

06498841

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\* Includes 1 in chamber.

*Remington*

*Still  
Smiling.*

**Remington**  
MODEL 700™ M24

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

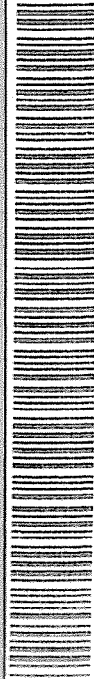
**DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.  
C6498841

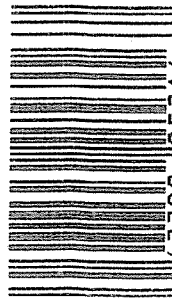
ORDER NO.  
5716

31



5716 C6498841

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6498841  
31 Jul 1990

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .243526  |
| 1 TO | 2 | .298811  |
| 1 TO | 3 | .154263  |
| 1 TO | 4 | .174642  |
| 1 TO | 5 | .0770065 |

$\pm_2$  <----POA

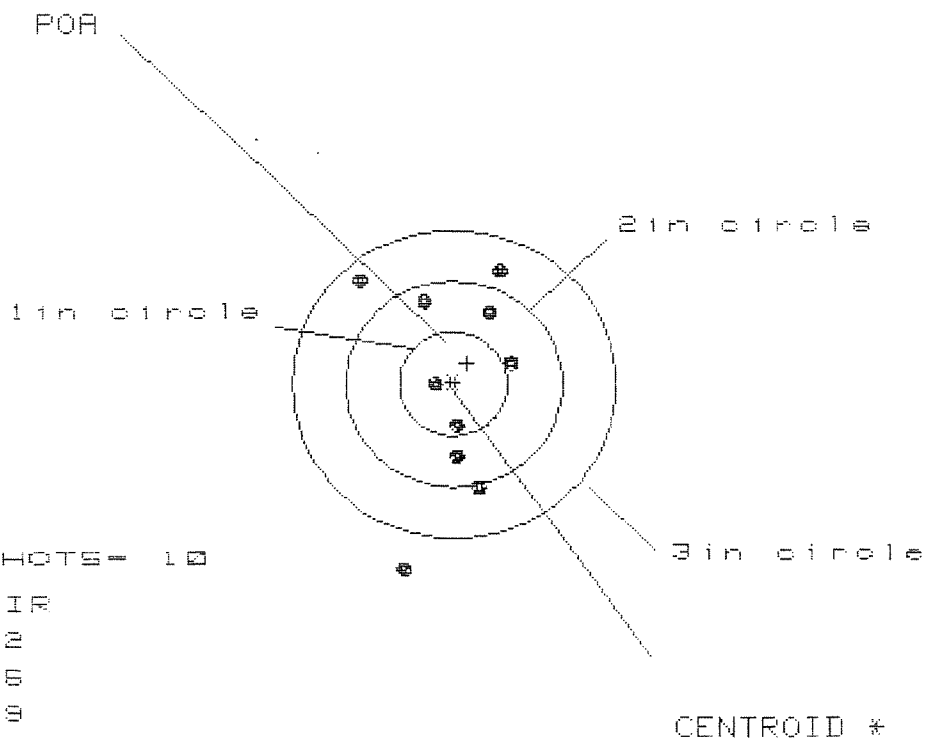
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0972  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2724  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .289222

THE AMR FOR THIS RIFLE IS: .814

31 Jul 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/CS49B841

## CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.352

VS= 2.914

GS= 3.048

CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .483   | .434   | .320   |
| MINIMUM X                     | -.869  | -.918  | -.383  |
| MAXIMUM Y                     | 1.111  | .910   | 1.014  |
| MINIMUM Y                     | -1.803 | -1.241 | -1.137 |
| CENTROID X                    | -.133  | -.084  | .030   |
| CENTROID Y                    | -.204  | -.003  | -.107  |
| POR TO CENTROID in.           | .243   | .084   | .111   |
| MIN RADIUS                    | .188   | .280   | .334   |
| MEAN RADIUS                   | .886   | .767   | .697   |
| MAX RADIUS                    | 1.856  | 1.258  | 1.141  |
| HORIZONTAL SPREAD             | 1.352  | 1.352  | .703   |
| VERTICAL SPREAD               | 2.914  | 2.151  | 2.151  |
| EXTREME SPREAD                | 3.048  | 2.358  | 2.160  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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## CENTERFIRE PATTERNS

# 2

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.349

VS = 2.097

GS = 2.117

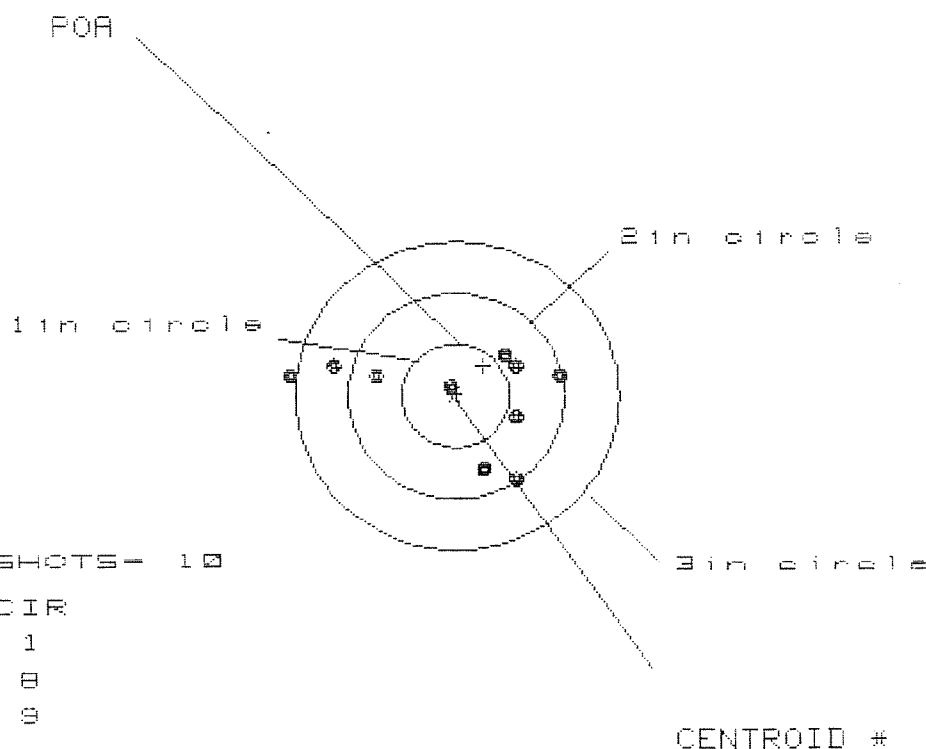
CENTROID \*

| PATTERN #                   | : | 2      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .605   | .616  | .524  |
| MINIMUM X                   | : | -.744  | -.733 | -.825 |
| MAXIMUM Y                   | : | .905   | .772  | .849  |
| MINIMUM Y                   | : | -1.192 | -.901 | -.825 |
| CENTROID X                  | : | .165   | .154  | .246  |
| CENTROID Y                  | : | -.226  | -.093 | -.169 |
| POA TO CENTROID in.         | : | .280   | .180  | .299  |
| MIN RADIUS                  | : | .070   | .184  | .168  |
| MEAN RADIUS                 | : | .725   | .675  | .624  |
| MAX RADIUS                  | : | 1.197  | .987  | .962  |
| HORIZONTAL SPREAD           | : | 1.349  | 1.349 | 1.349 |
| VERTICAL SPREAD             | : | 2.097  | 1.673 | 1.673 |
| EXTREME SPREAD              | : | 2.117  | 1.858 | 1.858 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 8

3in = 9

HS= 2.498

VS= 1.188

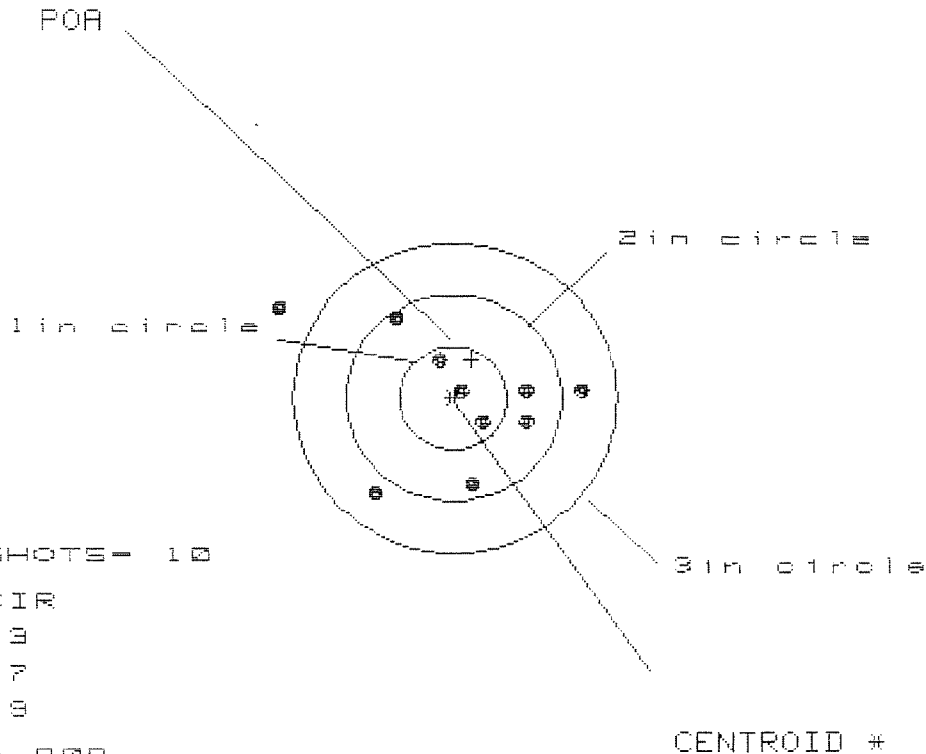
GS= 2.498

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .946   | .773   | .615   |
| MINIMUM X                   | : | -1.552 | -1.265 | -1.074 |
| MAXIMUM Y                   | : | .414   | .439   | .474   |
| MINIMUM Y                   | : | -.774  | -.749  | -.714  |
| CENTROID X                  | : | -.259  | -.086  | .072   |
| CENTROID Y                  | : | -.293  | -.318  | -.353  |
| POA TO CENTROID in.         | : | .391   | .330   | .360   |
| MIN RADIUS                  | : | .108   | .242   | .296   |
| MEAN RADIUS                 | : | .817   | .705   | .603   |
| MAX RADIUS                  | : | 1.569  | 1.295  | 1.105  |
| HORIZONTAL SPREAD           | : | 2.498  | 2.038  | 1.689  |
| VERTICAL SPREAD             | : | 1.188  | 1.188  | 1.188  |
| EXTREME SPREAD              | : | 2.498  | 2.039  | 1.689  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.809

VS= 1.884

GS= 2.923

| PATTERN #                   | : | 4      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.191  | 1.011 | .896  |
| MINIMUM X                   | : | -1.618 | -.917 | -.844 |
| MAXIMUM Y                   | : | .916   | .885  | .777  |
| MINIMUM Y                   | : | -.968  | -.866 | -.832 |
| CENTROID X                  | : | -.173  | .007  | .122  |
| CENTROID Y                  | : | -.374  | -.476 | -.368 |
| POA TO CENTROID in.         | : | .412   | .476  | .388  |
| MIN RADIUS                  | : | .109   | .154  | .215  |
| MEAN RADIUS                 | : | .827   | .673  | .587  |
| MAX RADIUS                  | : | 1.860  | 1.261 | 1.147 |
| HORIZONTAL SPREAD           | : | 2.809  | 1.928 | 1.740 |
| VERTICAL SPREAD             | : | 1.884  | 1.751 | 1.609 |
| EXTREME SPREAD              | : | 2.923  | 2.207 | 1.867 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.561

VS= 1.821

GS= 2.562

CENTROID #

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.214  | 1.132  | .953   |
| MINIMUM X                   | : | -1.347 | -1.429 | -1.019 |
| MAXIMUM Y                   | : | .684   | .557   | .546   |
| MINIMUM Y                   | : | -1.137 | -.600  | -.611  |
| CENTROID X                  | : | -.086  | -.004  | .175   |
| CENTROID Y                  | : | -.265  | -.138  | -.127  |
| POA TO CENTROID in.         | : | .278   | .138   | .216   |
| MIN RADIUS                  | : | .250   | .185   | .098   |
| MEAN RADIUS                 | : | .815   | .736   | .624   |
| MAX RADIUS                  | : | 1.359  | 1.432  | 1.084  |
| HORIZONTAL SPREAD           | : | 2.561  | 2.561  | 1.972  |
| VERTICAL SPREAD             | : | 1.821  | 1.157  | 1.157  |
| EXTREME SPREAD              | : | 2.562  | 2.562  | 2.010  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498841

DATE 8/22/90

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.41             | 2.30                     | 2.29                           | 2.29  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.44             | 2.11                     | 2.22                           | 2.27  |                                                                        |
| PULL #3 | 2.18             | 2.22                     | 2.23                           | 2.23  |                                                                        |
| PULL #4 | 2.34             | 2.19                     | 2.26                           | 2.33  |                                                                        |
| PULL #5 | 2.25             | 2.22                     | 2.27                           | 2.40  |                                                                        |
| TOTAL   | 11.62            | 11.04                    | 11.27                          | 11.52 |                                                                        |
| AVG.    | 2.324            | 2.208                    | 2.254                          | 2.304 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.34             | 3.34                     |  |          |
| PULL #2 | 3.25             | 3.34                     |  |          |
| PULL #3 | 3.34             | 3.28                     |  |          |
| PULL #4 | 3.28             | 3.21                     |  |          |
| PULL #5 | 3.28             | 3.29                     |  |          |
| TOTAL   | 16.49            | 16.46                    |  |          |
| AVG.    | 3.298            | 3.292                    |  |          |

|         | 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 | 4.45             | 4.34                     |                                | 4.41                                 |
| PULL #2 | 4.31             | 4.35                     |                                | 4.35                                 |
| PULL #3 | 4.28             | 4.35                     |                                | 4.30                                 |
| PULL #4 | 4.37             | 4.28                     |                                | 4.44                                 |
| PULL #5 | 4.29             | 4.30                     |                                | 4.43                                 |
| TOTAL   | 21.70            | 21.62                    |                                | 21.93                                |
| AVG.    | 4.34             | 4.324                    |                                | 4.386                                |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498841

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 5 17     | 90      | RW   |
| 600          | Proof                                                          | 5 17     | 90      | RW   |
| 607          | Check Headspace                                                | 5 17     | 90      | RW   |
| 610          | Dis-assemble Gun                                               | 5 17     | 90      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 5/22/90 | KCR  |
|              | Magnaflux Bolt                                                 |          | 5/22/90 | KCR  |
| 615          | Rollmark Caliber                                               |          | 5/22/90 | G.S. |
| 617          | Drill and Tap Sight Holes                                      |          | 5/23/90 | FB   |
| 618          | Polish Barrel RB                                               |          | 5/24/90 | W.B. |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 6/4/90  | JA   |
|              | Apply Coating (Bolt)                                           |          | 6/4/90  | JA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 6/12/90 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 6/12/90 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 6/12/90 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 6/12/90 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/22/90 | JA   |

| BARBER - M24 0008754 |                                                             | READINGS |       |       |      |      | DATE    | INIT |
|----------------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| op. #                | OP. NAME                                                    |          |       |       |      |      |         |      |
| 625<br>cont.         | F) Safety On Force                                          | 4        | 4     | 4     |      |      | 7/25/90 | JK   |
|                      | G) Safety Off Force                                         | 3        | 3     | 3     |      |      | 7/25/90 | JK   |
|                      | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/22/90 | JK   |
|                      | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 7/25/90 | JK   |
|                      | J) Assemble Stock                                           |          |       |       |      |      | 7/25/90 | RW   |
|                      | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8/29/90 | JK   |
|                      | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 7/25/90 | RW   |
|                      | M) Iron Sight Alignment                                     |          |       |       |      |      | 7/25/90 | RW   |
|                      | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 7/25/90 | RW   |
|                      | O) Attach Scope to Rifle                                    |          |       |       |      |      | 7/25/90 | RW   |
|                      | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 7/25/90 | RW   |
| 640                  | Gallery Target & Test                                       |          |       |       |      |      | 7-31-90 | AC   |
|                      | A) Time                                                     |          |       |       |      |      | 7-31-90 | AC   |
|                      | B) Malfunctions                                             |          |       |       |      |      | 7-31-90 | AC   |
|                      | C) Pierced Primers                                          |          |       |       |      |      | 7-31-90 | AC   |
|                      | D) Optical Clarity of Scope                                 |          |       |       |      |      | 7-31-90 | AC   |
| 645                  | Inspect for Live Ammo                                       |          |       |       |      |      | 7-31-90 | AC   |
| 655                  | Final Inspection                                            |          |       |       |      |      |         |      |
|                      | A) Headspace                                                |          |       |       |      |      | 8/29/90 | JK   |
|                      | B) Trigger Pull                                             | 2.24     | 2.27  | 2.23  | 2.33 | 2.40 | 8/29/90 | JK   |
|                      | C) Function                                                 |          |       |       |      |      | 8/29/90 | JK   |
| 660                  | Pack                                                        |          |       |       |      |      | 9/20/90 | NF   |