

C6523455

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

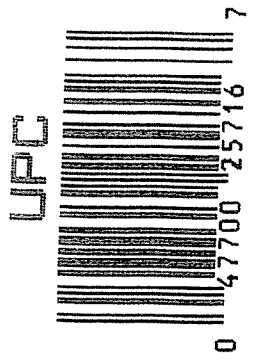
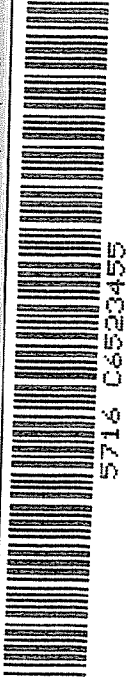
Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6523455

ORDER NO.
5716



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523455
15 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.217412
1 TO	2	.201896
1 TO	3	.128316
1 TO	4	.210609
1 TO	5	.404505

± 2 <----POA
5

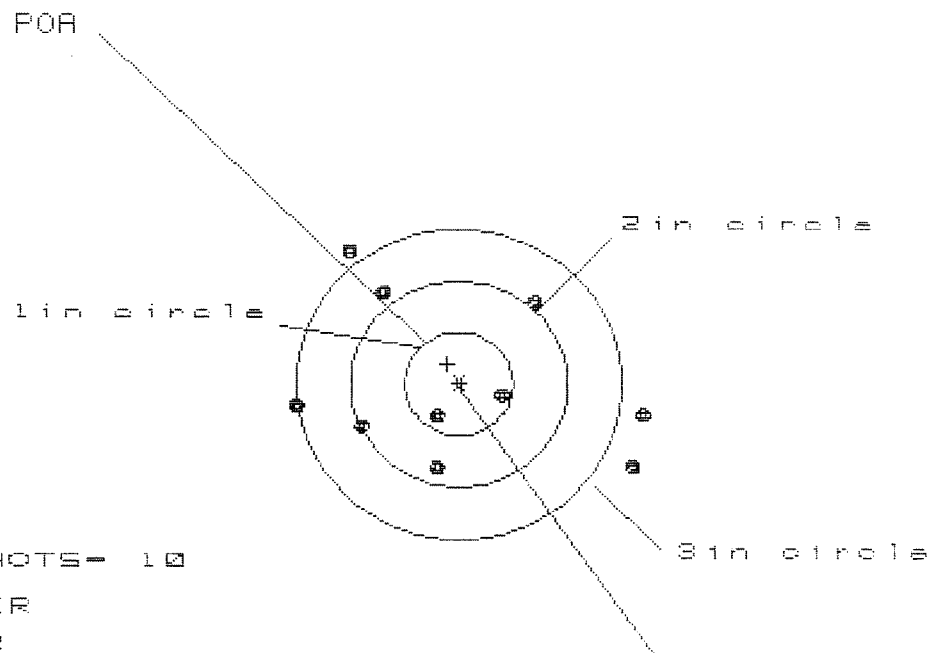
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .029
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2788
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .280384

THE AMR FOR THIS RIFLE IS: 1.024

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523455

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 3.246

VS= 2.046

GS= 3.265

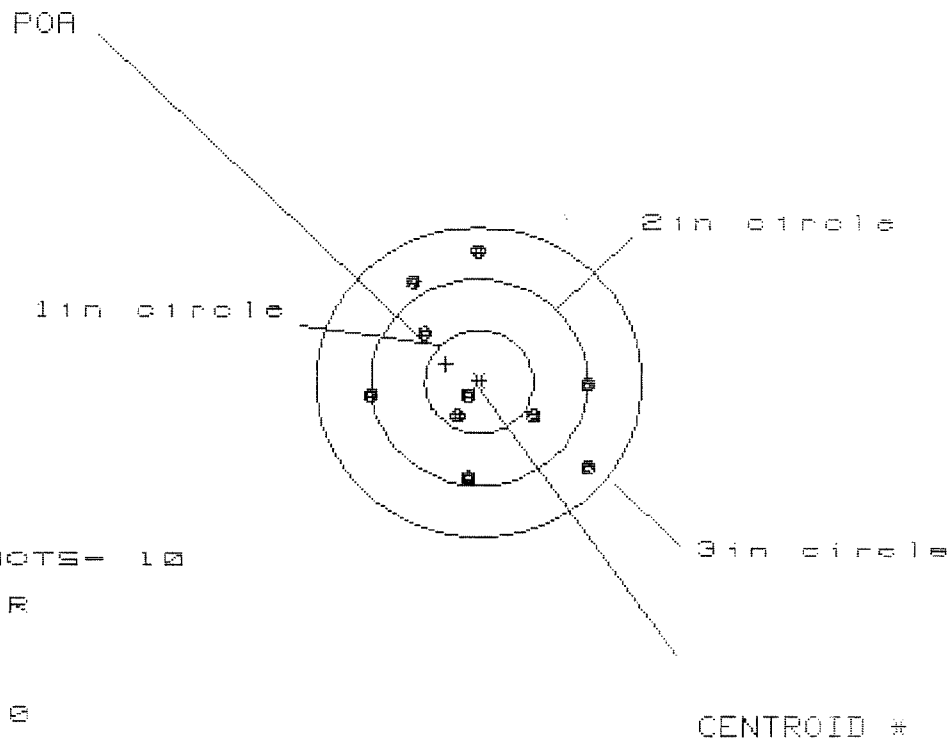
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.744	1.759	1.158
MINIMUM X	:	-1.502	-1.309	-1.089
MAXIMUM Y	:	1.256	1.225	1.123
MINIMUM Y	:	-.790	-.821	-.911
CENTROID X	:	.102	-.091	-.311
CENTROID Y	:	-.192	-.161	-.059
POA TO CENTROID in.	:	.218	.185	.317
MIN RADIUS	:	.369	.369	.517
MEAN RADIUS	:	1.136	1.053	.939
MAX RADIUS	:	1.766	1.941	1.323
HORIZONTAL SPREAD	:	3.246	3.068	2.247
VERTICAL SPREAD	:	2.046	2.046	2.034
EXTREME SPREAD	:	3.265	3.265	2.454
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

15 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.978

VS= 2.231

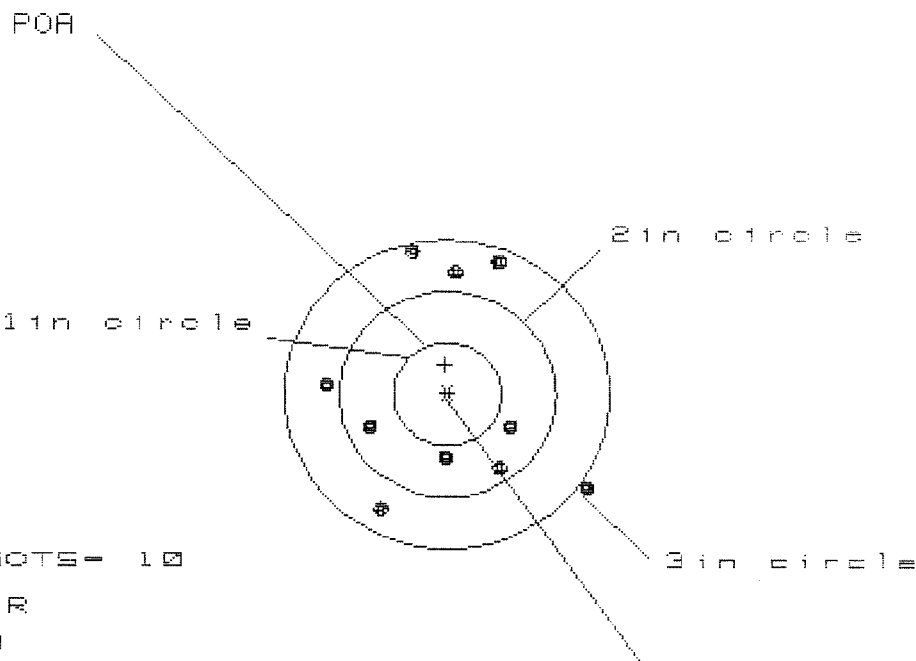
GS= 2.456

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.986	1.069	1.082
MINIMUM X	:	-.992	-.882	-.869
MAXIMUM Y	:	1.271	1.175	1.063
MINIMUM Y	:	-.960	-1.056	-.909
CENTROID X	:	.303	.193	.180
CENTROID Y	:	-.173	-.077	-.224
POA TO CENTROID in.	:	.349	.208	.287
MIN RADIUS	:	.166	.252	.117
MEAN RADIUS	:	.847	.798	.713
MAX RADIUS	:	1.311	1.180	1.164
HORIZONTAL SPREAD	:	1.978	1.951	1.951
VERTICAL SPREAD	:	2.231	2.231	1.972
EXTREME SPREAD	:	2.456	2.234	2.031
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Sep 1980

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.354

VS= 2.551

GS= 2.785

CENTROID *

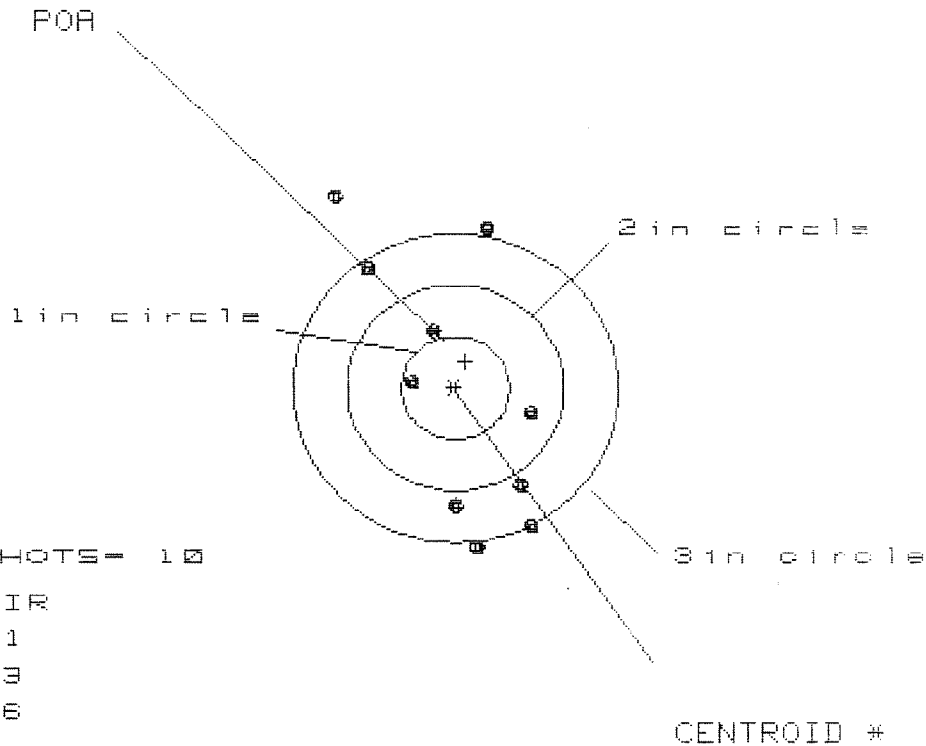
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.237	.669	.652
MINIMUM X	:	-1.117	-.980	-.997
MAXIMUM Y	:	1.431	1.330	1.315
MINIMUM Y	:	-1.120	-1.221	-1.054
CENTROID X	:	.018	-.119	-.102
CENTROID Y	:	-.289	-.188	-.355
POA TO CENTROID in.	:	.290	.223	.369
MIN RADIUS	:	.611	.744	.599
MEAN RADIUS	:	1.094	1.047	.978
MAX RADIUS	:	1.534	1.337	1.445
HORIZONTAL SPREAD	:	2.354	1.649	1.649
VERTICAL SPREAD	:	2.551	2.551	2.369
EXTREME SPREAD	:	2.785	2.623	2.623
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1938

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 1.800

VS= 3.350

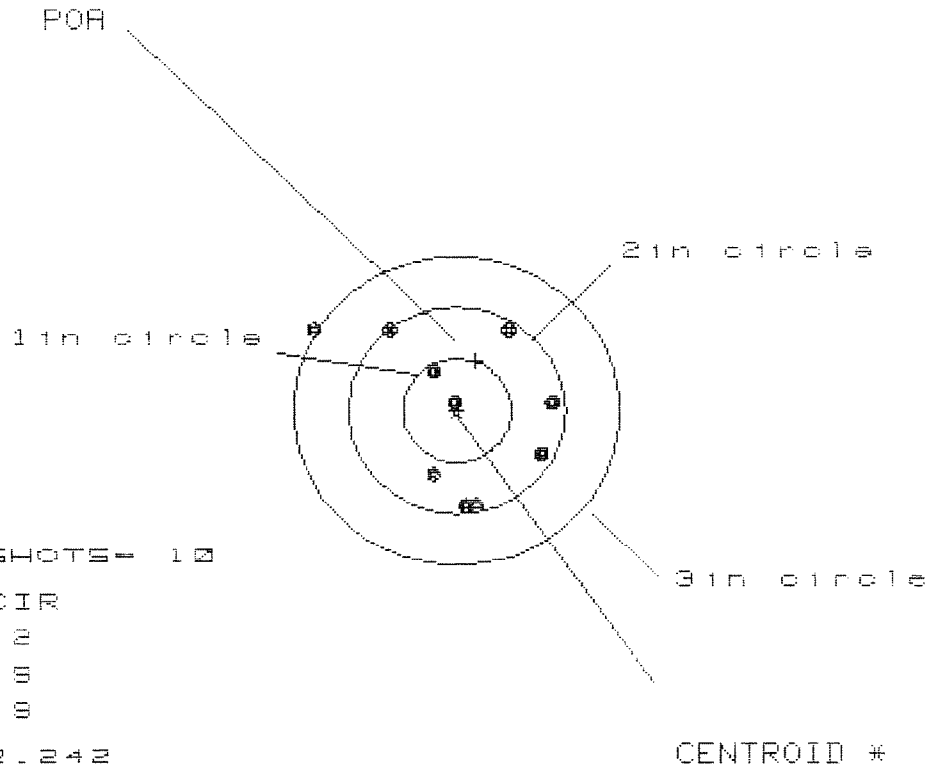
GS= 3.662

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.704	.581	.599
MINIMUM X	-1.104	-.899	-.881
MAXIMUM Y	1.829	1.791	1.594
MINIMUM Y	-1.521	-1.318	-1.094
CENTROID X	-.098	.025	.007
CENTROID Y	-.258	-.461	-.685
POA TO CENTROID in.	.276	.462	.685
MIN RADIUS	.373	.550	.634
MEAN RADIUS	1.208	1.081	.961
MAX RADIUS	2.136	1.797	1.821
HORIZONTAL SPREAD	1.800	1.480	1.480
VERTICAL SPREAD	3.350	3.109	2.688
EXTREME SPREAD	3.662	3.110	2.924
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

15 Sep 1998

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CENTERFIRE PATTERNS # 5



PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.910	.762	.666
MINIMUM X	-1.332	-.768	-.512
MAXIMUM Y	.806	.888	.991
MINIMUM Y	-.938	-.856	-.753
CENTROID X	-.180	-.032	.064
CENTROID Y	-.482	-.564	-.667
POA TO CENTROID in.	.514	.565	.670
MIN RADIUS	.107	.271	.410
MEAN RADIUS	.837	.759	.707
MAX RADIUS	1.524	1.124	1.029
HORIZONTAL SPREAD	2.242	1.530	1.178
VERTICAL SPREAD	1.744	1.744	1.744
EXTREME SPREAD	2.414	1.872	1.772
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

SWS TRIGGER PULL TEST

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

3455
SERIAL NO. C6527137
DATE 9/14/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.50	2.52	2.05	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.52	2.36	2.02	
PULL #3	2.38	2.45	2.30	2.08	
PULL #4	2.33	2.54	2.38	2.10	
PULL #5	2.25	2.60	2.26	2.15	
TOTAL	11.56	12.61	11.82	10.40	
AVG.	2.31	2.52	2.36	2.08	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.35		
PULL #2	3.00	3.19		
PULL #3	3.04	3.33		
PULL #4	3.10	3.40		
PULL #5	3.10	3.47		
TOTAL	15.38	16.74		
AVG.	3.08	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.33		4.02
PULL #2	4.07	4.39		4.07
PULL #3	4.05	4.33		4.11
PULL #4	4.09	4.43		4.07
PULL #5	3.98	4.33		4.07
TOTAL	20.32	21.81		20.34
AVG.	4.06	4.36		4.07

CAN 702

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523455

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action	NEW Barrel 8/22/90	8/23/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/23/90	JS
617	Drill and Tap Sight Holes		8/23/90	LB
618	Polish Barrel RUB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-23-90	JS
	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		9/14/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/14/90	WB
	G) Safety Off Force	2	2	2			9/14/90	WB
	H) Trigger Pull Test & Retainability						9/14/90	WB
	I) Firing Pin Indent	.023	.024	.0235			9/14/90	WB
	J) Assemble Stock						9/14/90	RW
	K) Assemble Swivel Studs						9/16/90	JS
	L) Attach Front and Rear Sight Assemblies						9/14/90	RW
	M) Iron Sight Alignment						9/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/14/90	RW
	O) Attach Scope to Rifle						9/14/90	RW
	P) Detach & Attach Scope 20 Times						9/14/90	RW
640	Gallery Target & Test						9-15-90	AC
	A) Time						9-15-90	AC
	B) Malfunctions						9-15-90	AC
	C) Pierced Primers						9-15-90	AC
	D) Optical Clarity of Scope						9-15-90	AC
645	Inspect for Live Ammo						9-15-90	AC
655	Final Inspection							
	A) Headspace						9/16/90	JS
	B) Trigger Pull	2.05	2.02	2.08	2.10	2.15	9-16-90	JS
	C) Function						9/16/90	JS
660	Pack						9/20/90	AF