

C6523489

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.



**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> H24

SERIAL NO.  
C6523489

ORDER NO.  
**5716**

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

01

  
5716 C6523489

UPC

  
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523489

| OP. #     | OP. NAME                                                 | READINGS | DATE     | INIT |
|-----------|----------------------------------------------------------|----------|----------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 10/2/90  | Y/L  |
| 600       | Proof                                                    |          | 10/2/90  | Y/L  |
| 607       | Check Headspace                                          |          | 10/2/90  | Y/L  |
| 610       | Dis-assemble Gun                                         |          | 10/2/90  | Y/L  |
| 612       | Magnaflux Barrel Action                                  |          | 10/5/90  | KR   |
|           | Magnaflux Bolt                                           |          | 10/5/90  | KR   |
| 615       | Rollmark Caliber                                         |          | 10/5/90  | JS   |
| 617       | Drill and Tap Sight Holes                                |          | 10/8/90  | LB   |
| 618       | Polish Barrel RB                                         |          | 10/9/90  | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 10-20-90 | TH   |
|           | Apply Coating (Bolt)                                     |          |          |      |
| 625       | Final Assembly<br>A) Clean inside of Bolt Assembly       |          | 10/21/90 | WB   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 10/21/90 | WB   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 10/21/90 | WB   |
|           | D) Oil Firing Pin Ass'y                                  |          | 10/21/90 | WB   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 10/31/90 | Y/L  |

**BARBER - M24 0028969**

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 10/31/90 | WB   |
|              | G) Safety Off Force                                         | 2 3/4    | 2 3/4 | 2 3/4 |      |      | 10/31/90 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 10/31/90 | JH   |
|              | I) Firing Pin Indent                                        | 1022     | 1022  | 1022  |      |      | 10/31/90 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 11/2/90  | Kel  |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 11-20-90 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 11/2/90  | Kel  |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 11/2/90  | Kel  |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 11/2/90  | Kel  |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 11/2/90  | Kel  |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 11/2/90  | Kel  |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 11-6-90  | DH   |
|              | A) Time                                                     |          |       |       |      |      | 11-6-90  | DH   |
|              | B) Malfunctions                                             |          |       |       |      |      | 11-6-90  | DH   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 11-6-90  | DH   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 11-6-90  | DH   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 11-6-90  | DH   |
| 655          | Final Inspection                                            |          |       |       |      |      | 11-20-90 | DH   |
|              | A) Headspace                                                |          |       |       |      |      | 11-20-90 | DH   |
|              | B) Trigger Pull                                             | 2.09     | 2.07  | 2.08  | 2.13 | 2.09 | 11-20-90 | DH   |
|              | C) Function                                                 |          |       |       |      |      | 11-20-90 | DH   |
| 660          | Pack                                                        |          |       |       |      |      | 12/18/90 | VF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6623489

DATE 10/31/90

TESTER JR

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.39             | 2.18                     | 2.36                           | 205 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.19             | 2.42                     | 2.36                           | 207 |                                                                        |
| PULL #3 | 2.37             | 2.40                     | 2.46                           | 208 |                                                                        |
| PULL #4 | 2.38             | 2.38                     | 2.40                           | 213 |                                                                        |
| PULL #5 | 2.33             | 2.46                     | 2.35                           | 209 |                                                                        |
| TOTAL   | 11.66            | 11.84                    | 11.93                          |     |                                                                        |
| AVG.    | 2.332            | 2.368                    | 2.386                          |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.21             | 3.45                     |  |          |
| PULL #2 | 3.47             | 3.43                     |  |          |
| PULL #3 | 3.47             | 3.40                     |  |          |
| PULL #4 | 3.43             | 3.38                     |  |          |
| PULL #5 | 3.43             | 3.30                     |  |          |
| TOTAL   | 17.01            | 16.96                    |  |          |
| AVG.    | 3.402            | 3.392                    |  |          |

|         | 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 | 4.32             | 4.27                     |                                | 4.46                                 |
| PULL #2 | 4.25             | 4.39                     |                                | 4.47                                 |
| PULL #3 | 4.26             | 4.30                     |                                | 4.24                                 |
| PULL #4 | 4.29             | 4.36                     |                                | 4.10                                 |
| PULL #5 | 4.26             | 4.36                     |                                | 4.50                                 |
| TOTAL   | 21.38            | 21.67                    |                                | 21.77                                |
| AVG.    | 4.276            | 4.334                    |                                | 4.354                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523489  
6 Nov 1990

CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .187683 |
| 1 | TO | 2 | .31293  |
| 1 | TO | 3 | .4724   |
| 1 | TO | 4 | .219513 |
| 1 | TO | 5 | .424058 |

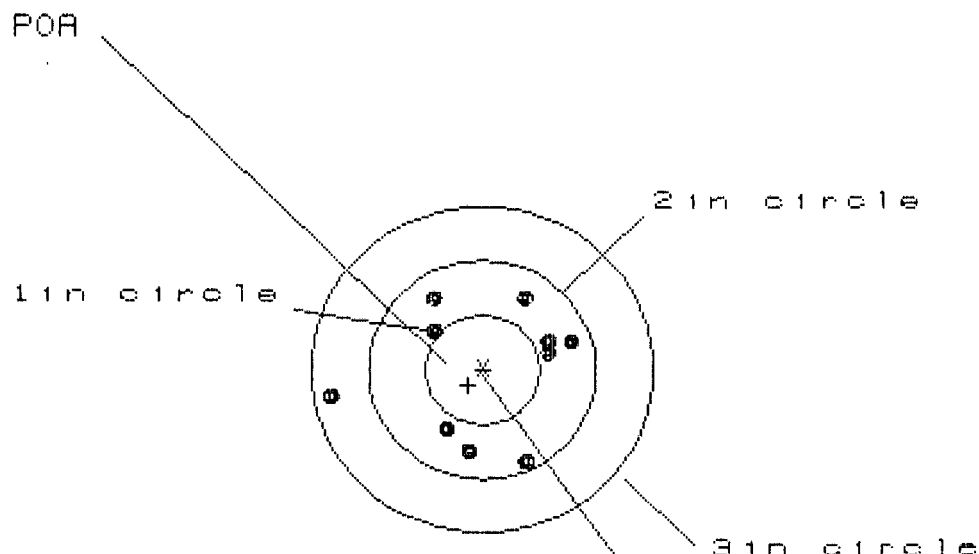
34.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0848  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0174  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0865667  
THE AMR FOR THIS RIFLE IS: .8068

6 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C65234B9

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in - 0

2 in - 9

3 in = 10

HS= 2.149

VS= 1.417

GS= 2.203

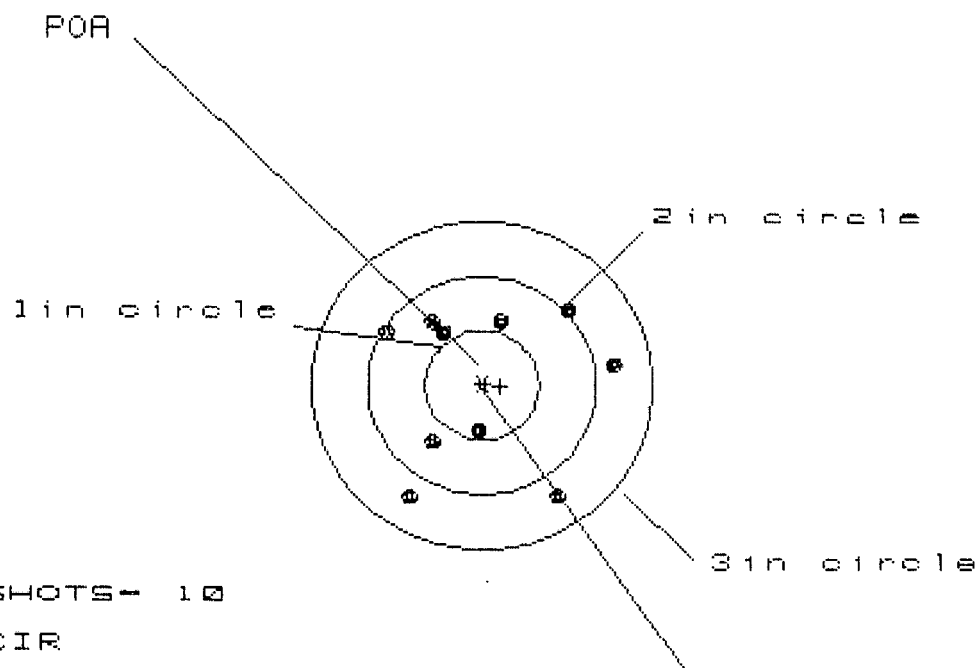
CENTROID \*

| PATTERN #                   | : | 1      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .822   | .675  | .708  |
| MINIMUM X                   | : | -1.327 | -.600 | -.567 |
| MAXIMUM Y                   | : | .622   | .598  | .496  |
| MINIMUM Y                   | : | -.795  | -.819 | -.883 |
| CENTROID X                  | : | .125   | .272  | .239  |
| CENTROID Y                  | : | .140   | .164  | .266  |
| POA TO CENTROID in.         | : | .187   | .317  | .358  |
| MIN RADIUS                  | : | .570   | .427  | .429  |
| MEAN RADIUS                 | : | .770   | .684  | .649  |
| MAX RADIUS                  | : | 1.344  | .860  | .914  |
| HORIZONTAL SPREAD           | : | 2.149  | 1.275 | 1.275 |
| VERTICAL SPREAD             | : | 1.417  | 1.417 | 1.379 |
| EXTREME SPREAD              | : | 2.203  | 1.644 | 1.454 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in - 1

2 in - 6

3 in = 10

HS= 1.980

VS= 1.657

GS= 2.214

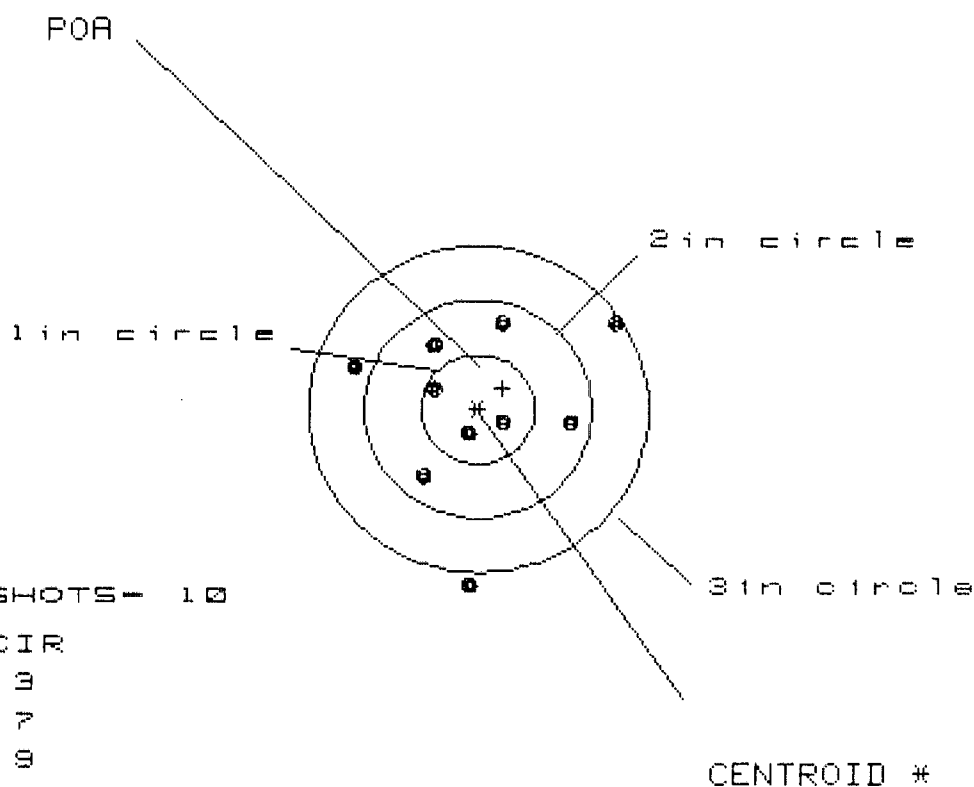
CENTROID \*

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.148  | 1.225  | 1.152 |
| MINIMUM X                   | : | -.832  | -.755  | -.828 |
| MAXIMUM Y                   | : | .642   | .529   | .389  |
| MINIMUM Y                   | : | -1.015 | -1.128 | -.796 |
| CENTROID X                  | : | -.161  | -.238  | -.165 |
| CENTROID Y                  | : | .013   | .126   | .267  |
| POA TO CENTROID in.         | : | .162   | .269   | .313  |
| MIN RADIUS                  | : | .404   | .442   | .377  |
| MEAN RADIUS                 | : | .866   | .804   | .728  |
| MAX RADIUS                  | : | 1.228  | 1.271  | 1.154 |
| HORIZONTAL SPREAD           | : | 1.980  | 1.980  | 1.980 |
| VERTICAL SPREAD             | : | 1.657  | 1.657  | 1.185 |
| EXTREME SPREAD              | : | 2.214  | 2.214  | 1.999 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.297

VS= 2.449

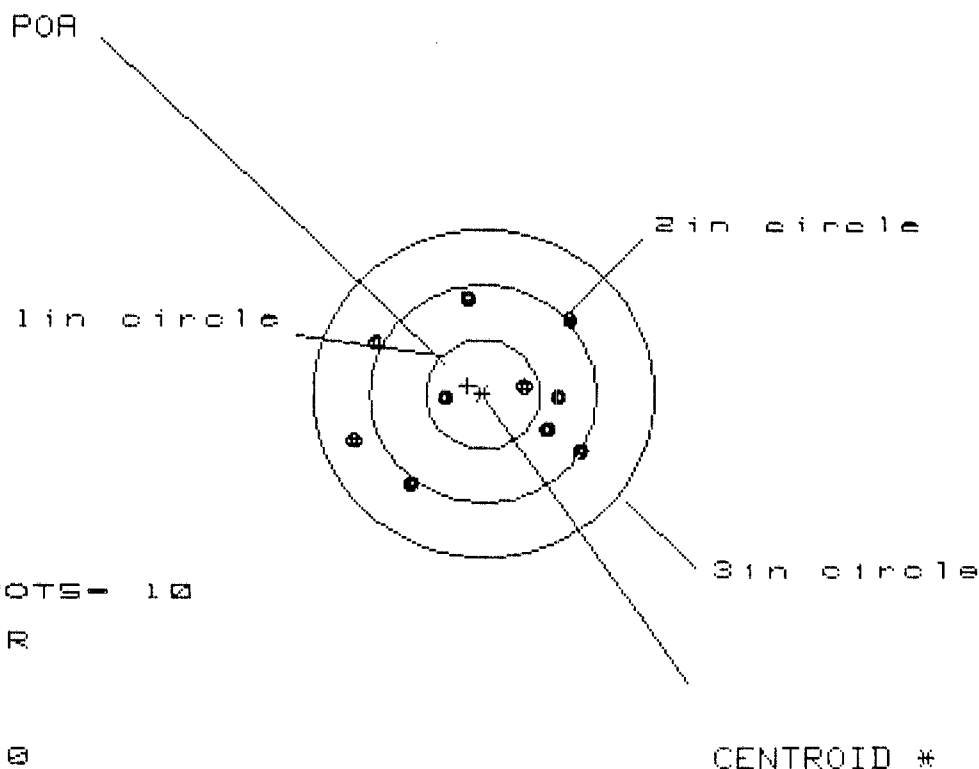
GS= 2.749

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.213  | 1.209  | 1.006 |
| MINIMUM X                   | : | -1.084 | -1.088 | -.937 |
| MAXIMUM Y                   | : | .817   | .635   | .646  |
| MINIMUM Y                   | : | -1.632 | -.800  | -.721 |
| CENTROID X                  | : | -.214  | -.210  | -.361 |
| CENTROID Y                  | : | -.189  | -.007  | -.086 |
| POA TO CENTROID in.         | : | .285   | .210   | .371  |
| MIN RADIUS                  | : | .187   | .365   | .253  |
| MEAN RADIUS                 | : | .828   | .739   | .636  |
| MAX RADIUS                  | : | 1.633  | 1.365  | 1.037 |
| HORIZONTAL SPREAD           | : | 2.297  | 2.297  | 1.943 |
| VERTICAL SPREAD             | : | 2.449  | 1.435  | 1.366 |
| EXTREME SPREAD              | : | 2.749  | 2.337  | 2.016 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.958

VS= 1.688

GS= 2.205

CENTROID \*

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .819   | .692   | .594   |
| MINIMUM X                   | : | -1.139 | -1.044 | -1.142 |
| MAXIMUM Y                   | : | .891   | .843   | .738   |
| MINIMUM Y                   | : | -.796  | -.845  | -.654  |
| CENTROID X                  | : | .140   | .267   | .365   |
| CENTROID Y                  | : | -.079  | -.030  | .075   |
| POA TO CENTROID in.         | : | .161   | .269   | .373   |
| MIN RADIUS                  | : | .354   | .240   | .156   |
| MEAN RADIUS                 | : | .825   | .758   | .687   |
| MAX RADIUS                  | : | 1.219  | 1.152  | 1.178  |
| HORIZONTAL SPREAD           | : | 1.958  | 1.736  | 1.736  |
| VERTICAL SPREAD             | : | 1.688  | 1.688  | 1.392  |
| EXTREME SPREAD              | : | 2.205  | 2.041  | 1.975  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

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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 = 4

2 in = 7

3 in = 10

HS= 1.656

VS= 2.431

GS= 2.445

| PATTERN #                   | : | 5      | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.006  | 1.009 | 1.045 |
| MINIMUM X                   | : | -.650  | -.647 | -.611 |
| MAXIMUM Y                   | : | 1.190  | 1.052 | .932  |
| MINIMUM Y                   | : | -1.241 | -.799 | -.668 |
| CENTROID X                  | : | .534   | .531  | .495  |
| CENTROID Y                  | : | .028   | .166  | .035  |
| POA TO CENTROID in.         | : | .535   | .556  | .496  |
| MIN RADIUS                  | : | .140   | .013  | .134  |
| MEAN RADIUS                 | : | .745   | .674  | .619  |
| MAX RADIUS                  | : | 1.242  | 1.091 | 1.104 |
| HORIZONTAL SPREAD           | : | 1.656  | 1.656 | 1.656 |
| VERTICAL SPREAD             | : | 2.431  | 1.851 | 1.600 |
| EXTREME SPREAD              | : | 2.445  | 2.000 | 1.904 |
| NUMBER IN ONE INCH CIRCLE   | = | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 7      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 10     |       |       |