

C6611551

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ M24

SERIAL NO.
C6611551

ORDER NO.
5716

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

20



5716 C6611551

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611551

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KA
600	Proof		2/1/91	KA
607	Check Headspace		2/1/91	KA
610	Dis-assemble Gun		2/1/91	KA
612	Magnaflux Barrel Action	2 11 91		Ked
	Magnaflux Bolt	2 11 91		KCR
615	Rollmark Caliber	2 11 91		CS
617	Drill and Tap Sight Holes	2 13 91		WB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		3-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		3/21/91	JA

Op. #	BARBERNAME	0078680	READINGS					DATE	INIT
625 cont.	F) Safety On Force		4	4	4			3/21/91	KS
	G) Safety Off Force		2 3/4	2 1/2	2 3/4			3/21/91	KS
	H) Trigger Pull Test & Retainability							3/21/91	JL
	I) Firing Pin Indent		.0215	.022	.022			3/21/91	KS
	J) Assemble Stock							3/21/91	KS
	K) Assemble Swivel Studs							4-8-91	DH
	L) Attach Front and Rear Sight Assemblies							3/21/91	KS
	M) Iron Sight Alignment							3/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container							3/21/91	KS
	O) Attach Scope to Rifle							3/21/91	KS
	P) Detach & Attach Scope 20 Times							3/21/91	KS
640	Gallery Target & Test							4-3-91	NF
	A) Time							"	NF
	B) Malfunctions							"	NF
	C) Pierced Primers							"	NF
	D) Optical Clarity of Scope							"	NF
645	Inspect for Live Ammo							4-3-91	NF
655	Final Inspection								
	A) Headspace							4-8-91	DH
	B) Trigger Pull		2.59	2.57	2.52	2.54	2.60	4/5/91	JL
	C) Function							4-8-91	DH
660	Pack							6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-661155DATE 3/21/91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.54	2.42	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.30	2.38	2.57	
PULL #3	2.38	2.31	2.36	2.52	
PULL #4	2.44	2.34	2.30	2.54	
PULL #5	2.44	2.31	2.39	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.23		
PULL #2	3.51	3.23		
PULL #3	3.47	3.40		
PULL #4	3.20	3.44		
PULL #5	3.44	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.38		4.29
PULL #2	4.40	4.24		4.23
PULL #3	4.49	4.24		4.30
PULL #4	4.55	4.27		4.35
PULL #5	4.50	4.28		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611551
4 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.232349
1 TO	2	.204793
1 TO	3	.472822
1 TO	4	.144222
1 TO	5	.351118

~~15~~
13 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1908
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .254354
THE AMR FOR THIS RIFLE IS: 1.006

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611551

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.298

VS= 3.315

GS= 3.492

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.853	1.145	1.161
MINIMUM X	-1.445	-1.239	-1.223
MAXIMUM Y	1.878	1.817	.761
MINIMUM Y	-1.437	-1.498	-1.271
CENTROID X	-.025	-.231	-.247
CENTROID Y	.231	.292	.065
POA TO CENTROID in.	.232	.373	.255
MIN RADIUS	.202	.303	.337
MEAN RADIUS	1.156	1.055	.955
MAX RADIUS	1.934	1.821	1.441
HORIZONTAL SPREAD	3.298	2.384	2.384
VERTICAL SPREAD	3.315	3.315	2.032
EXTREME SPREAD	3.492	3.342	2.704
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611551

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.162

VS= 2.222

GS= 3.065

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.292	1.006	.921
MINIMUM X	-.870	-.726	-.811
MAXIMUM Y	1.068	.940	.845
MINIMUM Y	-1.154	-.961	-.843
CENTROID X	.179	.035	.120
CENTROID Y	.213	.341	.223
POR TO CENTROID in.	.278	.343	.254
MIN RADIUS	.162	.324	.183
MEAN RADIUS	.879	.795	.718
MAX RADIUS	1.732	1.171	1.171
HORIZONTAL SPREAD	2.162	1.732	1.732
VERTICAL SPREAD	2.222	1.901	1.688
EXTREME SPREAD	3.065	2.239	2.091
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611551

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.705

VS= 2.316

GS= 4.369

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.819	1.610	1.005
MINIMUM X	-1.886	-1.740	-1.539
MAXIMUM Y	1.211	1.088	1.089
MINIMUM Y	-1.105	-.833	-.697
CENTROID X	.380	.589	.388
CENTROID Y	-.013	.110	-.026
POR TO CENTROID in.	.380	.599	.389
MIN RADIUS	.407	.528	.408
MEAN RADIUS	1.200	1.071	.952
MAX RADIUS	2.186	1.943	1.689
HORIZONTAL SPREAD	3.705	3.350	2.544
VERTICAL SPREAD	2.316	1.921	1.786
EXTREME SPREAD	4.369	3.862	2.652
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611551

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 = 9

HS= 1.659

VS= 2.668

GS= 3.059

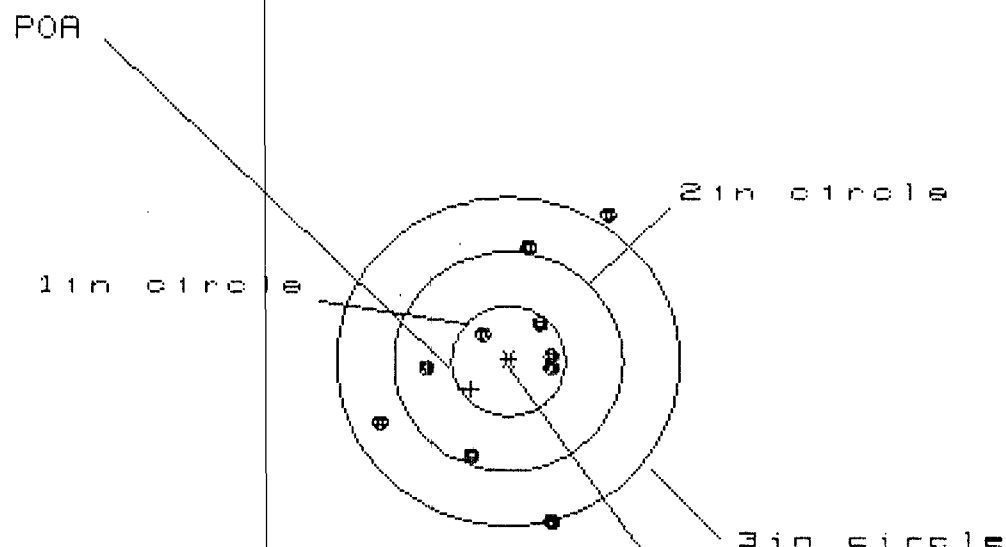
CENTROID *

PATTERN #	:	#4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.795	.699	.766
MINIMUM X	:	-.864	-.716	-.649
MAXIMUM Y	:	1.265	1.109	1.080
MINIMUM Y	:	-1.403	-1.137	-.998
CENTROID X	:	.095	.191	.124
CENTROID Y	:	.151	.307	.168
POA TO CENTROID in.	:	.179	.362	.209
MIN RADIUS	:	.388	.206	.360
MEAN RADIUS	:	.924	.823	.772
MAX RADIUS	:	1.648	1.335	1.258
HORIZONTAL SPREAD	:	1.659	1.415	1.415
VERTICAL SPREAD	:	2.668	2.246	2.078
EXTREME SPREAD	:	3.059	2.417	2.162
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611551

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.025

VS= 2.844

GS= 2.893

CENTROID #

PATTERN #	15	15	15
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.875	.504	.559
MINIMUM X	-1.150	-1.052	-.997
MAXIMUM Y	1.349	1.197	1.029
MINIMUM Y	-1.496	-1.346	-.842
CENTROID X	.325	.227	.172
CENTROID Y	.259	.109	.277
POA TO CENTROID in.	.415	.252	.326
MIN RADIUS	.300	.366	.190
MEAN RADIUS	.873	.803	.698
MAX RADIUS	1.608	1.417	1.163
HORIZONTAL SPREAD	2.025	1.556	1.556
VERTICAL SPREAD	2.844	2.543	1.871
EXTREME SPREAD	2.893	2.548	2.108
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6611551DATE 2-22-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.59	2.75	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.87	2.71	
PULL #3	2.71	2.57	2.76	
PULL #4	2.53	2.87	2.74	
PULL #5	2.65	2.70	2.80	
TOTAL	12.88	13.70	13.65	
AVG.	2.57	2.74	2.73	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.00		
PULL #2	3.09	2.96		
PULL #3	2.96	3.00		
PULL #4	3.13	2.86		
PULL #5	3.16	3.00		
TOTAL	15.50	14.82		
AVG.	3.10	2.96		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.13		4.05
PULL #2	4.27	4.15		4.15
PULL #3	4.44	3.92		3.95
PULL #4	4.15	4.18		3.98
PULL #5	3.94	3.90		4.30
TOTAL	21.05	20.28		20.43
AVG.	4.21	4.05		4.08

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6661551

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/8/96	AC
	G) Safety Off Force	3	3	3			3/8/96	AC
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.64	2.37	2.59	2.62	2.68	7/8/96	WB
	C) Function							
660	Pack							