

C6636190

MODEL 700<sup>TM</sup> M24

Model **SMS** <sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

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

**MODEL 700<sup>TM</sup> M24**

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

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

**SERIAL NO.**  
C6636190

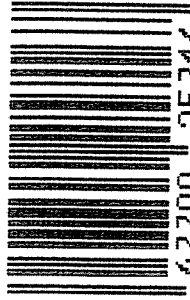
**ORDER NO.**  
**5716**

**20**



5716 C6636190

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636190

| OP. #     | OP. NAME                                                 | READINGS | DATE        | INIT |
|-----------|----------------------------------------------------------|----------|-------------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 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     | 28   |
| 617       | Drill and Tap Sight Holes                                |          | APR 19 1991 | F.B. |
| 618       | Polish Barrel                                            |          | APR 19 1991 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 5-10-91     | 14   |
|           | Apply Coating (Bolt)                                     |          |             |      |
| 625       | Final Assembly                                           |          | 5/22/91     | KS   |
|           | A) Clean inside of Bolt Assembly                         |          |             |      |
|           | 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     | 9/1  |

| Op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 5/24/91 | KS   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |      |      | 5/24/91 | KS   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 5/24/91 | KS   |
|              | I) Firing Pin Indent                                        | .021     | .021 | .021 |      |      | 5/24/91 | KS   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 5/29/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 6-1-91  | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 5/29/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 5/29/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 5/29/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 5/29/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 5/29/91 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 5-30-91 | NF   |
|              | A) Time                                                     |          |      |      |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 5-30-91 | NF   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 6-1-91  | D/H  |
|              | B) Trigger Pull                                             | 2.32     | 2.25 | 2.35 | 2.30 | 2.42 | 6/1/91  | KS   |
|              | C) Function                                                 |          |      |      |      |      | 6-1-91  | D/H  |
| 660          | Pack                                                        |          |      |      |      |      | 6-20-91 | NF   |

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

SERIAL NO. C6636190DATE 5/24/91TESTER JM

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS          |
|---------|------------------|--------------------------|--------------------------------|------|-------------------|
| PULL #1 | 2.22             | 2.36                     | 2.38                           | 2.32 | MIN. SETTING,     |
| PULL #2 | 2.18             | 2.39                     | 2.46                           | 2.25 | NO AVG. OF 5      |
| PULL #3 | 2.35             | 2.45                     | 2.48                           | 2.35 | READINGS ACCEPT-  |
| PULL #4 | 2.35             | 2.45                     | 2.50                           | 2.30 | ABLE LESS THAN 2# |
| PULL #5 | 2.36             | 2.42                     | 2.44                           | 2.42 |                   |
| TOTAL   |                  |                          |                                |      |                   |
| AVG.    |                  |                          |                                |      |                   |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.15             | 3.52                     |  |          |
| PULL #2 | 3.41             | 3.38                     |  |          |
| PULL #3 | 3.34             | 3.44                     |  |          |
| PULL #4 | 3.56             | 3.22                     |  |          |
| PULL #5 | 3.52             | 3.42                     |  |          |
| 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 | 4.41             | 4.60                     |                                | 4.20                                 |
| PULL #2 | 4.41             | 4.20                     |                                | 4.18                                 |
| PULL #3 | 4.38             | 4.24                     |                                | 4.14                                 |
| PULL #4 | 4.42             | 4.22                     |                                | 4.18                                 |
| PULL #5 | 4.56             | 4.21                     |                                | 4.18                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06636190  
30 May 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .469234 |
| 1 TO | 2 | .380789 |
| 1 TO | 3 | .272721 |
| 1 TO | 4 | .323215 |
| 1 TO | 5 | .244076 |

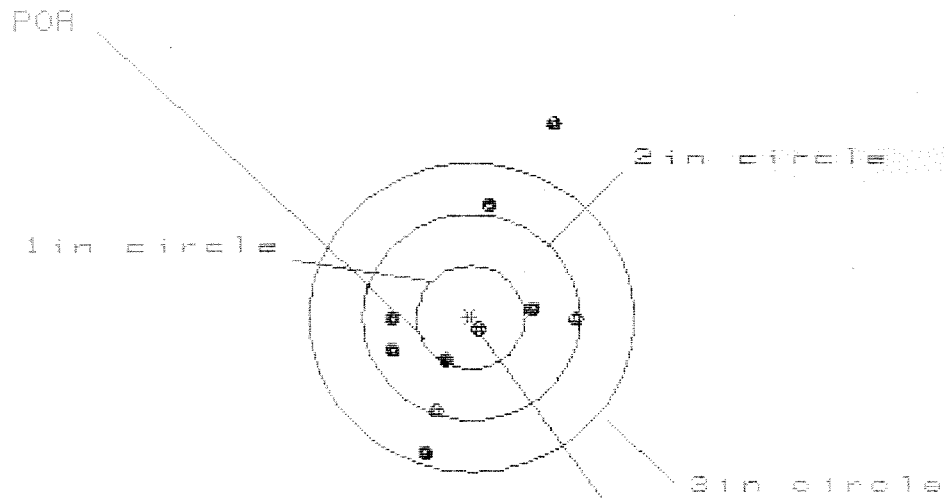
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1376  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1906  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .235073  
THE AMR FOR THIS RIFLE IS: 1.009

30 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8636150

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.728

VS= 3.178

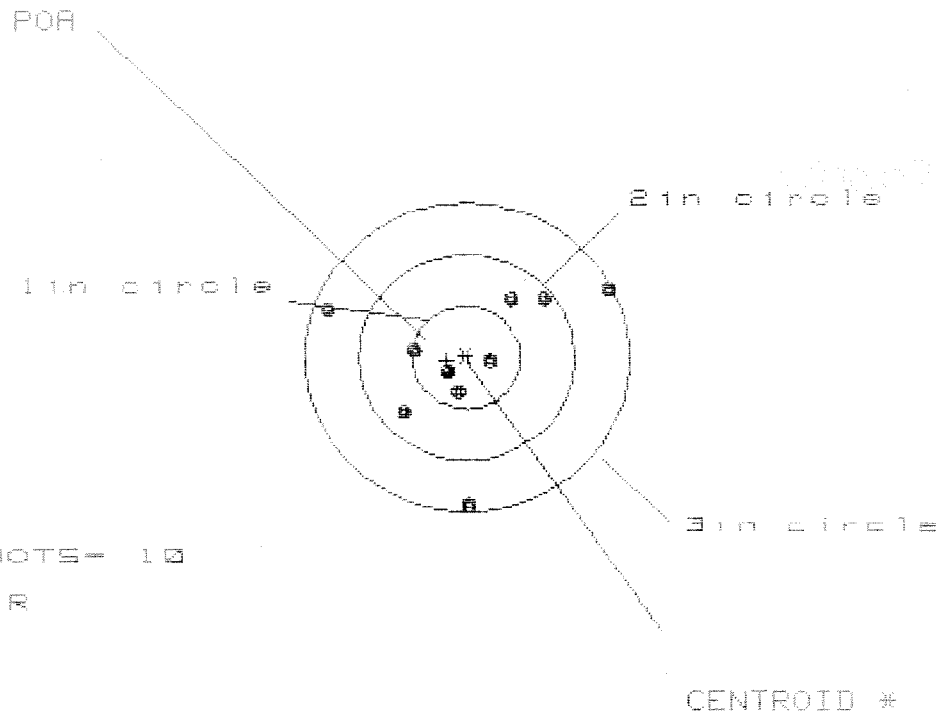
GS= 3.382

| PATTERN #                     | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .949   | 1.035  | .998  |
| MINIMUM X                     | -.779  | -.693  | -.731 |
| MAXIMUM Y                     | 1.848  | 1.266  | 1.125 |
| MINIMUM Y                     | -1.330 | -1.125 | -.882 |
| CENTROID X                    | .230   | .144   | .181  |
| CENTROID Y                    | .409   | .204   | .345  |
| POA TO CENTROID in.           | .469   | .250   | .389  |
| MIN RADIUS                    | .168   | .181   | .156  |
| MEAN RADIUS                   | .987   | .746   | .698  |
| MAX RADIUS                    | 2.002  | 1.288  | 1.143 |
| HORIZONTAL SPREAD             | 1.728  | 1.728  | 1.728 |
| VERTICAL SPREAD               | 3.178  | 2.391  | 1.927 |
| EXTREME SPREAD                | 3.382  | 2.451  | 1.996 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.540

VS= 2.113

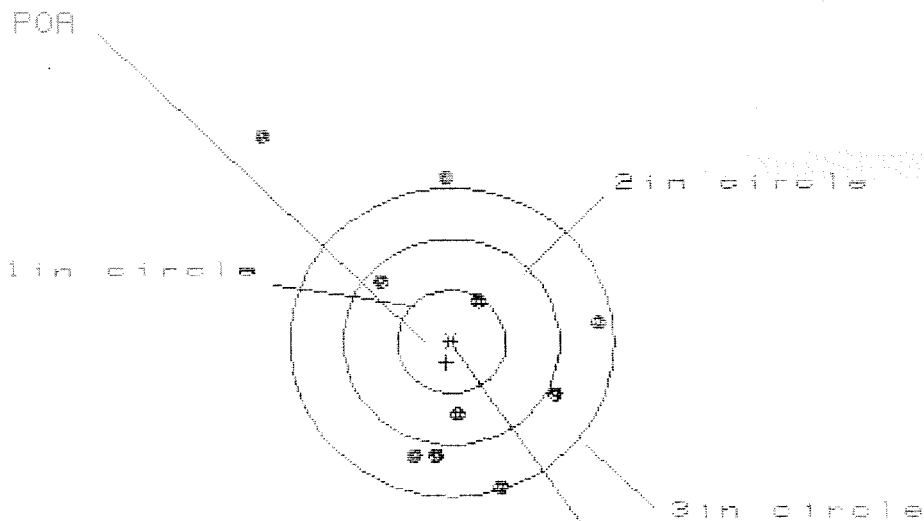
GS= 2.649

| PATTERN #                     | 2      | 2      | 2      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.329  | .881   | .736   |
| MINIMUM X                     | -1.311 | -1.164 | -.558  |
| MAXIMUM Y                     | .712   | .663   | .735   |
| MINIMUM Y                     | -1.401 | -1.322 | -1.250 |
| CENTROID X                    | .184   | .037   | .182   |
| CENTROID Y                    | .031   | -.048  | -.120  |
| POA TO CENTROID in.           | .187   | .061   | .218   |
| MIN RADIUS                    | .236   | .071   | .189   |
| MEAN RADIUS                   | .797   | .688   | .618   |
| MAX RADIUS                    | 1.508  | 1.329  | 1.250  |
| HORIZONTAL SPREAD             | 2.640  | 2.045  | 1.294  |
| VERTICAL SPREAD               | 2.113  | 1.985  | 1.985  |
| EXTREME SPREAD                | 2.649  | 2.299  | 2.079  |
| NUMBER IN ONE INCH CIRCLE =   |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 3

3in = 8

HS= 3.090

VS= 3.373

GS= 4.034

CENTROID #

PATTERN #

3

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | 1.320  | 1.123  | 1.091 |
| MINIMUM X                     | -1.770 | -.887  | -.919 |
| MAXIMUM Y                     | 1.963  | 1.824  | 1.064 |
| MINIMUM Y                     | -1.410 | -1.192 | -.964 |
| CENTROID X                    | .049   | .246   | .278  |
| CENTROID Y                    | .205   | -.013  | -.241 |
| POA TO CENTROID in.           | .211   | .246   | .368  |
| MIN RADIUS                    | .453   | .471   | .282  |
| MEAN RADIUS                   | 1.246  | 1.039  | .892  |
| MAX RADIUS                    | 2.643  | 1.842  | 1.406 |
| HORIZONTAL SPREAD             | 3.090  | 2.010  | 2.010 |
| VERTICAL SPREAD               | 3.373  | 3.016  | 2.020 |
| EXTREME SPREAD                | 4.034  | 3.057  | 2.323 |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 3      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |       |

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## CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS = 10

# IN CIR

1in = 0

2in = 4

3in = 7

HS = 3.849

VS = 1.787

GS = 3.859

PATTERN #

4

| SHOTS (BEST OF)               | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| MAXIMUM X                     | 1.574  | 1.322  | 1.256  |
| MINIMUM X                     | -2.275 | -1.616 | -1.451 |
| MAXIMUM Y                     | .784   | .780   | .740   |
| MINIMUM Y                     | -1.003 | -1.007 | -1.047 |
| CENTROID X                    | .132   | .384   | .219   |
| CENTROID Y                    | .101   | .105   | .145   |
| POA TO CENTROID in.           | .166   | .399   | .263   |
| MIN RADIUS                    | .508   | .511   | .452   |
| MEAN RADIUS                   | 1.188  | 1.042  | .991   |
| MAX RADIUS                    | 2.275  | 1.718  | 1.579  |
| HORIZONTAL SPREAD             | 3.849  | 2.938  | 2.707  |
| VERTICAL SPREAD               | 1.787  | 1.787  | 1.787  |
| EXTREME SPREAD                | 3.859  | 3.030  | 3.030  |
| NUMBER IN ONE INCH CIRCLE =   |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

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## CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 3.204

VS = 2.319

GS = 3.594

CENTROID #

| PATTERN #                   | : | 5      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.673  | 1.503 | .853  |
| MINIMUM X                   | : | -1.531 | -.951 | -.764 |
| MAXIMUM Y                   | : | 1.311  | .735  | .714  |
| MINIMUM Y                   | : | -1.008 | -.862 | -.883 |
| CENTROID X                  | : | .093   | .263  | .076  |
| CENTROID Y                  | : | .207   | .062  | .083  |
| POA TO CENTROID in.         | : | .228   | .271  | .112  |
| MIN RADIUS                  | : | .079   | .155  | .138  |
| MEAN RADIUS                 | : | .909   | .766  | .665  |
| MAX RADIUS                  | : | 2.016  | 1.512 | 1.000 |
| HORIZONTAL SPREAD           | : | 3.204  | 2.454 | 1.617 |
| VERTICAL SPREAD             | : | 2.319  | 1.597 | 1.597 |
| EXTREME SPREAD              | : | 3.594  | 2.593 | 1.801 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8     |       |