

66348743

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348743
DATE 6-22-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.73	2.66		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.61	2.75		
PULL #3	2.43	2.71	2.57		
PULL #4	2.47	2.53	2.85		
PULL #5	2.45	2.80	2.80		
TOTAL	12.16	13.38	13.57		
AVG.	2.43	2.67	2.71		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.12		
PULL #2	3.09	3.22		
PULL #3	3.00	3.29		
PULL #4	3.11	3.38		
PULL #5	3.22	3.37		
TOTAL	15.45	16.38		
AVG.	3.09	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.04		4.29
PULL #2	4.00	4.11		4.31
PULL #3	3.96	4.08		4.27
PULL #4	4.05	4.27		4.34
PULL #5	4.00	4.20		4.35
TOTAL	20.05	20.70		21.56
AVG.	4.01	4.14		4.31

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

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		6-26	REP
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-26	REP
	C) Inspect Ejector Hole for Chamfer		6-26	REP
	D) Oil Firing Pin Ass'y		6-26	REP
	E) Adjust Trigger Pull to Min Setting and Stake			

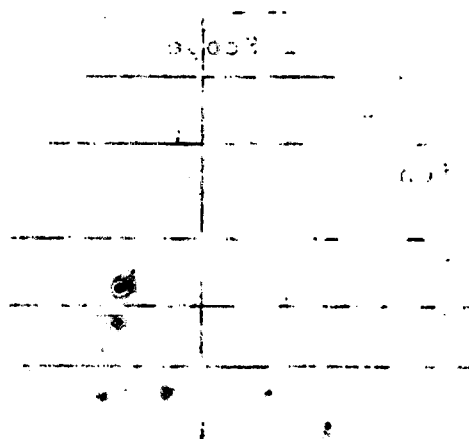
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	7	7			6-26	REP
	G) Safety Off Force	4	4	4			6-26	REP
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.024	.0225	.023			6-26	REP
	J) Assemble Stock						6-26	REP
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle						6-26	REP
	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	2.51	2.50	2.50	2.51	2.75	7/14	SF
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348743
11 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	.408325
1 TO	2	.661753
1 TO	3	.676805
1 TO	4	.295373
1 TO	5	.45127

←----FOR



THE AVERAGE X-COORDINATE FOR THIS :

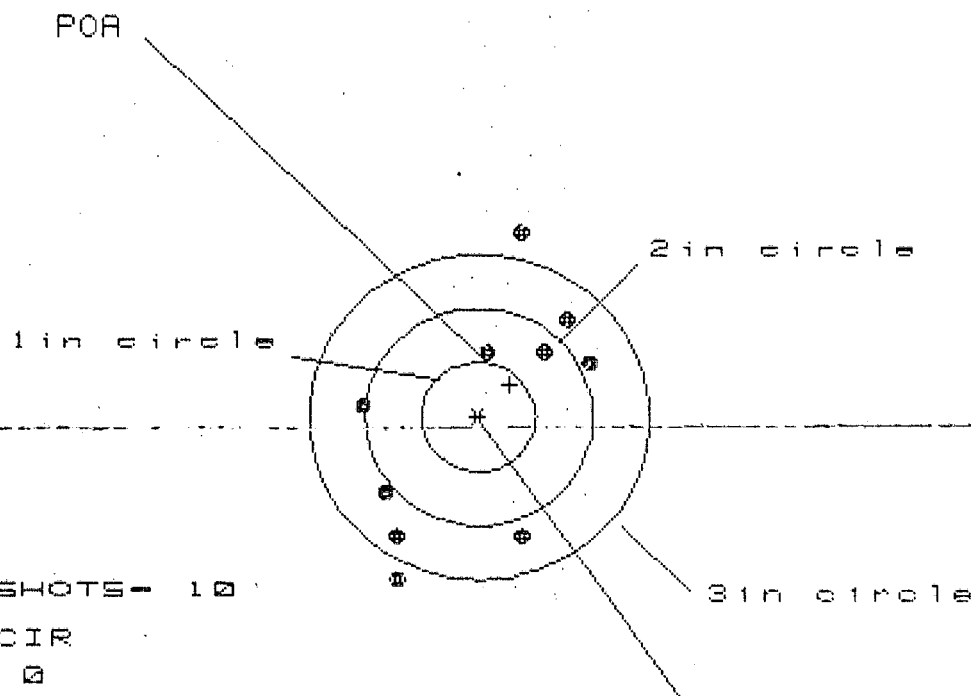
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0000
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0475987

THE AMR FOR THIS RIFLE IS: .8994

11 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6348743

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 1.988

VS= 3.166

GS= 3.365

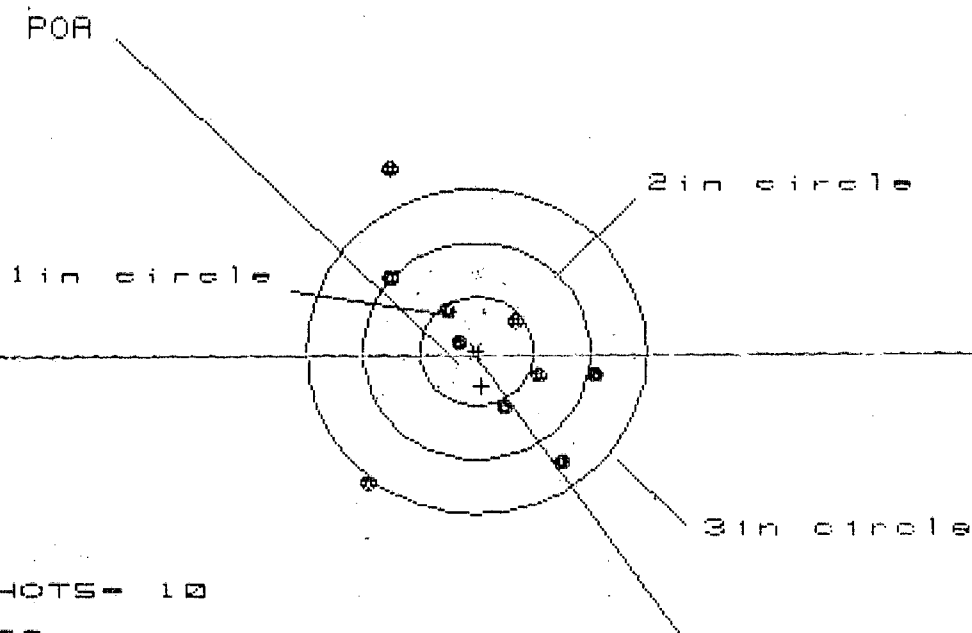
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	1.042	.959
MINIMUM X	:	-.993	-.946	-1.029
MAXIMUM Y	:	1.667	1.127	.963
MINIMUM Y	:	-1.499	-1.314	-1.031
CENTROID X	:	-.277	-.324	-.241
CENTROID Y	:	-.380	-.485	-.321
POA TO CENTROID in.	:	.408	.594	.401
MIN RADIUS	:	.594	.785	.608
MEAN RADIUS	:	1.174	1.113	1.046
MAX RADIUS	:	1.720	1.474	1.329
HORIZONTAL SPREAD	:	1.988	1.988	1.988
VERTICAL SPREAD	:	3.166	2.441	2.044
EXTREME SPREAD	:	3.365	2.846	2.526
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	3	3	3
NUMBER IN THREE INCH CIRCLE	=	8	8	8

11 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6348743

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 1.955

VS= 2.927

GS= 3.111

CENTROID #

PATTERN #	225	226	227
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.945	.818
MINIMUM X	-.925	-1.010	-.943
MAXIMUM Y	1.722	.842	.716
MINIMUM Y	-1.205	-1.014	-.944
CENTROID X	-.043	.042	.169
CENTROID Y	.319	.128	.254
POA TO CENTROID in.	.322	.134	.305
MIN RADIUS	.153	.310	.350
MEAN RADIUS	.882	.765	.653
MAX RADIUS	1.886	1.431	1.184
HORIZONTAL SPREAD	1.955	1.955	1.761
VERTICAL SPREAD	2.927	1.856	1.660
EXTREME SPREAD	3.111	2.207	2.205
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

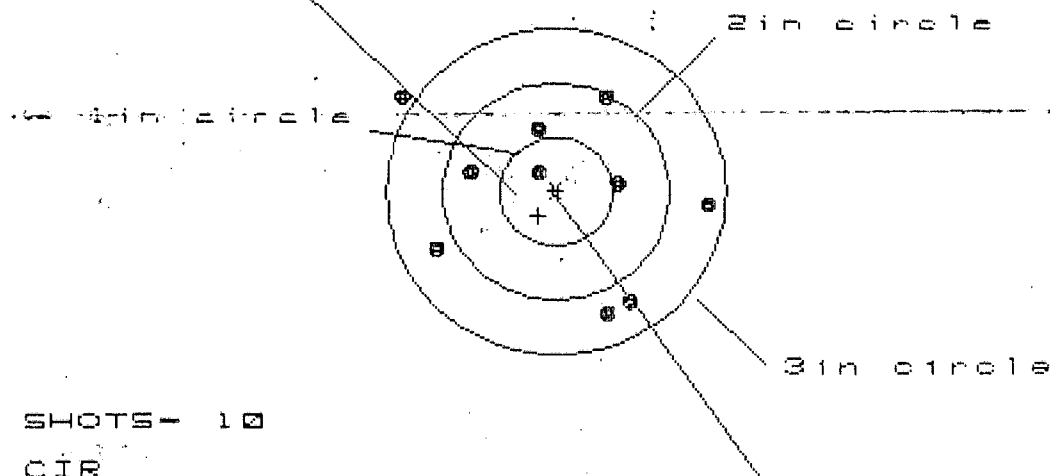
11 Jan 1968

FILE: PATTERNING/CENTERFIRE PAIT/C6348743

CENTERFIRE PATTERNS # 3

POB

1110



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.707

VS= 1.989

GS= 2.890

CENTROID *

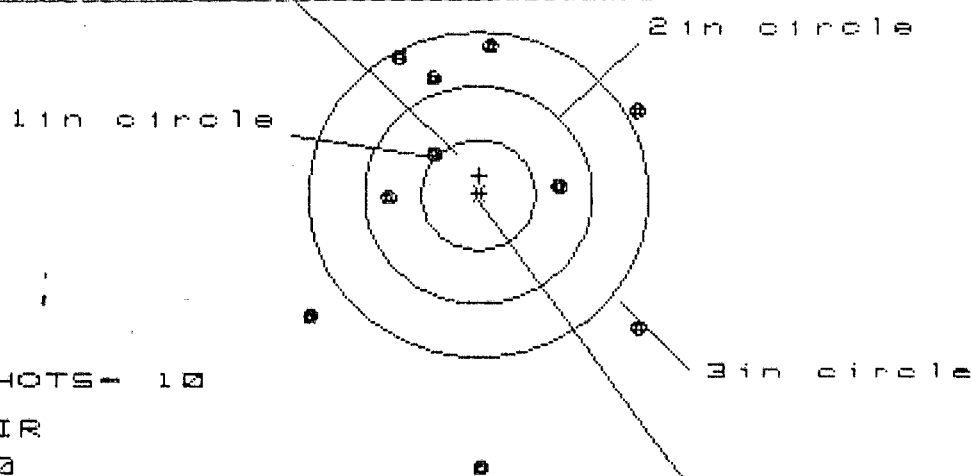
PATTERN #	:	731		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.353	1.202	.666
MINIMUM X	:	-1.354	-1.172	-1.021
MAXIMUM Y	:	.855	.949	.941
MINIMUM Y	:	-1.134	-1.039	-1.047
CENTROID X	:	.155	.306	.155
CENTROID Y	:	.221	.126	.134
POB TO CENTROID in.	:	.270	.331	.205
MIN RADIUS	:	.239	.381	.317
MEAN RADIUS	:	.955	.887	.835
MAX RADIUS	:	1.602	1.231	1.126
HORIZONTAL SPREAD	:	2.707	2.374	1.687
VERTICAL SPREAD	:	1.989	1.988	1.988
EXTREME SPREAD	:	2.890	2.395	1.988
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C634B743

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 2.931

VS = 3.920

GS = 3.924

CENTROID *

PATTERN #	:	041		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.454	1.453	1.627
MINIMUM X	:	-1.477	-1.478	-1.304
MAXIMUM Y	:	1.368	1.085	.893
MINIMUM Y	:	-2.552	-1.536	-1.590
CENTROID X	:	-.008	-.007	-.181
CENTROID Y	:	-.178	.105	.297
POA TO CENTROID in.	:	.179	.105	.348
MIN RADIUS	:	.527	.372	.203
MEAN RADIUS	:	1.399	1.207	1.036
MAX RADIUS	:	2.552	2.072	2.056
HORIZONTAL SPREAD	:	2.931	2.931	2.931
VERTICAL SPREAD	:	3.920	2.621	2.483
EXTREME SPREAD	:	3.924	3.469	3.469
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

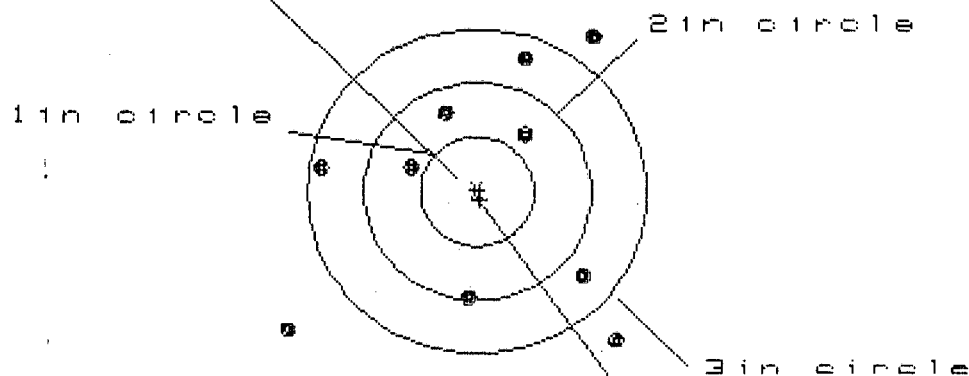
11 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348743

CENTERFIRE PATTERNS

5

POA



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.890

VS= 2.771

GS= 3.818

CENTROID *

PATTERN #	:	35		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	.999	.990
MINIMUM X	:	-1.702	-1.585	-1.460
MAXIMUM Y	:	1.419	1.283	1.097
MINIMUM Y	:	-1.352	-1.488	-1.256
CENTROID X	:	-.023	.166	.041
CENTROID Y	:	.073	.209	.395
POA TO CENTROID in.	:	.076	.267	.397
MIN RADIUS	:	.663	.455	.436
MEAN RADIUS	:	1.261	1.145	1.025
MAX RADIUS	:	2.096	1.792	1.478
HORIZONTAL SPREAD	:	2.890	2.584	2.450
VERTICAL SPREAD	:	2.771	2.771	2.353
EXTREME SPREAD	:	3.818	3.004	2.745
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

M-24

Score 0635

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348743

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	10/31/89		KCR
	Magnaflux Bolt	10/31/89		KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		11/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		14/NOV/89	958

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-14-89	JH
	G) Safety Off Force	3	3	3			11-14-89	JH
	H) Trigger Pull Test & Retainability						14 NOV 89	JDS
	I) Firing Pin Indent	.0205	.0215	.0215			11-14-89	JH
	J) Assemble Stock						11/14/89	RW
	K) Assemble Swivel Studs						17 NOV 89	JDS
	L) Attach Front and Rear Sight Assemblies						11/14/89	RW
	M) Iron Sight Alignment						11/14/89	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/89	RW
	O) Attach Scope to Rifle						11-14-89	JH
	P) Detach & Attach Scope 20 Times						11-14-89	JH
640	Gallery Target & Test						11-15-89	AC
	A) Time						11-15-89	AC
	B) Malfunctions						11-15-89	AC
	C) Pierced Primers						11-15-89	AC
	D) Optical Clarity of Scope						11-15-89	AC
645	Inspect for Live Ammo						11-15-89	AC
655	Final Inspection						17 NOV 89	JDS
	A) Headspace						17 NOV 89	JDS
	B) Trigger Pull	2.38	2.31	2.67	2.48	2.52	17 NOV 89	JDS
	C) Function						17 NOV 89	JDS
660	Pack						15 NOV 89	JDS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348743
DATE 10/Mar/90
TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	245	247		258	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	234	242		256	
PULL #3	239	238		225	
PULL #4	238	239		257	
PULL #5	242	243		258	
TOTAL	1198	1209			
AVG.	2396	2418			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	330	303		
PULL #2	329	330		
PULL #3	328	327		
PULL #4	323	292		
PULL #5	312	329		
TOTAL	1622	1581		
AVG.	3244	3162		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	409	415		
PULL #2	398	408		
PULL #3	412	410		
PULL #4	414	415		
PULL #5	410	403		
TOTAL	2043	2051		
AVG.	4086	4102		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348743
15 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.281192
1 TO	2	.51545
1 TO	3	.242594
1 TO	4	.42063
1 TO	5	.427482

$\bar{x}$ <----FOR

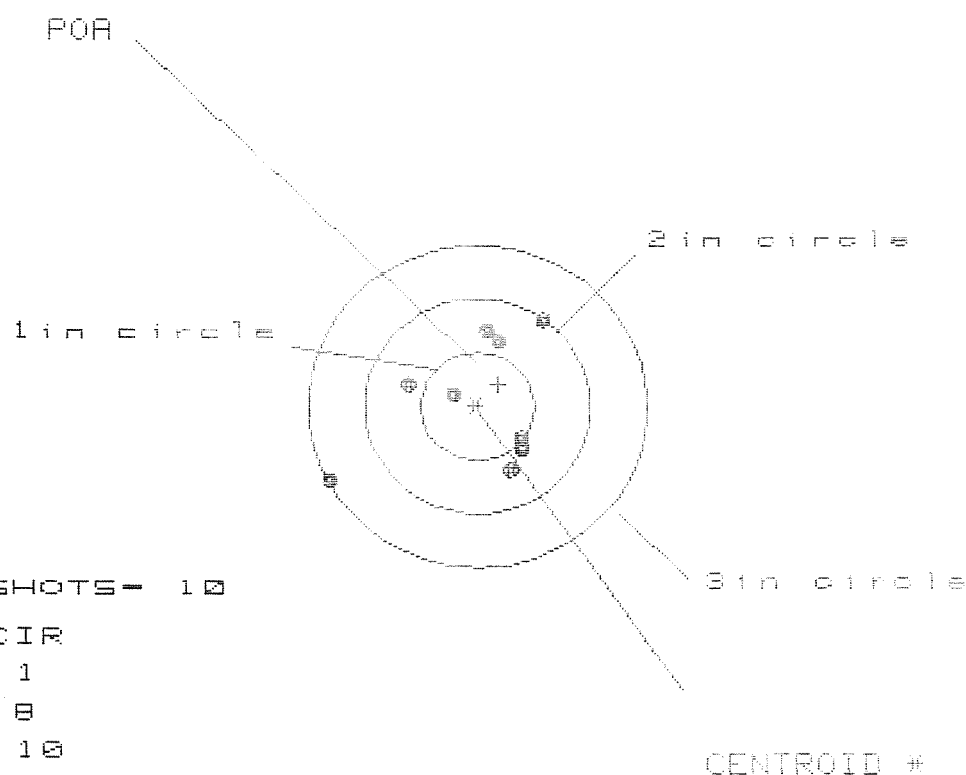
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0253211

THE AMR FOR THIS RIFLE IS: .841

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348743

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 1.901

VS= 1.487

GS= 2.413

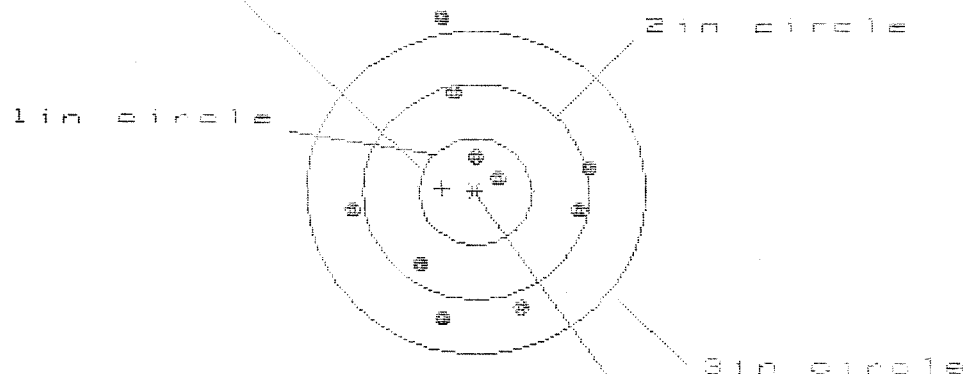
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.570	.422	.315
MINIMUM X	:	-1.331	-.792	-.740
MAXIMUM Y	:	.827	.753	.702
MINIMUM Y	:	-.660	-.667	-.573
CENTROID X	:	-.187	-.039	-.091
CENTROID Y	:	-.210	-.136	-.200
POA TO CENTROID in.	:	.281	.141	.248
MIN RADIUS	:	.213	.333	.307
MEAN RADIUS	:	.708	.611	.566
MAX RADIUS	:	1.486	.863	.781
HORIZONTAL SPREAD	:	1.901	1.214	1.055
VERTICAL SPREAD	:	1.487	1.420	1.275
EXTREME SPREAD	:	2.413	1.451	1.288
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

15 Nov 1989

FILE://PATTERNING/CENTERFIRE_PATT/08348743

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.140

VS= 2.782

GS= 2.782

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.005	.974	.938
MINIMUM X	:	-1.135	-1.166	-1.202
MAXIMUM Y	:	1.601	1.111	.986
MINIMUM Y	:	-1.181	-1.004	-.974
CENTROID X	:	.296	.327	.363
CENTROID Y	:	-.030	-.208	-.083
POA TO CENTROID in.	:	.298	.387	.372
MIN RADIUS	:	.250	.367	.241
MEAN RADIUS	:	.941	.866	.820
MAX RADIUS	:	1.624	1.166	1.205
HORIZONTAL SPREAD	:	2.140	2.140	2.140
VERTICAL SPREAD	:	2.782	2.115	1.960
EXTREME SPREAD	:	2.782	2.167	2.167
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348743

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.390

VS= 1.747

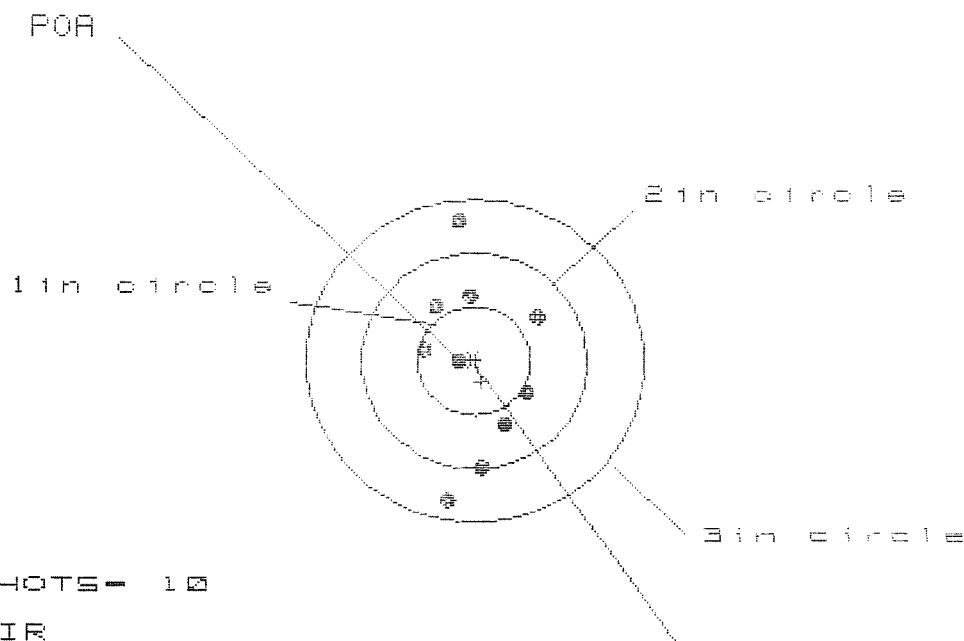
GS= 3.407

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.782	1.479	1.302
MINIMUM X	:	-1.608	-1.410	-1.077
MAXIMUM Y	:	.751	.776	.765
MINIMUM Y	:	-.996	-.971	-.982
CENTROID X	:	.047	-.151	.026
CENTROID Y	:	-.274	-.299	-.288
POA TO CENTROID in.	:	.278	.335	.289
MIN RADIUS	:	.098	.288	.114
MEAN RADIUS	:	1.017	.937	.847
MAX RADIUS	:	1.796	1.570	1.409
HORIZONTAL SPREAD	:	3.390	2.889	2.379
VERTICAL SPREAD	:	1.747	1.747	1.747
EXTREME SPREAD	:	3.407	2.922	2.509
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Nov 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06348743

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.057

VS = 2.613

GS = 2.614

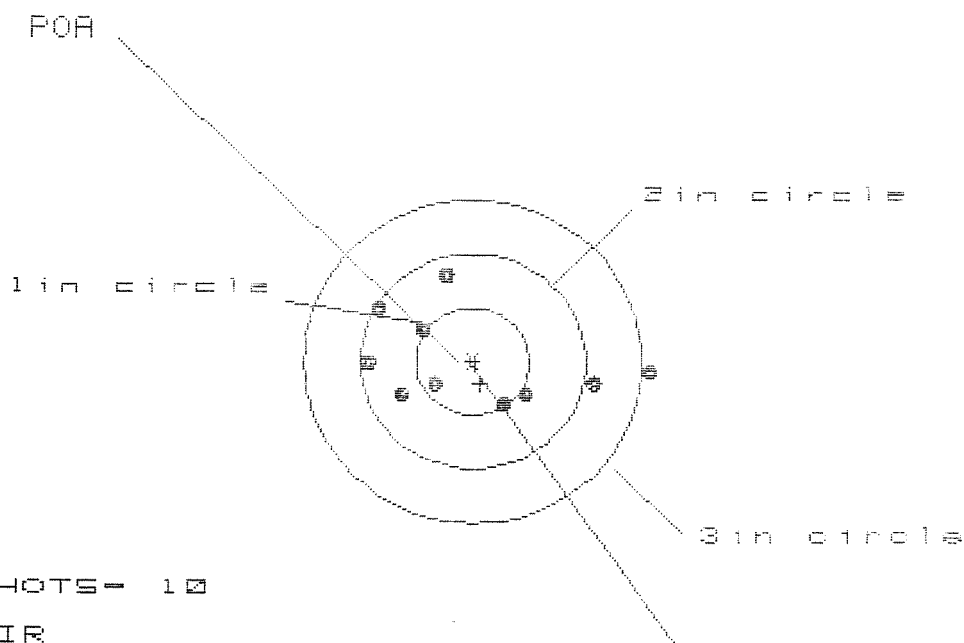
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.602	.585	.556
MINIMUM X	:	-.455	-.472	-.501
MAXIMUM Y	:	1.341	.767	.627
MINIMUM Y	:	-1.272	-1.123	-.938
CENTROID X	:	-.060	-.043	-.014
CENTROID Y	:	.191	.042	.182
POA TO CENTROID in.	:	.200	.060	.183
MIN RADIUS	:	.140	.213	.186
MEAN RADIUS	:	.736	.670	.594
MAX RADIUS	:	1.349	1.147	.938
HORIZONTAL SPREAD	:	1.057	1.057	1.057
VERTICAL SPREAD	:	2.613	1.890	1.565
EXTREME SPREAD	:	2.614	1.911	1.570
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

15 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348743

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.478

VS = 1.202

GS = 2.482

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.548	1.188	.818
MINIMUM X	:	-.930	-.758	-.609
MAXIMUM Y	:	.810	.795	.771
MINIMUM Y	:	-.392	-.407	-.431
CENTROID X	:	-.066	-.238	-.387
CENTROID Y	:	.200	.215	.239
POA TO CENTROID in.	:	.211	.321	.455
MIN RADIUS	:	.394	.291	.279
MEAN RADIUS	:	.803	.688	.595
MAX RADIUS	:	1.554	1.204	.894
HORIZONTAL SPREAD	:	2.478	1.946	1.427
VERTICAL SPREAD	:	1.202	1.202	1.202
EXTREME SPREAD	:	2.482	1.982	1.571
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6348743

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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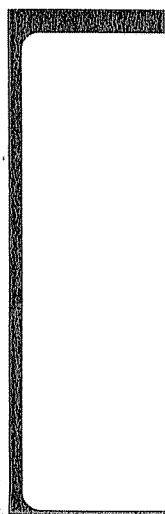


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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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