

C6348765

(Start Date)
6/21/87

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington



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

MODEL 700™ H24

SERIAL NO.
C6348765

ORDER NO.
5716

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

01



5716 C6348765

UPC



0 47700 25716 7

25

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498765

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5 2 90	RW
600	Proof		5 2 90	RW
607	Check Headspace		5 2 90	RW
610	Dis-assemble Gun		5 2 90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5-8-90	CS
617	Drill and Tap Sight Holes		5-9-90	FB
618	Polish Barrel RUB		5-10-90	WB
620	Apply Coatings (Barrel Action)		5-16-90	DA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/21/90	JH

BARBER - M24 0063419		READINGS			DATE	INIT		
op. #	OP. NAME							
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	5/22/90	WB		
	G) Safety Off Force	2	2	2	5/22/90	WB		
	H) Trigger Pull Test & Retainability				5/21/90	RL		
	I) Firing Pin Indent	.024	.0235	.0235	5/22/90	WB		
	J) Assemble Stock				5/22/90	RL		
	K) Assemble Swivel Studs				24 May 90	PD		
	L) Attach Front and Rear Sight Assemblies				5/22/90	RL		
	M) Iron Sight Alignment				5/22/90	RL		
	N) Detach Front & Rear Sights & place in numbered container				5/22/90	RL		
	O) Attach Scope to Rifle				5/22/90	WB		
	P) Detach & Attach Scope 20 Times				5/22/90	WB		
640	Gallery Target & Test				5-22-90	AC		
	A) Time				5-22-90	AC		
	B) Malfunctions				5-22-90	AC		
	C) Pierced Primers				5-22-90	AC		
	D) Optical Clarity of Scope				5-22-90	AC		
645	Inspect for Live Ammo				5-22-90	AC		
655	Final Inspection							
	A) Headspace				24 May 90	PD		
	B) Trigger Pull	245	222	216	218	227	24 May 90	PD
	C) Function						24 May 90	PD
660	Pack						6-7-90	DH

SWS TRIGGER PULL TEST

BARBER - M24 0063420

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06498765

DATE 5/21/89

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.16	2.25	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.45	2.22	2.22	
PULL #3	2.51	2.23	2.20	2.16	
PULL #4	2.39	2.33	2.31	2.18	
PULL #5	2.46	2.31	2.30	2.27	
TOTAL	12.23	11.48	11.28		
AVG.	2.446	2.296	2.256		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.07		
PULL #2	3.25	3.11		
PULL #3	3.42	3.19		
PULL #4	3.21	3.15		
PULL #5	3.25	3.16		
TOTAL	16.68	15.68		
AVG.	3.336	3.136		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.30		4.26
PULL #2	4.17	4.26		4.20
PULL #3	4.26	4.24		4.23
PULL #4	4.25	4.33		4.22
PULL #5	4.24	4.35		4.20
TOTAL	21.17	21.48		21.11
AVG.	4.234	4.296		4.222

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498765
23 May 1990

CENTROIDAL DISTANCES

0 TO	1	.348093
1 TO	2	.226497
1 TO	3	.652432
1 TO	4	.323903
1 TO	5	.337769

5.4 ³ <----POB

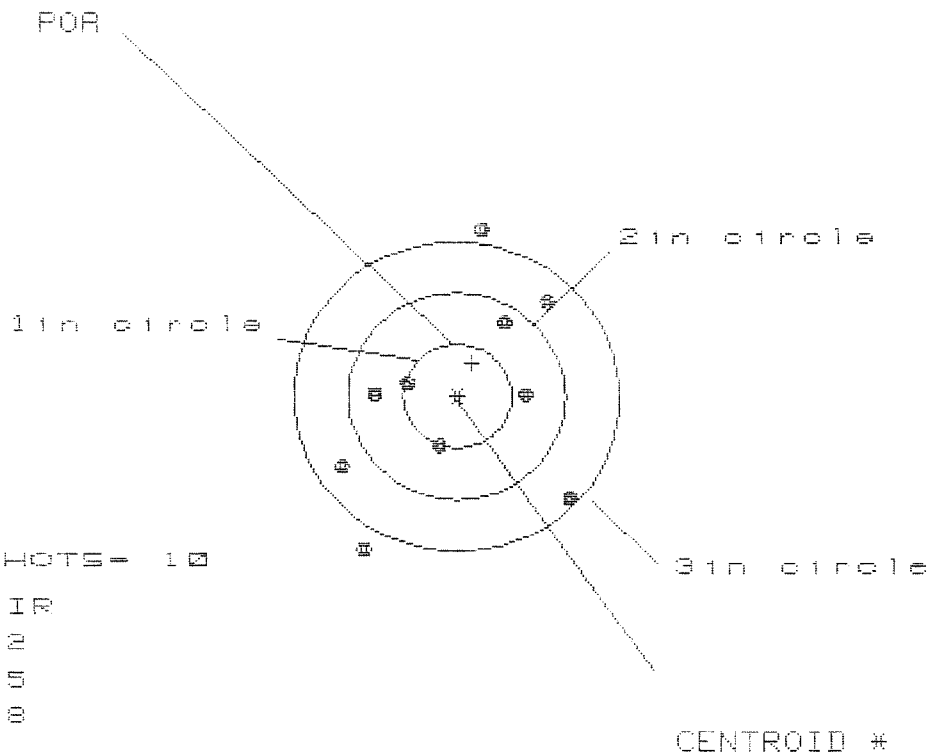
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1464
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0658
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168807
THE ANR FOR THIS RIFLE IS: .888

22 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CS436765

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

ME = 2.083

VO = 3.029

GS = 3.206

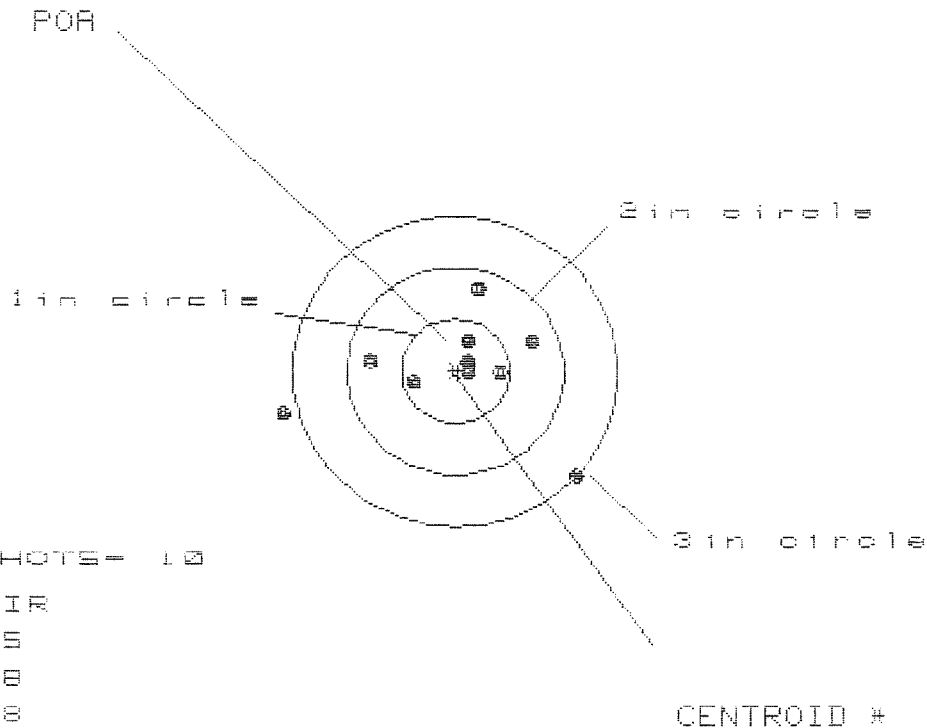
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.035	.941	.954
MINIMUM X	:	-1.048	-1.142	-1.129
MAXIMUM Y	:	1.592	1.432	.967
MINIMUM Y	:	-1.437	-1.100	-.921
CENTROID X	:	-.137	-.043	-.056
CENTROID Y	:	-.320	-.160	-.339
POR TO CENTROID in.	:	.348	.166	.344
MIN RADIUS	:	.460	.537	.491
MEAN RADIUS	:	1.051	.979	.908
MAX RADIUS	:	1.671	1.447	1.326
HORIZONTAL SPREAD	:	2.083	2.083	2.083
VERTICAL SPREAD	:	3.029	2.532	1.988
EXTREME SPREAD	:	3.206	2.666	2.515
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

22 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498785

CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 8

HS= 2.738

VS= 1.845

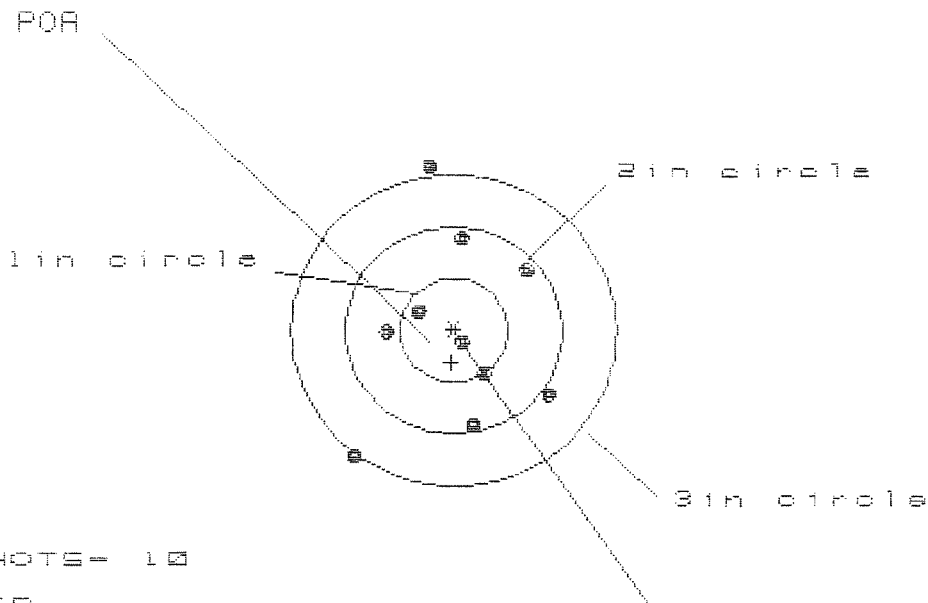
GS= 2.803

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.141	.964	.646
MINIMUM X	:	-1.597	-.966	-.846
MAXIMUM Y	:	.801	.752	.615
MINIMUM Y	:	-1.044	-1.093	-.288
CENTROID X	:	-.111	.066	-.055
CENTROID Y	:	-.095	-.046	.091
POA TO CENTROID in.	:	.147	.080	.106
MIN RADIUS	:	.085	.039	.120
MEAN RADIUS	:	.698	.553	.439
MAX RADIUS	:	1.657	1.457	.853
HORIZONTAL SPREAD	:	2.738	1.930	1.492
VERTICAL SPREAD	:	1.845	1.845	.903
EXTREME SPREAD	:	2.803	2.230	1.513
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

22 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08438765

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 1.835

VS= 2.738

GS= 2.834

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.868	.747
MINIMUM X	:	-.944	-.967	-.731
MAXIMUM Y	:	1.546	1.065	.938
MINIMUM Y	:	-1.192	-1.021	-.838
CENTROID X	:	.025	.048	.169
CENTROID Y	:	.312	.141	.268
POA TO CENTROID in.	:	.313	.149	.317
MIN RADIUS	:	.092	.084	.125
MEAN RADIUS	:	.839	.746	.664
MAX RADIUS	:	1.560	1.406	.953
HORIZONTAL SPREAD	:	1.835	1.835	1.478
VERTICAL SPREAD	:	2.738	2.086	1.768
EXTREME SPREAD	:	2.834	2.399	1.771
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

22 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08438785

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.013

VS = 2.028

GS = 2.474

CENTROID #

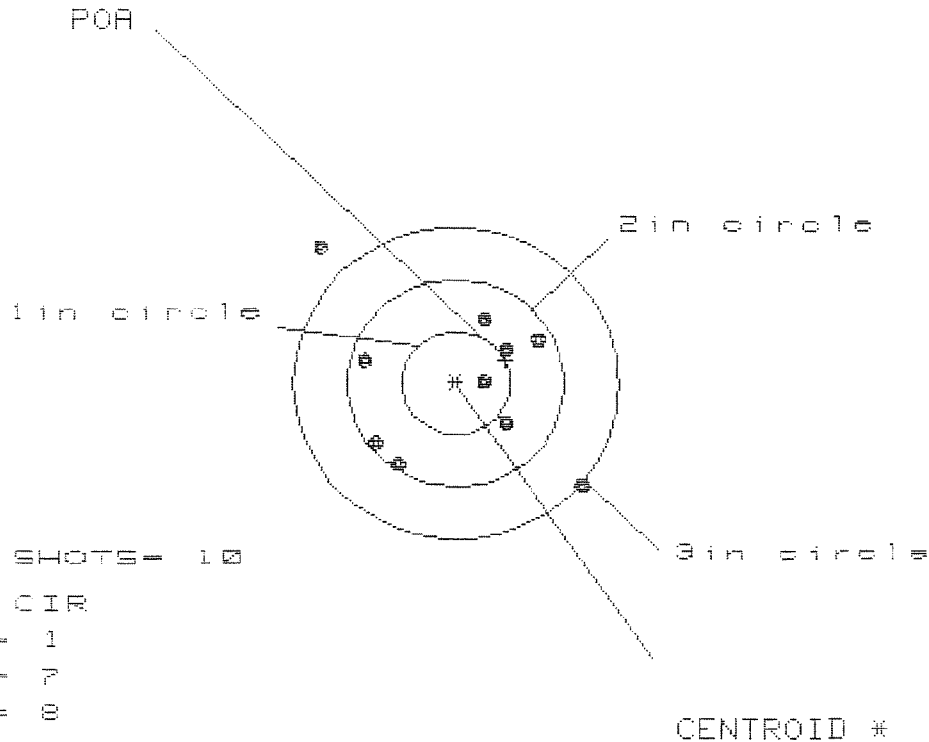
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	1.176	1.303
MINIMUM X	:	-.939	-.837	-.690
MAXIMUM Y	:	.989	.874	.774
MINIMUM Y	:	-1.039	-.977	-1.077
CENTROID X	:	-.050	-.152	-.299
CENTROID Y	:	-.008	.107	.206
POA TO CENTROID in.	:	.050	.186	.363
MIN RADIUS	:	.235	.389	.462
MEAN RADIUS	:	.934	.861	.751
MAX RADIUS	:	1.388	1.418	1.339
HORIZONTAL SPREAD	:	2.013	2.013	1.993
VERTICAL SPREAD	:	2.028	1.851	1.851
EXTREME SPREAD	:	2.474	2.380	2.109
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

22 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08496765

CENTERFIRE PATTERNS

5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.190	1.054	.727
MINIMUM X	:	-1.217	-.959	-.827
MAXIMUM Y	:	1.363	.757	.649
MINIMUM Y	:	-1.019	-.868	-.781
CENTROID X	:	-.459	-.323	-.455
CENTROID Y	:	-.218	-.369	-.261
POA TO CENTROID in.	:	.508	.491	.525
MIN RADIUS	:	.268	.228	.374
MEAN RADIUS	:	.918	.796	.724
MAX RADIUS	:	1.827	1.366	.981
HORIZONTAL SPREAD	:	2.407	2.013	1.554
VERTICAL SPREAD	:	2.382	1.625	1.430
EXTREME SPREAD	:	3.386	2.339	1.813
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498765
18 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.448371
1 TO	2	.497064
1 TO	3	.808935
1 TO	4	.382215
1 TO	5	.654911

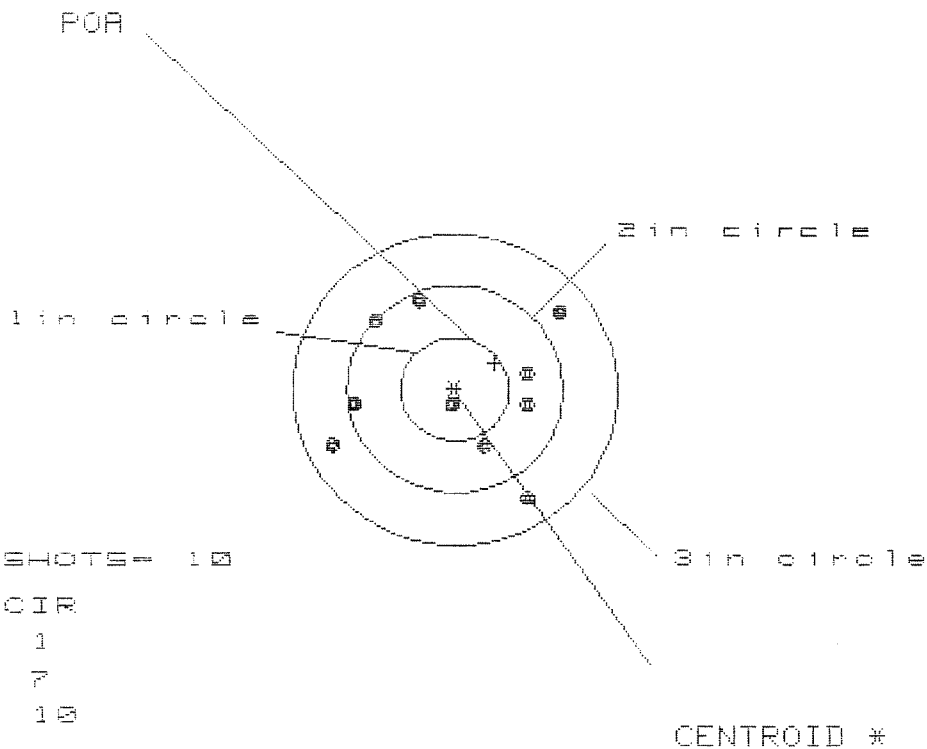
1.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0784
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.181
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .19725
THE AMR FOR THIS RIFLE IS: .9158

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498765.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.095

VS= 1.977

GS= 2.471

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.935	.807	.868
MINIMUM X	-1.160	-1.023	-.962
MAXIMUM Y	.899	.842	.700
MINIMUM Y	-1.078	-1.135	-.718
CENTROID X	-.366	-.238	-.299
CENTROID Y	-.259	-.202	-.060
POA TO CENTROID in.	.449	.312	.305
MIN RADIUS	.138	.260	.348
MEAN RADIUS	.862	.810	.765
MAX RADIUS	1.268	1.236	1.054
HORIZONTAL SPREAD	2.095	1.830	1.830
VERTICAL SPREAD	1.977	1.977	1.418
EXTREME SPREAD	2.471	2.196	2.036
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498785.1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.665

VS= 2.388

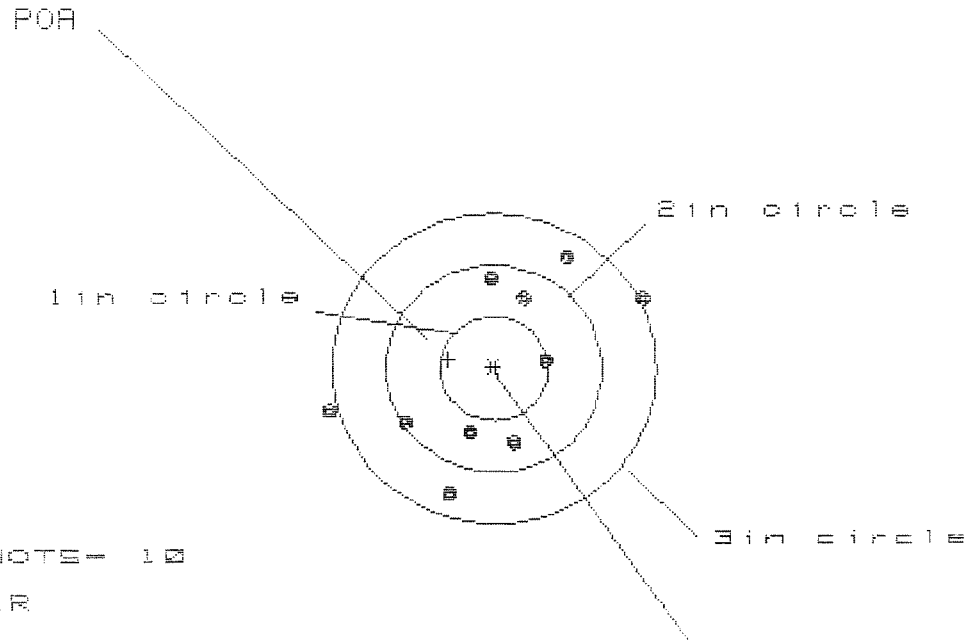
GS= 2.400

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.656	.644	.658
MINIMUM X	:	-1.009	-1.021	-1.007
MAXIMUM Y	:	1.203	1.031	.900
MINIMUM Y	:	-1.185	-1.052	-.771
CENTROID X	:	.131	.143	.129
CENTROID Y	:	-.251	-.384	-.253
POA TO CENTROID in.	:	.283	.410	.284
MIN RADIUS	:	.247	.155	.247
MEAN RADIUS	:	.844	.777	.755
MAX RADIUS	:	1.207	1.085	1.123
HORIZONTAL SPREAD	:	1.665	1.665	1.665
VERTICAL SPREAD	:	2.388	2.083	1.671
EXTREME SPREAD	:	2.400	2.100	1.906
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08498765.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.947

VS = 2.261

ES = 3.158

CENTROID *

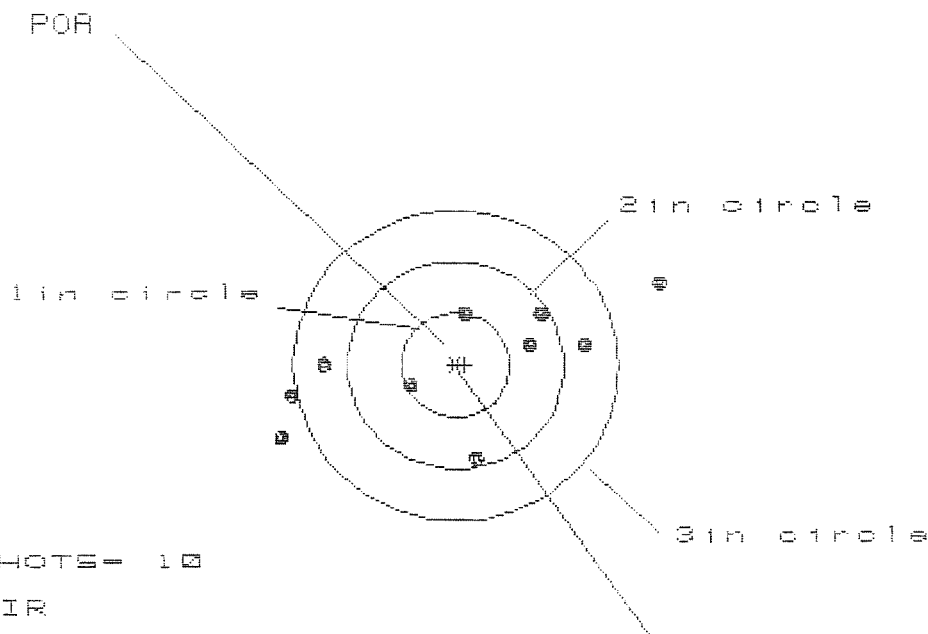
PATTERN #	1	3	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.401	1.229	.630
MINIMUM X	-1.546	-.971	-.817
MAXIMUM Y	1.035	.990	1.075
MINIMUM Y	-1.226	-1.271	-1.186
CENTROID X	.424	.596	.442
CENTROID Y	-.085	-.040	-.125
POA TO CENTROID in.	.432	.597	.459
MIN RADIUS	.449	.271	.445
MEAN RADIUS	1.003	.916	.854
MAX RADIUS	1.599	1.411	1.272
HORIZONTAL SPREAD	2.947	2.200	1.447
VERTICAL SPREAD	2.261	2.261	2.261
EXTREME SPREAD	3.158	2.685	2.510
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

16 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498765.1

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

IS = 3.438

VS = 1.737

GS = 3.738

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.840	1.341	1.167
MINIMUM X	:	-1.598	-1.393	-1.473
MAXIMUM Y	:	.791	.572	.498
MINIMUM Y	:	-.946	-.858	-.931
CENTROID X	:	-.084	-.289	-.115
CENTROID Y	:	-.001	-.089	-.016
POA TO CENTROID in.	:	.084	.302	.116
MIN RADIUS	:	.495	.280	.469
MEAN RADIUS	:	1.131	1.027	.949
MAX RADIUS	:	2.003	1.512	1.507
HORIZONTAL SPREAD	:	3.438	2.734	2.640
VERTICAL SPREAD	:	1.737	1.430	1.430
EXTREME SPREAD	:	3.738	2.863	2.689
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06438785.1

CENTERFIRE PATTERNS

5

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 1.447

VS = 2.669

ES = 2.748

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.465	.423	.406
MINIMUM X	-.982	-.930	-.947
MAXIMUM Y	1.235	1.076	.721
MINIMUM Y	-1.434	-1.008	-.874
CENTROID X	.287	.235	.252
CENTROID Y	-.309	-.150	-.284
POB TO CENTROID in.	.421	.279	.380
MIN RADIUS	.245	.383	.287
MEAN RADIUS	.739	.659	.586
MAX RADIUS	1.508	1.084	1.013
HORIZONTAL SPREAD	1.447	1.353	1.353
VERTICAL SPREAD	2.669	2.084	1.595
EXTREME SPREAD	2.748	2.087	1.682
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		