

C6594680

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**<sup>®</sup>

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

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

MODEL 700<sup>TM</sup> M24

20

SERIAL NO.  
C6594680

ORDER NO.  
**5716**

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



5716 C6594680

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594680

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 1 16     | 91      | RW   |
| 600       | Proof                                                    | 1 16     | 91      | RW   |
| 607       | Check Headspace                                          | 1 16     | 91      | RW   |
| 610       | Dis-assemble Gun                                         | 1 16     | 91      | RW   |
| 612       | Magnaflux Barrel Action                                  | 1 18     | 91      | KR   |
|           | Magnaflux Bolt                                           | 1 18     | 91      | KR   |
| 615       | Rollmark Caliber                                         | 1 18     | 91      | LS   |
| 617       | Drill and Tap Sight Holes                                | 1 24     | 91      | FB   |
| 618       | Polish Barrel                                            | 1 24     | 91      | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 2-15-91 | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 2/18/91 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 2/18/91 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 2/18/91 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 2/18/91 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 2-18-91 |      |

| Op. #        | BARBER M24 0021682                                          | READINGS        |                 |                 |      |      | DATE    | INITIAL |
|--------------|-------------------------------------------------------------|-----------------|-----------------|-----------------|------|------|---------|---------|
| 625<br>cont. | F) Safety On Force                                          | 5               | 5               | 4 $\frac{3}{4}$ |      |      | 2-22-91 | DH      |
|              | G) Safety Off Force                                         | 2 $\frac{1}{4}$ | 2 $\frac{1}{4}$ | 2 $\frac{1}{4}$ |      |      | 2-22-91 | DH      |
|              | H) Trigger Pull Test & Retainability                        |                 |                 |                 |      |      | 2/24/91 |         |
|              | I) Firing Pin Indent                                        | .0215           | .021            | .0205           |      |      | 2-22-91 | DH      |
|              | J) Assemble Stock                                           |                 |                 |                 |      |      | 2/28/91 | RW      |
|              | K) Assemble Swivel Studs                                    |                 |                 |                 |      |      | 2/21/91 | WB      |
|              | L) Attach Front and Rear Sight Assemblies                   |                 |                 |                 |      |      | 2/28/91 | RW      |
|              | M) Iron Sight Alignment                                     |                 |                 |                 |      |      | 2/28/91 | RW      |
|              | N) Detach Front & Rear Sights & place in numbered container |                 |                 |                 |      |      | 2/28/91 | RW      |
|              | O) Attach Scope to Rifle                                    |                 |                 |                 |      |      | 2/28/91 | RW      |
|              | P) Detach & Attach Scope 20 Times                           |                 |                 |                 |      |      | 2/28/91 | RW      |
| 640          | Gallery Target & Test.                                      |                 |                 |                 |      |      | 2/28/91 | NF      |
|              | A) Time                                                     |                 |                 |                 |      |      | "       | NF      |
|              | B) Malfunctions                                             |                 |                 |                 |      |      | "       | NF      |
|              | C) Pierced Primers                                          |                 |                 |                 |      |      | "       | NF      |
|              | D) Optical Clarity of Scope                                 |                 |                 |                 |      |      | "       | NF      |
| 645          | Inspect for Live Ammo                                       |                 |                 |                 |      |      | 2-24-91 | NF      |
| 655          | Final Inspection                                            |                 |                 |                 |      |      | 2/21/91 | WB      |
|              | A) Headspace                                                |                 |                 |                 |      |      |         |         |
|              | B) Trigger Pull                                             | 2.43            | 2.27            | 2.24            | 2.24 | 2.29 | 3-1-91  | 82/     |
|              | G) Function                                                 |                 |                 |                 |      |      | 3/2/91  | WB      |
| 660          | Pack                                                        |                 |                 |                 |      |      | 3-15-91 | DH      |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594680DATE 2-21-97TESTER D.H.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 256              | 251                      | 250                            | 2.43 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 262              | 247                      | 256                            | 2.22 |                                                                        |
| PULL #3 | 253              | 252                      | 260                            | 2.24 |                                                                        |
| PULL #4 | 264              | 242                      | 250                            | 2.24 |                                                                        |
| PULL #5 | 246              | 248                      | 254                            | 2.29 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.13             | 3.14                     |  |          |
| PULL #2 | 3.11             | 3.03                     |  |          |
| PULL #3 | 3.13             | 3.01                     |  |          |
| PULL #4 | 3.12             | 3.11                     |  |          |
| PULL #5 | 3.16             | 3.00                     |  |          |
| 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 | 4.40             | 4.13                     |                                | 4.06                                   |
| PULL #2 | 4.34             | 4.32                     |                                | 4.04                                   |
| PULL #3 | 4.33             | 4.31                     |                                | 4.00                                   |
| PULL #4 | 4.19             | 4.10                     |                                | 4.06                                   |
| PULL #5 | 4.32             | 4.18                     |                                | 4.07                                   |
| TOTAL   |                  |                          |                                |                                        |
| AVG.    |                  |                          |                                |                                        |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6594680  
1 Mar 1991

CENTROIDAL DISTANCES

|        |          |
|--------|----------|
| 0 TO 1 | .122483  |
| 1 TO 2 | .151013  |
| 1 TO 3 | .177674  |
| 1 TO 4 | .0960052 |
| 1 TO 5 | .359668  |

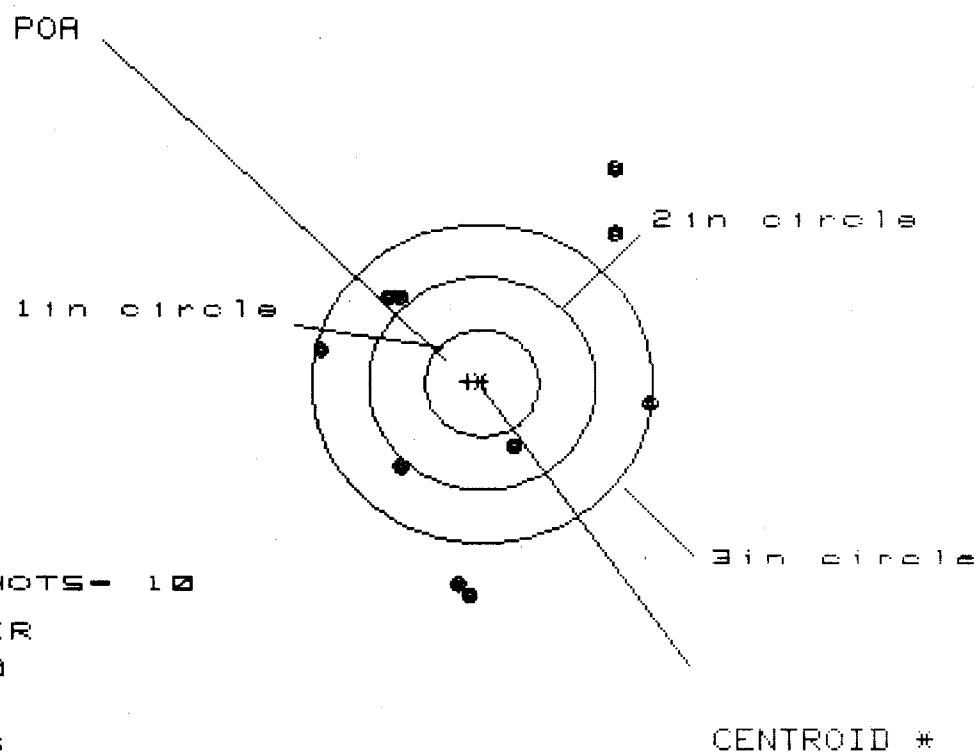
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .003  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0508  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0508883  
THE AMR FOR THIS RIFLE IS: 1.11

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6594680

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in - 0

2in - 1

3in - 6

HS- 2.938

VS- 3.951

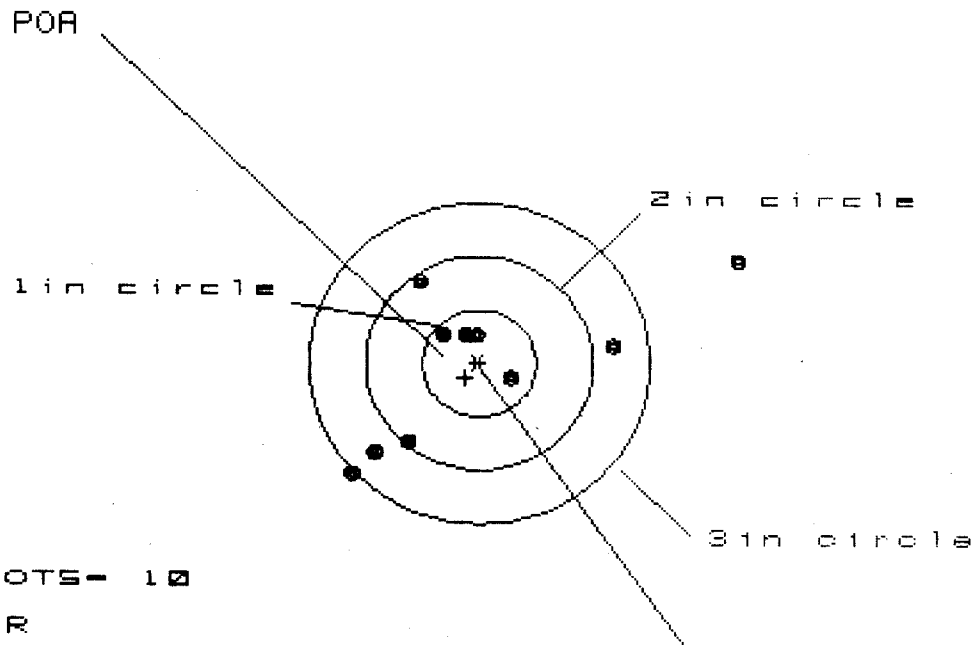
GS- 4.146

| PATTERN #                   | : | 1      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.481  | 1.609  | 1.613  |
| MINIMUM X                   | : | -1.457 | -1.329 | -1.325 |
| MAXIMUM Y                   | : | 2.003  | 1.647  | 1.432  |
| MINIMUM Y                   | : | -1.948 | -1.726 | -1.853 |
| CENTROID X                  | : | .121   | -.007  | -.011  |
| CENTROID Y                  | : | -.019  | -.241  | -.036  |
| POA TO CENTROID in.         | : | .123   | .242   | .028   |
| MIN RADIUS                  | : | .626   | .546   | .697   |
| MEAN RADIUS                 | : | 1.494  | 1.371  | 1.321  |
| MAX RADIUS                  | : | 2.314  | 2.085  | 1.922  |
| HORIZONTAL SPREAD           | : | 2.938  | 2.938  | 2.939  |
| VERTICAL SPREAD             | : | 3.951  | 3.373  | 3.285  |
| EXTREME SPREAD              | : | 4.146  | 3.596  | 3.555  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

1 Mar 1991

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in - 4

2in - 6

3in = 8

HS- 3.435

VS= 1.923

GS= 3.937

CENTROID #

| PATTERN #                   | : | 10     | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 2.286  | 1.450 | 1.339 |
| MINIMUM X                   | : | -1.149 | -.895 | -.755 |
| MAXIMUM Y                   | : | .933   | .824  | .713  |
| MINIMUM Y                   | : | -.990  | -.887 | -.840 |
| CENTROID X                  | : | .123   | -.131 | -.020 |
| CENTROID Y                  | : | .132   | .028  | .139  |
| POA TO CENTROID in.         | : | .180   | .134  | .140  |
| MIN RADIUS                  | : | .253   | .399  | .275  |
| MEAN RADIUS                 | : | .960   | .783  | .688  |
| MAX RADIUS                  | : | 2.469  | 1.479 | 1.351 |
| HORIZONTAL SPREAD           | : | 3.435  | 2.345 | 2.094 |
| VERTICAL SPREAD             | : | 1.923  | 1.711 | 1.553 |
| EXTREME SPREAD              | : | 3.937  | 2.624 | 2.329 |
| NUMBER IN ONE INCH CIRCLE   | = | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |       |       |

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6594680

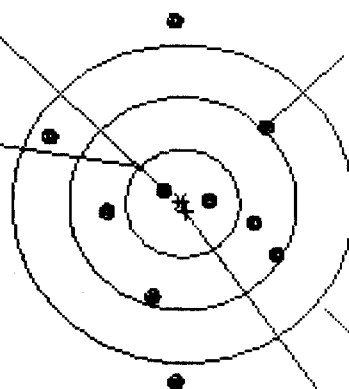
## CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle



CENTROID #

# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.958

VS= 3.355

GS= 3.355

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .814   | .802   | .791   |
| MINIMUM X                   | : | -1.144 | -1.156 | -1.167 |
| MAXIMUM Y                   | : | 1.697  | .893   | .710   |
| MINIMUM Y                   | : | -1.658 | -1.470 | -.868  |
| CENTROID X                  | : | -.031  | -.019  | -.008  |
| CENTROID Y                  | : | .073   | -.115  | .068   |
| POA TO CENTROID in.         | : | .080   | .117   | .069   |
| MIN RADIUS                  | : | .244   | .342   | .232   |
| MEAN RADIUS                 | : | .934   | .850   | .746   |
| MAX RADIUS                  | : | 1.700  | 1.472  | 1.323  |
| HORIZONTAL SPREAD           | : | 1.958  | 1.958  | 1.958  |
| VERTICAL SPREAD             | : | 3.355  | 2.363  | 1.578  |
| EXTREME SPREAD              | : | 3.355  | 2.515  | 2.227  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

1 Mar 1991

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## CENTERFIRE PATTERNS

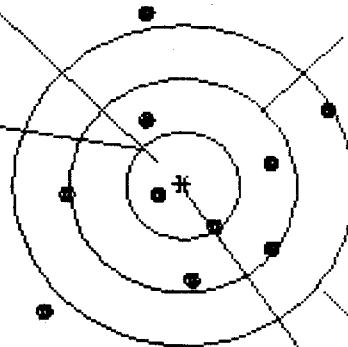
# 4

POA

1 in circle

2 in circle

3 in circle



CENTROID #

# OF SHOTS- 10

# IN CIR

1 in - 2

2 in - 7

3 in - 8

HS- 2.520

VS- 2.739

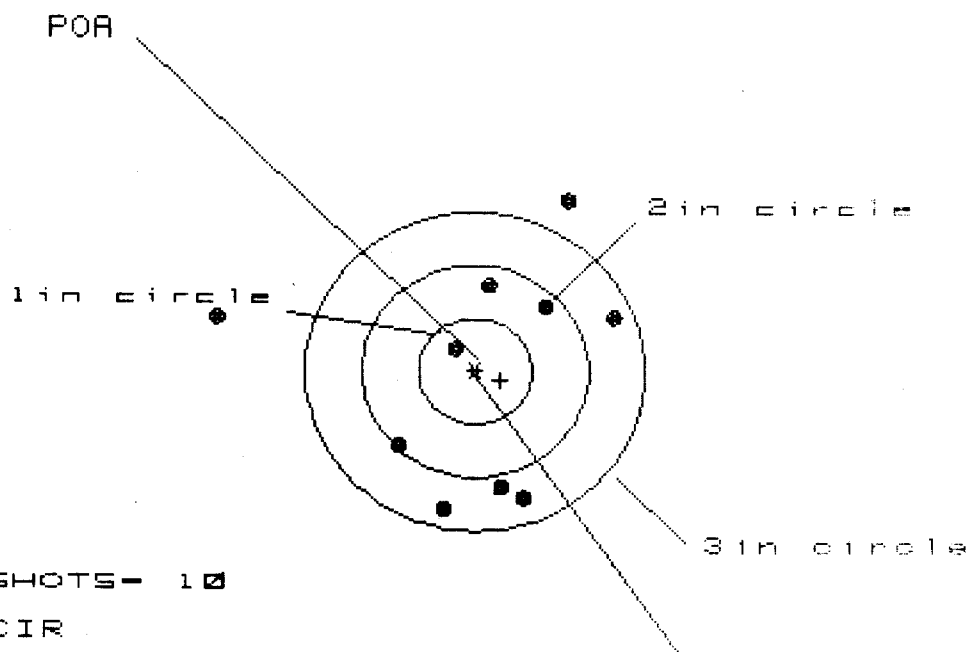
GS- 3.117

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.273  | 1.134  | 1.080  |
| MINIMUM X                   | : | -1.247 | -1.122 | -1.176 |
| MAXIMUM Y                   | : | 1.605  | 1.479  | .760   |
| MINIMUM Y                   | : | -1.134 | -.990  | -.805  |
| CENTROID X                  | : | .025   | .164   | .218   |
| CENTROID Y                  | : | -.018  | .108   | -.077  |
| POA TO CENTROID in.         | : | .031   | .196   | .231   |
| MIN RADIUS                  | : | .206   | .392   | .332   |
| MEAN RADIUS                 | : | .970   | .899   | .781   |
| MAX RADIUS                  | : | 1.686  | 1.541  | 1.321  |
| HORIZONTAL SPREAD           | : | 2.520  | 2.256  | 2.256  |
| VERTICAL SPREAD             | : | 2.739  | 2.469  | 1.565  |
| EXTREME SPREAD              | : | 3.117  | 2.491  | 2.376  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6594680

## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 3.505

VS= 2.944

GS= 3.505

CENTROID \*

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.211  | .956   | 1.024  |
| MINIMUM X                   | : | -2.294 | -.895  | -.827  |
| MAXIMUM Y                   | : | 1.661  | 1.713  | 1.032  |
| MINIMUM Y                   | : | -1.283 | -1.231 | -1.017 |
| CENTROID X                  | : | -.223  | .032   | -.036  |
| CENTROID Y                  | : | .086   | .034   | -.180  |
| POA TO CENTROID in.         | : | .239   | .047   | .184   |
| MIN RADIUS                  | : | .266   | .481   | .591   |
| MEAN RADIUS                 | : | 1.193  | 1.056  | .951   |
| MAX RADIUS                  | : | 2.343  | 1.799  | 1.272  |
| HORIZONTAL SPREAD           | : | 3.505  | 1.851  | 1.851  |
| VERTICAL SPREAD             | : | 2.944  | 2.944  | 2.049  |
| EXTREME SPREAD              | : | 3.505  | 3.129  | 2.306  |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |        |

| FROM:                                                                                                        | SHIP TO:                                                                                                     |
|--------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|
| COMMANDER (W52H094138H226)<br>DEFENSE DIST DEPOT ANNISTON<br>ATTN DDAA-UR BLDG 112<br>ANNISTON AL 36201-5025 | COMMANDER (W52H094138H226)<br>DEFENSE DIST DEPOT ANNISTON<br>ATTN DDAA-UR BLDE 112<br>ANNISTON AL 36201-5025 |

| CUSTOMER CONCERN | AMMO | FUNCTION | FINISH | ACCURACY | FIT | INSPECT |
|------------------|------|----------|--------|----------|-----|---------|
| CYCLE            | A1   | B1       |        |          |     |         |
| TRIGGER GROUP    |      | B2       |        |          | E1  | F1      |
| BOLT ASSY.       |      | B3       |        |          | E2  | F2      |
| BARREL ASSY.     |      | B4       |        | D1       | E3  | F3      |
| REC. ASSY.       |      | B5       |        | D2       | E4  | F4      |
| WOOD             |      |          | C1     | D3       | E5  | F5      |
| METAL            |      |          | C2     |          |     |         |

[illegible]

RD6925 REV. 1/94

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#  
3.00# + .75#  
4.00# + 1.00#

SERIAL NO. C6594680DATE 10-30-95TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.44             | 2.52                     | 2.57                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.41             | 2.55                     | 2.50                           |                                                                        |
| PULL #3 | 2.54             | 2.66                     | 2.49                           |                                                                        |
| PULL #4 | 2.31             | 2.28                     | 2.51                           |                                                                        |
| PULL #5 | 2.65             | 2.28                     | 2.47                           |                                                                        |
| TOTAL   | 12.35            | 12.29                    | 12.54                          |                                                                        |
| AVG.    | 2.47             | 2.45                     | 2.50                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.04             | 3.14                     |  |          |
| PULL #2 | 3.02             | 3.06                     |  |          |
| PULL #3 | 3.06             | 3.00                     |  |          |
| PULL #4 | 3.21             | 3.11                     |  |          |
| PULL #5 | 3.18             | 3.00                     |  |          |
| TOTAL   | 15.51            | 15.31                    |  |          |
| AVG.    | 3.10             | 3.06                     |  |          |

|         | 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 | 4.08             | 4.03                     | 4.13                           |                                      |
| PULL #2 | 4.03             | 3.93                     | 4.07                           |                                      |
| PULL #3 | 4.04             | 3.94                     | 4.02                           |                                      |
| PULL #4 | 4.09             | 3.99                     | 4.09                           |                                      |
| PULL #5 | 4.04             | 4.02                     | 4.12                           |                                      |
| TOTAL   | 20.28            | 19.91                    | 20.43                          |                                      |
| AVG.    | 4.05             | 3.98                     | 4.08                           |                                      |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594680

| OP. #        | OP. NAME                                                       | READINGS | DATE | INITIAL |
|--------------|----------------------------------------------------------------|----------|------|---------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          |      |         |
| 600          | Proof                                                          |          |      |         |
| 607          | Check Headspace                                                |          |      |         |
| 610          | Dis-assemble Gun                                               |          |      |         |
| 612          | Magnaflux Barrel<br>Action                                     |          |      |         |
|              | Magnaflux Bolt                                                 |          |      |         |
| 615          | Rollmark Caliber                                               |          |      |         |
| 617          | Drill and Tap Sight Holes                                      |          |      |         |
| 618          | Polish Barrel                                                  |          |      |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |      |         |
|              | Apply Coating (Bolt)                                           |          |      |         |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          |      |         |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          |      |         |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          |      |         |
|              | D) Oil Firing Pin Ass'y                                        |          |      |         |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          |      |         |

| op. #        | OP. NAME                                                    | READINGS |       |      |      |      | DATE  | INIT |
|--------------|-------------------------------------------------------------|----------|-------|------|------|------|-------|------|
| 625<br>cont. | F) Safety On Force                                          | 5 1/2    | 5 1/2 | 5    |      |      | 12/14 | WB   |
|              | G) Safety Off Force                                         | 3        | 3 1/4 | 3    |      |      | 12/14 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |      |      |      |       |      |
|              | I) Firing Pin Indent                                        |          |       |      |      |      |       |      |
|              | J) Assemble Stock                                           |          |       |      |      |      |       |      |
|              | K) Assemble Swivel Studs                                    |          |       |      |      |      |       |      |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |      |      |      |       |      |
|              | M) Iron Sight Alignment                                     |          |       |      |      |      |       |      |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |      |      |      |       |      |
|              | O) Attach Scope to Rifle                                    |          |       |      |      |      |       |      |
|              | P) Detach & Attach Scope 20 Times                           |          |       |      |      |      |       |      |
| 640          | Gallery Target & Test                                       |          |       |      |      |      |       |      |
|              | A) Time                                                     |          |       |      |      |      |       |      |
|              | B) Malfunctions                                             |          |       |      |      |      |       |      |
|              | C) Pierced Primers                                          |          |       |      |      |      |       |      |
|              | D) Optical Clarity of Scope                                 |          |       |      |      |      |       |      |
| 645          | Inspect for Live Ammo                                       |          |       |      |      |      |       |      |
| 655          | Final Inspection                                            |          |       |      |      |      |       |      |
|              | A) Headspace                                                |          |       |      |      |      |       |      |
|              | B) Trigger Pull                                             | 2.44     | 2.40  | 2.50 | 2.36 | 2.49 | 12/14 | WB   |
|              | C) Function                                                 |          |       |      |      |      |       |      |
| 660          | Pack                                                        |          |       |      |      |      |       |      |