

C6636107

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

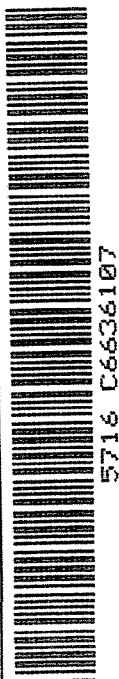
DU PONT

SERIAL NO.
C6636107

ORDER NO.
5716

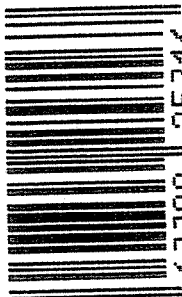
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636107

UPC



0 42700 25716 7

GUN SERIAL #

C6636107

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	JS
617	Drill and Tap Sight Holes		APR 19 1991	W.B.
618	Polish Barrel		APR 19 1991	W.B.
620	Apply Coatings (Barrel Action)		5/10/91	JA
	Apply Coating (Bolt)		5/10/91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/22/91	K.S.
	D) Oil Firing Pin Ass'y		5/22/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JS

op. #	BARBER - M24 0037779	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/24/91	SL
	G) Safety Off Force	3	3	3			5/24/91	SL
	H) Trigger Pull Test & Retainability						5/24/91	SL
	I) Firing Pin Indent	.0225	.0225	.0225			5/24/91	SL
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	KS
	M) Iron Sight Alignment						5/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	KS
	O) Attach Scope to Rifle						5/25/91	KS
	P) Detach & Attach Scope 20 Times						5/25/91	KS
640	Gallery Target & Test						6/1/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/1/91	KT
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	2.40	2.27	2.24	2.24	2.29	6/3/91	SL
	C) Function						6-3-91	D/H
660	Pack						6-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636107

DATE 5/24/91

TESTER SM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.28	2.27	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.30	2.33	2.27	
PULL #3	2.24	2.30	2.36	2.29	
PULL #4	2.28	2.35	2.44	2.29	
PULL #5	2.27	2.29	2.43	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.50		
PULL #2	3.26	3.33		
PULL #3	3.29	3.37		
PULL #4	3.30	3.30		
PULL #5	3.29	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.25		4.33
PULL #2	4.11	4.23		4.33
PULL #3	4.15	4.29		4.27
PULL #4	4.23	4.27		4.35
PULL #5	4.25	4.14		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06636107
 1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.285351
1 TO	2	.494818
1 TO	3	.287253
1 TO	4	.380047
1 TO	5	.618606

34

<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0376
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0422
 THE RESULTING AVERAGE PO RADIUS FOR THIS RIFLE IS: .0565208
 THE AMP FOR THIS RIFLE IS: 1.1221

1 JUN 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836107

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

ME = 4.287

VS = 3.788

GS = 5.598

CENTROID *

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.544

1.136

.954

MINIMUM X

-1.743

-1.460

-1.356

MAXIMUM Y

2.402

1.398

1.282

MINIMUM Y

-1.305

-1.039

-1.155

CENTROID X

.124

-.159

.023

CENTROID Y

.257

-.010

.106

POB TO CENTROID in.

.285

.159

.108

MIN RADIUS

.128

.095

.136

MEAN RADIUS

.1271

.0956

.046

MAX RADIUS

3.499

1.731

1.368

HORIZONTAL SPREAD

4.287

2.596

2.310

VERTICAL SPREAD

3.788

2.437

2.437

EXTREME SPREAD

5.598

3.186

2.643

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

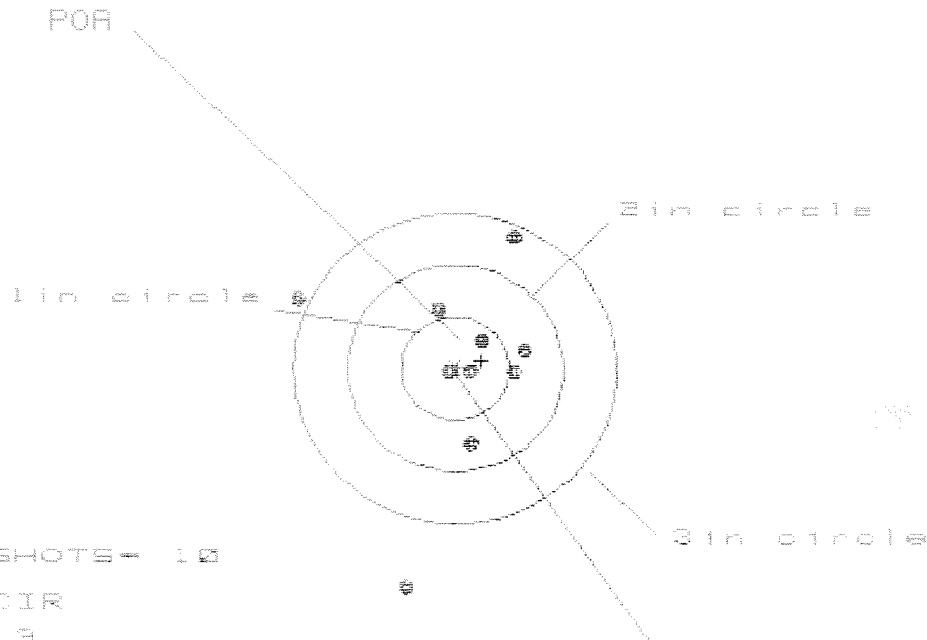
NUMBER IN THREE INCH CIRCLE =

8

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06638187

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.081

VS = 3.439

GS = 3.576

PATTERN # : 75W

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.634	.581	.394
MINIMUM X	-1.447	-1.500	-.352
MAXIMUM Y	1.295	1.057	1.111
MINIMUM Y	-2.144	-.997	-.943
CENTROID X	-.242	-.189	-.002
CENTROID Y	-.076	.162	.108
POA TO CENTROID in.	.254	.249	.188
MIN RADIUS	.187	.201	.185
MEAN RADIUS	.828	.656	.505
MAX RADIUS	2.197	1.562	1.141
HORIZONTAL SPREAD	2.081	2.081	.746
VERTICAL SPREAD	3.439	2.054	2.054
EXTREME SPREAD	3.576	2.145	2.088
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836107

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.971

VS = 3.221

GS = 3.388

CENTROID *

PATTERN

107

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.567	1.513	.956
MINIMUM X	-1.404	-1.458	-1.269
MAXIMUM Y	1.263	1.046	1.107
MINIMUM Y	-1.958	-1.249	-1.188
CENTROID X	.041	.095	-.094
CENTROID Y	-.018	.199	.138
POA TO CENTROID in.	.045	.221	.167
MIN RADIUS	.257	.254	.061
MEAN RADIUS	1.101	.973	.968
MAX RADIUS	2.017	1.590	1.311
HORIZONTAL SPREAD	2.971	2.971	2.225
VERTICAL SPREAD	3.221	2.295	2.295
EXTREME SPREAD	3.388	3.050	2.528
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C863B107

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 4.748

VS= 4.211

GS= 6.312

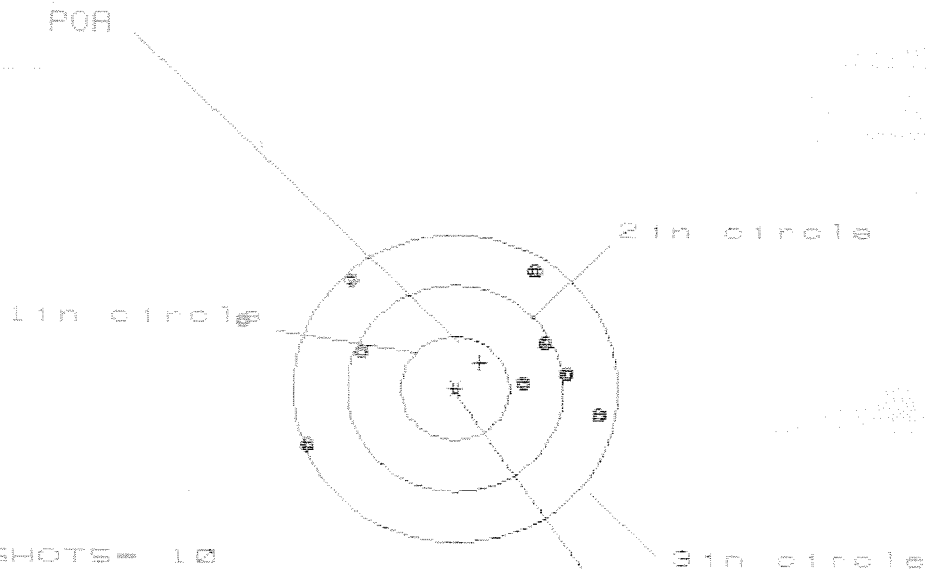
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	3.369	.721	.596
MINIMUM X	-1.379	-1.005	-.885
MAXIMUM Y	1.993	2.209	1.959
MINIMUM Y	-2.218	-2.002	-1.515
CENTROID X	.118	-.256	-.131
CENTROID Y	-.123	-.339	-.089
POA TO CENTROID in.	.171	.425	.158
MIN RADIUS	.258	.183	.182
MEAN RADIUS	1.458	1.128	.976
MAX RADIUS	3.888	2.240	2.001
HORIZONTAL SPREAD	4.748	1.726	1.481
VERTICAL SPREAD	4.211	4.211	3.474
EXTREME SPREAD	6.312	4.272	3.541
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638187

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.322

VS= 4.132

CS= 4.614

CENTROID: #

PATTERN

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.318

1.401

1.160

MINIMUM X

-2.004

-1.921

-1.572

MAXIMUM Y

1.101

.764

.806

MINIMUM Y

-3.031

-.932

-.890

CENTROID X

-.229

-.312

-.071

CENTROID Y

-.251

.086

.044

POA TO CENTROID in.

.339

.323

.084

MIN RADIUS

.656

.779

.540

MEAN RADIUS

1.449

1.223

1.079

MAX RADIUS

3.122

1.950

1.806

HORIZONTAL SPREAD

3.322

3.322

2.732

VERTICAL SPREAD

4.132

1.696

1.696

EXTREME SPREAD

4.614

3.453

2.751

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

7

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C5636107
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.195256
1 TO	2	.357687
1 TO	3	.437138
1 TO	4	.269358
1 TO	5	.338009

✱ (----POA

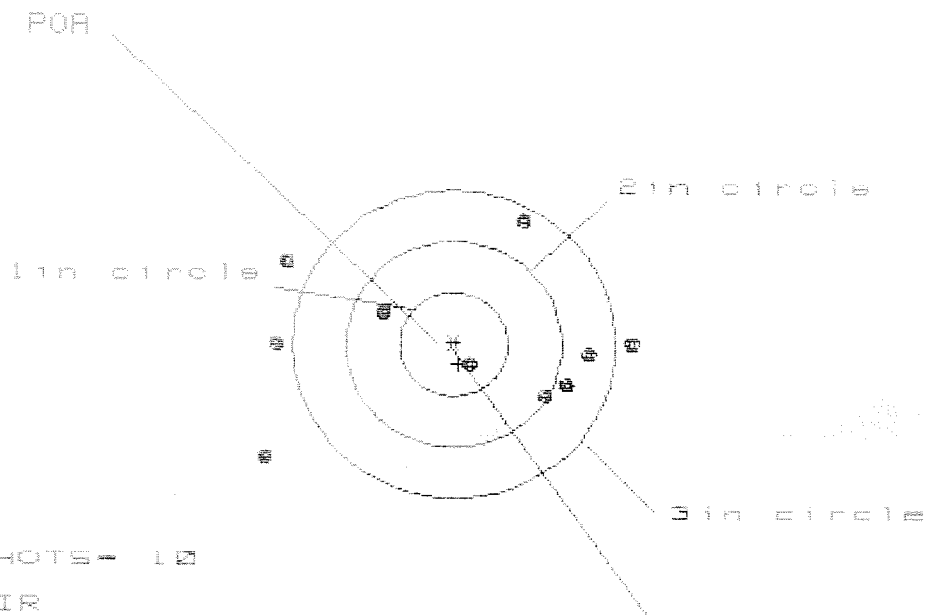
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1136
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114534

THE AMR FOR THIS RIFLE IS: 1.127

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636107.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 6

HS = 3.372

VS = 2.324

GS = 3.570

CENTROID #

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.622	1.427	1.214
MINIMUM X	-1.750	-1.809	-2.022
MAXIMUM Y	1.200	1.075	1.155
MINIMUM Y	-1.124	-.641	-.561
CENTROID X	-.045	.150	.363
CENTROID Y	.190	.315	.235
POA TO CENTROID IN.	.195	.349	.433
MIN RADIUS	.258	.313	.328
MEAN RADIUS	1.264	1.147	1.012
MAX RADIUS	2.080	1.820	2.024
HORIZONTAL SPREAD	3.372	3.236	3.236
VERTICAL SPREAD	2.324	1.716	1.716
EXTREME SPREAD	3.570	3.237	3.237
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

17 Jun 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6636107.1

CENTERFIRE PATTERNS # 2

POB

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 1.761

VS = 2.897

GS = 3.255

CENTROID *

PATTERN #

1

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.952

.893

.637

MINIMUM X

-.889

-.868

-.757

MAXIMUM Y

1.264

1.082

.777

MINIMUM Y

-1.633

-1.274

-1.139

CENTROID X

.289

.348

.237

CENTROID Y

.062

.244

.108

POB TO CENTROID in.

.296

.425

.260

MIN RADIUS

.241

.412

.383

MEAN RADIUS

.902

.789

.716

MAX RADIUS

1.718

1.466

1.294

HORIZONTAL SPREAD

1.761

1.761

1.394

VERTICAL SPREAD

2.897

2.356

1.916

EXTREME SPREAD

3.255

2.859

2.089

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636107.1

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.684

VS= 3.296

GS= 3.297

CENTROID *

PATTERN

	10	9	8
SHOTS (BEST DF)	10	9	8
MAXIMUM X	1.163	1.228	1.046
MINIMUM X	-1.522	-1.456	-1.513
MAXIMUM Y	1.291	1.069	1.072
MINIMUM Y	-2.005	-1.131	-1.128
CENTROID X	.028	-.037	.144
CENTROID Y	-.241	-.019	-.022
POA TO CENTROID in.	.243	.042	.146
MIN RADIUS	.334	.176	.311
MEAN RADIUS	1.054	.922	.833
MAX RADIUS	2.091	1.456	1.544
HORIZONTAL SPREAD	2.684	2.684	2.559
VERTICAL SPREAD	3.296	2.200	2.200
EXTREME SPREAD	3.297	2.684	2.573
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6696107.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.939

VS= 1.981

GS= 3.038

CENTROID *

PATTERN #

4

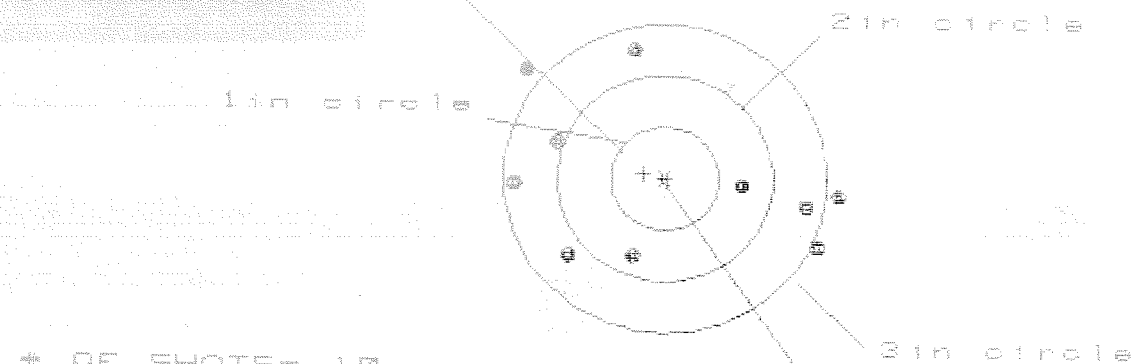
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.262	1.076	.848
MINIMUM X	-1.677	-1.821	-1.467
MAXIMUM Y	.679	.675	.721
MINIMUM Y	-1.302	-1.306	-1.260
CENTROID X	.100	.286	.514
CENTROID Y	-.037	-.033	-.079
POA TO CENTROID in.	.106	.288	.520
MIN RADIUS	.309	.146	.132
MEAN RADIUS	1.143	1.051	.916
MAX RADIUS	1.677	1.858	1.612
HORIZONTAL SPREAD	2.939	2.897	2.315
VERTICAL SPREAD	1.981	1.981	1.981
EXTREME SPREAD	3.038	3.038	2.593
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

12 JUN 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B36:07.1

CENTERFIRE PATTERNS # 5

POB



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 3.033

VS= 2.011

CS= 3.202

CENTROID #

PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.640	1.497	1.455
MINIMUM X	-1.393	-1.536	-1.349
MAXIMUM Y	1.246	1.364	1.358
MINIMUM Y	-1.765	-1.647	-1.653
CENTROID X	.196	.339	.151
CENTROID Y	-.047	-.165	-.159
POB TO CENTROID IN.	.201	.377	.220
MIN RADIUS	.754	.613	.668
MEAN RADIUS	1.274	1.213	1.167
MAX RADIUS	1.670	1.536	1.554
HORIZONTAL SPREAD	3.033	3.033	2.803
VERTICAL SPREAD	2.011	2.011	2.011
EXTREME SPREAD	3.202	3.034	2.861
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		7	