

C6611434

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington



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

MODEL 700TM M24

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

20

SERIAL NO.
C6611434

ORDER NO.
5716



5716 C6611434



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611434

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	5
615	Rollmark Caliber	3 28	91	JS
617	Drill and Tap Sight Holes	APR 3 1991		LB
618	Polish Barrel	APR 3 1991		WB
620	Apply Coatings (Barrel Action)		4-11-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/8/91	RU

op. #	BARBER - M24 0076795 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			5/8/91	JH
	G) Safety Off Force	4	4	4			5/8/91	LL
	H) Trigger Pull Test & Retainability						5/8/91	JH
	I) Firing Pin Indent	.0225	.022	.0225			5/8/91	JH
	J) Assemble Stock						5/9/91	RW
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/9/91	RW
	M) Iron Sight Alignment						5/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	RW
	O) Attach Scope to Rifle						5/9/91	RW
	P) Detach & Attach Scope 20 Times						5/9/91	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						5-21-91	D/H
	B) Trigger Pull	2.39	2.31	2.40	2.37	2.41	5/20/91	JH
	C) Function						5-21-91	D/H
660	Pack						6-20-91	RF

New Stock

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6611434
DATE 5/8/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.45	2.40	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.43	2.42	2.31	
PULL #3	2.22	2.48	2.36	2.40	
PULL #4	2.23	2.43	2.40	2.37	
PULL #5	2.21	2.38	2.40	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.45		
PULL #2	3.44	3.48		
PULL #3	3.49	3.45		
PULL #4	3.43	3.52		
PULL #5	3.53	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.36		4.26
PULL #2	4.24	4.27		4.33
PULL #3	4.27	4.27		4.32
PULL #4	4.35	4.31		4.34
PULL #5	4.32	4.36		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611434
13 May 1991

CENTROIDAL DISTANCES

0 TO	1	.316809
1 TO	2	.123491
1 TO	3	.615872
1 TO	4	.238918
1 TO	5	.718471

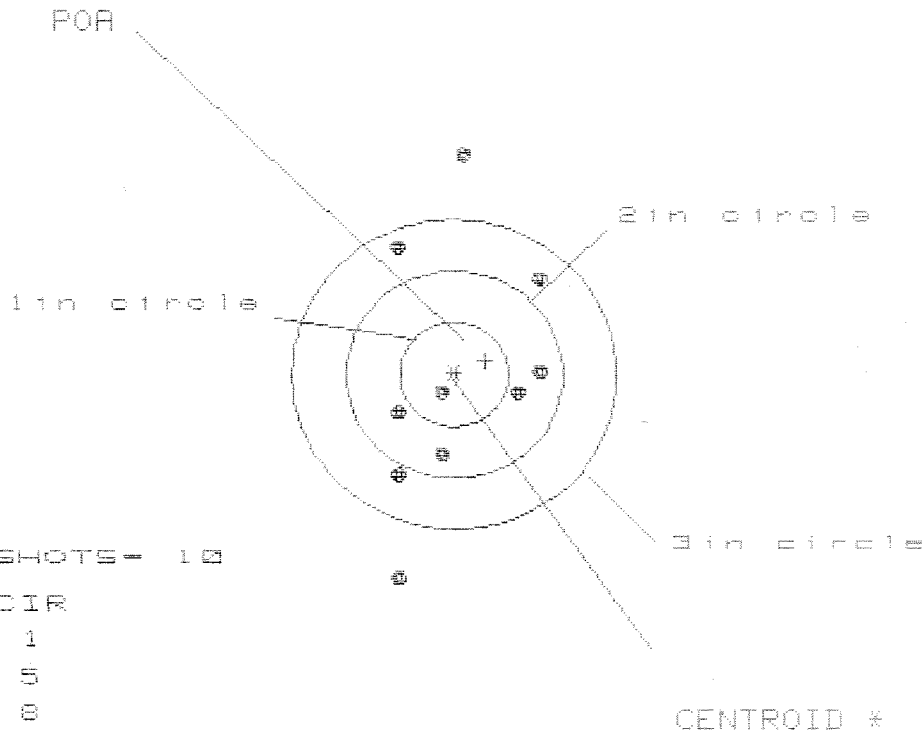
4.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .001
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00746726
THE AMR FOR THIS RIFLE IS: .9618

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611434

CENTERFIRE PATTERNS # 1



HE= 1.314

VS= 4.041

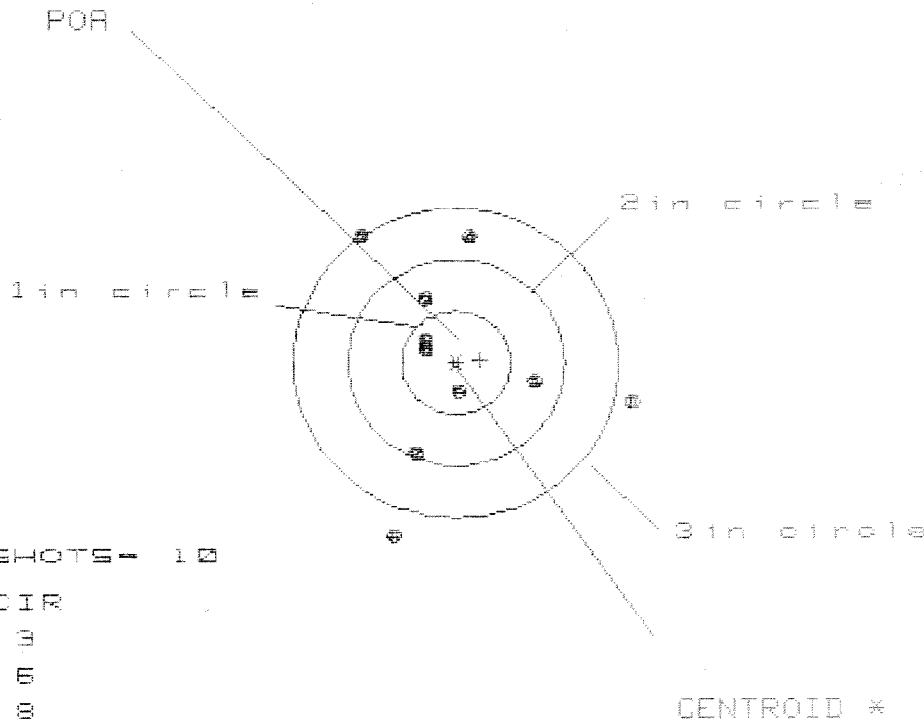
GS= 4.085

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.788	.797	.732
MINIMUM X	-.525	-.517	-.547
MAXIMUM Y	2.121	1.511	1.301
MINIMUM Y	-1.920	-1.685	-.901
CENTROID X	-.288	-.296	-.231
CENTROID Y	-.132	-.367	-.157
POA TO CENTROID in.	.316	.472	.279
MIN RADIUS	.210	.142	.234
MEAN RADIUS	1.069	.905	.817
MAX RADIUS	2.122	1.762	1.483
HORIZONTAL SPREAD	1.314	1.314	1.279
VERTICAL SPREAD	4.041	3.196	2.202
EXTREME SPREAD	4.085	3.197	2.265
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611434

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.441

VS = 2.870

GS = 2.942

PATTERN #

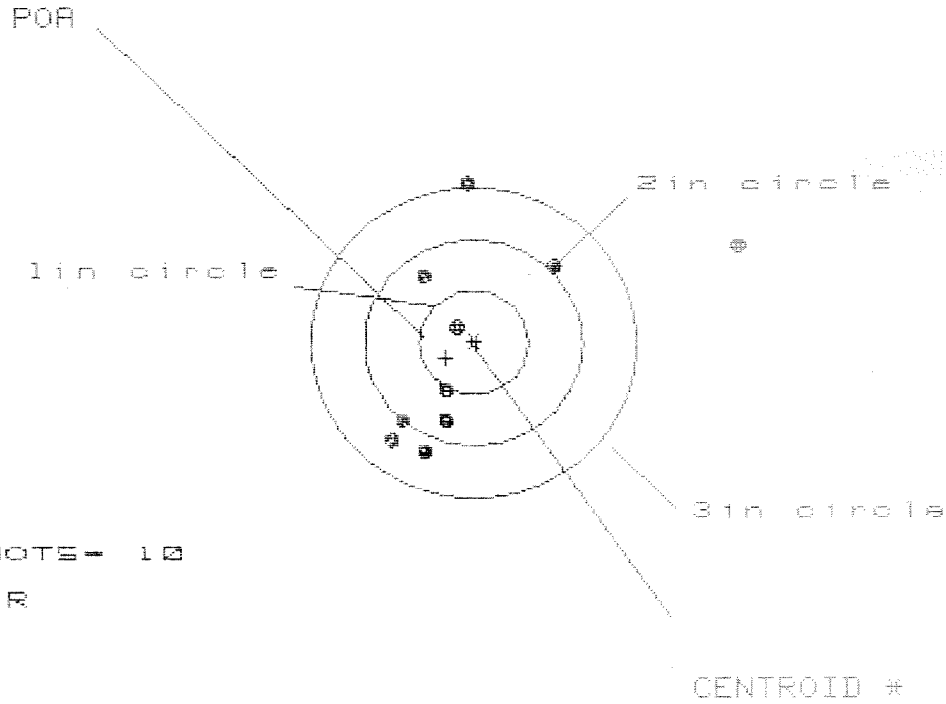
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.613	1.544	.894
MINIMUM X	-.829	-.897	-.705
MAXIMUM Y	1.217	1.034	.959
MINIMUM Y	-1.653	-1.060	-1.135
CENTROID X	-.223	-.155	-.348
CENTROID Y	-.027	.156	.231
POR TO CENTROID in.	.225	.220	.417
MIN RADIUS	.226	.301	.117
MEAN RADIUS	.936	.842	.689
MAX RADIUS	1.765	1.655	1.190
HORIZONTAL SPREAD	2.441	2.441	1.598
VERTICAL SPREAD	2.870	2.094	2.094
EXTREME SPREAD	2.942	2.936	2.149
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611434

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.194

VS= 2.575

GS= 3.716

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.437	.996	1.018
MINIMUM X	-.757	-.486	-.464
MAXIMUM Y	1.528	1.630	1.073
MINIMUM Y	-1.047	-.945	-.742
CENTROID X	.259	-.012	-.034
CENTROID Y	.151	.049	-.154
POA TO CENTROID in.	.300	.051	.158
MIN RADIUS	.217	.267	.152
MEAN RADIUS	1.093	.860	.709
MAX RADIUS	2.603	1.639	1.479
HORIZONTAL SPREAD	3.194	1.482	1.482
VERTICAL SPREAD	2.575	2.575	1.815
EXTREME SPREAD	3.716	2.605	2.295
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611434

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 1.848

VS= 2.719

GS= 2.725

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.192	1.235	1.266
MINIMUM X	-.656	-.613	-.582
MAXIMUM Y	1.345	1.192	.854
MINIMUM Y	-1.374	-1.266	-1.117
CENTROID X	-.057	-.100	-.131
CENTROID Y	-.193	-.040	-.109
POA TO CENTROID in.	.201	.108	.230
MIN RADIUS	.131	.278	.133
MEAN RADIUS	.875	.802	.736
MAX RADIUS	1.429	1.404	1.368
HORIZONTAL SPREAD	1.848	1.848	1.848
VERTICAL SPREAD	2.719	2.458	1.971
EXTREME SPREAD	2.725	2.458	2.302
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811434

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 10

HS = 2.530

VS = 1.620

GS = 2.741

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.261	1.120	.948
MINIMUM X	-1.269	-1.380	-.750
MAXIMUM Y	.618	.588	.515
MINIMUM Y	-1.002	-.934	-1.007
CENTROID X	.346	.487	.659
CENTROID Y	.206	.138	.211
POA TO CENTROID in.	.402	.506	.692
MIN RADIUS	.019	.143	.295
MEAN RADIUS	.836	.800	.731
MAX RADIUS	1.411	1.498	1.235
HORIZONTAL SPREAD	2.530	2.500	1.698
VERTICAL SPREAD	1.620	1.522	1.522
EXTREME SPREAD	2.741	2.741	2.224
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611434
22 May 1991

CENTROIDAL DISTANCES

0 TO	1	.153118
1 TO	2	.177102
1 TO	3	.238799
1 TO	4	.254568
1 TO	5	.126463

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165793
THE AMR FOR THIS RIFLE IS: 1.045

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611434.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.617

VS = 4.332

GS = 4.446

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.417	1.383
MINIMUM X	-1.273	-1.200	-1.234
MAXIMUM Y	2.172	1.933	1.693
MINIMUM Y	-2.160	-1.919	-1.013
CENTROID X	.006	-.067	-.033
CENTROID Y	-.153	-.394	-.154
POA TO CENTROID in.	.153	.400	.158
MIN RADIUS	.216	.446	.249
MEAN RADIUS	1.361	1.255	1.145
MAX RADIUS	2.268	2.029	1.813
HORIZONTAL SPREAD	2.617	2.617	2.617
VERTICAL SPREAD	4.332	3.852	2.706
EXTREME SPREAD	4.446	3.868	3.349
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811434.1

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS = 2.401

VS = 3.708

GS = 3.797

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.275	.762	.837
MINIMUM X	-1.126	-.985	-.910
MAXIMUM Y	1.832	.545	.336
MINIMUM Y	-1.876	-1.672	-.613
CENTROID X	.165	.024	-.051
CENTROID Y	-.075	-.279	-.070
POA TO CENTROID in.	.182	.280	.086
MIN RADIUS	.126	.124	.132
MEAN RADIUS	.829	.642	.467
MAX RADIUS	2.232	1.777	.954
HORIZONTAL SPREAD	2.401	1.747	1.747
VERTICAL SPREAD	3.708	2.217	.948
EXTREME SPREAD	3.797	2.686	1.747
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11434.1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.333

VS = 1.958

GS = 3.045

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.101	.964	1.083
MINIMUM X	-1.232	-1.249	-1.130
MAXIMUM Y	1.159	1.198	.633
MINIMUM Y	-.798	-.670	-.520
CENTROID X	-.065	.072	-.047
CENTROID Y	-.381	-.509	-.659
POA TO CENTROID in.	.386	.514	.661
MIN RADIUS	.466	.305	.220
MEAN RADIUS	.998	.880	.780
MAX RADIUS	1.692	1.526	1.217
HORIZONTAL SPREAD	2.333	2.213	2.213
VERTICAL SPREAD	1.958	1.868	1.153
EXTREME SPREAD	3.045	2.447	2.415
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/Q6611434.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

CENTROID *

HS = 2.468

VS = 2.918

GS = 2.924

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.095	1.080	.907
MINIMUM X	-1.373	-1.388	-.625
MAXIMUM Y	1.662	1.040	.967
MINIMUM Y	-1.256	-1.071	-1.144
CENTROID X	.088	.103	.276
CENTROID Y	.088	-.097	-.024
POA TO CENTROID in.	.124	.141	.277
MIN RADIUS	.214	.121	.309
MEAN RADIUS	.930	.838	.748
MAX RADIUS	1.667	1.505	1.151
HORIZONTAL SPREAD	2.468	2.468	1.532
VERTICAL SPREAD	2.918	2.111	2.111
EXTREME SPREAD	2.924	2.667	2.126
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

22 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611434.1

CENTERFIRE PATTERNS # 5

POH

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.9008

VS= 2.9608

GS= 3.1008

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.566	1.417	.757
MINIMUM X	-1.342	-1.332	-1.155
MAXIMUM Y	1.484	1.233	1.311
MINIMUM Y	-1.476	-1.311	-1.233
CENTROID X	.054	.203	.026
CENTROID Y	-.270	-.435	-.513
POA TO CENTROID in.	.275	.480	.513
MIN RADIUS	.496	.278	.415
MEAN RADIUS	1.107	.972	.918
MAX RADIUS	2.001	1.548	1.385
HORIZONTAL SPREAD	2.908	2.749	1.912
VERTICAL SPREAD	2.960	2.544	2.544
EXTREME SPREAD	3.108	2.957	2.671
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		