

C6636108

MODEL 700™ M24

Model **SMS**™

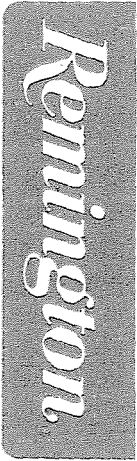
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington®

MODEL 700™ M24

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

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

SERIAL NO.
C6636108

ORDER NO.
5716

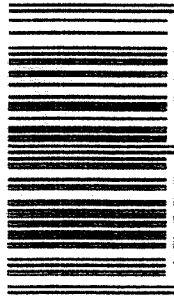
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636108

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636108

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

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/24/91	PH
	G) Safety Off Force	3	3	3			5/24/91	PH
	H) Trigger Pull Test & Retainability						5/23/91	PH
	I) Firing Pin Indent	.0215	.0225	.0225			5/24/91	PH
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs						6-8-91	PH
	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						6-4-91	PH
	A) Time						6-4-91	PH
	B) Malfunctions						6-4-91	PH
	C) Pierced Primers						6-4-91	PH
	D) Optical Clarity of Scope						6-4-91	PH
645	Inspect for Live Ammo						6-4-91	PH
655	Final Inspection							
	A) Headspace						6-8-91	PH
	B) Trigger Pull	2.54	2.51	2.49	2.52	2.53	6-8-91	PH
	C) Function						6-8-91	PH
660	Pack						6-14-91	PH

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

SERIAL NO. C6636108DATE 5/24/91TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.51	2.50	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.53	2.37	2.51	
PULL #3	2.55	2.56	2.58	2.49	
PULL #4	2.56	2.56	2.53	2.52	
PULL #5	2.52	2.55	2.53	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.22		
PULL #2	3.24	3.20		
PULL #3	3.19	3.21		
PULL #4	3.22	3.23		
PULL #5	3.20	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.31		4.31
PULL #2	4.32	4.30		4.30
PULL #3	4.28	4.33		4.32
PULL #4	4.29	4.33		4.32
PULL #5	4.32	4.31		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636108

4 JUN 1991

CENTROIDAL DISTANCES

0 TO 1	.147231
1 TO 2	.104019
1 TO 3	.172905
1 TO 4	.356093
1 TO 5	.338362

47

<----POB

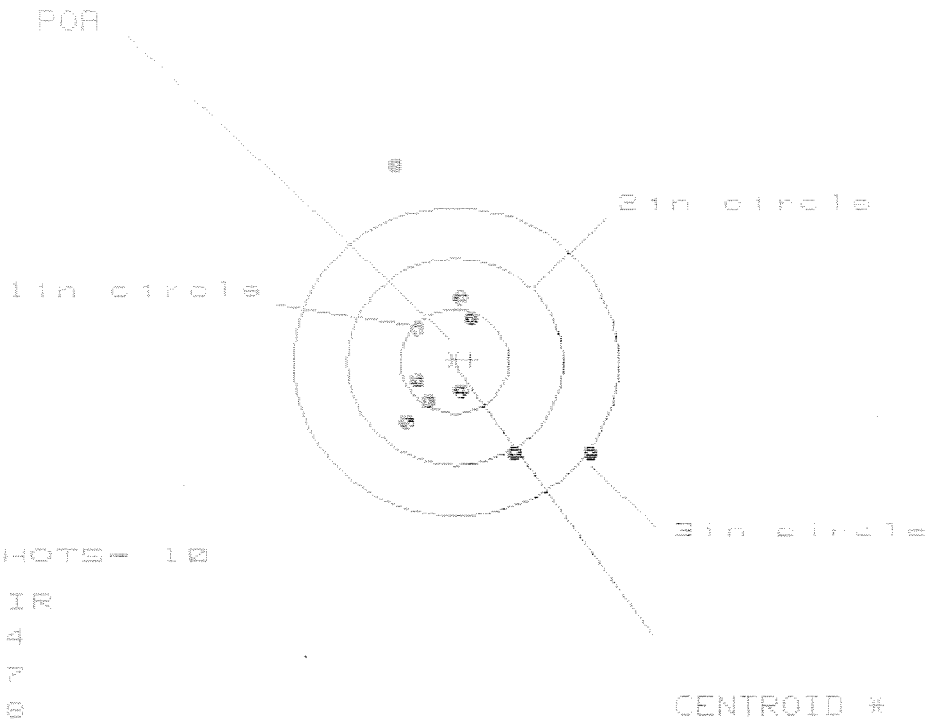
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0922
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .147
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168422

THE AMP FOR THIS RIFLE IS: .09222

4 Jun 1991

FILE: \PATTERNING\CENTERFIRE_PATT\C8635108

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 1.727

VS= 2.867

GS= 3.347

PATTERN #

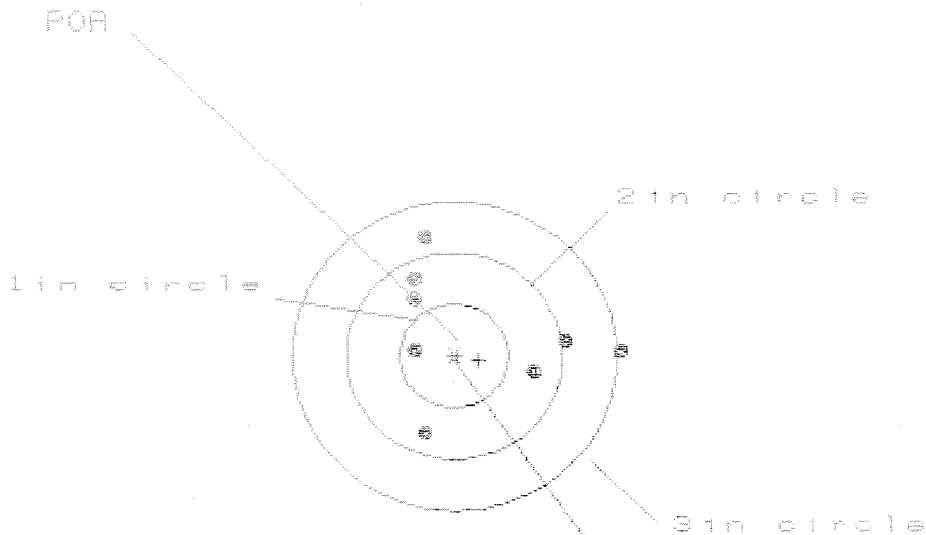
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.218	1.152	.624
MINIMUM X	-.517	-.496	-.352
MAXIMUM Y	1.962	.855	.778
MINIMUM Y	1.985	1.687	-.766
CENTROID X	-.146	-.088	-.232
CENTROID Y	-.019	-.237	-.152
POA TO CENTROID in.	.147	.253	.277
MIN RADIUS	.624	.084	.212
MEAN RADIUS	1.882	1.643	.527
MAX RADIUS	2.029	1.341	.988
HORIZONTAL SPREAD	1.727	1.648	.976
VERTICAL SPREAD	2.867	1.542	1.535
EXTREME SPREAD	3.347	1.958	1.625
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636108

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.837

VS= 3.113

GS= 3.450

CENTROID #

PATTERN

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.498	1.349	1.086
MINIMUM X	-1.339	-.531	-.362
MAXIMUM Y	1.157	.940	.914
MINIMUM Y	-1.956	-.920	-.946
CENTROID X	-.228	-.079	-.248
CENTROID Y	.045	.262	.260
POA TO CENTROID in.	.232	.274	.380
MIN RADIUS	.356	.587	.356
MEAN RADIUS	.982	.816	.704
MAX RADIUS	2.370	1.365	1.009
HORIZONTAL SPREAD	2.837	1.880	1.368
VERTICAL SPREAD	3.113	1.860	1.860
EXTREME SPREAD	3.450	2.072	1.861
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

Jun 1591

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.971

VS= 1.919

GS= 2.202

CENTROID *

PATTERN

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.946	1.033	.916
MINIMUM X	-1.022	-.938	-.766
MAXIMUM Y	.957	.850	.872
MINIMUM Y	-.962	-.793	-.771
CENTROID X	.004	-.081	.036
CENTROID Y	.067	.174	.152
POA TO CENTROID in.	.067	.192	.156
MIN RADIUS	.180	.155	.236
MEAN RADIUS	.705	.638	.596
MAX RADIUS	1.226	1.039	.941
HORIZONTAL SPREAD	1.971	1.971	1.682
VERTICAL SPREAD	1.919	1.643	1.643
EXTREME SPREAD	2.202	1.992	1.755
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CSB35100

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 3.014

VS= 2.707

GS= 3.042

CENTROID #

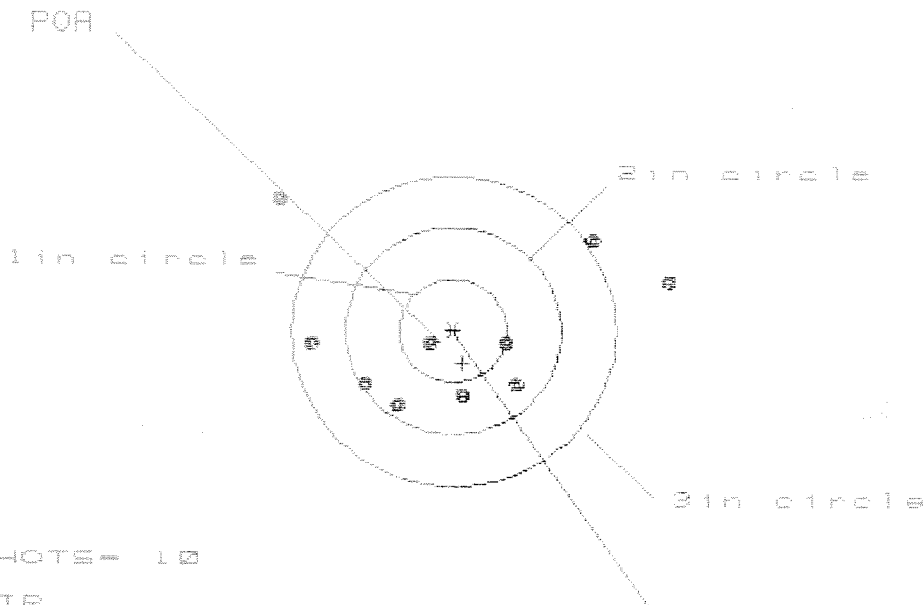
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.257	1.062	1.096
MINIMUM X	-1.757	-1.190	-1.156
MAXIMUM Y	1.298	1.368	1.201
MINIMUM Y	-1.409	-1.339	-0.950
CENTROID X	.045	.240	.206
CENTROID Y	.328	.258	.425
POA TO CENTROID in.	.331	.352	.472
MIN RADIUS	.167	.320	.229
MEAN RADIUS	1.014	.936	.867
MAX RADIUS	1.867	1.431	1.496
HORIZONTAL SPREAD	3.014	2.252	2.252
VERTICAL SPREAD	2.707	2.707	2.151
EXTREME SPREAD	3.042	2.711	2.685
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636108

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 3.658

VS= 2.019

GS= 3.758

CENTROID *

PATTERN #

10

SHOTS (BEST OF)

10

9

8

MAXIMUM X	2.032	1.851	1.319
MINIMUM X	-1.626	-1.466	-1.234
MAXIMUM Y	1.309	1.066	1.140
MINIMUM Y	-1.710	-1.564	-1.490
CENTROID X	-.086	.095	-.137
CENTROID Y	.314	.168	.094
POA TO CENTROID in.	.325	.193	.166
MIN RADIUS	.227	.338	.176
MEAN RADIUS	1.100	.967	.802
MAX RADIUS	2.088	1.944	1.743
HORIZONTAL SPREAD	3.658	3.317	2.553
VERTICAL SPREAD	2.019	1.630	1.630
EXTREME SPREAD	3.758	3.359	2.742
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636100
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.264327
1 TO	2	.159524
1 TO	3	.0978008
1 TO	4	.207966
1 TO	5	.247051

14.5
4T

-----POA

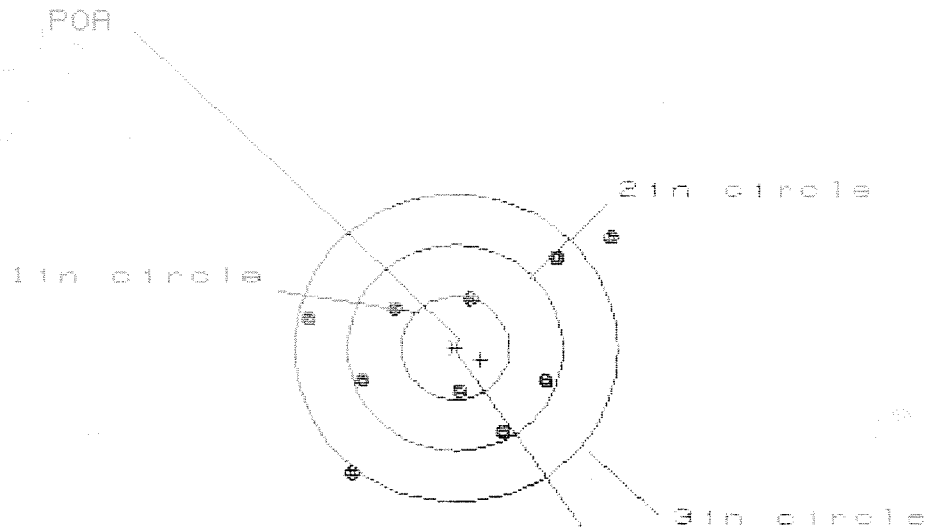
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2712
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .295441

THE AMR FOR THIS RIFLE IS: .8978

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8835108.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.804

VS= 2.317

GS= 3.270

CENTROID #

PATTERN #

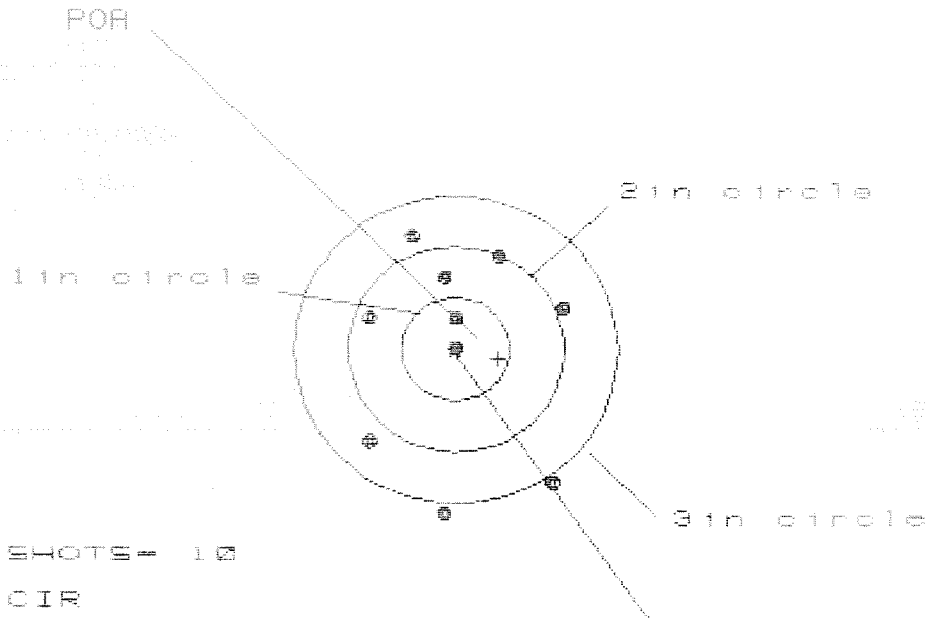
	10	9	8
SHOTS (BEST DF)	10	9	8
MAXIMUM X	1.395	1.073	.978
MINIMUM X	-1.409	-1.254	-1.349
MAXIMUM Y	1.092	.995	.857
MINIMUM Y	-1.225	-1.104	-.829
CENTROID X	-.238	-.393	-.298
CENTROID Y	.115	-.006	.132
POA TO CENTROID in.	.264	.393	.326
MIN RADIUS	.455	.401	.485
MEAN RADIUS	1.034	.939	.881
MAX RADIUS	1.771	1.463	1.383
HORIZONTAL SPREAD	2.804	2.327	2.327
VERTICAL SPREAD	2.317	2.099	1.686
EXTREME SPREAD	3.270	2.785	2.392
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636108.1

CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 1.782

VS = 2.747

GS = 2.788

CENTROID #

PATTERN

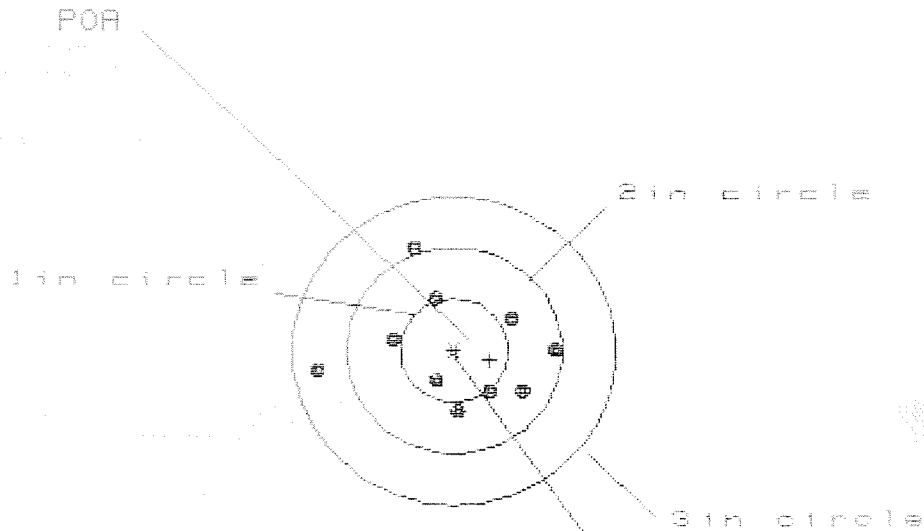
SHOTS (BEST OF)

		10	9	8
MAXIMUM X		.964	.948	1.060
MINIMUM X		-.818	-.834	-.722
MAXIMUM Y		1.138	.959	.773
MINIMUM Y		-1.609	-1.490	-1.227
CENTROID X		-.396	-.388	-.492
CENTROID Y		.093	.272	.459
POA TO CENTROID in.		.487	.467	.672
MIN RADIUS		.059	.125	.099
MEAN RADIUS		.954	.835	.687
MAX RADIUS		1.616	1.740	1.392
HORIZONTAL SPREAD		1.782	1.782	1.782
VERTICAL SPREAD		2.747	2.449	1.999
EXTREME SPREAD		2.788	2.788	2.134
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636100.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.216

VS= 1.554

GS= 2.222

CENTROID #

PATTERN #

3

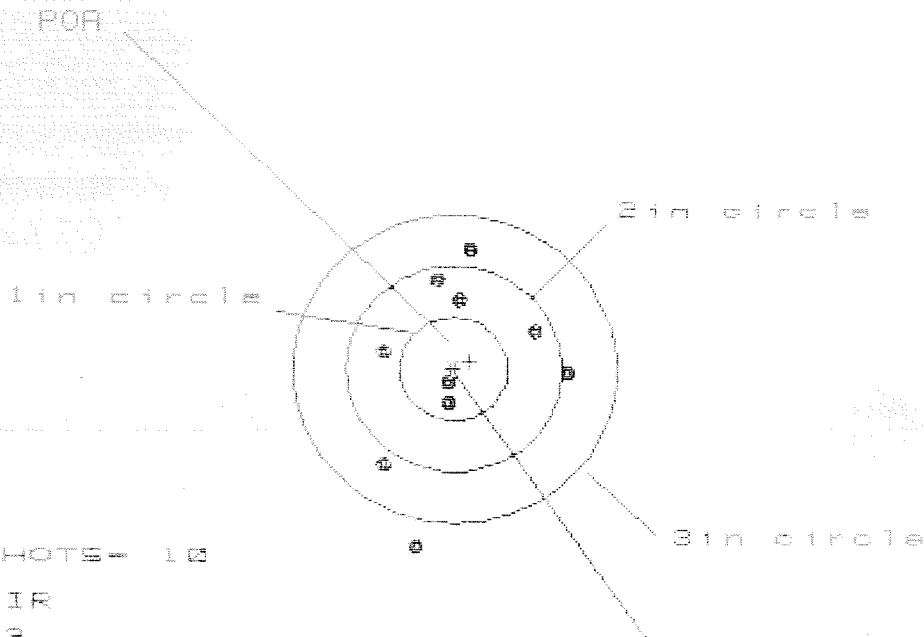
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.945	.804	.740
MINIMUM X	-1.271	-.667	-.731
MAXIMUM Y	1.008	.985	.591
MINIMUM Y	-.546	-.569	-.445
CENTROID X	-.332	-.191	-.127
CENTROID Y	.088	.111	-.013
POA TO CENTROID in.	.344	.221	.128
MIN RADIUS	.382	.464	.331
MEAN RADIUS	.715	.641	.558
MAX RADIUS	1.287	1.110	.771
HORIZONTAL SPREAD	2.216	1.471	1.471
VERTICAL SPREAD	1.554	1.554	1.036
EXTREME SPREAD	2.222	1.719	1.482
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636188.1

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.771

VS= 2.954

GS= 2.999

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.099	1.047	1.059
MINIMUM X	-.681	-.724	-.712
MAXIMUM Y	1.188	.991	.838
MINIMUM Y	-1.766	-1.144	-1.020
CENTROID X	-.147	-.104	-.116
CENTROID Y	-.072	.124	-.000
POA TO CENTROID IN.	.164	.162	.116
MIN RADIUS	.147	.348	.225
MEAN RADIUS	.884	.773	.734
MAX RADIUS	1.807	1.337	1.226
HORIZONTAL SPREAD	1.771	1.771	1.771
VERTICAL SPREAD	2.954	2.135	1.858
EXTREME SPREAD	2.999	2.275	1.949
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635108.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.971

VS= 2.123

GS= 2.503

CENTROID *

PATTERN

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.021	.939	1.036
MINIMUM X	-.950	-1.032	-.935
MAXIMUM Y	1.266	1.051	.847
MINIMUM Y	-.857	-.716	-.585
CENTROID X	-.243	-.161	-.258
CENTROID Y	.362	.221	.090
POA TO CENTROID in.	.436	.273	.273
MIN RADIUS	.369	.265	.102
MEAN RADIUS	.902	.816	.714
MAX RADIUS	1.466	1.306	1.064
HORIZONTAL SPREAD	1.971	1.971	1.971
VERTICAL SPREAD	2.123	1.767	1.431
EXTREME SPREAD	2.503	2.382	1.975
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	