

C6611394

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**  
MODEL 700™ M24

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

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

SERIAL NO.  
C6611394

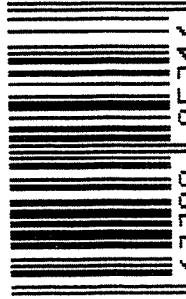
ORDER NO.  
5716

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



5716 C6611394

UPC



0 47700 25216 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611394

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 28     | 91      | Rw   |
| 600          | Proof                                                          | 3 28     | 91      | Rw   |
| 607          | Check Headspace                                                | 3 28     | 91      | Rw   |
| 610          | Dis-assemble Gun                                               | 3 28     | 91      | Rw   |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991  | K.B. |
|              | Magnaflux Bolt                                                 | APR      | 2 1991  | (1)  |
| 615          | Rollmark Caliber                                               | APR      | 2 1991  | JS   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991  | LB   |
| 618          | Polish Barrel                                                  | APR      | 5 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-9-91  | JS   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 4/16/91 | Rw   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/16/91 | Rw   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/16/91 | Rw   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/16/91 | Rw   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 5/2/91  | JS   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 8        | 8    | 8    |      |      | 5-2-91  | D/H  |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 5-2-91  | D/H  |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 5/2/91  | JY   |
|              | I) Firing Pin Indent                                        | .022     | .023 | .023 |      |      | 5-2-91  | D/H  |
|              | J) Assemble Stock                                           |          |      |      |      |      | 5/10/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 5-2-91  | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 5/10/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 5/10/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 5/10/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 5/10/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 5/10/91 | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 5-13-91 | AC   |
|              | A) Time                                                     |          |      |      |      |      | 5-13-91 | AC   |
|              | B) Malfunctions                                             |          |      |      |      |      | 5-13-91 | AC   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 5-13-91 | AC   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 5-13-91 | AC   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 5-13-91 | AC   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 5-20-91 | D/H  |
|              | B) Trigger Pull                                             | 2.66     | 2.67 | 2.69 | 2.55 | 2.70 | 5/20/91 | JY   |
|              | C) Function                                                 |          |      |      |      |      | 5-20-91 | D/H  |
| 660          | Pack                                                        |          |      |      |      |      | 6-18-91 | VF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611-394

DATE 5/2/91

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.35             | 2.51                     | 2.48                           | 2.66 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.49             | 2.46                     | 2.45                           | 2.67 |                                                                        |
| PULL #3 | 2.48             | 2.47                     | 2.38                           | 2.69 |                                                                        |
| PULL #4 | 2.45             | 2.47                     | 2.35                           | 2.65 |                                                                        |
| PULL #5 | 2.49             | 2.45                     | 2.40                           | 2.70 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.37             | 3.39                     |  |          |
| PULL #2 | 3.38             | 3.39                     |  |          |
| PULL #3 | 3.42             | 3.42                     |  |          |
| PULL #4 | 3.16             | 3.44                     |  |          |
| PULL #5 | 3.39             | 3.48                     |  |          |
| 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 | 4.24             | 4.25                     |                                | 4.21                                  |
| PULL #2 | 4.22             | 4.25                     |                                | 4.30                                  |
| PULL #3 | 4.32             | 4.18                     |                                | 4.35                                  |
| PULL #4 | 4.27             | 4.34                     |                                | 4.31                                  |
| PULL #5 | 4.24             | 4.43                     |                                | 4.40                                  |
| TOTAL   |                  |                          |                                |                                       |
| AVG.    |                  |                          |                                |                                       |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611394  
13 May 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0601082 |
| 1 TO | 2 | .101124  |
| 1 TO | 3 | .171213  |
| 1 TO | 4 | .30761   |
| 1 TO | 5 | .543244  |

54-9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1002  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0369  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .106744  
THE AMR FOR THIS RIFLE IS: .8854

13 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611394

## CENTERFIRE PATTERNS # 1

POH

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.547

VS = 2.064

GS = 2.548

CENTROID \*

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.909

.727

.763

MINIMUM X

:

-1.638

-.958

-.922

MAXIMUM Y

:

1.002

1.010

.878

MINIMUM Y

:

-1.062

-1.054

-.703

CENTROID X

:

.042

.224

.188

CENTROID Y

:

-.043

-.051

.081

POA TO CENTROID in.

:

.060

.230

.205

MIN RADIUS

:

.381

.269

.189

MEAN RADIUS

:

.830

.712

.647

MAX RADIUS

:

1.639

1.092

.957

HORIZONTAL SPREAD

:

2.547

1.665

1.685

VERTICAL SPREAD

:

2.064

2.064

1.581

EXTREME SPREAD

:

2.548

2.078

1.691

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

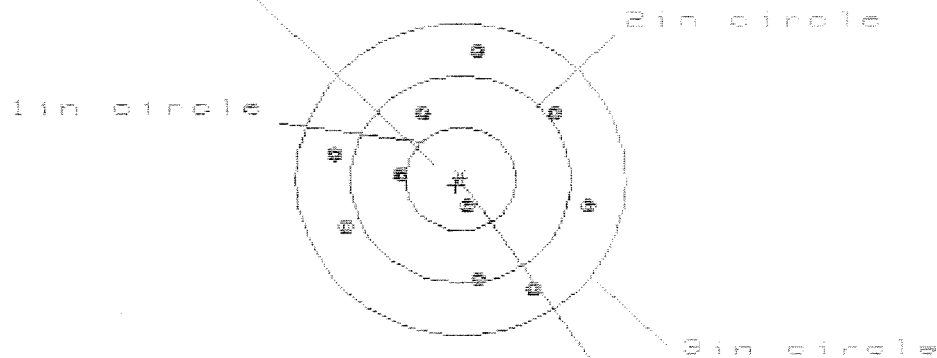
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## CENTERFIRE PATTERNS # 2

POR



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.281

VS= 2.295

GS= 2.353

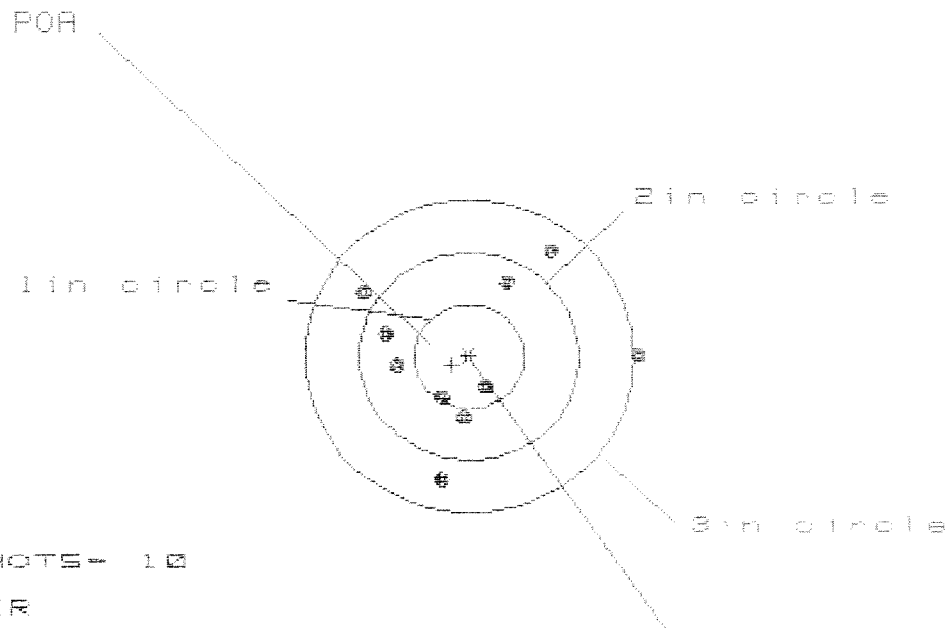
CENTROID #

| PATTERN #                     | 2      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.150  | 1.169  | 1.258  |
| MINIMUM X                     | -1.131 | -1.112 | -1.023 |
| MAXIMUM Y                     | 1.284  | .827   | .719   |
| MINIMUM Y                     | -1.010 | -.868  | -.913  |
| CENTROID X                    | .047   | .028   | -.061  |
| CENTROID Y                    | .058   | -.085  | .023   |
| POR TO CENTROID in.           | .074   | .090   | .066   |
| MIN RADIUS                    | .226   | .100   | .241   |
| MEAN RADIUS                   | .956   | .898   | .865   |
| MAX RADIUS                    | 1.296  | 1.182  | 1.277  |
| HORIZONTAL SPREAD             | 2.281  | 2.281  | 2.281  |
| VERTICAL SPREAD               | 2.295  | 1.695  | 1.632  |
| EXTREME SPREAD                | 2.353  | 2.326  | 2.326  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.437

VS = 2.217

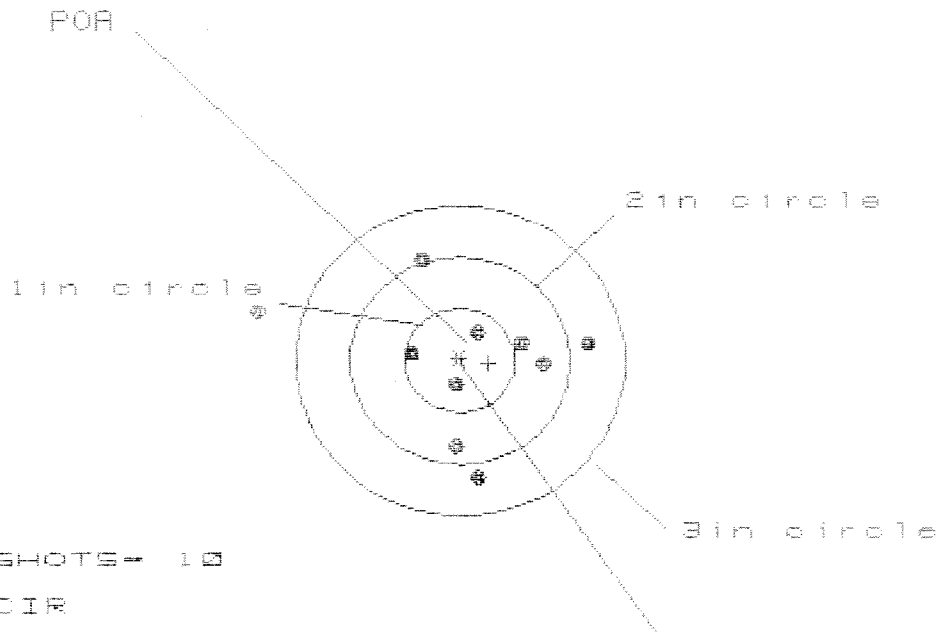
GS = 2.510

| PATTERN #                   | 3      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.518  |
| MINIMUM X                   | -.918  |
| MAXIMUM Y                   | 1.010  |
| MINIMUM Y                   | -1.207 |
| CENTROID X                  | .159   |
| CENTROID Y                  | .082   |
| POA TO CENTROID in.         | .179   |
| MIN RADIUS                  | .336   |
| MEAN RADIUS                 | .864   |
| MAX RADIUS                  | 1.519  |
| HORIZONTAL SPREAD           | 2.437  |
| VERTICAL SPREAD             | 2.217  |
| EXTREME SPREAD              | 2.510  |
| NUMBER IN ONE INCH CIRCLE   | 2      |
| NUMBER IN TWO INCH CIRCLE   | 6      |
| NUMBER IN THREE INCH CIRCLE | 9      |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.930

VS= 2.061

GS= 2.943

CENTROID \*

| PATTERN #                     | 4      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.135  |
| MINIMUM X                     | -1.795 |
| MAXIMUM Y                     | .981   |
| MINIMUM Y                     | -1.080 |
| CENTROID X                    | -.258  |
| CENTROID Y                    | .025   |
| POA TO CENTROID in.           | .259   |
| MIN RADIUS                    | .231   |
| MEAN RADIUS                   | .822   |
| MAX RADIUS                    | 1.848  |
| HORIZONTAL SPREAD             | 2.930  |
| VERTICAL SPREAD               | 2.061  |
| EXTREME SPREAD                | 2.943  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |
| NUMBER IN TWO INCH CIRCLE =   | 6      |
| NUMBER IN THREE INCH CIRCLE = | 9      |

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## CENTERFIRE PATTERNS

# 5

FOR

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 9

HS = 3.442

VS = 1.628

GS = 3.629

CENTROID #

| PATTERN #                     | 5      | 5      | 5      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 9      |
| MAXIMUM X                     | 1.439  | 1.216  | 1.342  |
| MINIMUM X                     | -2.003 | -1.588 | -1.450 |
| MAXIMUM Y                     | .966   | .599   | .500   |
| MINIMUM Y                     | -.862  | -.555  | -.565  |
| CENTROID X                    | -.491  | -.268  | -.420  |
| CENTROID Y                    | .062   | -.045  | .035   |
| FOR TO CENTROID in.           | .495   | .272   | .422   |
| MIN RADIUS                    | .284   | .376   | .258   |
| MEAN RADIUS                   | .955   | .788   | .720   |
| MAX RADIUS                    | 2.224  | 1.620  | 1.470  |
| HORIZONTAL SPREAD             | 3.442  | 2.884  | 2.385  |
| VERTICAL SPREAD               | 1.628  | 1.154  | 1.154  |
| EXTREME SPREAD                | 3.629  | 2.832  | 2.386  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |