

06348971

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



	RECORDS CONTROL SCHEDULE
RECORDS CATEGORY OR TITLE: <u>117 - ILION PLANT LEDGER ACCOUNT</u>	
<u>1981</u>	
COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒	
TOTAL RETENTION: <u>UNTIL SUPERSEDED</u> <u>OR OBSOLETE</u>	
GS-11050 Rev. 8/78	

ACCOUNT - 1981

JR

Remington®  REG. U.S. PAT. & TM. OFF.

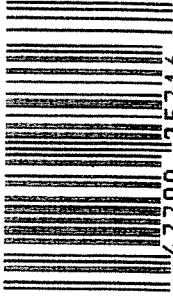
MODEL 700™ H24

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

SERIAL NO. C6348971

ORDER NO. 5716

 5716 C6348971

 0 47700 25716 7

LPC

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

GUN SERIAL #

C6348971

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY 10-9	89	RW
600	Proof	QUALITY 10-9	89	A.C.
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	10 1689		LB
618	Polish Barrel <i>LB</i>	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/89	LB

BARBER - M24 0042922								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	11/7/89	JL		
	G) Safety Off Force	3	3	3	11/7/89	JL		
	H) Trigger Pull Test & Retainability				6/10/89	JL		
	I) Firing Pin Indent	.022	.0215	.022	11/7/89	JL		
	J) Assemble Stock				11/9/89	JL		
	K) Assemble Swivel Studs				11/10/89	JL		
	L) Attach Front and Rear Sight Assemblies				11/9/89	JL		
	M) Iron Sight Alignment				11/9/89	JL		
	N) Detach Front & Rear Sights & place in numbered container				11/9/89	JL		
	O) Attach Scope to Rifle				11-9-89	JL		
	P) Detach & Attach Scope 20 Times				11-9-89	JL		
640	Gallery Target & Test				11-13-89	DH		
	A) Time				11-13-89	DH		
	B) Malfunctions				11-13-89	DH		
	C) Pierced Primers				11-13-89	DH		
	D) Optical Clarity of Scope				11-13-89	DH		
645	Inspect for Live Ammo				11-13-89	DH		
655	Final Inspection							
	A) Headspace				14/10/89	JL		
	B) Trigger Pull	249	268	266	264	271	14/10/89	JL
	C) Function						14/10/89	JL
660	Pack						14/Dec/89	JL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 8921

DATE 23 MAR 90

TESTER QD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.28	2.22	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.19	2.27	
PULL #3	2.18	2.23	2.21	
PULL #4	2.17	2.25	2.15	
PULL #5	2.17	2.27	2.24	
TOTAL	11.06	11.16		
AVG.	2.212	2.232		

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.26	3.09	
PULL #2	3.19	2.95	
PULL #3	3.22	3.21	
PULL #4	3.21	3.20	
PULL #5	3.22	3.19	
TOTAL	16.10	15.64	
AVG.	3.22	3.128	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.22		
PULL #2	4.24	4.23		
PULL #3	4.22	4.18		
PULL #4	4.20	4.21		
PULL #5	4.23	4.12		
TOTAL	21.10	20.96		
AVG.	4.22	4.192		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348971
13 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.304685
1 TO	2	.155293
1 TO	3	.519897
1 TO	4	.431393
1 TO	5	.146103

³
PM (----FOR

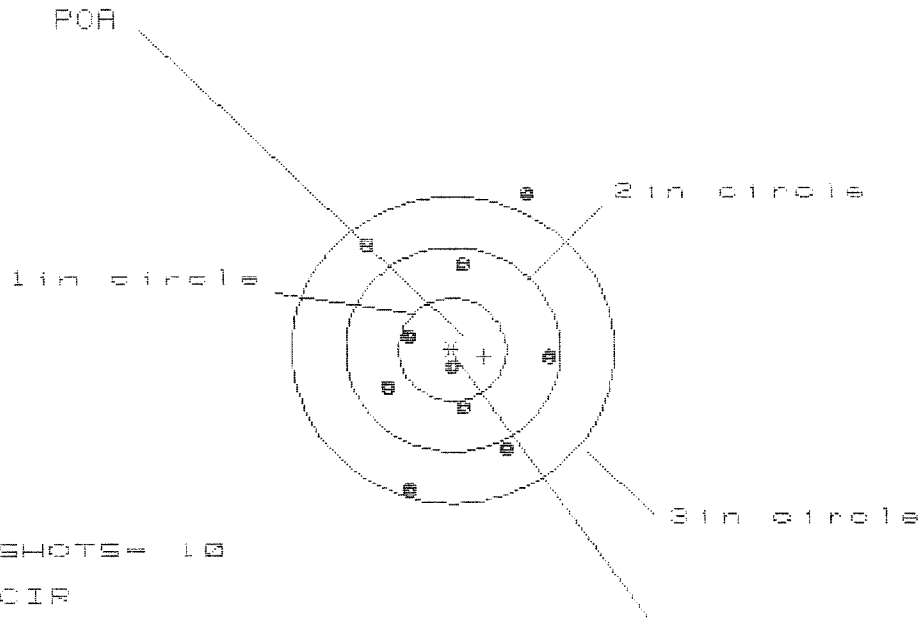
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0962
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .097
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136614
THE AMP FOR THIS RIFLE IS: .9264

13 Nov 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6348971

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.687

VS = 2.882

GS = 3.084

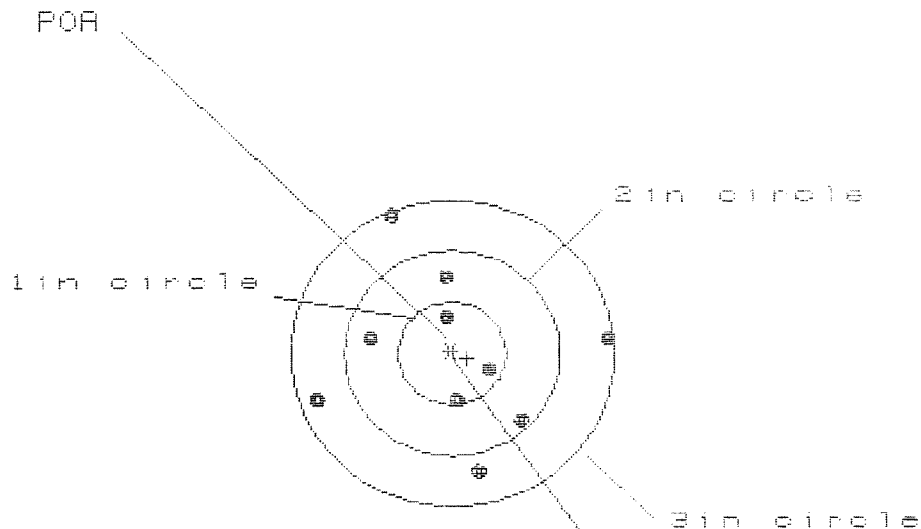
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.863	.945	.910
MINIMUM X	-.834	-.752	-.787
MAXIMUM Y	1.499	1.181	1.029
MINIMUM Y	-1.383	-1.216	-.946
CENTROID X	-.297	-.379	-.344
CENTROID Y	.068	-.099	.053
POA TO CENTROID in.	.305	.392	.348
MIN RADIUS	.153	.050	.135
MEAN RADIUS	.894	.775	.724
MAX RADIUS	1.669	1.400	1.295
HORIZONTAL SPREAD	1.697	1.697	1.697
VERTICAL SPREAD	2.882	2.397	1.975
EXTREME SPREAD	3.084	2.443	2.385
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

13 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348971

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.661

VS= 2.474

GS= 2.718

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.422	1.363	.709
MINIMUM X	-1.239	-1.298	-1.127
MAXIMUM Y	1.357	.937	.973
MINIMUM Y	-1.117	-.966	-.930
CENTROID X	-.143	-.084	-.255
CENTROID Y	.048	-.103	-.139
POA TO CENTROID in.	.151	.133	.290
MIN RADIUS	.353	.242	.315
MEAN RADIUS	.892	.810	.744
MAX RADIUS	1.456	1.394	1.149
HORIZONTAL SPREAD	2.661	2.661	1.836
VERTICAL SPREAD	2.474	1.903	1.903
EXTREME SPREAD	2.718	2.718	1.926
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B971

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS = 2.485

VS = 1.515

GS = 2.618

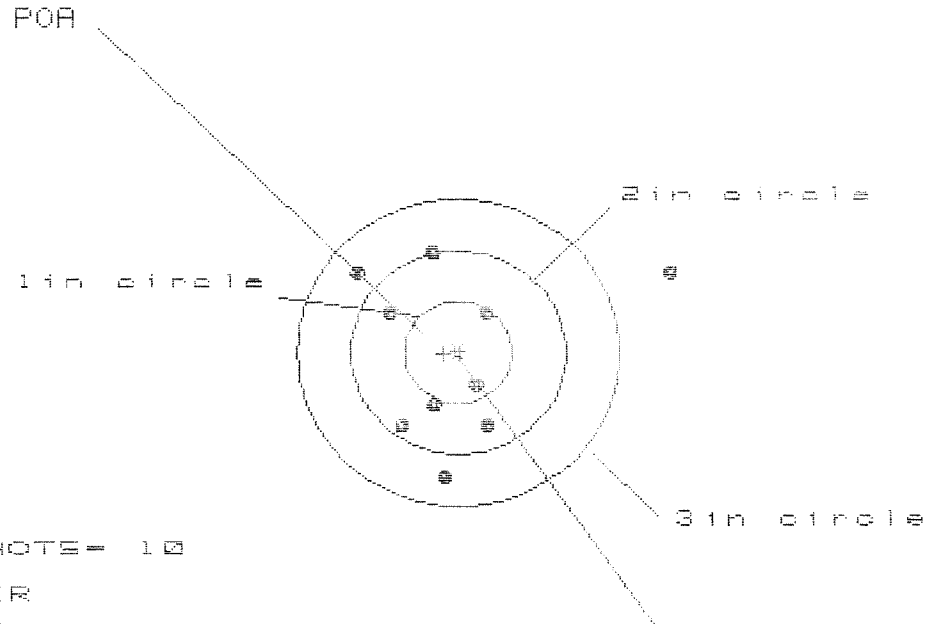
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.213	1.072	1.149
MINIMUM X	-1.272	-1.283	-1.149
MAXIMUM Y	.752	.667	.648
MINIMUM Y	-.763	-.430	-.449
CENTROID X	.080	.221	.087
CENTROID Y	.426	.511	.530
POA TO CENTROID in.	.434	.557	.537
MIN RADIUS	.357	.405	.456
MEAN RADIUS	.965	.892	.879
MAX RADIUS	1.483	1.334	1.211
HORIZONTAL SPREAD	2.485	2.355	2.298
VERTICAL SPREAD	1.515	1.097	1.097
EXTREME SPREAD	2.618	2.365	2.350
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348971

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.904

VS = 2.184

GS = 2.905

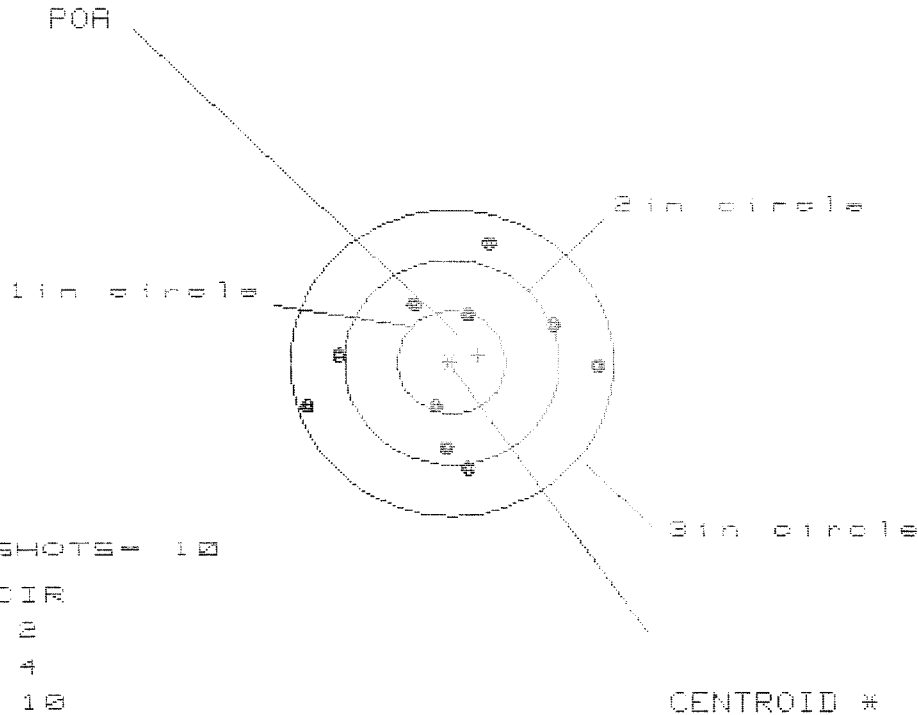
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.963	.525	.434
MINIMUM X	:	-.941	-.723	-.461
MAXIMUM Y	:	.989	1.072	1.185
MINIMUM Y	:	-1.195	-1.112	-.999
CENTROID X	:	.131	-.087	.004
CENTROID Y	:	.014	-.069	-.182
POA TO CENTROID in.	:	.132	.111	.182
MIN RADIUS	:	.346	.419	.326
MEAN RADIUS	:	.933	.779	.705
MAX RADIUS	:	2.101	1.155	1.189
HORIZONTAL SPREAD	:	2.904	1.248	.895
VERTICAL SPREAD	:	2.184	2.184	2.184
EXTREME SPREAD	:	2.905	2.186	2.186
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08848971

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS = 2.694

VS = 2.194

GS = 2.722

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.306
MINIMUM X	-1.388
MAXIMUM Y	1.187
MINIMUM Y	-1.007
CENTROID X	-.252
CENTROID Y	-.071
POR TO CENTROID in.	.262
MIN RADIUS	.428
MEAN RADIUS	.948
MAX RADIUS	1.444
HORIZONTAL SPREAD	2.694
VERTICAL SPREAD	2.194
EXTREME SPREAD	2.722
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	10

CONFIDENTIAL - OUR TESTS

BBL - 96003



RE00014588

Final Inspection

S.N. C6348971

DATE REC'D: 9-27-00

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☒ Scope☒ Scope Rings☒ Mounting Screws☒ Mounting Base☒ SCREWS☒ FINISH☒ Looseness☒ CLARITY

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☐ Scope Case☐ IRON SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER		14588	
SERIAL NUMBER		C6348971	
LOG-IN DATE		9-27-00	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-29-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	10-11-00	RW
605	CHECK HEADSPACE	10-11-00	CK
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-1-00	RW
655	FINAL INSPECT	11-3-00	CK
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

BARBER - M24 0042933

Remington Test Lab, Ilion, N.Y.

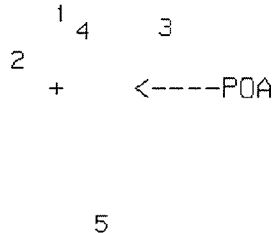
Centroidal distance calculations for Rifle # c6348971
1 Nov 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1932
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .223517

THE AMR FOR THIS RIFLE IS: 1.207

CENTROIDAL DISTANCES

Ø TO	1	.504397
1 TO	2	.426813
1 TO	3	.722626
1 TO	4	.197003
1 TO	5	1.46108

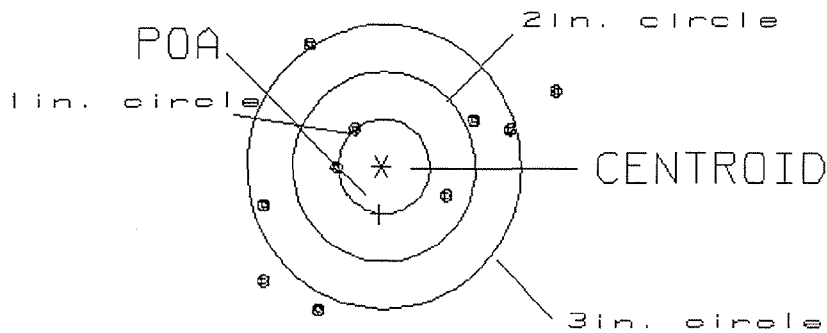


PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .505
 MIN RADIUS : .514
 MEAN RADIUS : 1.275
 MAX RADIUS : 2.070
 CENTROID X : .020
 CENTROID Y : .504

31 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348971

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.20
 VS= 2.84
 GS= 3.79

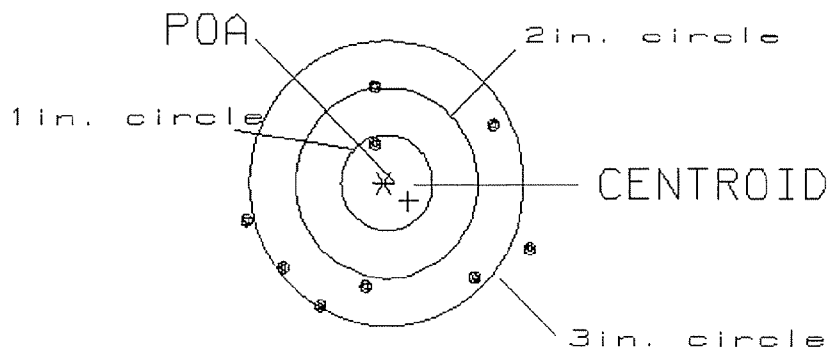
0
 3
 6

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .328
 MIN RADIUS : .404
 MEAN RADIUS : 1.476
 MAX RADIUS : 3.367
 CENTROID X : -.268
 CENTROID Y : .189

31 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348971

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.09
 VS= 4.63
 GS= 4.70

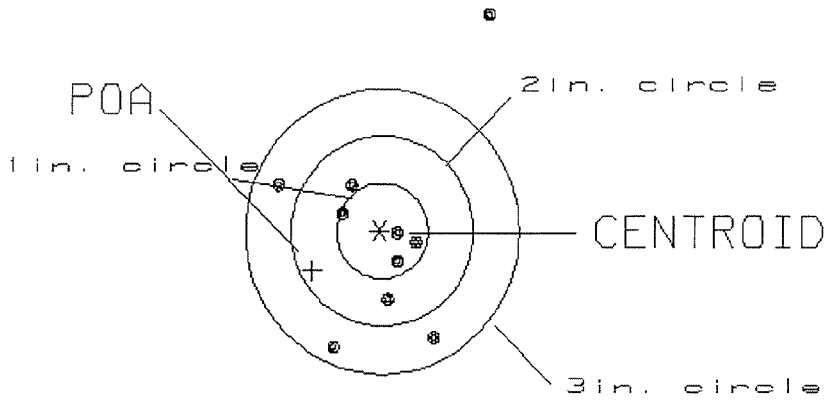
1
 2
 7

PATTERN #: 3
 POA TO CENTROID: .845
 MIN RADIUS : .155
 MEAN RADIUS : .918
 MAX RADIUS : 2.590
 CENTROID X : .737
 CENTROID Y : .414

31 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348971

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.39
 VS= 3.47
 GS= 3.89

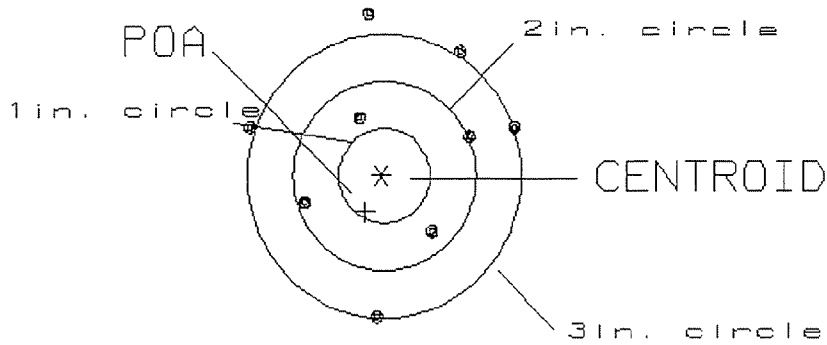
4
 6
 9

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .423
 MIN RADIUS : .633
 MEAN RADIUS : 1.386
 MAX RADIUS : 2.701
 CENTROID X : .177
 CENTROID Y : .385

31 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348971

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.83

0

VS= 4.35

4

GS= 4.38

5

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .978

MIN RADIUS : .170

MEAN RADIUS : .982

MAX RADIUS : 2.291

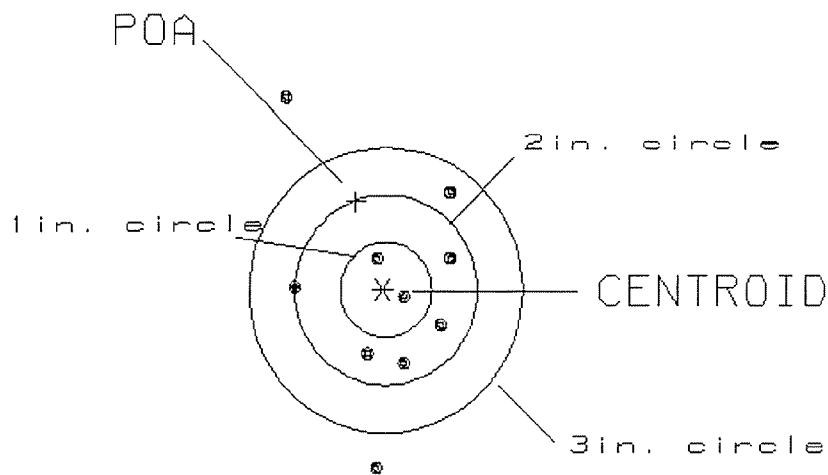
CENTROID X : .300

CENTROID Y : -.930

31 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348971

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.79

2

VS= 3.86

7

GS= 3.97

8