

C6523320

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400000

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523320
8 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.238411
1 TO	2	.26414
1 TO	3	.519362
1 TO	4	.251859
1 TO	5	.356931

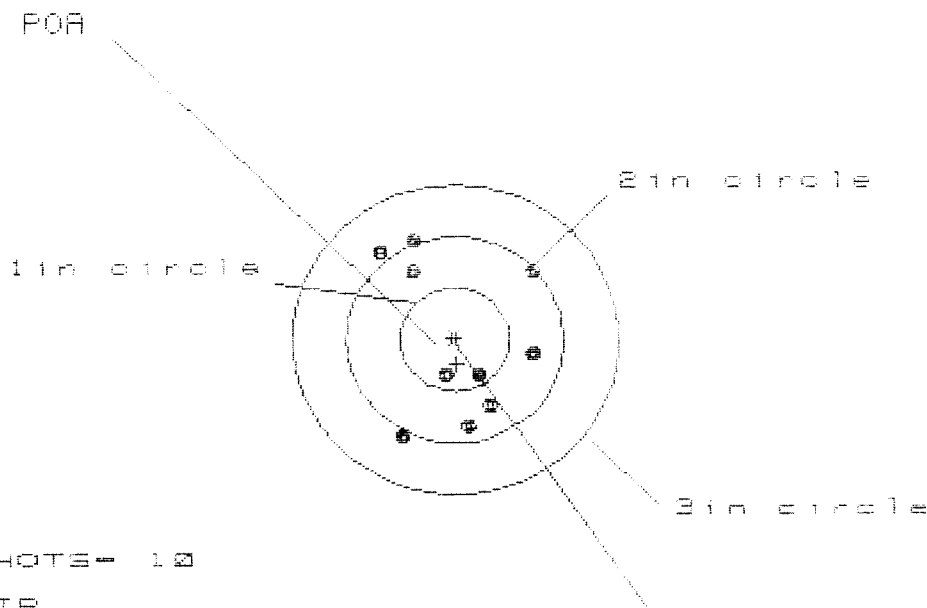
4% <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1078
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0010
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107615
THE AMR FOR THIS RIFLE IS: .7752

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523320

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.348

VS = 1.891

GS = 1.968

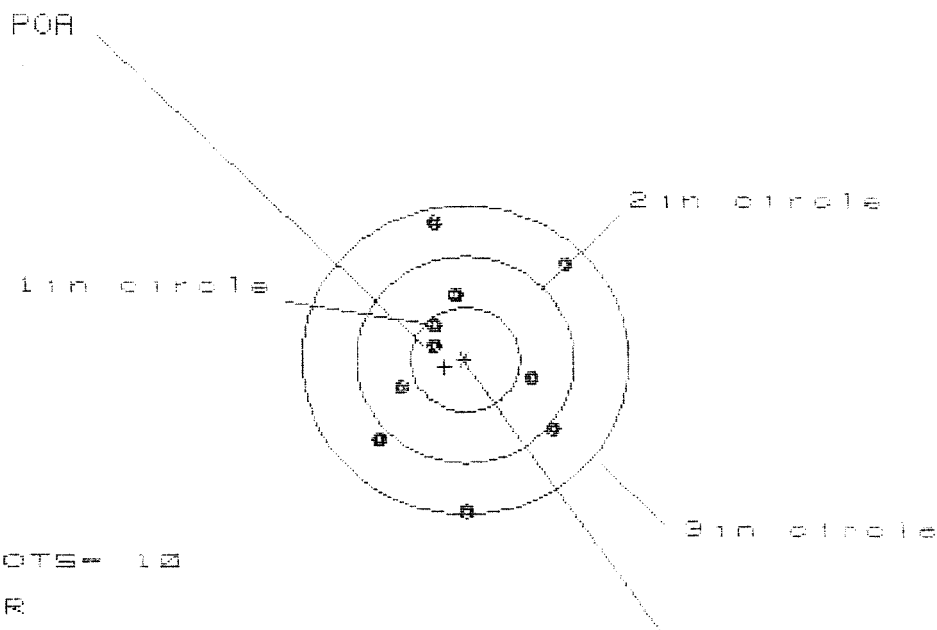
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.704	.632	.558
MINIMUM X	:	-.644	-.595	-.554
MAXIMUM Y	:	.956	1.056	.952
MINIMUM Y	:	-.935	-.835	-.808
CENTROID X	:	-.014	.058	.132
CENTROID Y	:	.238	.138	.242
POA TO CENTROID in.	:	.238	.149	.276
MIN RADIUS	:	.329	.276	.337
MEAN RADIUS	:	.785	.720	.692
MAX RADIUS	:	1.107	1.136	1.072
HORIZONTAL SPREAD	:	1.348	1.227	1.112
VERTICAL SPREAD	:	1.891	1.891	1.760
EXTREME SPREAD	:	1.968	1.968	1.812
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 May 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.720

VS= 2.809

GS= 2.827

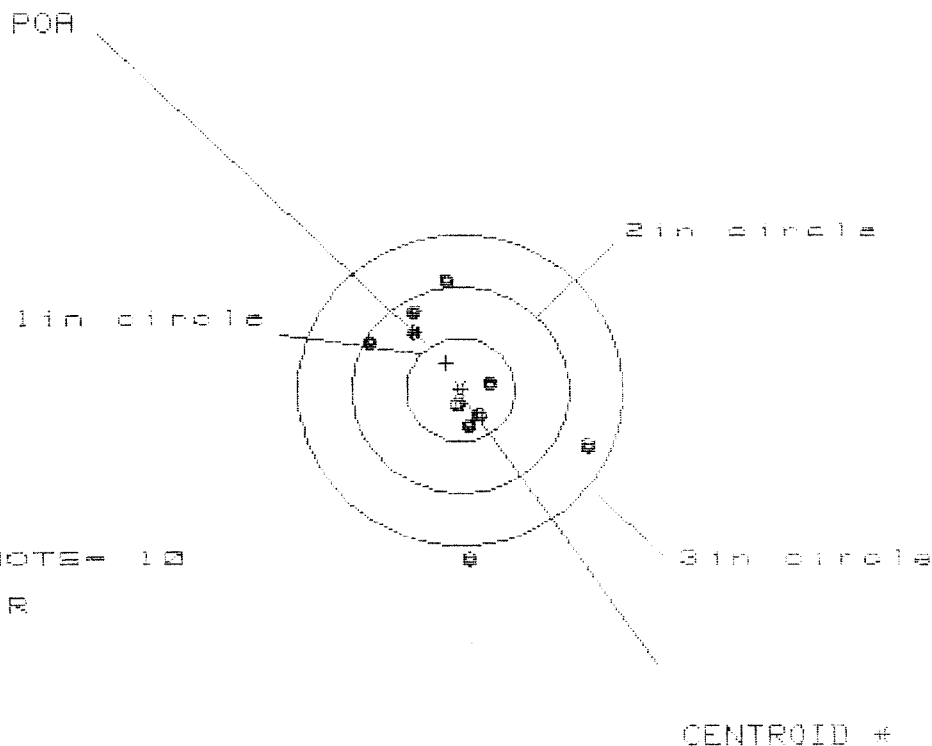
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.936	.937	.898
MINIMUM X	:	-.784	-.783	-.822
MAXIMUM Y	:	1.319	1.154	.932
MINIMUM Y	:	-1.490	-.940	-.796
CENTROID X	:	.189	.188	.227
CENTROID Y	:	.069	.234	.090
POA TO CENTROID in.	:	.201	.301	.244
MIN RADIUS	:	.299	.260	.324
MEAN RADIUS	:	.891	.801	.760
MAX RADIUS	:	1.490	1.224	1.294
HORIZONTAL SPREAD	:	1.720	1.720	1.720
VERTICAL SPREAD	:	2.809	2.094	1.720
EXTREME SPREAD	:	2.827	2.438	2.438
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.043

VS = 2.667

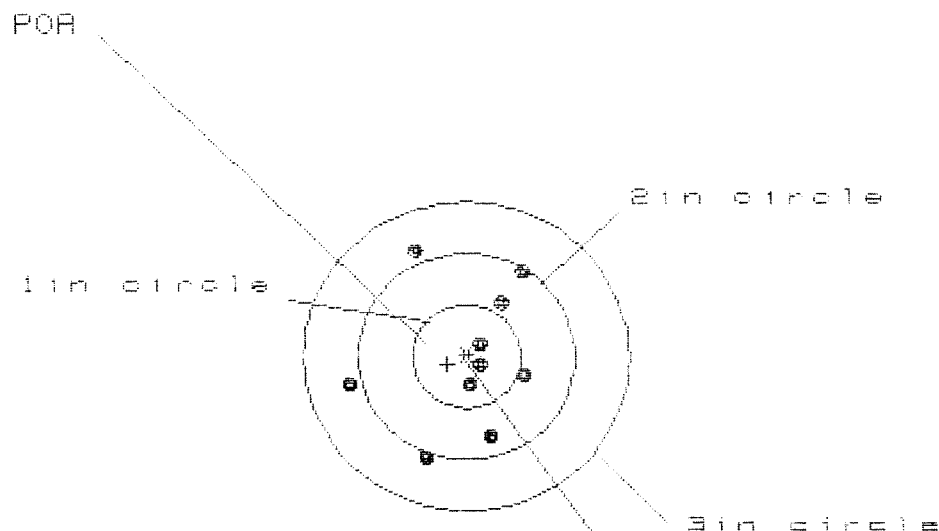
GS = 2.675

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.227	.454
MINIMUM X	:	-.827	-.816	-.663
MAXIMUM Y	:	1.042	.862	.776
MINIMUM Y	:	-1.625	-.685	-.596
CENTROID X	:	.130	.119	-.034
CENTROID Y	:	-.261	-.081	.005
POA TO CENTROID in.	:	.292	.144	.035
MIN RADIUS	:	.151	.329	.414
MEAN RADIUS	:	.764	.678	.583
MAX RADIUS	:	1.628	1.405	.778
HORIZONTAL SPREAD	:	2.043	2.043	1.117
VERTICAL SPREAD	:	2.667	1.547	1.372
EXTREME SPREAD	:	2.675	2.243	1.379
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.566

VS= 1.982

ES= 2.021

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.530	.478	.342
MINIMUM X	:	-1.036	-1.088	-1.598
MAXIMUM Y	:	1.013	.940	.919
MINIMUM Y	:	-.969	-.857	-.878
CENTROID X	:	.178	.230	.366
CENTROID Y	:	.075	-.037	-.016
POR TO CENTROID in.	:	.193	.233	.366
MIN RADIUS	:	.162	.086	.053
MEAN RADIUS	:	.682	.611	.531
MAX RADIUS	:	1.114	1.101	1.062
HORIZONTAL SPREAD	:	1.566	1.566	.940
VERTICAL SPREAD	:	1.982	1.797	1.797
EXTREME SPREAD	:	2.021	2.021	2.021
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.657

VS = 1.858

GS = 1.868

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.788	.752	.639
MINIMUM X	:	-.877	-.905	-.594
MAXIMUM Y	:	1.124	.859	.798
MINIMUM Y	:	-.734	-.609	-.670
CENTROID X	:	.056	.084	.197
CENTROID Y	:	-.112	-.237	-.176
POA TO CENTROID in.	:	.125	.252	.264
MIN RADIUS	:	.269	.244	.121
MEAN RADIUS	:	.754	.691	.631
MAX RADIUS	:	1.153	1.030	.995
HORIZONTAL SPREAD	:	1.657	1.657	1.233
VERTICAL SPREAD	:	1.858	1.468	1.468
EXTREME SPREAD	:	1.906	1.904	1.596
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6523320

DATE 1-6-90

TESTER JLF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.26	2.34	292	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.39	2.27	285	
PULL #3	2.26	2.28	2.28	291	
PULL #4	2.42	2.25	2.39	292	
PULL #5	2.32	2.28	2.32	290	
TOTAL	11.42	11.46	11.60		
AVG.	2.284	2.292	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.34		
PULL #2	3.17	3.31		
PULL #3	3.46	3.30		
PULL #4	3.41	3.30		
PULL #5	3.40	3.17		
TOTAL	16.71	16.42		
AVG.	3.342	3.284		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.30		4.18
PULL #2	4.50	4.33		4.22
PULL #3	4.19	4.32		4.23
PULL #4	4.52	4.30		4.17
PULL #5	4.41	4.31		4.22
TOTAL	22.10	21.62		21.02
AVG.	4.42	4.324		4.204

C 1.5

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523320

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KH
600	Proof		10/4/90	KH
607	Check Headspace		10/4/90	KH
610	Dis-assemble Gun		10/4/90	KH
612	Magnaflux Barrel Action		10/4/90	KR
	Magnaflux Bolt		10/4/90	KR
615	Rollmark Caliber		10/9/90	LL
617	Drill and Tap Sight Holes		10/6/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/19/90	WB
	C) Inspect Ejector Hole for Chamfer		10/19/90	WB
	D) Oil Firing Pin Ass'y		10/19/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	TH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3.5	3.0	3.0	11-2-90	KT
	G) Safety Off Force	2.0	2.0	2.0	11-2-90	KT
	H) Trigger Pull Test & Retainability				11-6-90	JH
	I) Firing Pin Indent	.026	.027	.026	11-2-90	KT
	J) Assemble Stock				11-6-90	KS
	K) Assemble Swivel Studs				11-20-90	JS
	L) Attach Front and Rear Sight Assemblies				11-6-90	KS
	M) Iron Sight Alignment				11-6-90	KS
	N) Detach Front & Rear Sights & place in numbered container				11-6-90	KS
	O) Attach Scope to Rifle				11-6-90	KS
	P) Detach & Attach Scope 20 Times				11-6-90	KS
640	Gallery Target & Test				11-8-90	AC
	A) Time				11-8-90	AC
	B) Malfunctions				11-8-90	AC
	C) Pierced Primers				11-8-90	AC
	D) Optical Clarity of Scope				11-8-90	AC
645	Inspect for Live Ammo				11-8-90	AC
655	Final Inspection				11-20-90	JS
	A) Headspace				11-20-90	JS
	B) Trigger Pull	292	285	291	292 290	11-20-90
	C) Function				11-20-90	JS
660	Pack				12/18/90	VF

Remington



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

MODEL 700™ M24

SERIAL NO.
C6523320

ORDER NO.
5716

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

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5716 C6523320

UPC



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