

C6611757

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

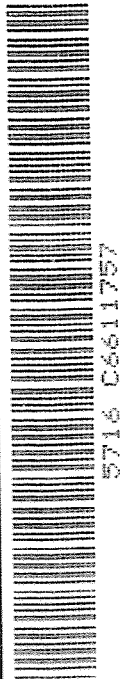
UPPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6611757

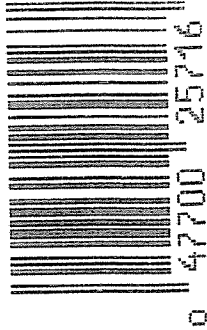
ORDER NO.
5716

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

46



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611757

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	U
615	Rollmark Caliber			GL
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4/1/91	SA
	Apply Coating (Bolt)			SA
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/4/91	SA

op. #	BARBER - M24 0035443 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/4/91	JK
	G) Safety Off Force	4	4	4			5/4/91	JK
	H) Trigger Pull Test & Retainability						5/4/91	JK
	I) Firing Pin Indent	.0205	.0205	.020			5/4/91	JK
	J) Assemble Stock						5/6/91	RW
	K) Assemble Swivel Studs						5-9-91	AC
	L) Attach Front and Rear Sight Assemblies						5/6/91	RW
	M) Iron Sight Alignment						5/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	RW
	O) Attach Scope to Rifle						5/6/91	RW
	P) Detach & Attach Scope 20 Times						5/6/90	RW
640	Gallery Target & Test						5-6-91	DH
	A) Time						5-6-91	DH
	B) Malfunctions						5-6-91	DH
	C) Pierced Primers						5-6-91	DH
	D) Optical Clarity of Scope						5-6-91	DH
645	Inspect for Live Ammo						5-6-91	DH
655	Final Inspection							
	A) Headspace						5-9-91	AC
	B) Trigger Pull	2.18	2.19	2.17	2.29	2.42	5/9/91	JK
	C) Function						5-9-91	AC
660	Pack						6-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611757

DATE 5/4/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.19	2.22	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.20	2.29	2.19	
PULL #3	2.23	2.28	2.18	2.17	
PULL #4	2.24	2.16	2.20	2.29	
PULL #5	2.21	2.18	2.20	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.49		
PULL #2	3.51	3.46		
PULL #3	3.55	3.45		
PULL #4	3.51	3.48		
PULL #5	3.48	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.50		4.31
PULL #2	4.49	4.63		4.54
PULL #3	4.48	4.47		4.50
PULL #4	4.49	4.62		4.26
PULL #5	4.35	4.51		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611757
6 May 1991

CENTROIDAL DISTANCES

0 TO	1	.297357
1 TO	2	.382782
1 TO	3	.186011
1 TO	4	.606885
1 TO	5	.0726911

431
36 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1282
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243144
THE AMR FOR THIS RIFLE IS: 1.351

8 May 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8511757

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 4

HS = 4.017

VS = 3.231

GS = 4.056

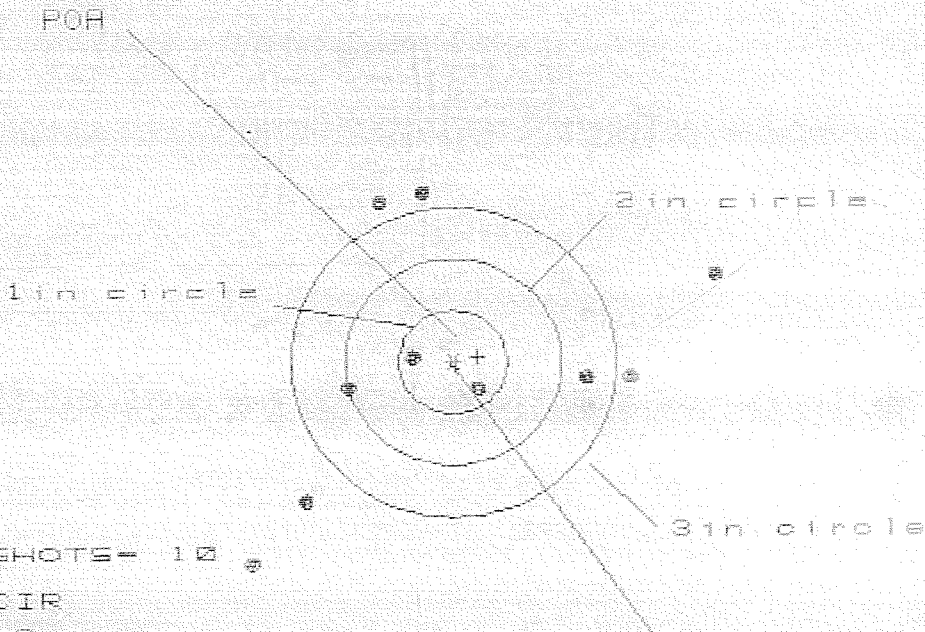
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.799	1.553	.769
MINIMUM X	-2.218	-1.772	-1.578
MAXIMUM Y	1.355	1.396	1.517
MINIMUM Y	-1.876	-1.835	-1.714
CENTROID X	.070	.316	.122
CENTROID Y	-.289	-.330	-.451
POA TO CENTROID in.	.298	.457	.468
MIN RADIUS	.603	.435	.657
MEAN RADIUS	1.433	1.325	1.279
MAX RADIUS	2.248	1.893	1.765
HORIZONTAL SPREAD	4.017	3.325	2.338
VERTICAL SPREAD	3.231	3.231	3.231
EXTREME SPREAD	4.056	3.706	3.239
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	4		

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611757

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 2

3 in = 4

HS = 4.335

VS = 3.524

GS = 5.135

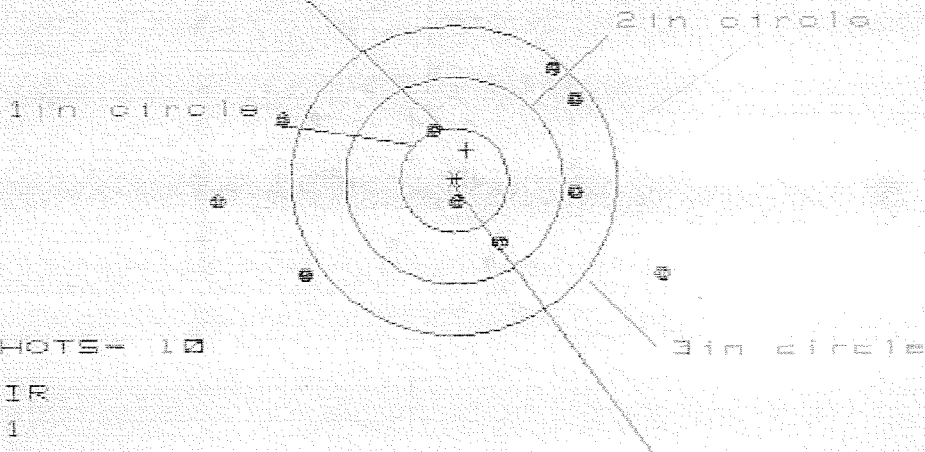
PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.464	2.256	1.726
MINIMUM X	-1.871	-1.563	-1.281
MAXIMUM Y	1.613	1.400	1.479
MINIMUM Y	-1.911	-1.528	-1.449
CENTROID X	-.229	-.021	-.303
CENTROID Y	-.050	.163	.084
POA TO CENTROID in.	.234	.164	.314
MIN RADIUS	.286	.429	.272
MEAN RADIUS	1.498	1.380	1.213
MAX RADIUS	2.675	2.342	1.934
HORIZONTAL SPREAD	4.335	3.819	3.007
VERTICAL SPREAD	3.524	2.928	2.928
EXTREME SPREAD	5.135	4.386	3.222
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	4		

6 May 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6611757

CENTERFIRE PATTERNS # 3

POB



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 4.093

VS = 2.033

GS = 4.165

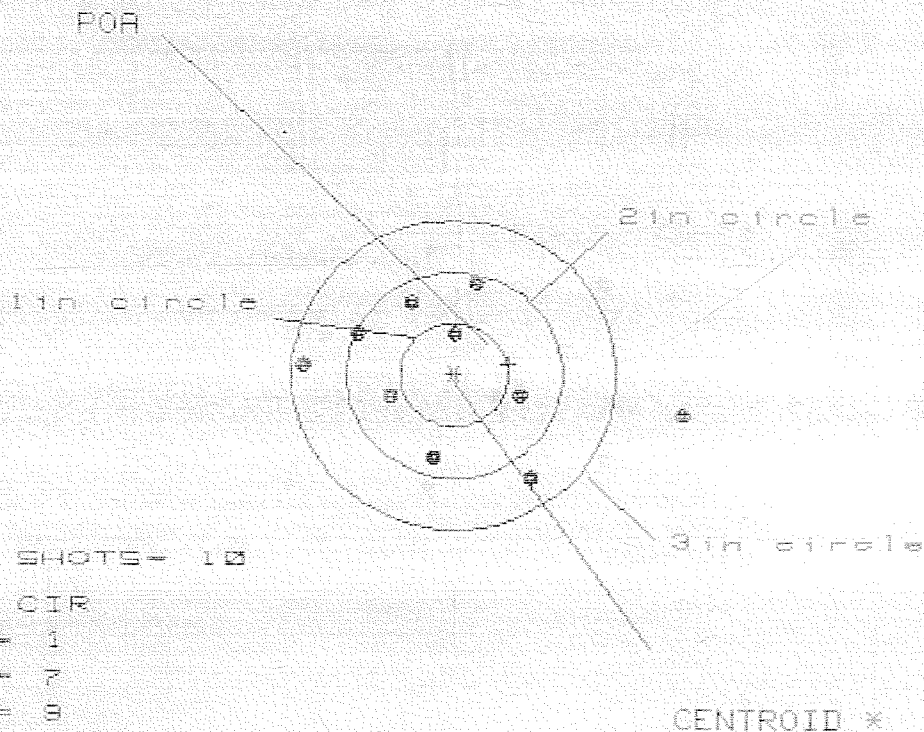
CENTROID *

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.940	1.701	1.089
MINIMUM X	-2.153	-1.866	-1.654
MAXIMUM Y	1.090	1.071	.951
MINIMUM Y	-.943	-.962	-1.026
CENTROID X	-.116	.123	-.090
CENTROID Y	-.291	-.272	-.152
POB TO CENTROID in.	.313	.299	.176
MIN RADIUS	.102	.331	.323
MEAN RADIUS	1.297	1.182	1.082
MAX RADIUS	2.160	1.954	1.739
HORIZONTAL SPREAD	4.093	3.567	2.742
VERTICAL SPREAD	2.033	2.033	1.977
EXTREME SPREAD	4.165	3.866	3.610
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

8 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/08611757

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 3.555

VS = 1.867

GS = 3.593

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.115	.948	.797
MINIMUM X	-1.440	-1.205	-.812
MAXIMUM Y	.914	.870	.881
MINIMUM Y	-.954	-.997	-.986
CENTROID X	-.508	-.743	-.592
CENTROID Y	-.104	-.061	-.072
POA TO CENTROID in.	.518	.745	.596
MIN RADIUS	.421	.427	.390
MEAN RADIUS	1.009	.846	.801
MAX RADIUS	2.151	1.376	1.268
HORIZONTAL SPREAD	3.555	2.153	1.609
VERTICAL SPREAD	1.867	1.867	1.867
EXTREME SPREAD	3.593	2.418	2.076
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

8 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6611757

CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS = 4.176

VS = 2.989

GS = 4.865

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.015	1.550	1.308
MINIMUM X	-2.161	-1.937	-1.836
MAXIMUM Y	1.472	1.418	1.311
MINIMUM Y	-1.517	-1.353	-1.460
CENTROID X	.142	-.082	.160
CENTROID Y	-.299	-.463	-.356
POB TO CENTROID in.	.331	.478	.390
MIN RADIUS	.218	.076	.219
MEAN RADIUS	1.519	1.401	1.285
MAX RADIUS	2.496	2.119	2.346
HORIZONTAL SPREAD	4.176	3.487	3.144
VERTICAL SPREAD	2.989	2.771	2.771
EXTREME SPREAD	4.865	3.964	3.943
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611757
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.177294
1 TO	2	.396146
1 TO	3	.533159
1 TO	4	.235705
1 TO	5	.193259

5.29
4.11 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0476
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .07275

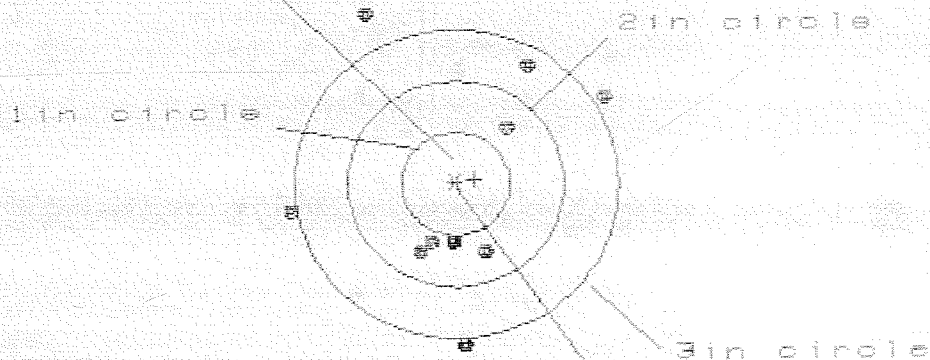
THE AMR FOR THIS RIFLE IS: 1.124

8 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/CGB11757.1

CENTERFIRE PATTERNS # 1

POR



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 6

HS= 2.930

VS= 3.174

GS= 3.293

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.395	1.305	.746
MINIMUM X	-1.536	-1.625	-1.461
MAXIMUM Y	1.641	1.277	1.405
MINIMUM Y	-1.533	-1.350	-1.222
CENTROID X	-.172	-.082	-.246
CENTROID Y	-.043	-.226	-.354
POR TO CENTROID in.	.177	.240	.431
MIN RADIUS	.537	.369	.234
MEAN RADIUS	1.106	.977	.836
MAX RADIUS	1.826	1.661	1.591
HORIZONTAL SPREAD	2.930	2.930	2.207
VERTICAL SPREAD	3.174	2.627	2.627
EXTREME SPREAD	3.293	3.125	2.694
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	6	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611757.1

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.375

VS = 3.320

GS = 3.969

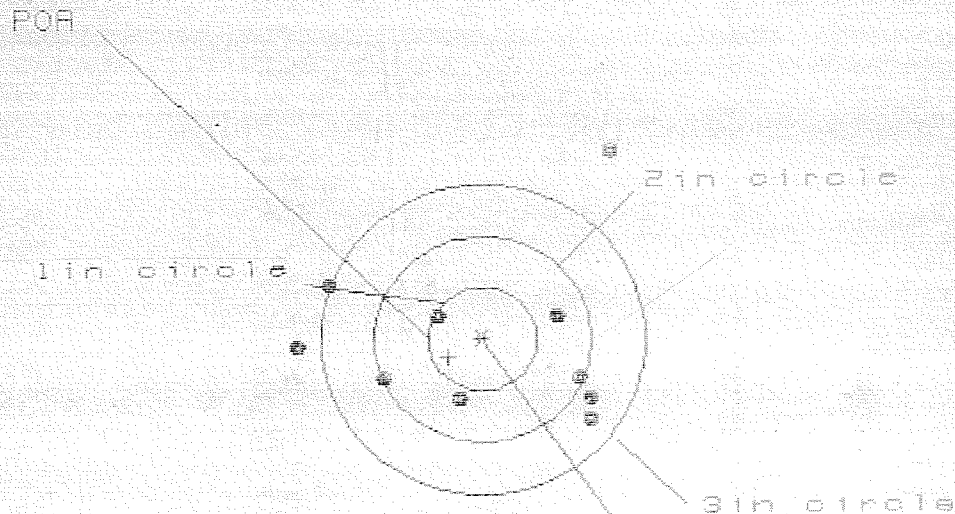
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	1.269	1.131
MINIMUM X	:	-1.227	-1.106	-1.114
MAXIMUM Y	:	1.784	1.043	.898
MINIMUM Y	:	-1.536	-1.337	-1.492
CENTROID X	:	.132	.011	.149
CENTROID Y	:	.211	.012	.167
POA TO CENTROID in.	:	.249	.016	.224
MIN RADIUS	:	.584	.718	.611
MEAN RADIUS	:	1.252	1.151	1.071
MAX RADIUS	:	2.091	1.662	1.537
HORIZONTAL SPREAD	:	2.375	2.375	2.245
VERTICAL SPREAD	:	3.320	2.380	2.380
EXTREME SPREAD	:	3.969	3.294	2.628
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PAT/CBB11757.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HE= 2.825

VS= 2.528

GS= 3.413

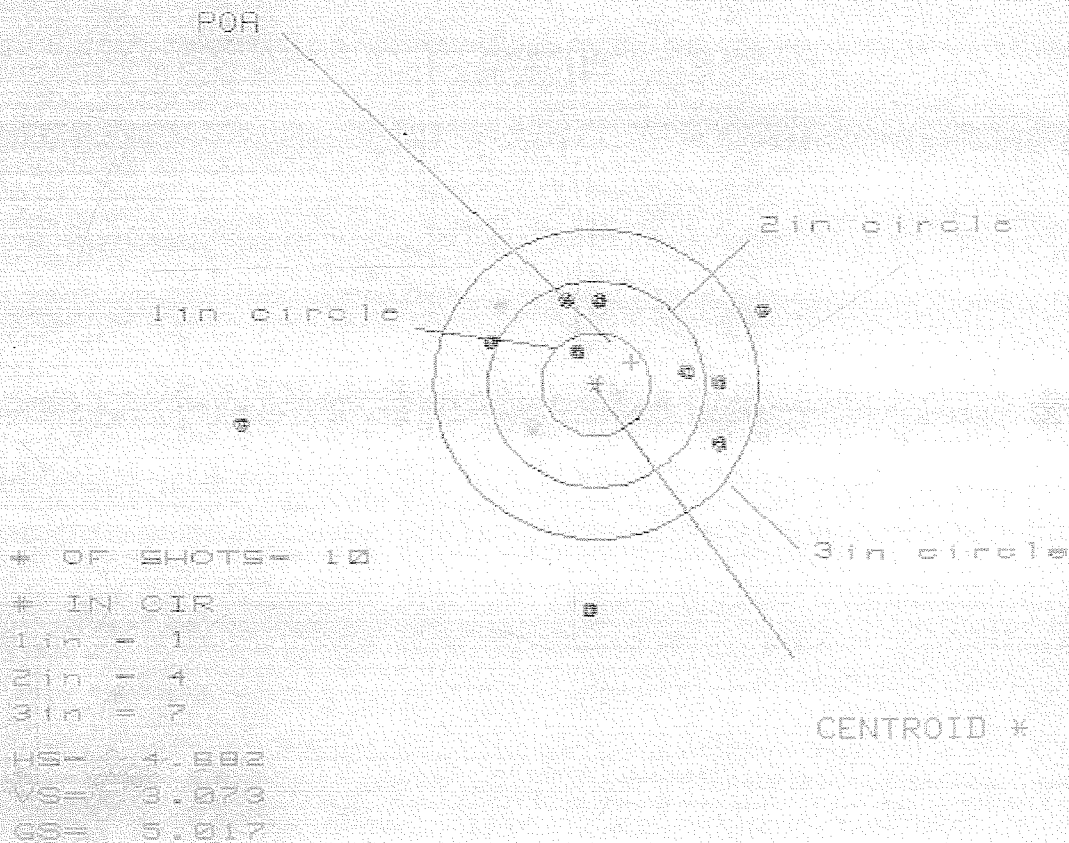
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.066	.871
MINIMUM X	-1.684	-1.557	-1.485
MAXIMUM Y	1.803	.718	.729
MINIMUM Y	-.725	-.524	-.513
CENTROID X	.315	.188	.383
CENTROID Y	.174	-.027	-.038
POA TO CENTROID in.	.360	.190	.385
MIN RADIUS	.441	.385	.463
MEAN RADIUS	1.126	.988	.899
MAX RADIUS	2.134	1.560	1.654
HORIZONTAL SPREAD	2.825	2.623	2.356
VERTICAL SPREAD	2.528	1.242	1.242
EXTREME SPREAD	3.413	2.692	2.662
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

8 May 1991

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CENTERFIRE PATTERNS # 4

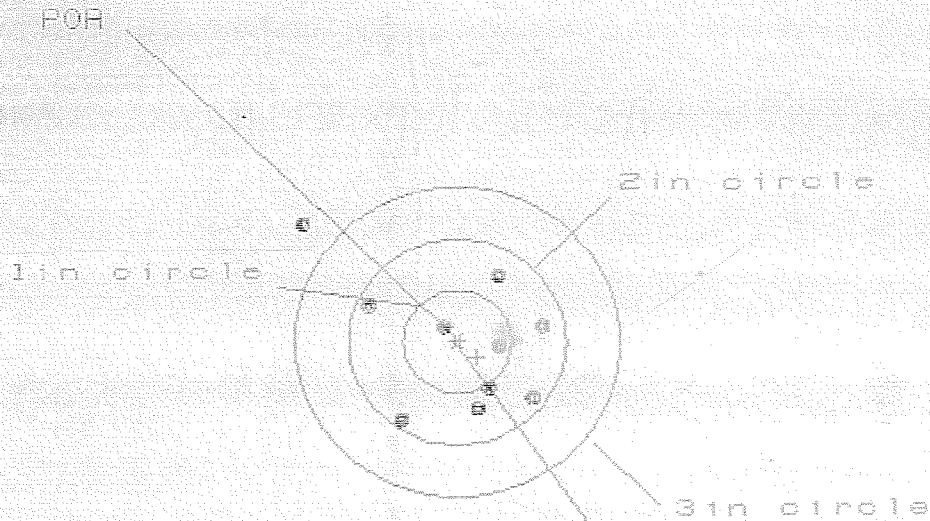


PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.580	1.213	1.158
MINIMUM X	-3.383	-1.325	-1.380
MAXIMUM Y	.845	.800	.515
MINIMUM Y	-2.228	-2.273	-.887
CENTROID X	-.331	.036	.091
CENTROID Y	-.217	-.172	.113
POA TO CENTROID in.	.396	.175	.145
MIN RADIUS	.332	.465	.467
MEAN RADIUS	1.363	1.086	.888
MAX RADIUS	3.327	2.316	1.385
HORIZONTAL SPREAD	4.882	2.538	2.538
VERTICAL SPREAD	3.073	3.073	1.402
EXTREME SPREAD	5.017	3.403	2.555
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811757.J

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 2.143

VS= 1.844

GS= 2.717

CENTROID #

PATTERN #	1	5	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	.743	.587	.656	
MINIMUM X	-1.400	-.980	-.911	
MAXIMUM Y	1.130	.744	.686	
MINIMUM Y	-.714	-.588	-.648	
CENTROID X	-.182	-.026	-.095	
CENTROID Y	.150	.024	.082	
POA TO CENTROID in.	.236	.036	.128	
MIN RADIUS	.171	.238	.270	
MEAN RADIUS	.771	.615	.608	
MAX RADIUS	1.799	1.094	1.007	
HORIZONTAL SPREAD	2.143	1.567	1.517	
VERTICAL SPREAD	1.844	1.332	1.332	
EXTREME SPREAD	2.717	1.800	1.644	
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	9		