

C6611536

MODEL 700™ M24

Model **SMS** TH

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 700™ M24	SERIAL NO. C6611536
	ORDER NO. 5716

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



5716 C6611536

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611536

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	2 1 91	Rw
600	Proof		2 1 91	Rw
607	Check Headspace		2 1 91	Rw
610	Dis-assemble Gun		2 1 91	Rw
612	Magnaflux Barrel Action		2 1 1 91	Ked
	Magnaflux Bolt		2 1 1 91	Ked
615	Rollmark Caliber		2 1 1 91	GB
617	Drill and Tap Sight Holes		2 1 3 91	LB
618	Polish Barrel RBB		2 1 3 91	WB
620	Apply Coatings (Barrel Action)		2/29/91	QA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/3/91	QA

op. #	BARBER M24 0078417	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			4-3-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			4-3-91	DH
	H) Trigger Pull Test & Retainability						4/3/91	JH
	I) Firing Pin Indent	.020	.021	.020			4-3-91	DH
	J) Assemble Stock						4/4/91	RW
	K) Assemble Swivel Studs						4-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	RW
	M) Iron Sight Alignment						4/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	RW
	O) Attach Scope to Rifle						4/4/91	RW
	P) Detach & Attach Scope 20 Times						4/4/91	RW
640	Gallery Target & Test						4-5-91	AC
	A) Time						4-5-91	AC
	B) Malfunctions						4-5-91	AC
	C) Pierced Primers						4-5-91	AC
	D) Optical Clarity of Scope						4-5-91	AC
645	Inspect for Live Ammo						4-5-91	AC
655	Final Inspection							
	A) Headspace						4-8-91	DH
	B) Trigger Pull	2.18	2.15	2.14	2.25	2.20	4/8/91	JH
	C) Function						4-8-91	DH
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611536

DATE 4/3/81

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.27	2.27	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.31	2.27	2.15	
PULL #3	2.29	2.30	2.33	2.14	
PULL #4	2.28	2.29	2.26	2.25	
PULL #5	2.30	2.28	2.30	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.40		
PULL #2	3.48	3.46		
PULL #3	3.43	3.48		
PULL #4	3.48	3.40		
PULL #5	3.47	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.24		4.15
PULL #2	4.22	4.20		4.23
PULL #3	4.28	4.22		4.18
PULL #4	4.21	4.25		4.27
PULL #5	4.27	4.21		4.22
TOTAL				
AVG.				

INTERCHANGEABILITY

INTERPOLAL DISTANCE CALCULATIONS

FOR RIFLE # 06611536

20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.408571
1 TO	2	.446919
1 TO	3	.744312
1 TO	4	.526186
1 TO	5	.429616

1
2
3 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.259

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.134

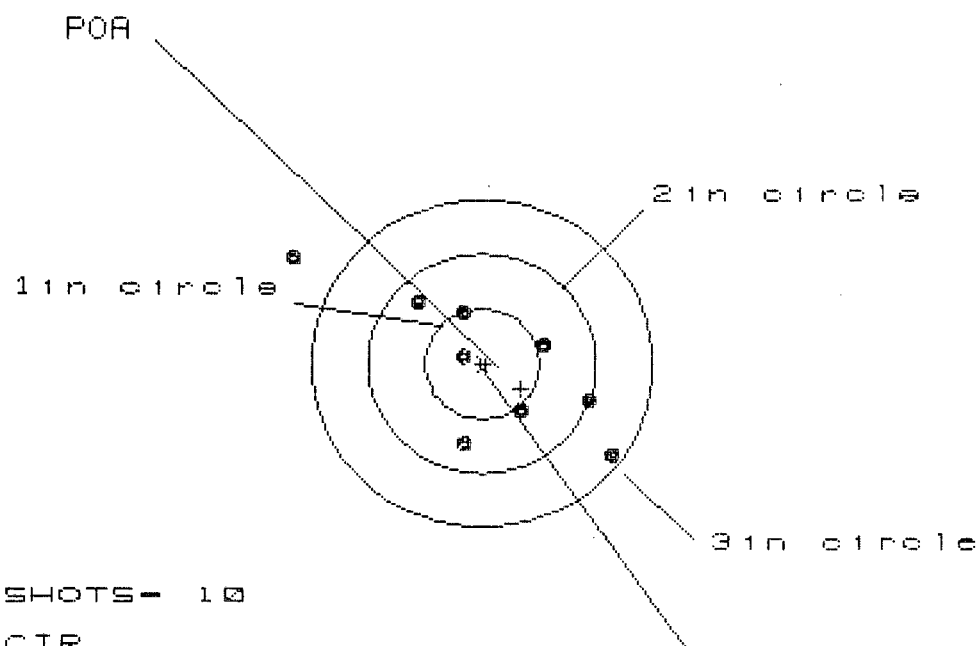
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .291611

THE AMR FOR THIS RIFLE IS: .9058

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11536.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.778

VS= 1.832

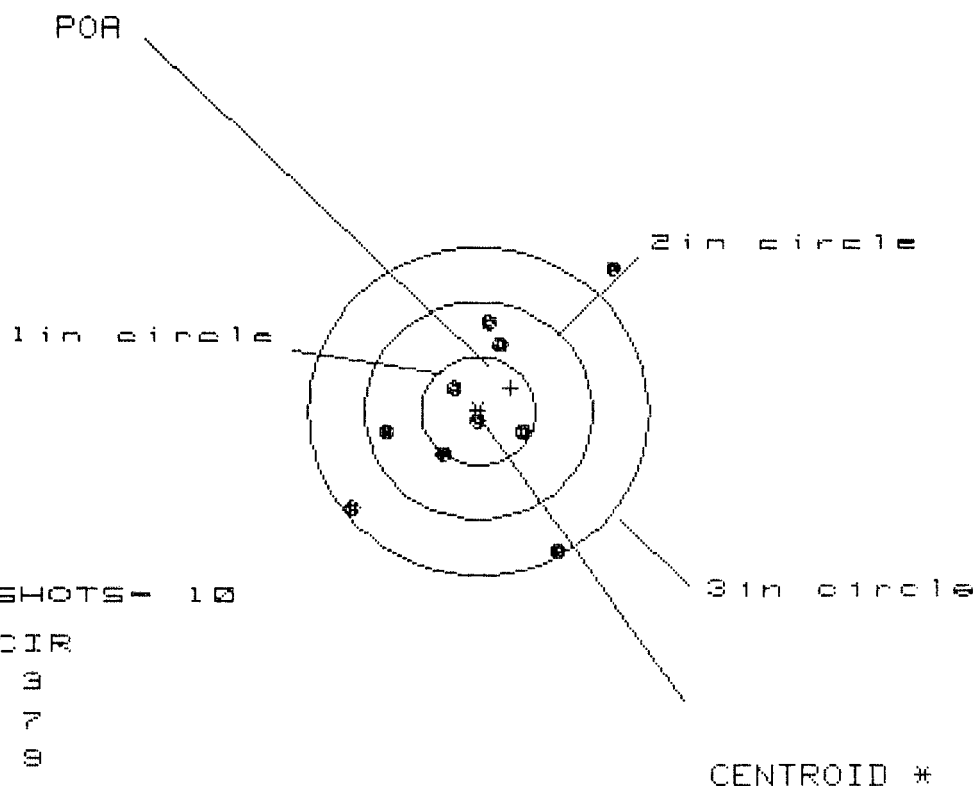
GS= 3.328

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.157	.977	.837
MINIMUM X	-1.621	-.756	-.633
MAXIMUM Y	.956	.715	.618
MINIMUM Y	-.876	-.769	-.682
CENTROID X	-.337	-.157	-.280
CENTROID Y	.231	.124	.221
POA TO CENTROID in.	.409	.201	.356
MIN RADIUS	.164	.317	.222
MEAN RADIUS	.774	.656	.557
MAX RADIUS	1.882	1.244	.894
HORIZONTAL SPREAD	2.778	1.733	1.470
VERTICAL SPREAD	1.832	1.484	1.301
EXTREME SPREAD	3.328	2.282	1.741
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611536.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.271

VS= 2.669

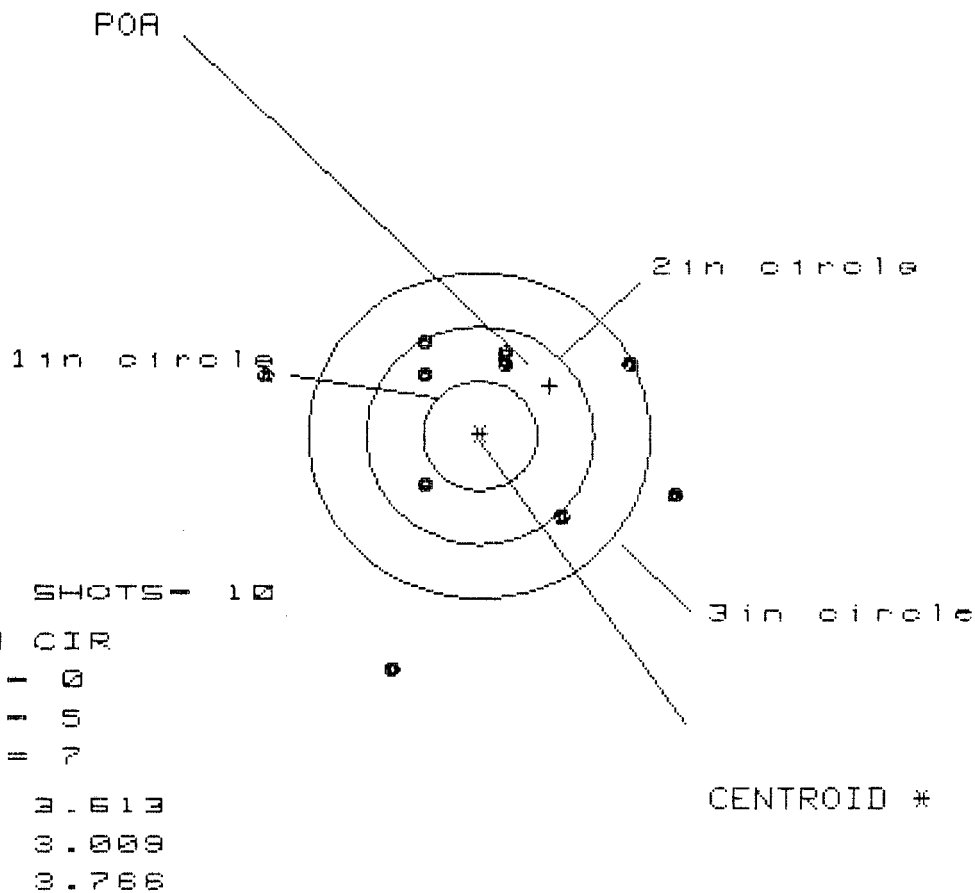
GS= 3.153

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.150	.810	.592
MINIMUM X	:	-1.121	-.993	-.892
MAXIMUM Y	:	1.347	.979	.833
MINIMUM Y	:	-1.321	-1.172	-.836
CENTROID X	:	-.286	-.414	-.515
CENTROID Y	:	-.213	-.363	-.217
POA TO CENTROID in.	:	.357	.551	.559
MIN RADIUS	:	.060	.157	.236
MEAN RADIUS	:	.833	.727	.629
MAX RADIUS	:	1.772	1.424	1.223
HORIZONTAL SPREAD	:	2.271	1.803	1.484
VERTICAL SPREAD	:	2.669	2.151	1.669
EXTREME SPREAD	:	3.153	2.235	2.053
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11536.1

CENTERFIRE PATTERNS # 3



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.687	1.595	1.343
MINIMUM X	:	-1.926	-2.018	-.835
MAXIMUM Y	:	.865	.626	.663
MINIMUM Y	:	-2.144	-1.014	-.977
CENTROID X	:	-.621	-.529	-.277
CENTROID Y	:	-.457	-.218	-.255
POA TO CENTROID in.	:	.770	.572	.376
MIN RADIUS	:	.675	.426	.457
MEAN RADIUS	:	1.233	1.059	.946
MAX RADIUS	:	2.297	2.039	1.530
HORIZONTAL SPREAD	:	3.613	3.613	2.178
VERTICAL SPREAD	:	3.009	1.640	1.640
EXTREME SPREAD	:	3.766	3.766	2.552
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11536.1

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.855

VS= 2.343

GS= 3.060

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.456	1.548	.839
MINIMUM X	:	-1.399	-1.307	-1.114
MAXIMUM Y	:	.982	.831	.885
MINIMUM Y	:	-1.361	-.672	-.618
CENTROID X	:	-.071	-.163	-.356
CENTROID Y	:	-.223	-.072	-.126
POA TO CENTROID in.	:	.235	.178	.378
MIN RADIUS	:	.295	.344	.215
MEAN RADIUS	:	.884	.802	.690
MAX RADIUS	:	1.589	1.606	1.274
HORIZONTAL SPREAD	:	2.855	2.855	1.953
VERTICAL SPREAD	:	2.343	1.503	1.503
EXTREME SPREAD	:	3.060	3.060	2.130
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611536.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.263

VS= 1.635

GS= 2.287

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.396	1.238	.699
MINIMUM X	:	-.867	-.712	-.557
MAXIMUM Y	:	.812	.838	.690
MINIMUM Y	:	-.823	-.797	-.692
CENTROID X	:	.020	-.135	-.290
CENTROID Y	:	-.008	-.034	-.139
POA TO CENTROID in.	:	.021	.140	.322
MIN RADIUS	:	.328	.174	.129
MEAN RADIUS	:	.805	.692	.559
MAX RADIUS	:	1.416	1.495	.984
HORIZONTAL SPREAD	:	2.263	1.950	1.256
VERTICAL SPREAD	:	1.635	1.635	1.382
EXTREME SPREAD	:	2.287	2.252	1.867
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611536
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0722011
1 TO	2	.152948
1 TO	3	.0859593
1 TO	4	.168048
1 TO	5	.434041

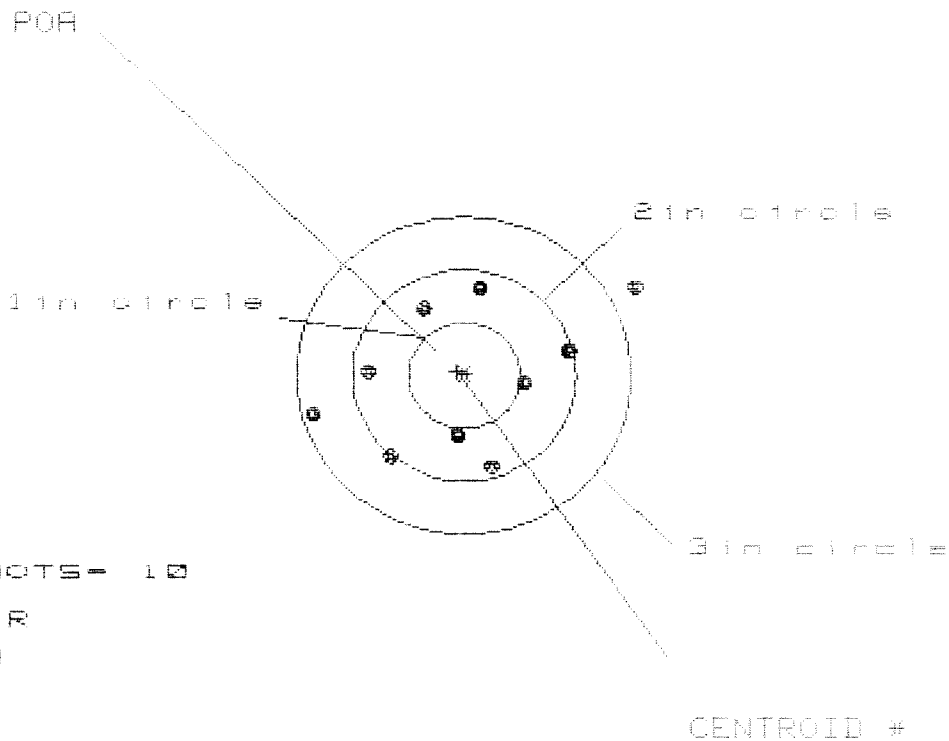
#45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179873
THE AMP FOR THIS RIFLE IS: .9692

5 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06B11536

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 0

3in = 9

HS= 2.914

VS= 1.667

GS= 3.163

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.530	1.095	.944
MINIMUM X	-1.384	-1.214	-.848
MAXIMUM Y	.831	.914	.876
MINIMUM Y	-.836	-.743	-.781
CENTROID X	.062	-.108	.043
CENTROID Y	-.037	-.130	-.091
POA TO CENTROID in.	.072	.169	.101
MIN RADIUS	.535	.459	.500
MEAN RADIUS	.952	.850	.789
MAX RADIUS	1.742	1.252	.979
HORIZONTAL SPREAD	2.914	2.309	1.792
VERTICAL SPREAD	1.667	1.657	1.657
EXTREME SPREAD	3.163	2.387	1.846
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	0		
NUMBER IN THREE INCH CIRCLE =	9		

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11536

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.611

VS= 2.528

GS= 3.250

CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.531	1.411	.759
MINIMUM X	-1.080	-1.152	-.975
MAXIMUM Y	1.008	.839	.869
MINIMUM Y	-1.520	-1.666	-1.635
CENTROID X	-.006	.114	-.063
CENTROID Y	-.174	-.005	-.035
POA TO CENTROID in.	.174	.114	.072
MIN RADIUS	.255	.363	.295
MEAN RADIUS	1.041	.912	.835
MAX RADIUS	1.865	1.670	1.637
HORIZONTAL SPREAD	2.611	2.563	1.734
VERTICAL SPREAD	2.528	2.505	2.505
EXTREME SPREAD	3.250	2.746	2.507
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611536

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.982

VS= 2.260

GS= 2.884

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.192
MINIMUM X	-1.790
MAXIMUM Y	.957
MINIMUM Y	-1.303
CENTROID X	.020
CENTROID Y	-.112
POA TO CENTROID in.	.114
MIN RADIUS	.379
MEAN RADIUS	.935
MAX RADIUS	1.524
HORIZONTAL SPREAD	1.982
VERTICAL SPREAD	2.260
EXTREME SPREAD	2.884
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611536

CENTERFIRE PATTERNS # 4

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.495

VS = 2.912

GS = 2.987

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.197	1.145	1.215
MINIMUM X	-1.298	-1.350	-1.280
MAXIMUM Y	1.306	1.127	.943
MINIMUM Y	-1.506	-1.477	-1.097
CENTROID X	.238	.282	.212
CENTROID Y	-.041	.138	.022
POB TO CENTROID in.	.234	.314	.386
MIN RADIUS	.343	.235	.133
MEAN RADIUS	1.064	.956	.830
MAX RADIUS	1.672	1.577	1.333
HORIZONTAL SPREAD	2.495	2.495	2.495
VERTICAL SPREAD	2.912	2.604	2.040
EXTREME SPREAD	2.987	2.635	2.512
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11536

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 2.521

VS = 1.998

GS = 2.675

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.165
MINIMUM X	-1.355
MAXIMUM Y	.897
MINIMUM Y	-1.101
CENTROID X	.496
CENTROID Y	-.043
POA TO CENTROID in.	.498
MIN RADIUS	.215
MEAN RADIUS	.849
MAX RADIUS	1.603
HORIZONTAL SPREAD	2.521
VERTICAL SPREAD	1.998
EXTREME SPREAD	2.675
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8