

C6611380

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



**Remington®**

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

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

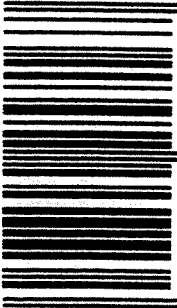
**MODEL 700™ M24**

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

**SERIAL NO.**  
C6611380

**ORDER NO.**  
5716

  
5716 C6611380

  
0 47700 25716 7

UPC

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611380

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 1 25 91  |         | RW   |
| 600       | Proof                                                    | 1 25 91  |         | RW   |
| 607       | Check Headspace                                          | 1 25 91  |         | RW   |
| 610       | Dis-assemble Gun                                         | 1 25 91  |         | RW   |
| 612       | Magnaflux Barrel Action                                  | 1 25 91  |         | KR   |
|           | Magnaflux Bolt                                           | 1 25 91  |         | KR   |
| 615       | Rollmark Caliber                                         | 1 25 91  |         | GL   |
| 617       | Drill and Tap Sight Holes                                | 1 30 91  |         | EB   |
| 618       | Polish Barrel RBB                                        | 1 30 91  |         | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 2-10-91 | TJA  |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 2/11/91 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 2/11/91 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 2/11/91 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 2/11/91 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 2/14/91 | RU   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 3/4    | 4 3/4 | 4 3/4 |      |      | 2/14/91 | WB   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/2 | 2 1/2 |      |      | 2/14/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 2/14/91 | JL   |
|              | I) Firing Pin Indent                                        | .023     | .023  | .023  |      |      | 2/14/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 2/18/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 2-25-91 | A    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 2/18/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 2/18/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 2/18/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 2/18/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 2/18/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 2/19/91 | KL   |
|              | A) Time                                                     |          |       |       |      |      | "       | KL   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | KL   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | KL   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | KL   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 2/19/91 | KL   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 2-25-91 | A    |
|              | B) Trigger Pull                                             | 2.21     | 2.31  | 2.32  | 2.24 | 2.26 | 2/21/91 | JL   |
|              | C) Function                                                 |          |       |       |      |      | 2-25-91 | A    |
| 660          | Pack                                                        |          |       |       |      |      | 3-19-91 | NF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611380DATE 2/14/91TESTER JPL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.34             | 2.23                     | 2.30                           | 2.21 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.17             | 2.30                     | 2.28                           | 2.31 |                                                                        |
| PULL #3 | 2.44             | 2.26                     | 2.33                           | 2.32 |                                                                        |
| PULL #4 | 2.40             | 2.29                     | 2.26                           | 2.24 |                                                                        |
| PULL #5 | 2.33             | 2.33                     | 2.32                           | 2.26 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.33             | 3.45                     |  |          |
| PULL #2 | 3.38             | 3.41                     |  |          |
| PULL #3 | 3.35             | 3.23                     |  |          |
| PULL #4 | 3.34             | 3.19                     |  |          |
| PULL #5 | 3.36             | 3.18                     |  |          |
| 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 | 4.27             | 4.26                     |                                | 4.50                                 |
| PULL #2 | 4.23             | 4.42                     |                                | 4.49                                 |
| PULL #3 | 4.22             | 4.40                     |                                | 4.52                                 |
| PULL #4 | 4.25             | 4.56                     |                                | 4.41                                 |
| PULL #5 | 4.21             | 4.49                     |                                | 4.39                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06611380  
20 Feb 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0711758 |
| 1 TO | 2 | .0633246 |
| 1 TO | 3 | .0888876 |
| 1 TO | 4 | .13636   |
| 1 TO | 5 | .127098  |

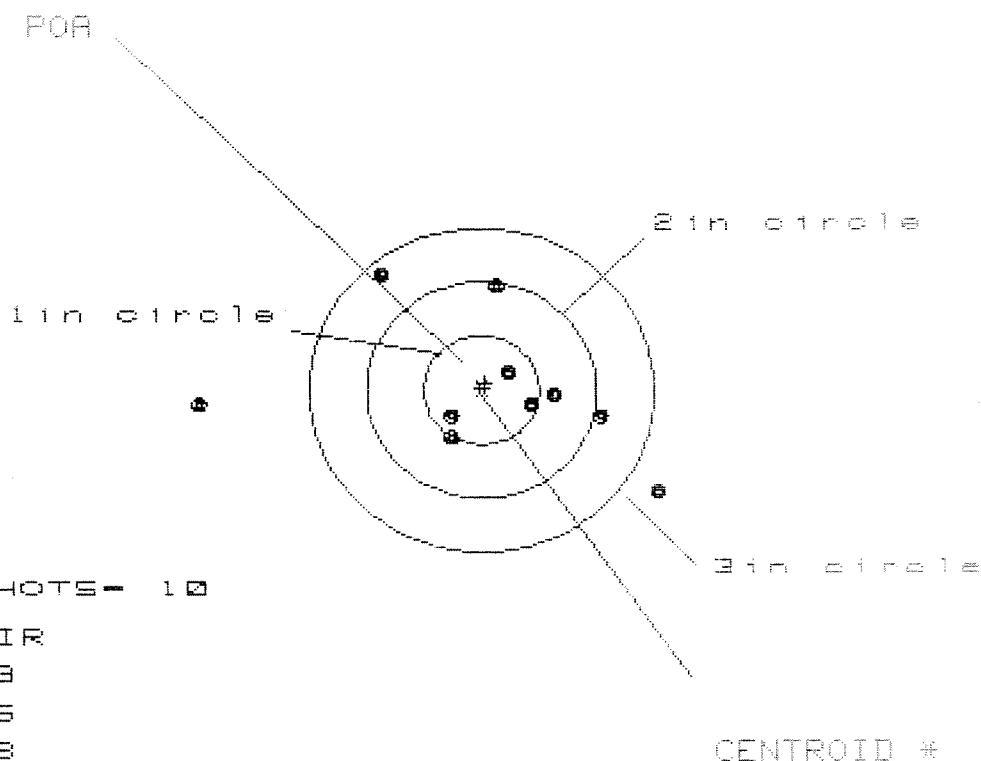
4 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0048  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0482  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0404856  
THE AMR FOR THIS RIFLE IS: .9116

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06611380

## CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1in = 3

2in = 6

3in = 8

HS = 3.985

VS = 1.994

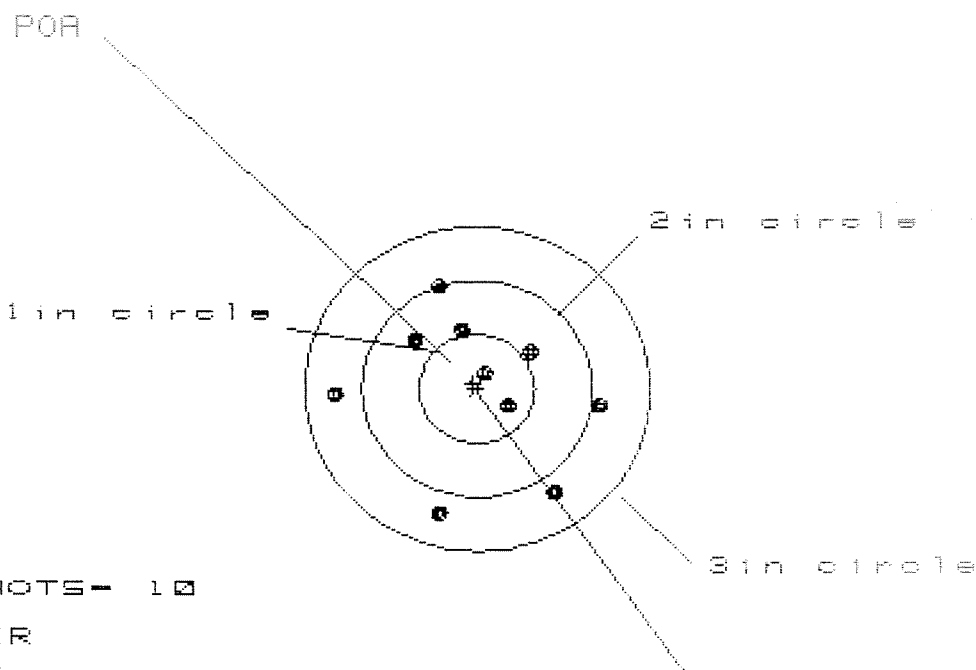
GS = 4.065

| PATTERN #                   | : | 1      | 2      | 3      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.513  | 1.239  | .938   |
| MINIMUM X                   | : | -2.472 | -1.184 | -1.029 |
| MAXIMUM Y                   | : | 1.030  | 1.012  | .889   |
| MINIMUM Y                   | : | -.964  | -.982  | -.592  |
| CENTROID X                  | : | -.029  | .245   | .090   |
| CENTROID Y                  | : | -.065  | -.047  | .076   |
| POA TO CENTROID in.         | : | .071   | .250   | .118   |
| MIN RADIUS                  | : | .282   | .188   | .101   |
| MEAN RADIUS                 | : | .999   | .785   | .692   |
| MAX RADIUS                  | : | 2.477  | 1.581  | 1.360  |
| HORIZONTAL SPREAD           | : | 3.985  | 2.423  | 1.968  |
| VERTICAL SPREAD             | : | 1.994  | 1.994  | 1.481  |
| EXTREME SPREAD              | : | 4.065  | 3.138  | 2.316  |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |        |

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611380

## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in - 2

2 in - 6

3 in - 10

HS= 2.273

VS= 2.110

GS= 2.277

CENTROID \*

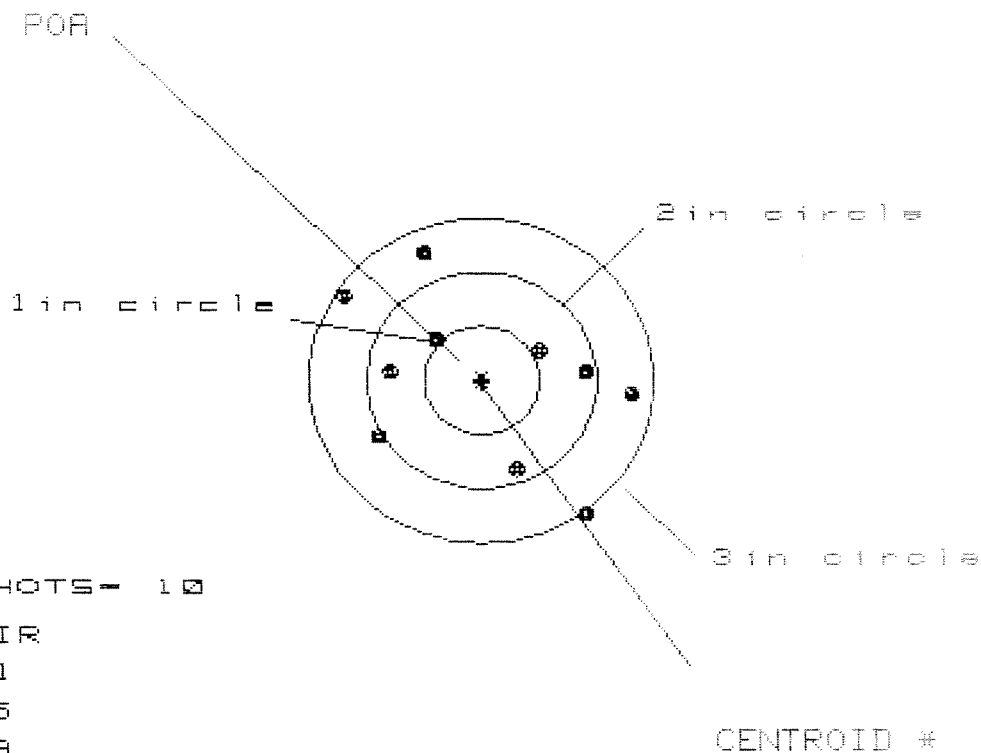
| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.075  | 1.037  | .883   |
| MINIMUM X                   | : | -1.198 | -1.236 | -.734  |
| MAXIMUM Y                   | : | .928   | .797   | .778   |
| MINIMUM Y                   | : | -1.182 | -1.043 | -1.062 |
| CENTROID X                  | : | .032   | .070   | .224   |
| CENTROID Y                  | : | -.048  | .083   | .102   |
| POA TO CENTROID in.         | : | .058   | .109   | .246   |
| MIN RADIUS                  | : | .180   | .044   | .133   |
| MEAN RADIUS                 | : | .801   | .719   | .647   |
| MAX RADIUS                  | : | 1.230  | 1.245  | 1.180  |
| HORIZONTAL SPREAD           | : | 2.273  | 2.273  | 1.617  |
| VERTICAL SPREAD             | : | 2.110  | 1.840  | 1.840  |
| EXTREME SPREAD              | : | 2.277  | 2.277  | 2.123  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |



20 Feb 1991

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in - 1

2 in - 5

3 in = 9

HS- 2.474

VS= 2.401

GS= 2.884

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.277  | 1.375  | 1.238 |
| MINIMUM X                   | : | -1.197 | -1.099 | -.983 |
| MAXIMUM Y                   | : | 1.150  | 1.011  | 1.087 |
| MINIMUM Y                   | : | -1.251 | -1.005 | -.929 |
| CENTROID X                  | : | -.003  | -.101  | .037  |
| CENTROID Y                  | : | .020   | .159   | .083  |
| POA TO CENTROID in.         | : | .020   | .188   | .090  |
| MIN RADIUS                  | : | .497   | .331   | .486  |
| MEAN RADIUS                 | : | 1.025  | .949   | .909  |
| MAX RADIUS                  | : | 1.531  | 1.398  | 1.250 |
| HORIZONTAL SPREAD           | : | 2.474  | 2.474  | 2.221 |
| VERTICAL SPREAD             | : | 2.401  | 2.016  | 2.016 |
| EXTREME SPREAD              | : | 2.884  | 2.619  | 2.256 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

20 Feb 1991

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## CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.109

VS= 2.403

GS= 2.421

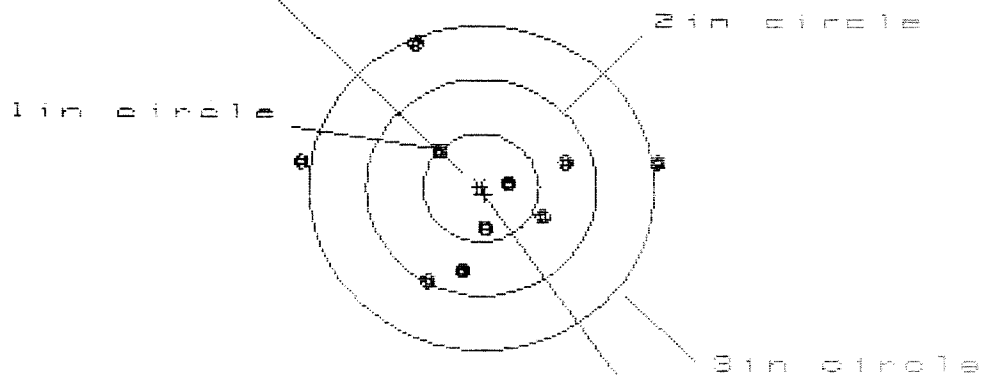
| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.297  | 1.252  | 1.238 |
| MINIMUM X                   | : | -.812  | -.857  | -.871 |
| MAXIMUM Y                   | : | 1.025  | .872   | .680  |
| MINIMUM Y                   | : | -1.378 | -1.531 | -.718 |
| CENTROID X                  | : | .058   | .103   | .117  |
| CENTROID Y                  | : | -.170  | -.017  | .175  |
| POA TO CENTROID in.         | : | .179   | .104   | .211  |
| MIN RADIUS                  | : | .349   | .276   | .085  |
| MEAN RADIUS                 | : | .867   | .777   | .640  |
| MAX RADIUS                  | : | 1.434  | 1.536  | 1.244 |
| HORIZONTAL SPREAD           | : | 2.109  | 2.109  | 2.109 |
| VERTICAL SPREAD             | : | 2.403  | 2.403  | 1.398 |
| EXTREME SPREAD              | : | 2.421  | 2.403  | 2.141 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

28 Feb 1991

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## CENTERFIRE PATTERNS # 5

POA



# OF SHOTS - 10

# IN CIR

1in = 3

2in = 7

3in = 8

HS = 3.104

VS = 2.238

GS = 3.104

| PATTERN #           | 5      | 5     | 5     |
|---------------------|--------|-------|-------|
| SHOTS (BEST OF)     | 10     | 9     | 8     |
| MAXIMUM X           | 1.525  | 1.350 | .682  |
| MINIMUM X           | -1.579 | -.727 | -.559 |
| MAXIMUM Y           | 1.354  | 1.379 | 1.406 |
| MINIMUM Y           | -.884  | -.859 | -.832 |
| CENTROID X          | -.034  | .141  | -.027 |
| CENTROID Y          | .062   | .037  | .010  |
| POA TO CENTROID in. | .071   | .146  | .029  |
| MIN RADIUS          | .222   | .084  | .233  |
| MEAN RADIUS         | .866   | .753  | .683  |
| MAX RADIUS          | 1.594  | 1.559 | 1.513 |
| HORIZONTAL SPREAD   | 3.104  | 2.077 | 1.241 |
| VERTICAL SPREAD     | 2.238  | 2.238 | 2.238 |
| EXTREME SPREAD      | 3.104  | 2.379 | 2.242 |

|                             |   |   |
|-----------------------------|---|---|
| NUMBER IN ONE INCH CIRCLE   | = | 6 |
| NUMBER IN TWO INCH CIRCLE   | = | 7 |
| NUMBER IN THREE INCH CIRCLE | = | 8 |