

C5611449

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

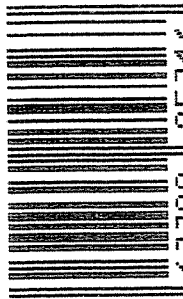
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6611449

ORDER NO.
5716

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

UPC



0 47700 25716 2



5716 C6611449

INTERCHANGEABILITY

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611449

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	JS
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	JA

op. #	BARBER M24 0077049 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/29/91	JK
	G) Safety Off Force	3	3	3			4/29/91	JK
	H) Trigger Pull Test & Retainability						4/29/91	JK
	I) Firing Pin Indent	1022	1022	1022			4/29/91	JK
	J) Assemble Stock						5/1/91	KS
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	KS
	M) Iron Sight Alignment						5/1/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	KS
	O) Attach Scope to Rifle						5/1/91	KS
	P) Detach & Attach Scope 20 Times						5/1/91	KS
640	Gallery Target & Test						5/1/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/1/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	D/H
	B) Trigger Pull	2.54	2.53	2.54	2.55	2.50	5/1/91	JK
	C) Function						5-1-91	D/H
660	Pack						6-19-91	VF

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

SERIAL NO. C6611449

DATE 3/24/91

TESTER J. J. (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.40	2.42	2.43	MIN. SETTING,
PULL #2	2.37	2.35	2.40	NO AVG. OF 5
PULL #3	2.29	2.43	2.39	READINGS ACCEPT-
PULL #4	2.34	2.39	2.36	ABLE LESS THAN 2#
PULL #5	2.36	2.39	2.40	
TOTAL				
AVG.				

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.30	3.28	
PULL #2	3.23	3.32	
PULL #3	3.20	3.36	
PULL #4	3.27	3.27	
PULL #5	3.29	3.34	
TOTAL			
AVG.			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.45		4.30
PULL #2	4.37	4.45		4.50
PULL #3	4.34	4.46		4.51
PULL #4	4.37	4.41		4.50
PULL #5	4.37	4.40		4.47
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611449
24 May 1991

CENTROIDAL DISTANCES

0 TO	1	.230931
1 TO	2	.351677
1 TO	3	.688585
1 TO	4	.523004
1 TO	5	.183984

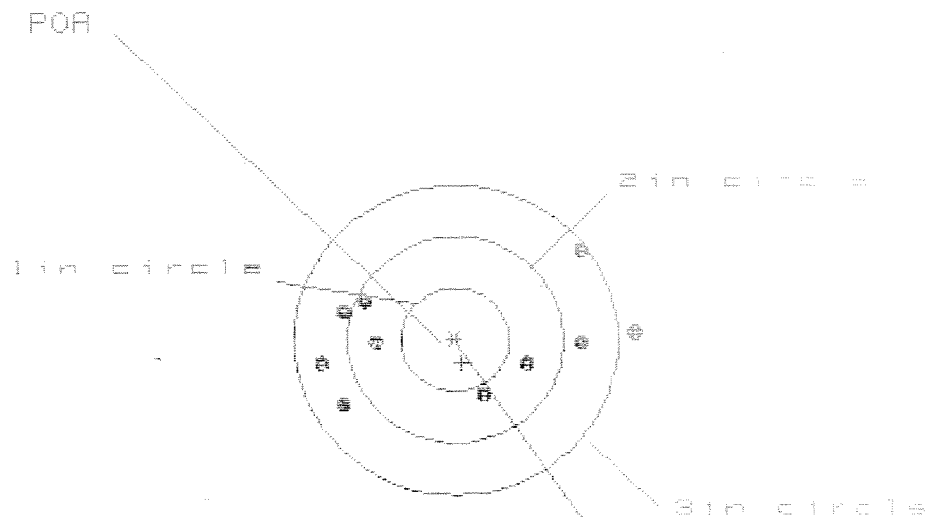
2.40 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131167
THE AMR FOR THIS RIFLE IS: .9572

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08811443

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR :

1 in = 0

2 in = 4

3 in = 5

HS = 2.849

VS = 1.488

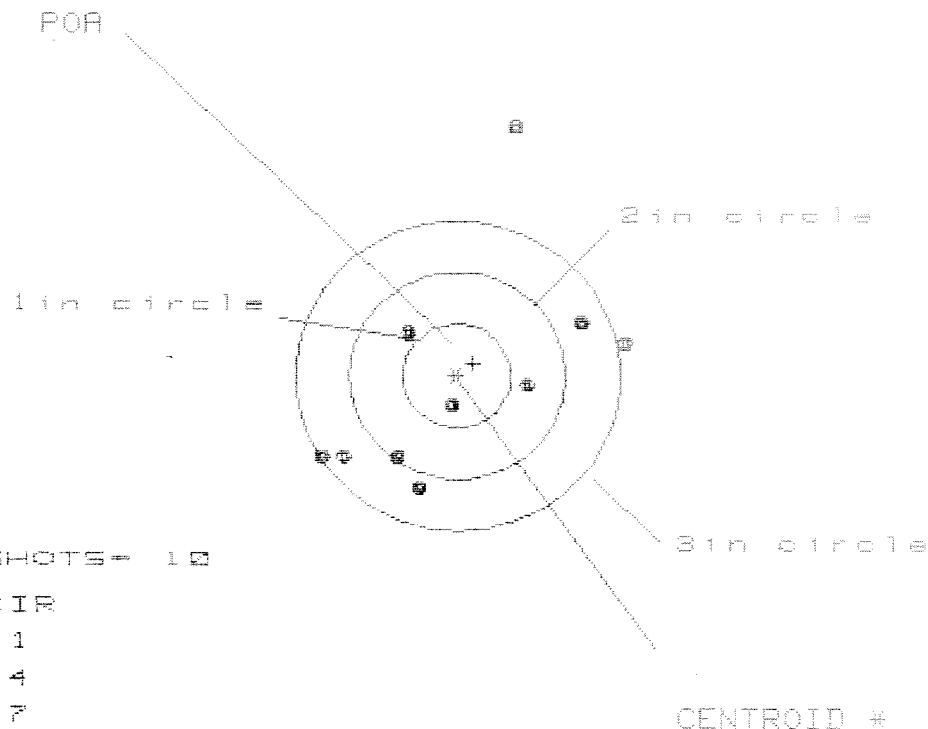
GS = 2.866

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.655	1.353	1.517
MINIMUM X	-1.194	-1.011	-.847
MAXIMUM Y	.912	.924	.461
MINIMUM Y	-.576	-.564	-.448
CENTROID X	-.860	-.243	-.407
CENTROID Y	.223	.211	.095
POA TO CENTROID in.	.231	.322	.418
MIN RADIUS	.551	.593	.446
MEAN RADIUS	1.068	.973	.852
MAX RADIUS	1.658	1.600	1.516
HORIZONTAL SPREAD	2.849	2.364	2.364
VERTICAL SPREAD	1.488	1.488	.909
EXTREME SPREAD	2.866	2.664	2.360
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611449.1

CENTERFIRE PATTERNS # 2



PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.499	1.555	1.413
MINIMUM X	-1.291	-1.235	-1.040
MAXIMUM Y	2.413	.784	.855
MINIMUM Y	-1.062	-.793	-.722
CENTROID X	-.146	-.282	-.397
CENTROID Y	-.118	-.386	-.457
POA TO CENTROID in.	.187	.435	.605
MIN RADIUS	.271	.031	.236
MEAN RADIUS	1.172	.967	.866
MAX RADIUS	2.466	1.657	1.651
HORIZONTAL SPREAD	2.790	2.790	2.453
VERTICAL SPREAD	3.474	1.577	1.577
EXTREME SPREAD	3.651	2.987	2.767
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611449.1

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.773

VS = 3.064

GS = 3.593

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.855	1.809	1.046
MINIMUM X	-.918	-.964	-.738
MAXIMUM Y	.946	.711	.765
MINIMUM Y	-2.118	-1.184	-1.129
CENTROID X	.533	.579	.353
CENTROID Y	-.127	.109	.054
POA TO CENTROID in.	.548	.589	.357
MIN RADIUS	.437	.330	.233
MEAN RADIUS	1.040	.873	.706
MAX RADIUS	2.157	1.860	1.143
HORIZONTAL SPREAD	2.773	2.773	1.784
VERTICAL SPREAD	3.064	1.895	1.895
EXTREME SPREAD	3.593	2.958	1.964
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0861L449.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.720

VS = 1.439

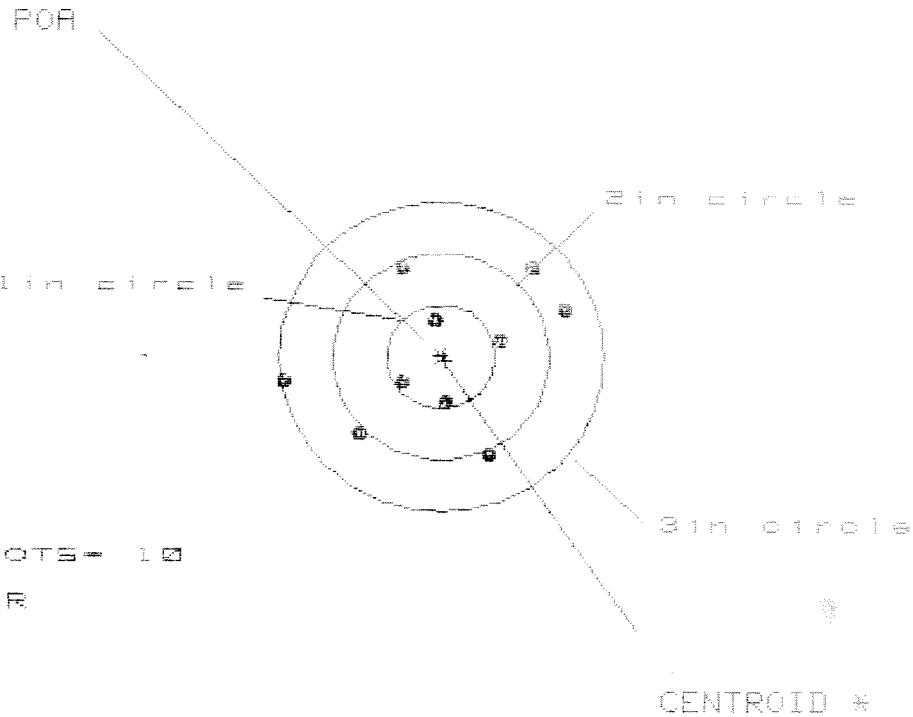
GS = 1.867

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.581	.598
MINIMUM X	:	-.768	-.662	-.645
MAXIMUM Y	:	.776	.784	.788
MINIMUM Y	:	-.663	-.735	-.647
CENTROID X	:	.367	.261	.244
CENTROID Y	:	-.079	-.087	-.095
POA TO CENTROID in.	:	.375	.261	.262
MIN RADIUS	:	.202	.283	.194
MEAN RADIUS	:	.630	.567	.532
MAX RADIUS	:	1.149	.741	.825
HORIZONTAL SPREAD	:	1.720	1.243	1.243
VERTICAL SPREAD	:	1.439	1.439	1.355
EXTREME SPREAD	:	1.867	1.452	1.431
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611449.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 2.605

VS = 1.782

GS = 2.693

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.112
MINIMUM X	-1.493
MAXIMUM Y	.848
MINIMUM Y	-.934
CENTROID X	-.041
CENTROID Y	.040
POA TO CENTROID in.	.057
MIN RADIUS	.399
MEAN RADIUS	.876
MAX RADIUS	1.516
HORIZONTAL SPREAD	2.605
VERTICAL SPREAD	1.782
EXTREME SPREAD	2.693
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611449
1 May 1991

CENTROIDAL DISTANCES

0 TO	1	.580662
1 TO	2	.612459
1 TO	3	.138885
1 TO	4	.499673
1 TO	5	.576771

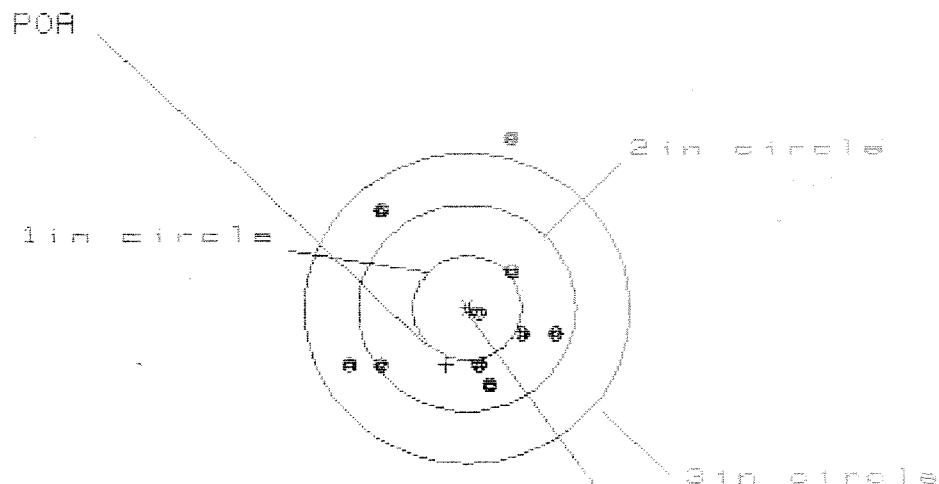
9.4
9.4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .01
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2414
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241607
THE AMR FOR THIS RIFLE IS: .7888

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811449

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.893

VS= 2.419

GS= 2.627

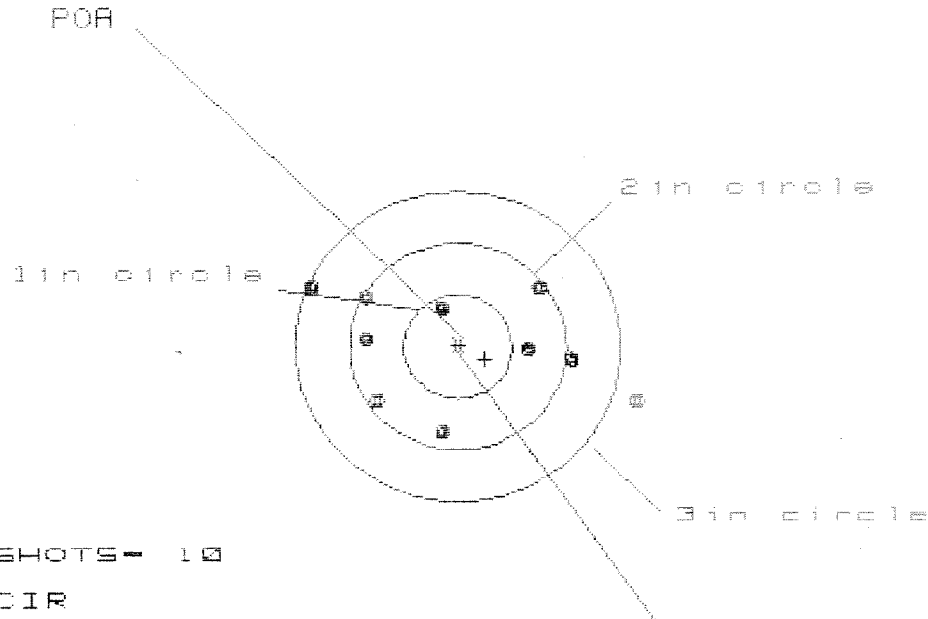
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.846	.891	.801
MINIMUM X	-1.047	-1.002	-1.092
MAXIMUM Y	1.639	1.119	.698
MINIMUM Y	-.780	-.598	-.458
CENTROID X	.192	.147	.237
CENTROID Y	.548	.366	.226
POA TO CENTROID in.	.581	.394	.327
MIN RADIUS	.131	.225	.274
MEAN RADIUS	.852	.740	.633
MAX RADIUS	1.689	1.332	1.115
HORIZONTAL SPREAD	1.893	1.893	1.893
VERTICAL SPREAD	2.419	1.717	1.156
EXTREME SPREAD	2.627	1.986	1.921
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11449

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.922

VS = 1.485

GS = 3.146

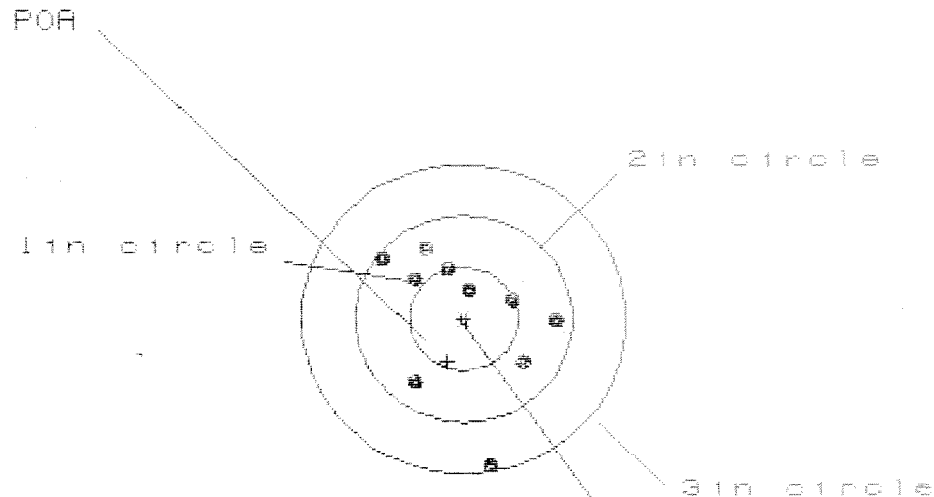
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.603	1.227	1.084
MINIMUM X	-1.320	-1.141	-.826
MAXIMUM Y	.618	.558	.562
MINIMUM Y	-.867	-.927	-.858
CENTROID X	-.249	-.427	-.284
CENTROID Y	.123	.183	.114
POA TO CENTROID in.	.277	.464	.306
MIN RADIUS	.446	.350	.442
MEAN RADIUS	.987	.885	.838
MAX RADIUS	1.693	1.270	1.093
HORIZONTAL SPREAD	2.922	2.368	1.910
VERTICAL SPREAD	1.485	1.485	1.420
EXTREME SPREAD	3.146	2.489	2.005
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611449

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.513

VS = 2.099

GS = 2.190

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.805	.836	.752
MINIMUM X	-.708	-.677	-.555
MAXIMUM Y	.719	.566	.614
MINIMUM Y	-1.380	-.795	-.747
CENTROID X	.152	.122	.206
CENTROID Y	.415	.568	.520
POA TO CENTROID in.	.442	.581	.559
MIN RADIUS	.293	.170	.178
MEAN RADIUS	.732	.619	.600
MAX RADIUS	1.407	.912	.917
HORIZONTAL SPREAD	1.513	1.513	1.307
VERTICAL SPREAD	2.099	1.361	1.361
EXTREME SPREAD	2.190	1.617	1.479
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611449

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 1.598

VS = 2.850

GS = 2.923

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.997	.957	.989
MINIMUM X	-.601	-.641	-.609
MAXIMUM Y	1.263	1.087	.631
MINIMUM Y	-1.587	-.869	-.733
CENTROID X	.064	.104	.072
CENTROID Y	.065	.241	.105
POA TO CENTROID in.	.091	.263	.128
MIN RADIUS	.108	.075	.095
MEAN RADIUS	.757	.640	.575
MAX RADIUS	1.626	1.116	1.173
HORIZONTAL SPREAD	1.598	1.598	1.598
VERTICAL SPREAD	2.850	1.956	1.364
EXTREME SPREAD	2.923	2.072	1.945
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611449

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 10

HS= 1.210

VS= 1.569

GS= 1.738

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.635
MINIMUM X	-.575
MAXIMUM Y	.765
MINIMUM Y	-.804
CENTROID X	-.109
CENTROID Y	.056
POA TO CENTROID in.	.123
MIN RADIUS	.176
MEAN RADIUS	.616
MAX RADIUS	1.025
HORIZONTAL SPREAD	1.210
VERTICAL SPREAD	1.569
EXTREME SPREAD	1.738
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	10