

C6649225

MODEL 700™ M24

Model **SMS**™

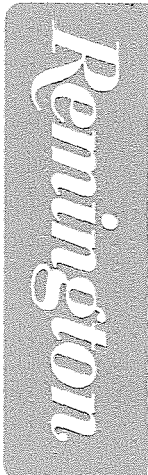
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

MODEL 700™ M24

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

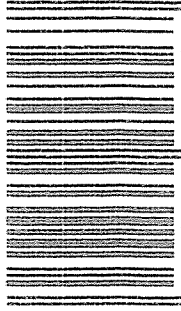
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

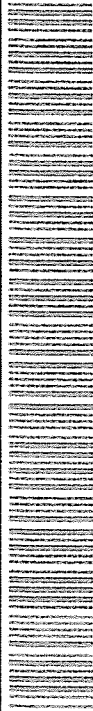
DUPONT

SERIAL NO. C6649225	20
ORDER NO. 5716	

UPC



0 47700 25716 2



5716 C6649225

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649225

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	GB
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-4-91	DH

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9-4-91	DH
	G) Safety Off Force	4	4	4			9-4-91	DH
	H) Trigger Pull Test & Retainability						9-4-91	DH
	I) Firing Pin Indent	.021	.021	.022			9-4-91	DH
	J) Assemble Stock						9/5/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/5/91	RW
	M) Iron Sight Alignment						9/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	RW
	O) Attach Scope to Rifle						9/5/91	RW
	P) Detach & Attach Scope 20 Times						9/5/91	RW
640	Gallery Target & Test						9-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-6-91	NF
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	209	219	211	201	208	9-10-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

MOD. _____ GA. CAL. _____ GUN # 9225

INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>NF</i>	<i>9/6</i>	<i>Bolt Handle Hits Stock</i>	<i>RW</i>
	2nd		
	<i>9/ 17/ 91</i>	<i>filed Bolt Slot</i>	<i>RW</i>
	3rd		
	4th		

FINAL INSPECTION

RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C664925

DATE 9-4-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.56	2.55	2.09	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.46	2.55	2.19	
PULL #3	2.15	2.44	2.65	2.11	
PULL #4	2.28	2.37	2.66	2.01	
PULL #5	2.24	2.47	2.58	2.08	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.00		
PULL #2	3.17	3.03		
PULL #3	3.22	3.12		
PULL #4	3.19	3.12		
PULL #5	3.22	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.00		4.43
PULL #2	4.10	3.98		4.59
PULL #3	4.14	4.12		4.49
PULL #4	4.18	4.24		4.55
PULL #5	4.12	3.93		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649225
7 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.337617
1 TO	2	.279401
1 TO	3	.2249
1 TO	4	.195023
1 TO	5	.227337

<----POA

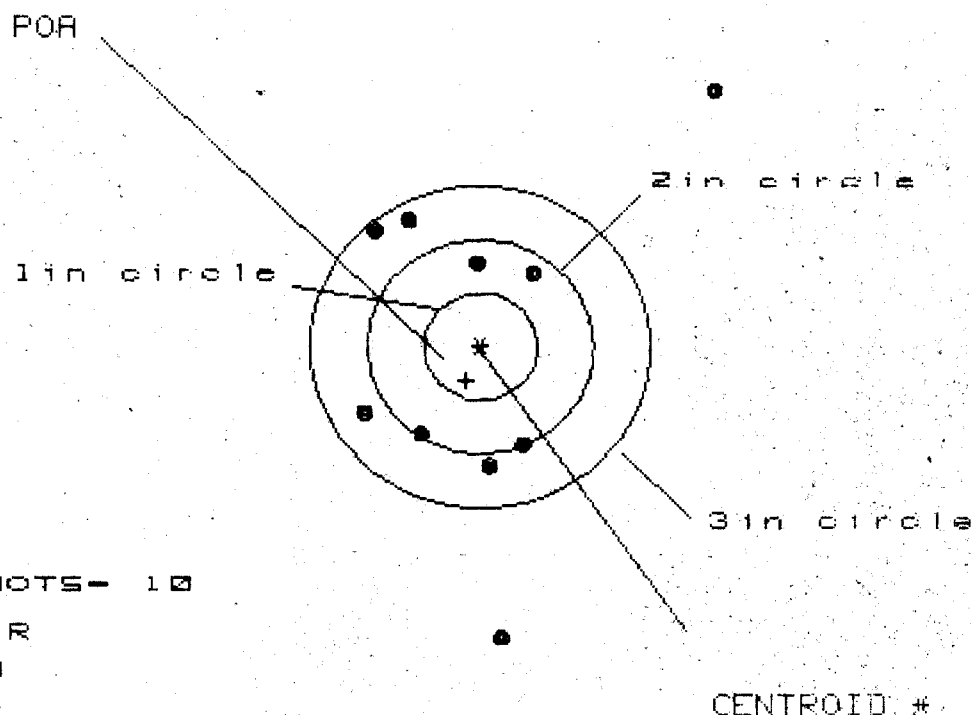
AVERAGE X-COORDINATE FOR THIS RIFLE IS: 2.1354
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1306
AVERAGE POI RADIUS FOR THIS RIFLE IS: .188121

THIS RIFLE IS: 1.255

2 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in = 8

HS- 3.072

VS= 5.162

GS= 5.510

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.086	.694	.742
MINIMUM X	:	-.986	-.754	-.706
MAXIMUM Y	:	2.402	1.411	1.099
MINIMUM Y	:	-2.760	-2.493	-1.149
CENTROID X	:	.129	-.103	-.151
CENTROID Y	:	.312	.045	.357
POR TO CENTROID in.	:	.338	.112	.388
MIN RADIUS	:	.761	.601	.751
MEAN RADIUS	:	1.447	1.217	1.037
MAX RADIUS	:	3.181	2.524	1.271
HORIZONTAL SPREAD	:	3.072	1.448	1.448
VERTICAL SPREAD	:	5.162	3.904	2.248
EXTREME SPREAD	:	5.510	4.046	2.471
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 2.719

VS= 3.340

GS= 4.013

PATTERN # :

SHOTS (BEST OF) :

MAXIMUM X : 1.608 1.509 1.664

MINIMUM X : -1.111 -1.210 -1.055

MAXIMUM Y : 1.446 1.235 1.197

MINIMUM Y : -1.895 -1.147 -.993

CENTROID X : .061 .160 .005

CENTROID Y : .041 .252 .098

POA TO CENTROID in.: .074 .298 .098

MIN RADIUS : .495 .263 .471

MEAN RADIUS : 1.239 1.127 1.041

MAX RADIUS : 2.093 1.747 1.665

HORIZONTAL SPREAD : 2.719 2.719 2.719

VERTICAL SPREAD : 3.340 2.382 2.190

EXTREME SPREAD : 4.013 2.993 2.993

NUMBER IN ONE INCH CIRCLE = 1

NUMBER IN TWO INCH CIRCLE = 5

NUMBER IN THREE INCH CIRCLE = 6

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 10

HS= 2.307

VS= 2.173

GS= 2.535

PATTERN # :

SHOTS (BEST OF) :

MAXIMUM X :

MINIMUM X :

MAXIMUM Y :

MINIMUM Y :

CENTROID X :

CENTROID Y :

POA TO CENTROID in.:

MIN RADIUS :

MEAN RADIUS :

MAX RADIUS :

HORIZONTAL SPREAD :

VERTICAL SPREAD :

EXTREME SPREAD :

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.306

1.195

.809

-1.001

-.800

-.651

1.291

1.194

1.172

-.882

-.918

-.940

.165

.276

.127

.090

.188

.210

.188

.334

.245

.329

.453

.318

.927

.889

.832

1.334

1.208

1.177

2.307

1.995

1.460

2.173

2.112

2.112

2.535

2.251

2.251

1

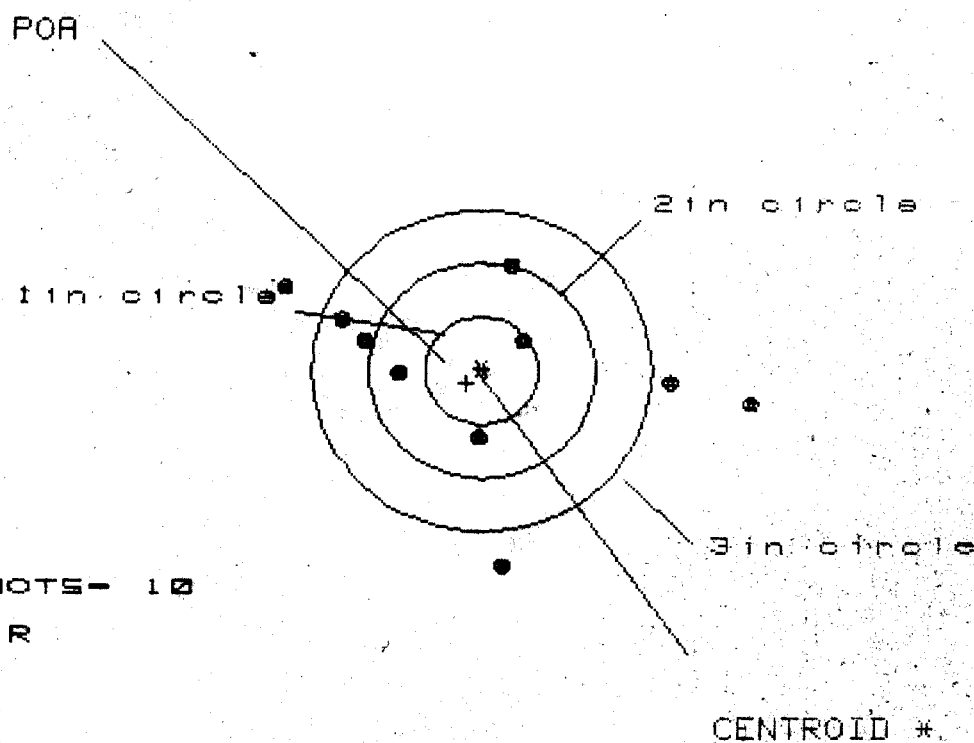
5

10

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 4.076

VS= 2.725

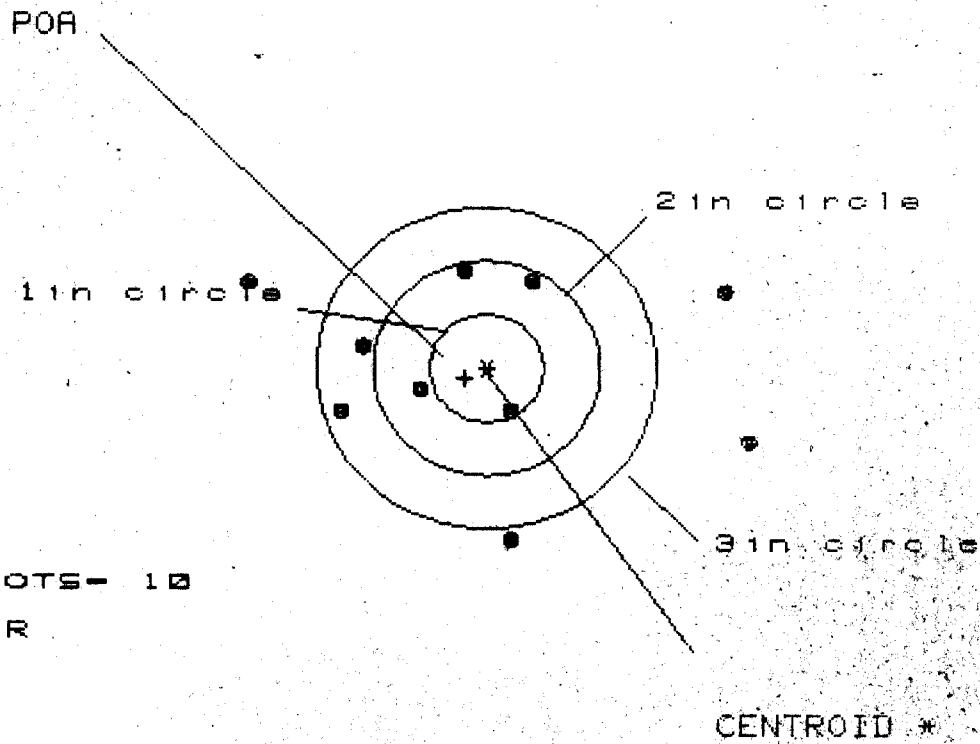
GS= 4.220

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.324	1.933	1.746
MINIMUM X	-1.752	-1.494	-1.140
MAXIMUM Y	.939	.906	1.001
MINIMUM Y	-1.786	-1.819	-1.724
CENTROID X	.132	-.126	.061
CENTROID Y	.117	.150	.055
POA TO CENTROID in.	.177	.196	.082
MIN RADIUS	.444	.524	.508
MEAN RADIUS	1.284	1.131	1.068
MAX RADIUS	2.343	1.938	1.747
HORIZONTAL SPREAD	4.076	3.427	2.886
VERTICAL SPREAD	2.725	2.725	2.725
EXTREME SPREAD	4.220	3.546	2.948
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 1

2in - 4

3in = 6

HS= 4.308

VS= 2.476

GS= 4.563

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.268	2.395	.938
MINIMUM X	-2.041	-1.789	-1.490
MAXIMUM Y	.863	.784	.859
MINIMUM Y	-1.613	-1.692	-1.617
CENTROID X	.190	-.062	-.361
CENTROID Y	.093	.172	.097
POA TO CENTROID in.	.212	.182	.374
MIN RADIUS	.484	.487	.240
MEAN RADIUS	1.378	1.224	1.014
MAX RADIUS	2.377	2.469	1.794
HORIZONTAL SPREAD	4.309	4.184	2.428
VERTICAL SPREAD	2.476	2.476	2.476
EXTREME SPREAD	4.563	4.185	3.302
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649225
14 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.10017
1 TO	2	.248502
1 TO	3	.101124
1 TO	4	.152118
1 TO	5	.135447

<----POA

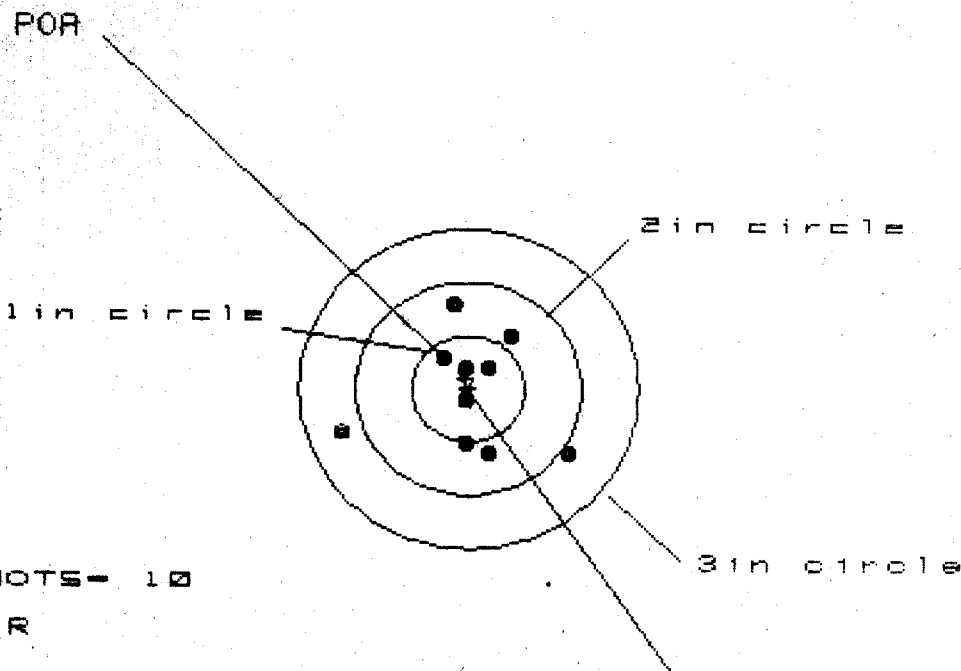
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0984
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0934
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .135669

THE AMR FOR THIS RIFLE IS: .8236

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.992

VS= 1.311

GS= 2.000

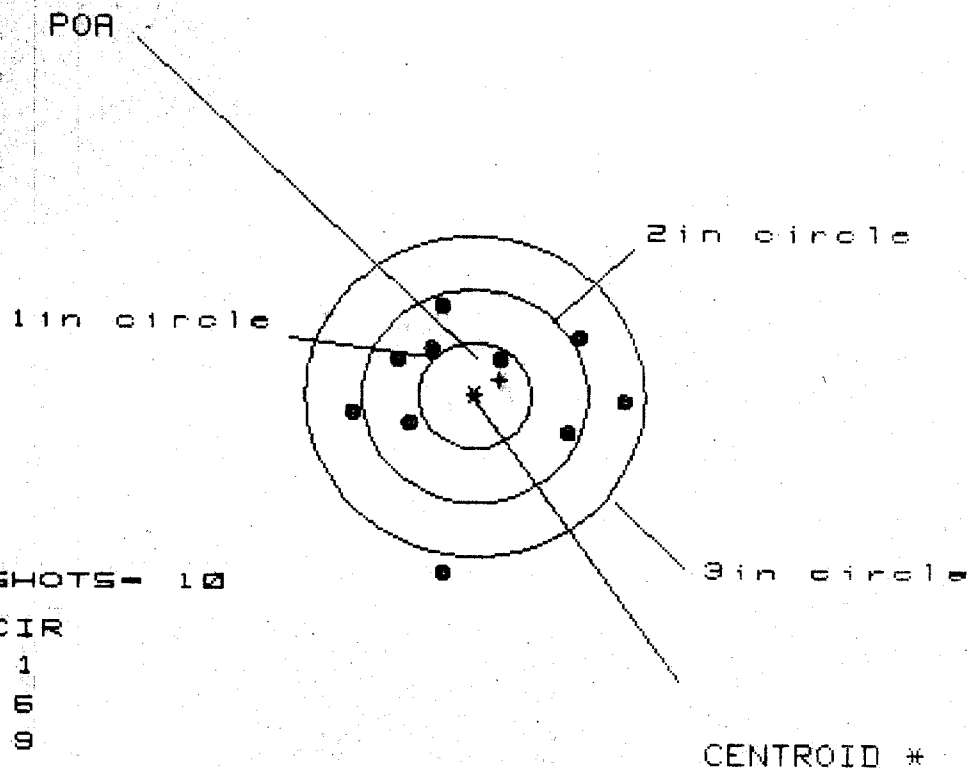
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.769	.309
MINIMUM X	:	-1.101	-.392	-.296
MAXIMUM Y	:	.751	.709	.634
MINIMUM Y	:	-.560	-.602	-.670
CENTROID X	:	.025	.147	.051
CENTROID Y	:	-.097	-.055	.020
POA TO CENTROID in.	:	.101	.157	.055
MIN RADIUS	:	.107	.188	.072
MEAN RADIUS	:	.568	.499	.414
MAX RADIUS	:	1.164	.976	.683
HORIZONTAL SPREAD	:	1.992	1.161	.605
VERTICAL SPREAD	:	1.311	1.311	1.304
EXTREME SPREAD	:	2.000	1.659	1.335
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.417

VS= 2.477

GS= 2.551

PATTERN #

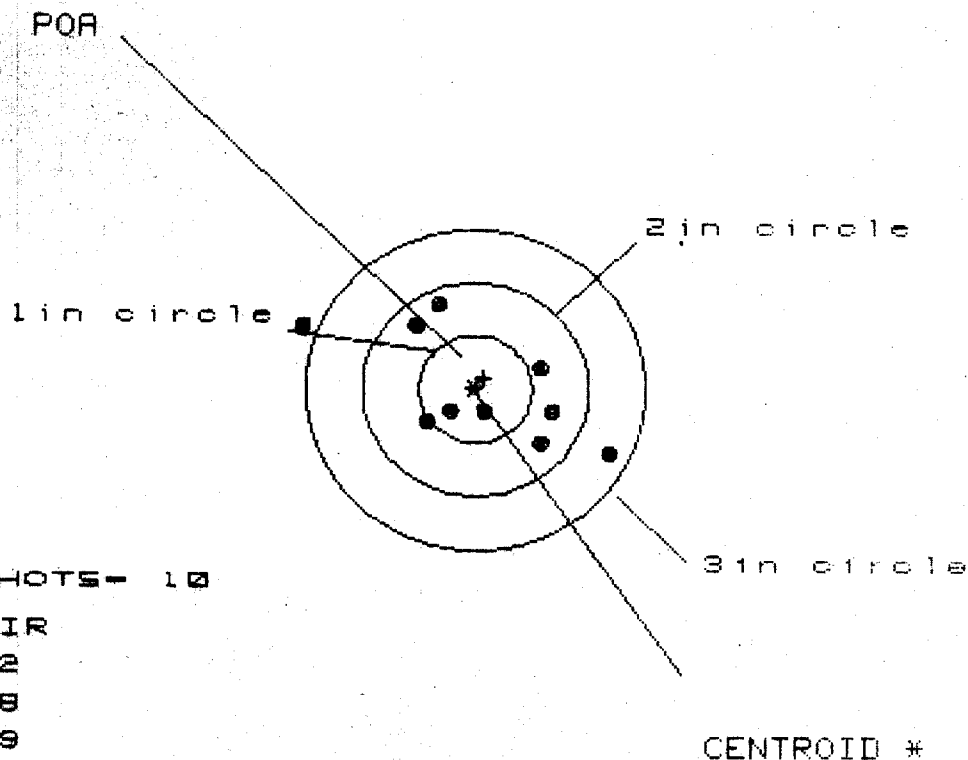
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.307	1.276	1.075
MINIMUM X	-1.110	-1.141	-.982
MAXIMUM Y	.819	.635	.604
MINIMUM Y	-1.658	-.488	-.519
CENTROID X	-.218	-.187	-.346
CENTROID Y	-.149	.035	.066
POA TO CENTROID in.	.264	.190	.353
MIN RADIUS	.405	.257	.389
MEAN RADIUS	.942	.826	.741
MAX RADIUS	1.682	1.300	1.134
HORIZONTAL SPREAD	2.417	2.417	2.057
VERTICAL SPREAD	2.477	1.123	1.123
EXTREME SPREAD	2.551	2.419	2.189
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.698

VS= 1.381

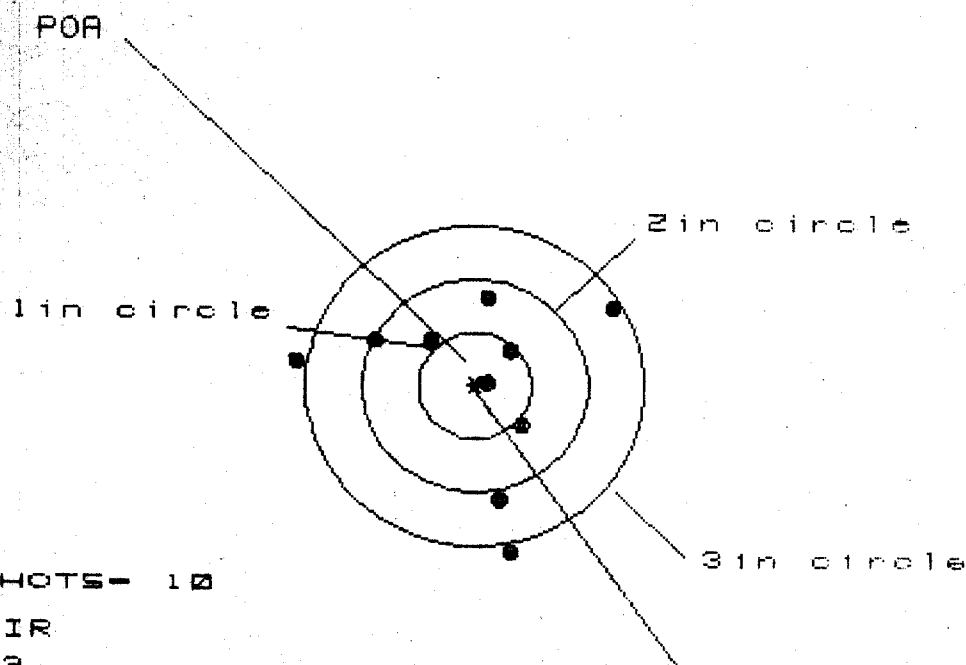
GS= 2.946

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.187	1.019	.595
MINIMUM X	:	-1.511	-.694	-.567
MAXIMUM Y	:	.761	.824	.754
MINIMUM Y	:	-.620	-.557	-.460
CENTROID X	:	-.076	.092	-.035
CENTROID Y	:	-.102	-.165	-.095
POA TO CENTROID in.	:	.127	.189	.101
MIN RADIUS	:	.261	.189	.254
MEAN RADIUS	:	.765	.648	.587
MAX RADIUS	:	1.613	1.161	.843
HORIZONTAL SPREAD	:	2.698	1.713	1.162
VERTICAL SPREAD	:	1.381	1.381	1.214
EXTREME SPREAD	:	2.946	2.080	1.508
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		

14 Sep 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.819

VS= 2.377

GS= 2.863

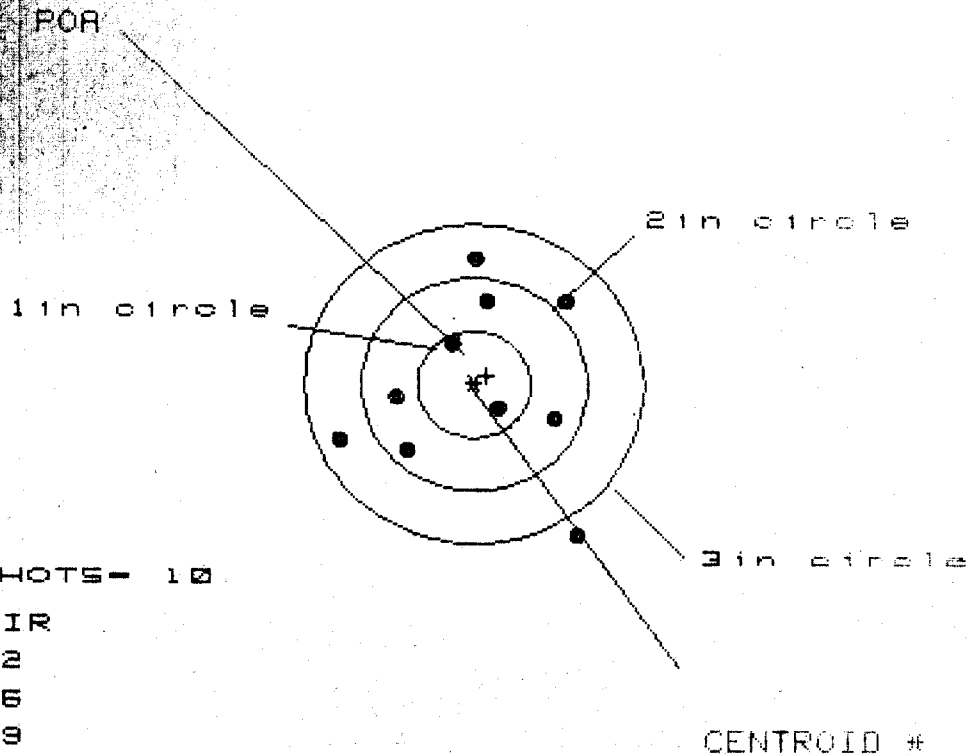
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.253	1.286	1.094
MINIMUM X	-1.566	-1.533	-1.004
MAXIMUM Y	.812	.638	.643
MINIMUM Y	-1.565	-1.217	-1.212
CENTROID X	-.113	-.146	.045
CENTROID Y	-.033	.141	.136
POA TO CENTROID in.	.117	.203	.143
MIN RADIUS	.154	.232	.137
MEAN RADIUS	.921	.827	.711
MAX RADIUS	1.594	1.533	1.221
HORIZONTAL SPREAD	2.819	2.819	2.099
VERTICAL SPREAD	2.377	1.855	1.855
EXTREME SPREAD	2.863	2.863	2.118
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	8	8	8

FILE:/PATTERNING/CENTERFIRE_PATT/C6649225.1

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.024

VS= 2.586

GS= 2.740

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.866	.857	.724
MINIMUM X	-1.158	-1.062	-.741
MAXIMUM Y	1.220	1.068	.982
MINIMUM Y	-1.366	-.808	-.894
CENTROID X	-.110	-.206	-.073
CENTROID Y	-.086	.066	.152
POR TO CENTROID in.	.139	.216	.169
MIN RADIUS	.310	.242	.287
MEAN RADIUS	.922	.828	.762
MAX RADIUS	1.617	1.268	1.106
HORIZONTAL SPREAD	2.024	1.919	1.465
VERTICAL SPREAD	2.586	1.876	1.876
EXTREME SPREAD	2.740	2.351	2.016
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	9	9	9