

C5498860

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

*Remington*

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498860

| OP. #     | OP. NAME                                                 | READINGS                                                                                                    | DATE    | INIT |
|-----------|----------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | <div style="border: 1px solid black; padding: 5px; display: inline-block;"> <b>QUALITY<br/>AUDIT</b> </div> | 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 Action                                  |                                                                                                             | 5/22/90 | KCR  |
|           | Magnaflux Bolt                                           |                                                                                                             | 6/22/90 | KCR  |
| 615       | Rollmark Caliber                                         |                                                                                                             | 6/22/90 | G.S. |
| 617       | Drill and Tap Sight Holes                                |                                                                                                             | 5/23/90 | F.B. |
| 618       | Polish Barrel RB                                         |                                                                                                             | 5/24/90 | W.B. |
| 620       | Apply Coatings (Barrel Action)                           |                                                                                                             | 6-4-90  | JA   |
|           | Apply Coating (Bolt)                                     |                                                                                                             |         |      |
| 625       | Final Assembly                                           |                                                                                                             |         |      |
|           | A) Clean inside of Bolt Assembly                         |                                                                                                             | 6/12/90 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                                                                                                             | 6/12/90 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |                                                                                                             | 6/12/90 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |                                                                                                             | 6/12/90 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                                                                                                             | 8/24/90 | JE   |

| BARBER - M24 0009055 |                                                             | READINGS |       |       |      |      | DATE    | INIT |
|----------------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| op. #                | OP. NAME                                                    |          |       |       |      |      |         |      |
| 625<br>cont.         | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 7/24/90 | SL   |
|                      | G) Safety Off Force                                         | 3        | 3     | 3     |      |      | 7/24/90 | SL   |
|                      | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/24/90 | SL   |
|                      | I) Firing Pin Indent                                        | .0215    | .0215 | .0215 |      |      | 7/24/90 | SL   |
|                      | J) Assemble Stock                                           |          |       |       |      |      | 8/1/90  | RW   |
|                      | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8/29/90 | SL   |
|                      | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/1/90  | RW   |
|                      | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/1/90  | RW   |
|                      | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/1/90  | RW   |
|                      | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/1/90  | RW   |
|                      | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/1/90  | RW   |
| 640                  | Gallery Target & Test                                       |          |       |       |      |      | 8-2-90  | DH   |
|                      | A) Time                                                     |          |       |       |      |      | 8-2-90  | DH   |
|                      | B) Malfunctions                                             |          |       |       |      |      | 8-2-90  | DH   |
|                      | C) Pierced Primers                                          |          |       |       |      |      | 8-2-90  | DH   |
|                      | D) Optical Clarity of Scope                                 |          |       |       |      |      | 8-2-90  | DH   |
| 645                  | Inspect for Live Ammo                                       |          |       |       |      |      | 8-2-90  | DH   |
| 655                  | Final Inspection                                            |          |       |       |      |      | 8/24/90 | SL   |
|                      | A) Headspace                                                |          |       |       |      |      | 8/24/90 | SL   |
|                      | B) Trigger Pull                                             | 2.50     | 2.21  | 2.10  | 2.50 | 2.45 | 8/24/90 | SL   |
|                      | C) Function                                                 |          |       |       |      |      | 8/24/90 | SL   |
| 660                  | Pack                                                        |          |       |       |      |      | 7/20/90 | SL   |

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

SERIAL NO. C 6498860DATE 8/24/90TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.21             | 2.34                     | 2.41                           | 2.50  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.43             | 2.39                     | 2.50                           | 2.21  |                                                                        |
| PULL #3 | 2.21             | 2.44                     | 2.23                           | 2.10  |                                                                        |
| PULL #4 | 2.38             | 2.38                     | 2.40                           | 2.50  |                                                                        |
| PULL #5 | 2.19             | 2.26                     | 2.00                           | 2.45  |                                                                        |
| TOTAL   | 11.42            | 11.81                    | 11.54                          | 11.76 |                                                                        |
| AVG.    | 2.284            | 2.362                    | 2.308                          | 2.352 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.40             | 3.26                     |  |          |
| PULL #2 | 3.18             | 3.23                     |  |          |
| PULL #3 | 3.22             | 3.11                     |  |          |
| PULL #4 | 3.03             | 3.22                     |  |          |
| PULL #5 | 3.17             | 3.40                     |  |          |
| TOTAL   | 16.00            | 16.22                    |  |          |
| AVG.    | 3.2              | 3.244                    |  |          |

|         | 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 | 4.36             | 4.27                     |                                | 4.33                                 |
| PULL #2 | 4.08             | 4.27                     |                                | 4.21                                 |
| PULL #3 | 4.49             | 4.09                     |                                | 4.29                                 |
| PULL #4 | 4.29             | 4.07                     |                                | 4.14                                 |
| PULL #5 | 4.19             | 4.17                     |                                | 4.25                                 |
| TOTAL   | 21.41            | 20.87                    |                                | 21.22                                |
| AVG.    | 4.282            | 4.174                    |                                | 4.244                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6498860  
2 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .614869 |
| 1 TO | 2 | .559064 |
| 1 TO | 3 | .644525 |
| 1 TO | 4 | .853197 |
| 1 TO | 5 | .271118 |

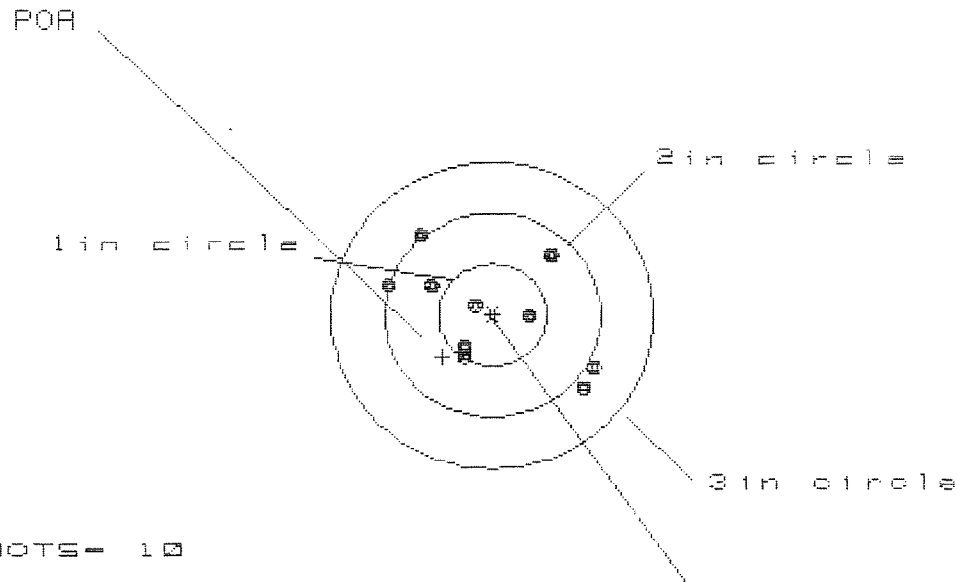
+  $\frac{1}{5}$  (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4914  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0518  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .494123  
THE AMR FOR THIS RIFLE IS: .7814

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6438860

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.905

VS= 1.532

GS= 2.089

CENTROID \*

| PATTERN #                   | : | 1     | 9     | 8     |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .975  | .901  | .798  |
| MINIMUM X                   | : | -.930 | -.822 | -.710 |
| MAXIMUM Y                   | : | .786  | .729  | .629  |
| MINIMUM Y                   | : | -.746 | -.803 | -.585 |
| CENTROID X                  | : | .460  | .352  | .239  |
| CENTROID Y                  | : | .408  | .465  | .565  |
| POA TO CENTROID in.         | : | .615  | .583  | .614  |
| MIN RADIUS                  | : | .188  | .076  | .086  |
| MEAN RADIUS                 | : | .703  | .639  | .558  |
| MAX RADIUS                  | : | 1.100 | 1.207 | .904  |
| HORIZONTAL SPREAD           | : | 1.905 | 1.723 | 1.508 |
| VERTICAL SPREAD             | : | 1.532 | 1.532 | 1.214 |
| EXTREME SPREAD              | : | 2.089 | 2.089 | 1.534 |
| NUMBER IN ONE INCH CIRCLE   | = | 4     |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 7     |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 10    |       |       |

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C649B860

## CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.642

VS= 2.137

GS= 2.238

CENTROID \*

| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.037  | 1.031  | .828   |
| MINIMUM X                   | : | -.605  | -.611  | -.482  |
| MAXIMUM Y                   | : | .902   | .765   | .666   |
| MINIMUM Y                   | : | -1.235 | -1.019 | -1.118 |
| CENTROID X                  | : | .412   | .418   | .289   |
| CENTROID Y                  | : | -.149  | -.012  | .087   |
| POA TO CENTROID in.         | : | .439   | .418   | .302   |
| MIN RADIUS                  | : | .301   | .417   | .324   |
| MEAN RADIUS                 | : | .838   | .776   | .686   |
| MAX RADIUS                  | : | 1.236  | 1.301  | 1.211  |
| HORIZONTAL SPREAD           | : | 1.642  | 1.642  | 1.310  |
| VERTICAL SPREAD             | : | 2.137  | 1.784  | 1.784  |
| EXTREME SPREAD              | : | 2.238  | 2.238  | 1.946  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/CB498860

## CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.628

VS= 1.516

GS= 2.633

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.299  | .847   | .699  |
| MINIMUM X                   | : | -1.329 | -1.184 | -.742 |
| MAXIMUM Y                   | : | .560   | .614   | .662  |
| MINIMUM Y                   | : | -.956  | -.902  | -.854 |
| CENTROID X                  | : | .517   | .372   | .521  |
| CENTROID Y                  | : | -.234  | -.288  | -.336 |
| POA TO CENTROID in.         | : | .567   | .471   | .620  |
| MIN RADIUS                  | : | .156   | .104   | .089  |
| MEAN RADIUS                 | : | .773   | .710   | .618  |
| MAX RADIUS                  | : | 1.388  | 1.245  | 1.131 |
| HORIZONTAL SPREAD           | : | 2.628  | 2.031  | 1.440 |
| VERTICAL SPREAD             | : | 1.516  | 1.516  | 1.516 |
| EXTREME SPREAD              | : | 2.633  | 2.039  | 1.908 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/06498860

## CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.915

VS= 1.812

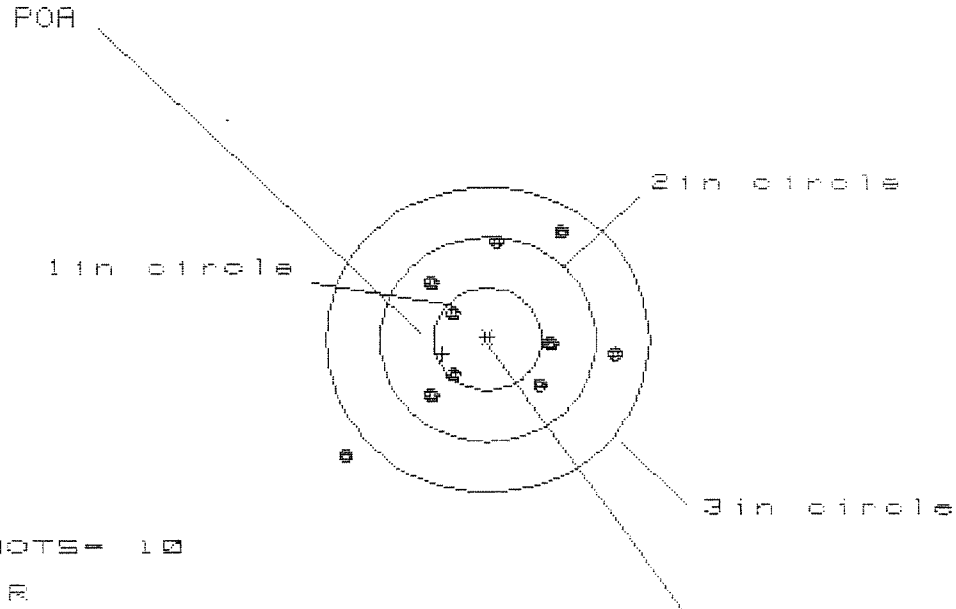
GS= 2.280

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .640   | .371   | .220  |
| MINIMUM X                   | : | -1.275 | -1.203 | -.545 |
| MAXIMUM Y                   | : | .623   | .490   | .480  |
| MINIMUM Y                   | : | -1.190 | -.935  | -.945 |
| CENTROID X                  | : | .649   | .577   | .728  |
| CENTROID Y                  | : | -.424  | -.291  | -.281 |
| POA TO CENTROID in.         | : | .775   | .647   | .780  |
| MIN RADIUS                  | : | .367   | .302   | .205  |
| MEAN RADIUS                 | : | .719   | .616   | .513  |
| MAX RADIUS                  | : | 1.351  | 1.206  | .955  |
| HORIZONTAL SPREAD           | : | 1.915  | 1.574  | .765  |
| VERTICAL SPREAD             | : | 1.812  | 1.425  | 1.425 |
| EXTREME SPREAD              | : | 2.280  | 1.716  | 1.437 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/CG498888

## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.468

VS= 2.197

GS= 2.961

| PATTERN #                   | : | 5      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.167  | 1.022 | 1.090 |
| MINIMUM X                   | : | -1.301 | -.673 | -.605 |
| MAXIMUM Y                   | : | 1.032  | .902  | .948  |
| MINIMUM Y                   | : | -1.165 | -.716 | -.603 |
| CENTROID X                  | : | .419   | .564  | .496  |
| CENTROID Y                  | : | .140   | .270  | .157  |
| POA TO CENTROID in.         | : | .442   | .625  | .520  |
| MIN RADIUS                  | : | .369   | .449  | .425  |
| MEAN RADIUS                 | : | .874   | .773  | .721  |
| MAX RADIUS                  | : | 1.747  | 1.064 | 1.105 |
| HORIZONTAL SPREAD           | : | 2.468  | 1.695 | 1.695 |
| VERTICAL SPREAD             | : | 2.197  | 1.618 | 1.551 |
| EXTREME SPREAD              | : | 2.961  | 2.022 | 1.818 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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

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

**MODEL 700™ H24**

**SERIAL NO.**  
C6498860

**ORDER NO.**  
5716

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

Q1

5716 C6498860

**UPC**

0 47700 25716 7