

C6594651

MODEL 700™ M24

Model **SMS**

™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

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

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

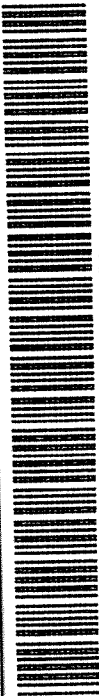
**MODEL 700™ H24**

**SERIAL NO. C6594651**

**ORDER NO. 5716**

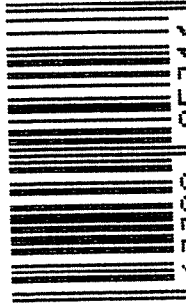
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6594651

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6594651**

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 1/15/91 | KS   |
| 600       | Proof                                                    |          | 1/15/91 | KS   |
| 607       | Check Headspace                                          |          | 1/15/91 | KS   |
| 610       | Dis-assemble Gun                                         |          | 1/15/91 | KS   |
| 612       | Magnaflux Barrel Action                                  | 1 18 91  |         | KR   |
|           | Magnaflux Bolt                                           | 1 18 91  |         | KR   |
| 615       | Rollmark Caliber                                         | 1 18 91  |         | 28   |
| 617       | Drill and Tap Sight Holes                                | 1 24 91  |         | EB   |
| 618       | Polish Barrel                                            | 1 24 91  |         | WOB  |
| 620       | Apply Coatings (Barrel Action)                           |          | 2-15-91 | TH   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 3/8/91  | KA   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 3/8/91  | KA   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 3/8/91  | KA   |
|           | D) Oil Firing Pin Ass'y                                  |          | 3/8/91  | KA   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 4/1/91  | KA   |

| op. #        | BARBER - M24 0021107<br>OP. NAME                            | READINGS                 |      |      |      |      | DATE    | INIT   |
|--------------|-------------------------------------------------------------|--------------------------|------|------|------|------|---------|--------|
| 625<br>cont. | F) Safety On Force                                          | 5                        | 5    | 5    |      |      | 4/1/91  | JP     |
|              | G) Safety Off Force                                         | 4                        | 4    | 4    |      |      | 4/1/91  | JP     |
|              | H) Trigger Pull Test & Retainability                        |                          |      |      |      |      | 4/1/91  | JP     |
|              | I) Firing Pin Indent                                        | .021                     | .020 | .021 |      |      | 4/1/91  | JP     |
|              | J) Assemble Stock                                           |                          |      |      |      |      | 4/2/91  | KS     |
|              | K) Assemble Swivel Studs                                    |                          |      |      |      |      | 4-8-91  | N/H    |
|              | L) Attach Front and Rear Sight Assemblies                   |                          |      |      |      |      | 4/2/91  | KS     |
|              | M) Iron Sight Alignment                                     |                          |      |      |      |      | 4/2/91  | KS     |
|              | N) Detach Front & Rear Sights & place in numbered container |                          |      |      |      |      | 4/2/91  | KS     |
|              |                                                             | O) Attach Scope to Rifle |      |      |      |      |         | 4/2/91 |
|              | P) Detach & Attach Scope 20 Times                           |                          |      |      |      |      | 4/2/91  | KS     |
| 640          | Gallery Target & Test                                       |                          |      |      |      |      | 4/3/91  | KJ     |
|              | A) Time                                                     |                          |      |      |      |      |         | KJ     |
|              | B) Malfunctions                                             |                          |      |      |      |      |         | KJ     |
|              | C) Pierced Primers                                          |                          |      |      |      |      |         | KJ     |
|              | D) Optical Clarity of Scope                                 |                          |      |      |      |      |         | KJ     |
| 645          | Inspect for Live Ammo                                       |                          |      |      |      |      | 4/3/91  | KS     |
| 655          | Final Inspection                                            |                          |      |      |      |      |         |        |
|              | A) Headspace                                                |                          |      |      |      |      | 4-8-91  | N/H    |
|              | B) Trigger Pull                                             | 2.29                     | 2.28 | 2.35 | 2.33 | 2.39 | 4/5/91  | JP     |
|              | C) Function                                                 |                          |      |      |      |      | 4-8-91  | N/H    |
| 660          | Pack                                                        |                          |      |      |      |      | 6-19-91 | NF     |

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

SERIAL NO. C6594651DATE 4/1/91TESTER JEL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.54             | 2.49                     | 2.37                           | 2.29 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.52                     | 2.36                           | 2.28 |                                                                        |
| PULL #3 | 2.45             | 2.55                     | 2.40                           | 2.35 |                                                                        |
| PULL #4 | 2.43             | 2.54                     | 2.45                           | 2.33 |                                                                        |
| PULL #5 | 2.46             | 2.37                     | 2.50                           | 2.39 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.26             | 3.31                     |  |          |
| PULL #2 | 3.37             | 3.35                     |  |          |
| PULL #3 | 3.36             | 3.38                     |  |          |
| PULL #4 | 3.34             | 3.32                     |  |          |
| PULL #5 | 3.32             | 3.34                     |  |          |
| 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 | 4.33             | 4.40                     |                                | 4.12                                 |
| PULL #2 | 4.40             | 4.43                     |                                | 4.35                                 |
| PULL #3 | 4.35             | 4.38                     |                                | 4.35                                 |
| PULL #4 | 4.36             | 4.42                     |                                | 4.30                                 |
| PULL #5 | 4.42             | 4.40                     |                                | 4.36                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6594651  
4 Apr 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .107187 |
| 1 TO | 2 | .188958 |
| 1 TO | 3 | .168962 |
| 1 TO | 4 | .144361 |
| 1 TO | 5 | .310161 |

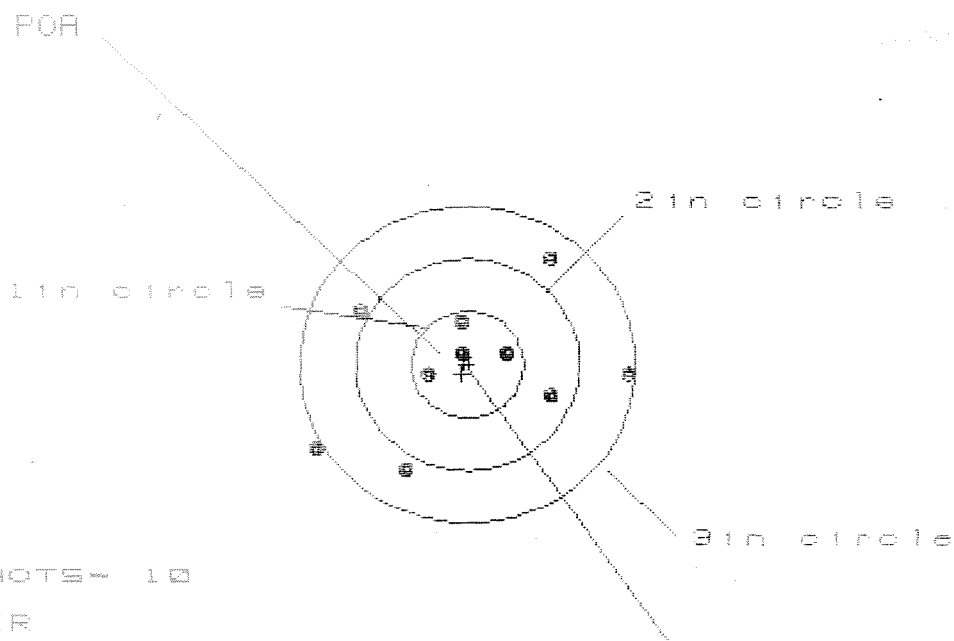
28<sup>5</sup> <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1018  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0914  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136811  
THE AMR FOR THIS RIFLE IS: .9236

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FILE:/PATTERNING/CENTERFIRE\_PATT/08534651

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.760

VS= 1.963

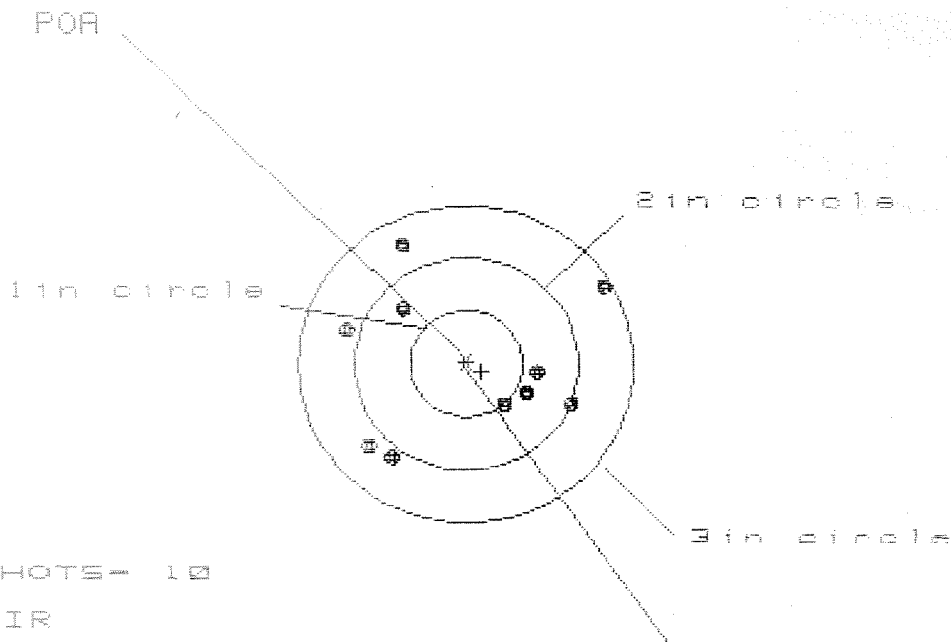
GS= 2.833

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.448  | 1.302  | .802   |
| MINIMUM X                     | -1.312 | -1.139 | -.976  |
| MAXIMUM Y                     | 1.015  | .931   | .907   |
| MINIMUM Y                     | -.948  | -1.032 | -1.056 |
| CENTROID X                    | .055   | .201   | .039   |
| CENTROID Y                    | .092   | .176   | .200   |
| POA TO CENTROID in.           | .107   | .267   | .204   |
| MIN RADIUS                    | .150   | .217   | .060   |
| MEAN RADIUS                   | .058   | .777   | .683   |
| MAX RADIUS                    | 1.513  | 1.317  | 1.179  |
| HORIZONTAL SPREAD             | 2.760  | 2.441  | 1.779  |
| VERTICAL SPREAD               | 1.963  | 1.963  | 1.963  |
| EXTREME SPREAD                | 2.833  | 2.519  | 2.339  |
| NUMBER IN ONE INCH CIRCLE =   | 4      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.326

VS= 2.017

GS= 2.588

CENTROID \*

| PATTERN #                   | : | 2      |       |        |
|-----------------------------|---|--------|-------|--------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8      |
| MAXIMUM X                   | : | 1.236  | 1.029 | .981   |
| MINIMUM X                   | : | -1.090 | -.953 | -1.001 |
| MAXIMUM Y                   | : | 1.132  | 1.214 | .734   |
| MINIMUM Y                   | : | -.885  | -.803 | -.651  |
| CENTROID X                  | : | -.133  | -.270 | -.222  |
| CENTROID Y                  | : | .073   | -.009 | -.161  |
| POA TO CENTROID in.         | : | .152   | .270  | .274   |
| MIN RADIUS                  | : | .535   | .594  | .489   |
| MEAN RADIUS                 | : | .962   | .908  | .842   |
| MAX RADIUS                  | : | 1.440  | 1.273 | 1.129  |
| HORIZONTAL SPREAD           | : | 2.326  | 1.982 | 1.982  |
| VERTICAL SPREAD             | : | 2.017  | 2.017 | 1.385  |
| EXTREME SPREAD              | : | 2.588  | 2.088 | 2.088  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0     |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5     |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |        |

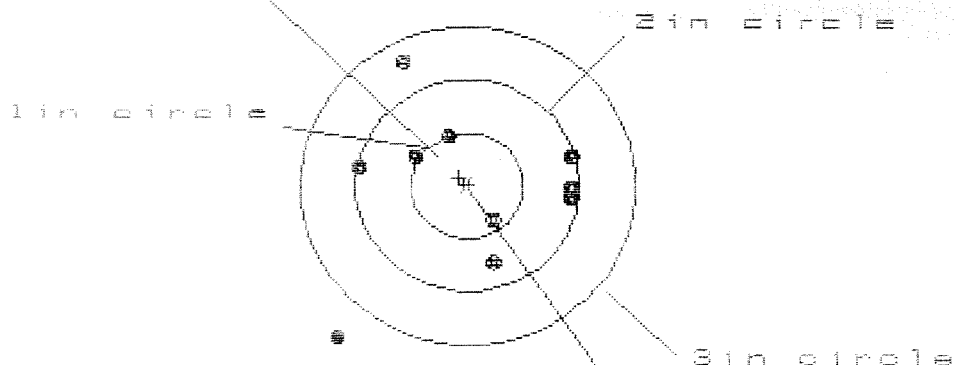


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## CENTERFIRE PATTERNS # 3

POA



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.117

VS= 2.598

GS= 2.704

CENTROID \*

| PATTERN #                     | 3      | 3      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .961   | .832   | .747   |
| MINIMUM X                     | -1.156 | -1.072 | -1.157 |
| MAXIMUM Y                     | 1.205  | 1.050  | .498   |
| MINIMUM Y                     | -1.393 | -.833  | -.702  |
| CENTROID X                    | .073   | .202   | .287   |
| CENTROID Y                    | -.076  | .079   | -.052  |
| POA TO CENTROID in.           | .105   | .217   | .292   |
| MIN RADIUS                    | .358   | .448   | .308   |
| MEAN RADIUS                   | .907   | .791   | .711   |
| MAX RADIUS                    | 1.811  | 1.254  | 1.167  |
| HORIZONTAL SPREAD             | 2.117  | 1.904  | 1.904  |
| VERTICAL SPREAD               | 2.598  | 1.883  | 1.200  |
| EXTREME SPREAD                | 2.704  | 2.055  | 1.907  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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## CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.868

VS= 2.226

GS= 3.079

CENTROID #

| PATTERN #                   | : | 4      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.771  | .926  | .925  |
| MINIMUM X                   | : | -1.097 | -.900 | -.901 |
| MAXIMUM Y                   | : | 1.210  | 1.281 | 1.112 |
| MINIMUM Y                   | : | -1.016 | -.945 | -.785 |
| CENTROID X                  | : | .161   | -.036 | -.036 |
| CENTROID Y                  | : | .190   | .119  | -.041 |
| POA TO CENTROID in.         | : | .249   | .124  | .055  |
| MIN RADIUS                  | : | .203   | .484  | .336  |
| MEAN RADIUS                 | : | .940   | .817  | .725  |
| MAX RADIUS                  | : | 1.885  | 1.281 | 1.131 |
| HORIZONTAL SPREAD           | : | 2.868  | 1.826 | 1.826 |
| VERTICAL SPREAD             | : | 2.226  | 2.226 | 1.897 |
| EXTREME SPREAD              | : | 3.079  | 2.226 | 1.942 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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## CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.735

VS= 2.479

GS= 3.691

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.435  | 1.086  | .943   |
| MINIMUM X                   | : | -1.300 | -1.140 | -1.035 |
| MAXIMUM Y                   | : | 1.518  | .946   | .847   |
| MINIMUM Y                   | : | -.961  | -.793  | -.465  |
| CENTROID X                  | : | .353   | .193   | .336   |
| CENTROID Y                  | : | .178   | .010   | .109   |
| POA TO CENTROID in.         | : | .395   | .194   | .353   |
| MIN RADIUS                  | : | .137   | .367   | .197   |
| MEAN RADIUS                 | : | .951   | .819   | .723   |
| MAX RADIUS                  | : | 2.089  | 1.389  | 1.056  |
| HORIZONTAL SPREAD           | : | 2.735  | 2.226  | 1.978  |
| VERTICAL SPREAD             | : | 2.479  | 1.739  | 1.312  |
| EXTREME SPREAD              | : | 3.691  | 2.345  | 1.979  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |