                | 3.90                                 |
| PULL #3 | 4.06             | 4.00                     |                                | 3.95                                 |
| PULL #4 | 4.06             | 4.01                     |                                | 4.02                                 |
| PULL #5 | 4.12             | 4.00                     |                                | 4.00                                 |
| TOTAL   | 20.28            | 20.22                    |                                | 19.89                                |
| AVG.    | 4.06             | 4.04                     |                                | 3.98                                 |

CAN 700

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06523524

| OP. #     | OP. NAME                                                 | READINGS                                                                                                  | DATE    | INIT |
|-----------|----------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | <div style="border: 1px solid black; padding: 10px; text-align: center;"> <b>QUALITY<br/>AUDIT</b> </div> | 8-21-90 | DM   |
| 600       | Proof                                                    |                                                                                                           | 8-21-90 | DM   |
| 607       | Check Headspace                                          |                                                                                                           | 8-21-90 | DM   |
| 610       | Dis-assemble Gun                                         |                                                                                                           | 8-21-90 | DM   |
| 612       | Magnaflux Barrel Action                                  | New Barrel 8/22/90                                                                                        | 8/23/90 | KCK  |
|           | Magnaflux Bolt                                           |                                                                                                           | 8/22/90 | KCK  |
| 615       | Rollmark Caliber                                         |                                                                                                           | 8/23/90 | GS   |
| 617       | Drill and Tap Sight Holes                                |                                                                                                           | 8/23/90 | WB   |
| 618       | Polish Barrel <i>WB</i>                                  |                                                                                                           | 8/23/90 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |                                                                                                           | 8/28/90 | WB   |
|           | Apply Coating (Bolt)                                     |                                                                                                           |         |      |
| 625       | Final Assembly                                           |                                                                                                           |         |      |
|           | A) Clean inside of Bolt Assembly                         |                                                                                                           | 8/31/90 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                                                                                                           | 8/31/90 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |                                                                                                           | 8/31/90 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |                                                                                                           | 8/31/90 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                                                                                                           | 9/8/90  | WB   |

| op. #      | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 35<br>Int. | F) Safety On Force                                          | 4        | 4     | 4     |      |      | 9/10/90 | WB   |
|            | G) Safety Off Force                                         | 2        | 2     | 2     |      |      | 9/10/90 | WB   |
|            | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 9/8/90  | WB   |
|            | I) Firing Pin Indent                                        | .022     | .0225 | .0225 |      |      | 9/10/90 | WB   |
|            | J) Assemble Stock                                           |          |       |       |      |      | 9/11/90 | RW   |
|            | K) Assemble Swivel Studs                                    |          |       |       |      |      | 9/15/90 | JS   |
|            | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 9/11/90 | RW   |
|            | M) Iron Sight Alignment                                     |          |       |       |      |      | 9/11/90 | RW   |
|            | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 9/11/90 | RW   |
|            | O) Attach Scope to Rifle                                    |          |       |       |      |      | 9/11/90 | RW   |
|            | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 9/11/90 | RW   |
| 640        | Gallery Target & Test                                       |          |       |       |      |      | 9-12-90 | AC   |
|            | A) Time                                                     |          |       |       |      |      | 9-12-90 | AC   |
|            | B) Malfunctions                                             |          |       |       |      |      | 9-12-90 | AC   |
|            | C) Pierced Primers                                          |          |       |       |      |      | 9-12-90 | AC   |
|            | D) Optical Clarity of Scope                                 |          |       |       |      |      | 9-12-90 | AC   |
| 645        | Inspect for Live Ammo                                       |          |       |       |      |      | 9-12-90 | AC   |
| 655        | Final Inspection                                            |          |       |       |      |      |         |      |
|            | A) Headspace                                                |          |       |       |      |      | 9/15/90 | JS   |
|            | B) Trigger Pull                                             | 2.27     | 2.31  | 2.31  | 2.32 | 2.32 | 9-15-90 | JS   |
|            | C) Function                                                 |          |       |       |      |      | 9/15/90 | JS   |
| 660        | Pack                                                        |          |       |       |      |      | 9/20/90 | AF   |