

C6636259

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

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

**MODEL 700™ H24**

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

**DUPONT**

**SERIAL NO. C6636259**

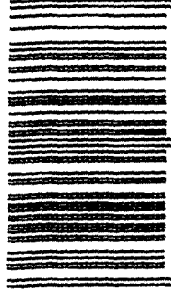
**ORDER NO. 5716**

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



5716 C6636259

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

**C 6636259**

| OP. #        | OP. NAME                                                       | READINGS                                                                                                  | DATE         | INIT |
|--------------|----------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|--------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | <div style="border: 1px solid black; padding: 10px; text-align: center;"> <b>QUALITY<br/>AUDIT</b> </div> | 6/24/91      | KA   |
| 600          | Proof                                                          |                                                                                                           | 6/26/91      | KA   |
| 607          | Check Headspace                                                |                                                                                                           | 6/26/91      | KA   |
| 610          | Dis-assemble Gun                                               |                                                                                                           | 6/26/91      | KA   |
| 612          | Magnaflux Barrel<br>Action                                     |                                                                                                           | JUL 1 8 1991 | GS   |
|              | Magnaflux Bolt                                                 |                                                                                                           | JUL 1 8 1991 | GS   |
| 615          | Rollmark Caliber                                               |                                                                                                           | JUL 1 8 1991 | GS   |
| 617          | Drill and Tap Sight Holes                                      |                                                                                                           | JUL 8 1991   | FB   |
| 618          | Polish Barrel                                                  |                                                                                                           | JUL 20 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |                                                                                                           | 8-7-91       | AS   |
|              | Apply Coating (Bolt)                                           |                                                                                                           |              |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |                                                                                                           | 8/22/91      | KA   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |                                                                                                           | 8/22/91      | KA   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |                                                                                                           | 8/22/91      | KA   |
|              | D) Oil Firing Pin Ass'y                                        |                                                                                                           | 8/22/91      | KA   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |                                                                                                           | 8/22/91      | KA   |

| op. #        | BARBER - M24 0032322<br>OP. NAME                            | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 8-26-91 | DH   |
|              | G) Safety Off Force                                         | 2 1/4    | 2    | 2    |      |      | 8-26-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8/24/91 | JU   |
|              | I) Firing Pin Indent                                        | .020     | .020 | .021 |      |      | 8-26-91 | DH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8/27/91 | KK   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 9-13-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8/27/91 | KK   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8/27/91 | KK   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8/27/91 | KK   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8/27/91 | KK   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8/27/91 | KK   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-27-91 | NF   |
|              | A) Time                                                     |          |      |      |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-27-91 | NF   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 9-13-91 | AC   |
|              | B) Trigger Pull                                             | 2.20     | 2.25 | 2.15 | 2.18 | 2.22 | 9/13/91 | JU   |
|              | C) Function                                                 |          |      |      |      |      | 9-13-91 | AC   |
| 660          | Pack                                                        |          |      |      |      |      | 9-17-91 | DH   |

| TEST INIT. ACTION TO CORRECT |                           | ASSEM.<br># |
|------------------------------|---------------------------|-------------|
| PROOF                        | <b>100 Rk<br/>Test OK</b> |             |
| TEST                         |                           |             |
| TGT                          |                           |             |
| PROOF                        | <b>9-13-91<br/>A.C.</b>   |             |
| TEST                         |                           |             |
| TGT                          |                           |             |
| PROOF                        | ENGINEER                  |             |
| TEST                         |                           |             |
| TGT                          |                           |             |
| PROOF                        | ENGINEER                  |             |
| TEST                         |                           |             |
| TGT                          |                           |             |

| MOD. _____ |         | GA.<br>CAL. _____                             | GUN<br># <u>6259</u> |
|------------|---------|-----------------------------------------------|----------------------|
| #<br>TEST  | DATE    | MALFUNCTION/DEFECT                            | ASSEM.<br>#          |
| ✓          | 1st     | Ejector sticking                              | KS                   |
|            | 8/27    |                                               |                      |
|            | 2nd     | REAMED<br>EJECTOR HOLE<br>POLISHED<br>EJECTOR | KS                   |
|            | 8/27/91 |                                               |                      |
|            | 3rd     |                                               |                      |
|            | 4th     |                                               |                      |
|            |         | FUNCTION                                      | RD 6654 Rev 1        |

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

SERIAL NO. C6636259DATE 8-24-91TESTER JU.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.31             | 2.34                     | 2.50                           | 2.20 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.46             | 2.28                     | 2.44                           | 2.25 |                                                                        |
| PULL #3 | 2.18             | 2.32                     | 2.42                           | 2.15 |                                                                        |
| PULL #4 | 2.44             | 2.54                     | 2.53                           | 2.18 |                                                                        |
| PULL #5 | 2.40             | 2.54                     | 2.55                           | 2.22 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.34             | 3.27                     |  |          |
| PULL #2 | 3.20             | 3.36                     |  |          |
| PULL #3 | 3.59             | 3.49                     |  |          |
| PULL #4 | 3.40             | 3.46                     |  |          |
| PULL #5 | 3.26             | 3.54                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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 | 4.56             | 4.53                     |                                | 4.41                                 |
| PULL #2 | 4.46             | 4.40                     |                                | 4.41                                 |
| PULL #3 | 4.41             | 4.45                     |                                | 4.48                                 |
| PULL #4 | 4.58             | 4.49                     |                                | 4.34                                 |
| PULL #5 | 4.54             | 4.39                     |                                | 4.47                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06636259  
27 Aug 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0940319 |
| 1 TO | 2 | .3588883 |
| 1 TO | 3 | .66751   |
| 1 TO | 4 | .12243   |
| 1 TO | 5 | .0731095 |

3  
4 3 <----POB

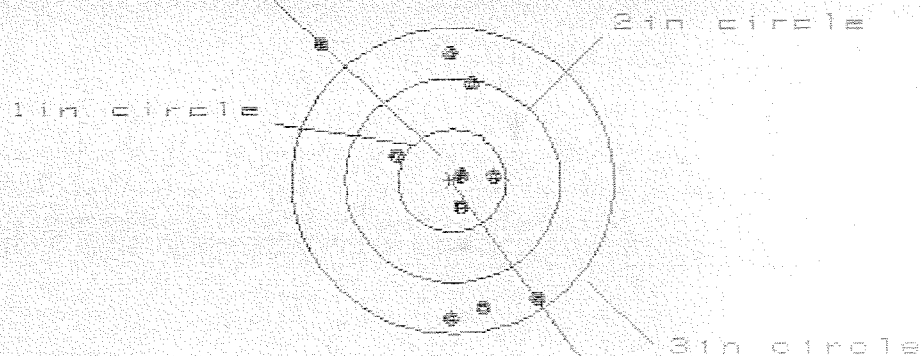
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0478  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0696  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0844334  
THE AMR FOR THIS RIFLE IS: .9492

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CBB36259

## CENTERFIRE PATTERNS # 1

POR



# OF SHOTS = 10

# IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.004

VS= 2.739

GS= 3.227

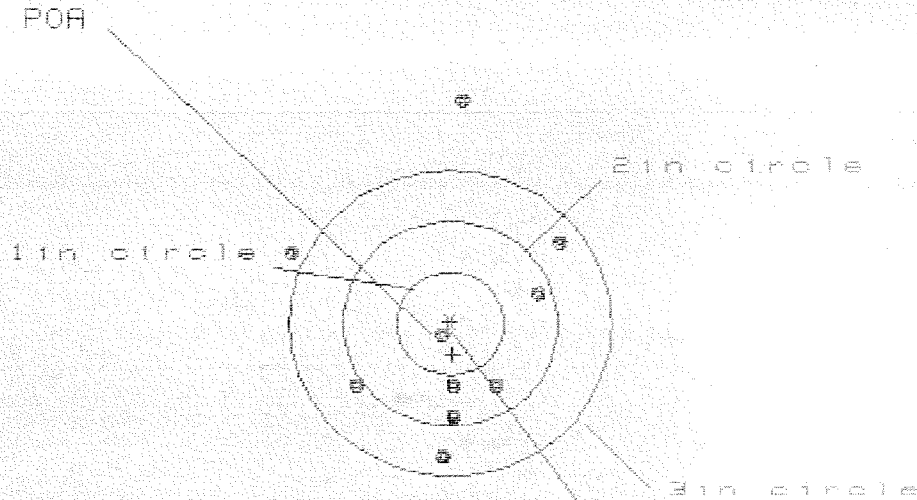
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .823   | .692   | .299   |
| MINIMUM X                     | -1.181 | -.635  | -.549  |
| MAXIMUM Y                     | 1.382  | 1.437  | 1.313  |
| MINIMUM Y                     | -1.357 | -1.204 | -1.328 |
| CENTROID X                    | -.079  | .052   | -.034  |
| CENTROID Y                    | -.051  | -.204  | -.080  |
| POR TO CENTROID in.           | .094   | .211   | .087   |
| MIN RADIUS                    | .056   | .118   | .073   |
| MEAN RADIUS                   | .929   | .828   | .757   |
| MAX RADIUS                    | 1.818  | 1.450  | 1.329  |
| HORIZONTAL SPREAD             | 2.004  | 1.327  | .848   |
| VERTICAL SPREAD               | 2.739  | 2.641  | 2.641  |
| EXTREME SPREAD                | 3.227  | 2.642  | 2.642  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/08636259

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.492

VS = 3.478

GS = 3.484

| PATTERN #                     | 2      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.015  | 1.031  | .849   |
| MINIMUM X                     | -1.477 | -1.461 | -1.011 |
| MAXIMUM Y                     | 2.221  | 1.865  | 1.184  |
| MINIMUM Y                     | -1.256 | -1.010 | -.891  |
| CENTROID X                    | -.020  | -.036  | .146   |
| CENTROID Y                    | .303   | .057   | -.062  |
| POA TO CENTROID in.           | .304   | .067   | .159   |
| MIN RADIUS                    | .144   | .139   | .291   |
| MEAN RADIUS                   | 1.068  | .870   | .733   |
| MAX RADIUS                    | 2.226  | 1.744  | 1.457  |
| HORIZONTAL SPREAD             | 2.492  | 2.492  | 1.860  |
| VERTICAL SPREAD               | 3.478  | 2.075  | 2.075  |
| EXTREME SPREAD                | 3.484  | 2.495  | 2.339  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8636259

## CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.196

VS= 2.187

CS= 2.276

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.424

1.356

1.393

MINIMUM X

-.772

-.614

-.577

MAXIMUM Y

1.293

1.293

1.025

MINIMUM Y

-.904

-.894

-.733

CENTROID X

.582

.424

.387

CENTROID Y

.042

.032

-.129

POA TO CENTROID in.

.584

.425

.408

MIN RADIUS

.563

.430

.515

MEAN RADIUS

.973

.893

.824

MAX RADIUS

1.426

1.385

1.399

HORIZONTAL SPREAD

2.196

1.970

1.970

VERTICAL SPREAD

2.187

2.187

1.758

EXTREME SPREAD

2.276

2.276

1.972

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

10

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/0663B259

## CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 1.780

VS = 2.577

CS = 2.842

| PATTERN #                     | 4      |        |       |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .861   | .759   | .795  |
| MINIMUM X                     | -.919  | -.640  | -.604 |
| MAXIMUM Y                     | 1.269  | 1.404  | 1.257 |
| MINIMUM Y                     | -1.308 | -1.173 | -.907 |
| CENTROID X                    | -.169  | -.067  | -.103 |
| CENTROID Y                    | .032   | -.103  | .044  |
| POA TO CENTROID in.           | .172   | .123   | .112  |
| MIN RADIUS                    | .287   | .134   | .283  |
| MEAN RADIUS                   | .939   | .829   | .810  |
| MAX RADIUS                    | 1.523  | 1.505  | 1.355 |
| HORIZONTAL SPREAD             | 1.780  | 1.399  | 1.399 |
| VERTICAL SPREAD               | 2.577  | 2.577  | 2.164 |
| EXTREME SPREAD                | 2.842  | 2.707  | 2.525 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |       |

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/08636259

## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.896

VS= 2.291

GS= 2.642

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.802

.739

.824

MINIMUM X

-1.094

-1.157

-1.072

MAXIMUM Y

1.368

1.015

.918

MINIMUM Y

-.923

-.771

-.837

CENTROID X

-.075

-.012

-.097

CENTROID Y

.022

-.130

-.033

POA TO CENTROID in.

.078

.130

.103

MIN RADIUS

.208

.277

.177

MEAN RADIUS

.837

.747

.701

MAX RADIUS

1.482

1.158

1.116

HORIZONTAL SPREAD

1.896

1.896

1.996

VERTICAL SPREAD

2.291

1.786

1.755

EXTREME SPREAD

2.642

2.090

2.090

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10