

C6636018

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
 MODEL 700™ M24

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

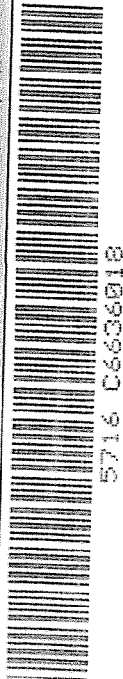
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
 C6636018

ORDER NO.
 5716

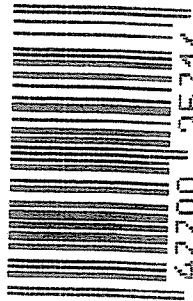
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636018

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636018

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	5 6 9 1		Kcd
	Magnaflux Bolt	5 6 9 1		Kcd
615	Rollmark Caliber			GB
617	Drill and Tap Sight Holes	5 10 9 1		LB
618	Polish Barrel	5 10 9 1		WB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	JF

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	5 3/4	5 3/4			6/8/91	WLB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			6/8/91	WLB
	H) Trigger Pull Test & Retainability						6-7-91	JH
	I) Firing Pin Indent	.0215	.021	.021			6/8/91	WLB
	J) Assemble Stock						6/8/91	RW
	K) Assemble Swivel Studs						6-12-91	L
	L) Attach Front and Rear Sight Assemblies						6/8/91	RW
	M) Iron Sight Alignment						6/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/8/91	RW
	O) Attach Scope to Rifle						6/8/91	RW
	P) Detach & Attach Scope 20 Times						6/8/91	RW
640	Gallery Target & Test						6-8-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-8-91	AF
655	Final Inspection							
	A) Headspace						6-12-91	L
	B) Trigger Pull	2.32	2.32	2.31	2.33	2.35	6-12-91	JPP
	C) Function						6-12-91	J
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636018

DATE 6-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.30	2.36	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.32	2.44	2.32	
PULL #3	2.28	2.27	2.28	2.31	
PULL #4	2.25	2.31	2.27	2.33	
PULL #5	2.31	2.27	2.28	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.52		
PULL #2	3.49	3.37		
PULL #3	3.52	3.15		
PULL #4	3.46	3.34		
PULL #5	3.54	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.29		4.38
PULL #2	4.40	4.42		4.25
PULL #3	4.41	4.44		4.35
PULL #4	4.47	4.22		4.26
PULL #5	4.45	4.33		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636018
8 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.145866
1 TO	2	.338904
1 TO	3	.1264
1 TO	4	.28764
1 TO	5	.366674

<----POA

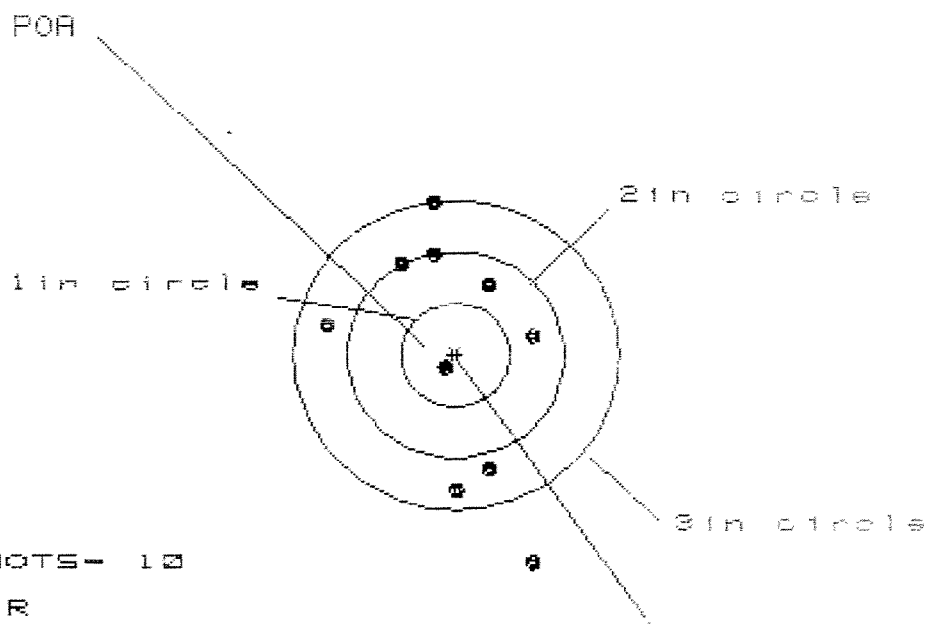
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0757937
THE AMR FOR THIS RIFLE IS: 1.049

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS636018

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 1.908

VS= 3.528

GS= 3.648

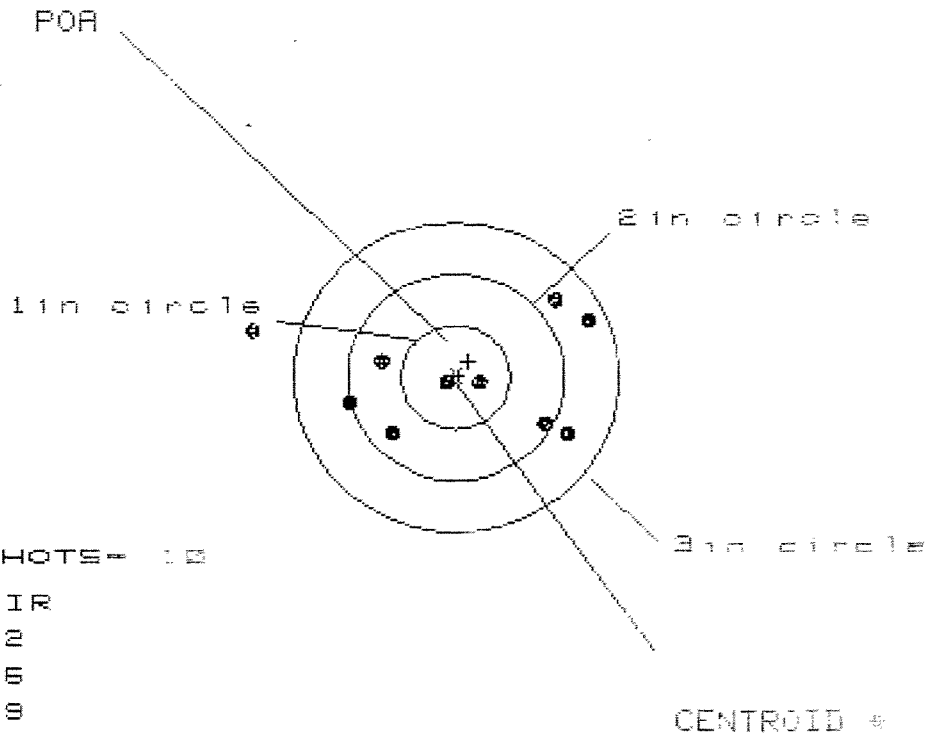
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.750	.831	.816
MINIMUM X	-1.158	-1.077	-1.092
MAXIMUM Y	1.528	1.306	.996
MINIMUM Y	-2.000	-1.563	-1.400
CENTROID X	.091	.010	.025
CENTROID Y	.114	.336	.172
POA TO CENTROID in.	.145	.336	.174
MIN RADIUS	.121	.315	.152
MEAN RADIUS	1.101	.958	.910
MAX RADIUS	2.120	1.564	1.401
HORIZONTAL SPREAD	1.908	1.908	1.908
VERTICAL SPREAD	3.528	2.869	2.285
EXTREME SPREAD	3.648	2.875	2.289
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636002

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 3.124

VS= 1.309

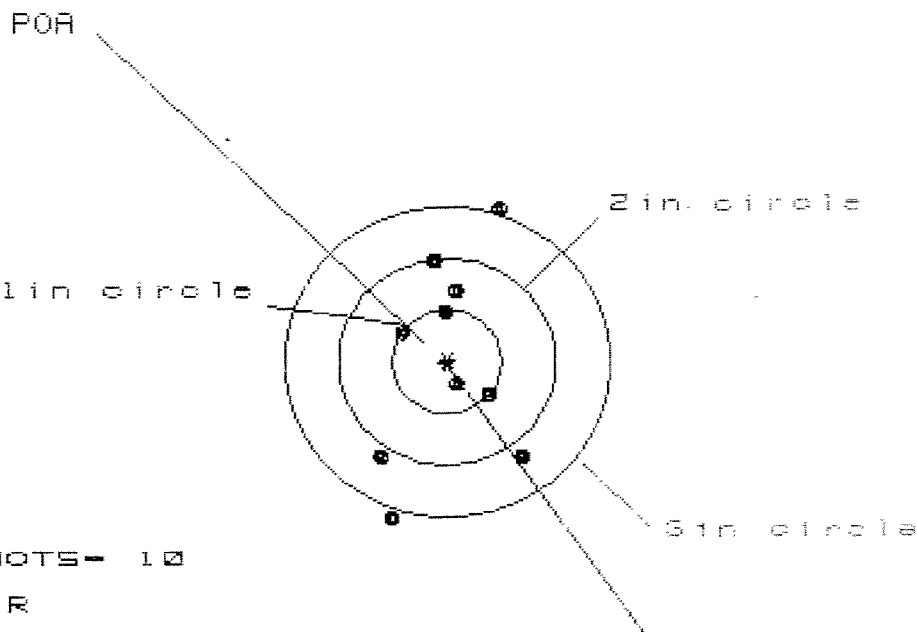
GS= 3.126

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.215	1.003	.892
MINIMUM X	:	-1.909	-1.161	-1.036
MAXIMUM Y	:	.719	.772	.851
MINIMUM Y	:	-.590	-.537	-.458
CENTROID X	:	-.119	.093	-.032
CENTROID Y	:	-.152	-.205	-.284
POA TO CENTROID in.	:	.193	.226	.265
MIN RADIUS	:	.125	.043	.167
MEAN RADIUS	:	.932	.800	.743
MAX RADIUS	:	1.968	1.185	1.199
HORIZONTAL SPREAD	:	3.124	2.164	1.928
VERTICAL SPREAD	:	1.309	1.309	1.309
EXTREME SPREAD	:	3.126	2.329	2.133
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

B Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS636018

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 1.350

VS= 3.051

GS= 3.213

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.653	.702
MINIMUM X	:	-.636	-.697	-.646
MAXIMUM Y	:	1.505	1.333	.944
MINIMUM Y	:	-1.546	-1.090	-.923
CENTROID X	:	.015	.076	.027
CENTROID Y	:	.013	.185	.010
POA TO CENTROID in.	:	.019	.200	.033
MIN RADIUS	:	.274	.299	.275
MEAN RADIUS	:	.889	.787	.708
MAX RADIUS	:	1.642	1.390	1.144
HORIZONTAL SPREAD	:	1.350	1.350	1.250
VERTICAL SPREAD	:	3.051	2.423	1.867
EXTREME SPREAD	:	3.213	2.656	2.008
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636010

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.666

VS= 3.251

GS= 3.763

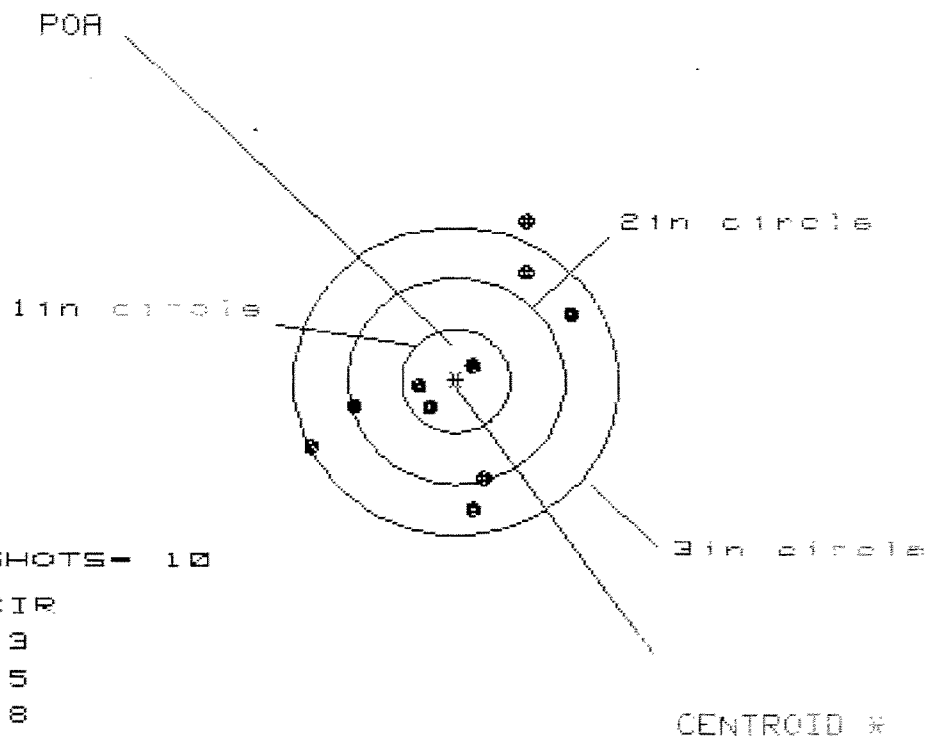
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.625	1.374	1.363
MINIMUM X	:	-1.041	-0.860	-0.871
MAXIMUM Y	:	1.815	1.656	1.517
MINIMUM Y	:	-1.435	-1.156	-0.949
CENTROID X	:	.010	-.171	-.160
CENTROID Y	:	-.162	-.002	-.209
POA TO CENTROID in.	:	.162	.171	.263
MIN RADIUS	:	.876	.839	.708
MEAN RADIUS	:	1.320	1.210	1.124
MAX RADIUS	:	2.169	1.658	1.527
HORIZONTAL SPREAD	:	2.666	2.234	2.234
VERTICAL SPREAD	:	3.251	2.812	2.466
EXTREME SPREAD	:	3.763	2.880	2.661
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636018

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.483

VS= 2.872

GS= 3.076

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.103	1.180	1.017
MINIMUM X	-1.300	-1.303	-1.058
MAXIMUM Y	1.588	1.259	1.196
MINIMUM Y	-1.284	-1.108	-1.171
CENTROID X	-.156	-.233	-.070
CENTROID Y	-.157	-.333	-.270
POA TO CENTROID in.	.221	.407	.279
MIN RADIUS	.223	.231	.285
MEAN RADIUS	1.005	.898	.850
MAX RADIUS	1.733	1.470	1.736
HORIZONTAL SPREAD	2.483	2.483	2.075
VERTICAL SPREAD	2.872	2.367	2.367
EXTREME SPREAD	3.076	2.805	2.430
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636018
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0404599
1 TO	2	.333065
1 TO	3	.499973
1 TO	4	.256726
1 TO	5	.113741

t^2_3 <----POA

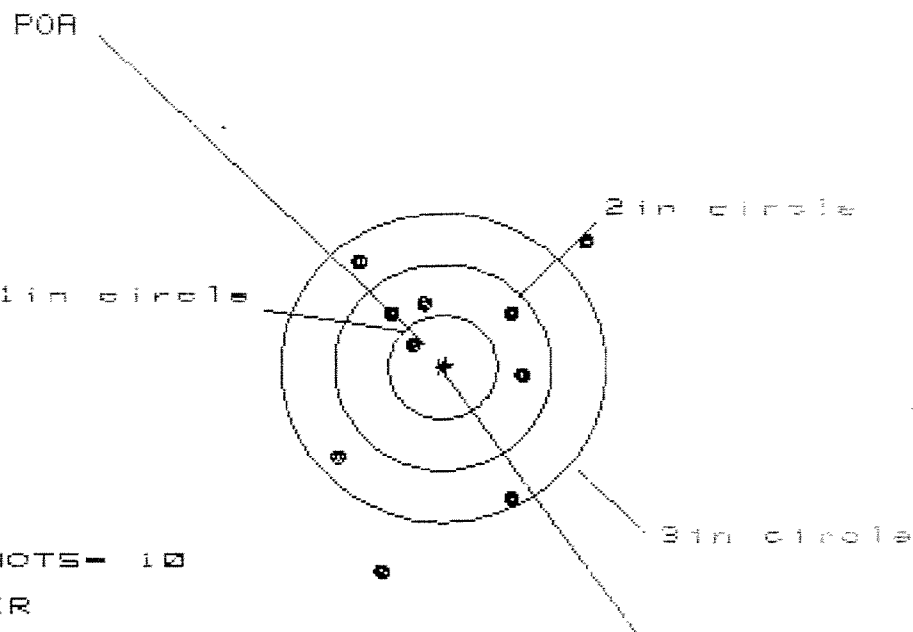
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1858
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .186137

THE AMR FOR THIS RIFLE IS: .8526

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636018.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.323

VS= 3.162

GS= 3.673

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.312	1.250	.797
MINIMUM X	-1.011	-1.073	-.917
MAXIMUM Y	1.185	.965	.895
MINIMUM Y	-1.977	-1.447	-1.326
CENTROID X	-.031	.031	-.125
CENTROID Y	-.026	.194	.074
POA TO CENTROID in.	.040	.197	.145
MIN RADIUS	.356	.361	.225
MEAN RADIUS	1.105	.955	.859
MAX RADIUS	2.054	1.579	1.523
HORIZONTAL SPREAD	2.323	2.323	1.714
VERTICAL SPREAD	3.162	2.412	2.222
EXTREME SPREAD	3.673	3.074	2.658
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06695018 1

CENTERFIRE PATTERNS

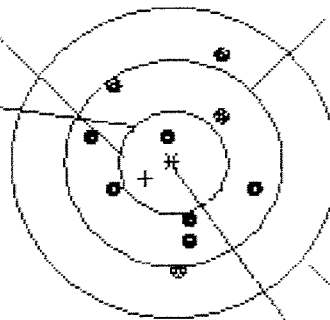
2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.534

VS= 2.058

GS= 2.101

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.733	.785	.796
MINIMUM X	:	-.801	-.749	-.738
MAXIMUM Y	:	1.043	.882	.769
MINIMUM Y	:	-1.015	-.899	-.725
CENTROID X	:	.253	.201	.190
CENTROID Y	:	.148	.032	.145
POA TO CENTROID in.	:	.293	.204	.239
MIN RADIUS	:	.304	.406	.293
MEAN RADIUS	:	.750	.697	.664
MAX RADIUS	:	1.142	.997	.893
HORIZONTAL SPREAD	:	1.534	1.534	1.534
VERTICAL SPREAD	:	2.058	1.781	1.494
EXTREME SPREAD	:	2.101	1.866	1.634
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636010.1

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 5

2 in - 7

3 in - 10

HS= 2.049

VS= 2.069

GS= 2.374

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.290	.468
MINIMUM X	:	-.841	-.759	-.598
MAXIMUM Y	:	1.102	.801	.751
MINIMUM Y	:	-.967	-.844	-.894
CENTROID X	:	.442	.360	.199
CENTROID Y	:	-.188	-.311	-.261
POA TO CENTROID in.	:	.480	.475	.328
MIN RADIUS	:	.078	.084	.179
MEAN RADIUS	:	.657	.558	.461
MAX RADIUS	:	1.324	1.350	.968
HORIZONTAL SPREAD	:	2.049	2.049	1.956
VERTICAL SPREAD	:	2.069	1.645	1.645
EXTREME SPREAD	:	2.374	2.374	1.216
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836018.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.001

VS= 1.949

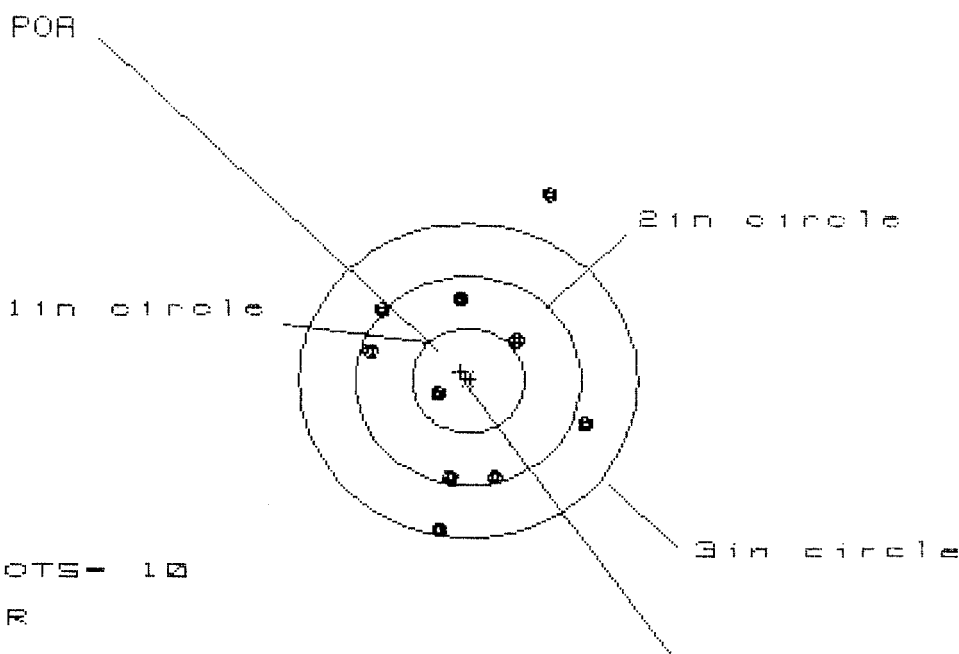
GS= 2.459

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	1.027	.985
MINIMUM X	:	-1.051	-.974	-.685
MAXIMUM Y	:	1.283	1.071	1.033
MINIMUM Y	:	-.666	-.523	-.561
CENTROID X	:	.197	.120	.241
CENTROID Y	:	.092	-.051	-.013
POA TO CENTROID in.	:	.217	.130	.242
MIN RADIUS	:	.251	.348	.221
MEAN RADIUS	:	.757	.659	.601
MAX RADIUS	:	1.460	1.210	1.240
HORIZONTAL SPREAD	:	2.001	2.001	1.591
VERTICAL SPREAD	:	1.949	1.594	1.594
EXTREME SPREAD	:	2.459	2.023	1.921
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636018.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.856

VS= 3.195

GS= 3.339

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	1.067	1.044
MINIMUM X	:	-.868	-.789	-.812
MAXIMUM Y	:	1.790	.931	.780
MINIMUM Y	:	-1.405	-1.206	-.893
CENTROID X	:	.068	-.011	.012
CENTROID Y	:	-.082	-.281	-.130
POA TO CENTROID in.	:	.106	.281	.130
MIN RADIUS	:	.314	.190	.241
MEAN RADIUS	:	.994	.868	.817
MAX RADIUS	:	1.926	1.220	1.112
HORIZONTAL SPREAD	:	1.856	1.856	1.856
VERTICAL SPREAD	:	3.195	2.137	1.673
EXTREME SPREAD	:	3.339	2.143	2.077
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	