

C6611560

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

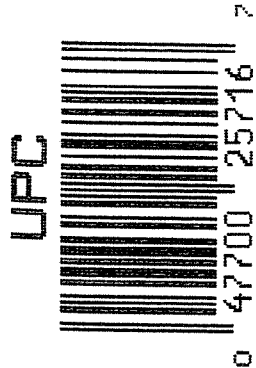
MODEL 700™ M24

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

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

SERIAL NO.	ORDER NO.
C6611560	5716

46



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611560

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	K.S.
600	Proof		2/1/91	K.S.
607	Check Headspace		2/1/91	K.S.
610	Dis-assemble Gun		2/1/91	K.S.
612	Magnaflux Barrel Action	2 1 1 9 1		K.S.
	Magnaflux Bolt	2 1 1 9 1		K.S.
615	Rollmark Caliber	2 1 1 9 1		G.S.
617	Drill and Tap Sight Holes	2 1 3 9 1		W.B.
618	Polish Barrel RBB	2 1 3 9 1		W.B.
620	Apply Coatings (Barrel Action)		3-12-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	K.S.
	C) Inspect Ejector Hole for Chamfer		3/20/91	K.S.
	D) Oil Firing Pin Ass'y		3/20/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		3/21/91	SL

op. #	BARBER - M24 0078839 OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4	4 3/4	3/21/91	KS
	G) Safety Off Force	2 3/4	2 1/2	2 1/2	3/21/91	KS
	H) Trigger Pull Test & Retainability				3/21/91	KS
	I) Firing Pin Indent	.021	.021	.021	3/21/91	KS
	J) Assemble Stock				3/21/91	KS
	K) Assemble Swivel Studs				4-17-91	A
	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				4-2-91	AF
	A) Time				"	AF
	B) Malfunctions				"	AF
	C) Pierced Primers				"	AF
	D) Optical Clarity of Scope				"	AF
645	Inspect for Live Ammo				4-2-91	AF
655	Final Inspection					
	A) Headspace				4-17-91	A
	B) Trigger Pull	2.59	2.66	2.60	4/16/91	KS
	C) Function				4-17-91	A
660	Pack				6-17-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C661156.0

DATE 3/21/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.43	2.40	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.39	2.48	2.66	
PULL #3	2.32	2.38	2.45	2.60	
PULL #4	2.37	2.47	2.36	2.65	
PULL #5	2.43	2.49	2.38	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.33		
PULL #2	3.14	3.35		
PULL #3	3.27	3.37		
PULL #4	3.37	3.22		
PULL #5	3.33	3.41		
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	4.20		4.40
PULL #2	4.22	4.38		4.40
PULL #3	4.31	4.38		4.36
PULL #4	4.34	4.38		4.37
PULL #5	4.41	4.39		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611560
9 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.293825
1 TO 2	.732067
1 TO 3	.093
1 TO 4	.813882
1 TO 5	.12105

2 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0464
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .121046
THE AMR FOR THIS RIFLE IS: 1.055

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.462

VS= 2.436

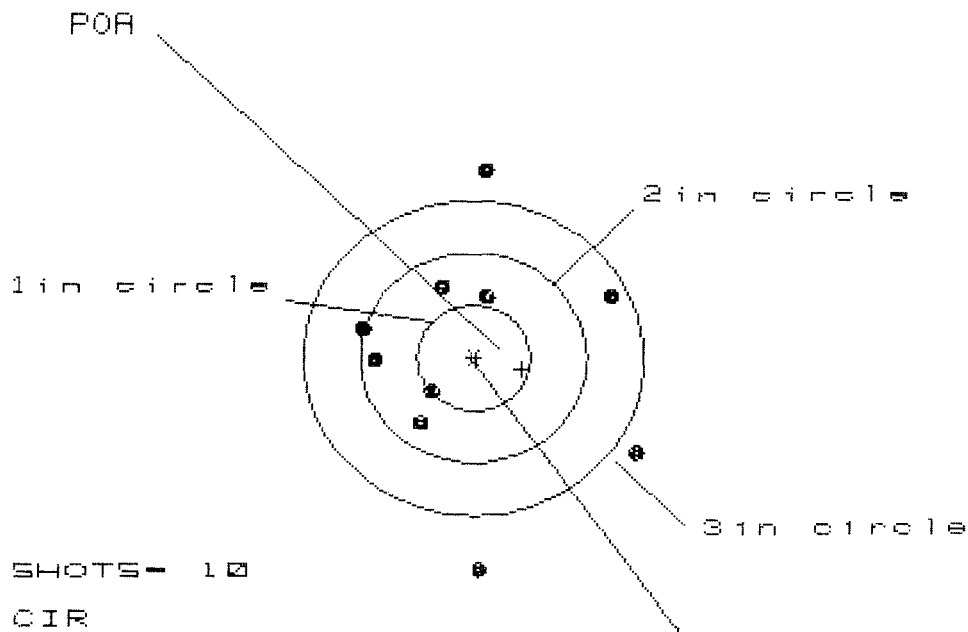
GS= 3.069

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.728	.896	.895
MINIMUM X	:	-.735	-.543	-.544
MAXIMUM Y	:	1.034	1.142	.981
MINIMUM Y	:	-1.403	-1.294	-1.130
CENTROID X	:	.277	.085	.086
CENTROID Y	:	-.098	-.206	-.045
POA TO CENTROID in.	:	.293	.223	.097
MIN RADIUS	:	.289	.150	.229
MEAN RADIUS	:	.937	.774	.707
MAX RADIUS	:	1.986	1.320	1.441
HORIZONTAL SPREAD	:	2.462	1.439	1.439
VERTICAL SPREAD	:	2.436	2.436	2.111
EXTREME SPREAD	:	3.069	2.437	2.391
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611560.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS= 2.449

VS= 3.813

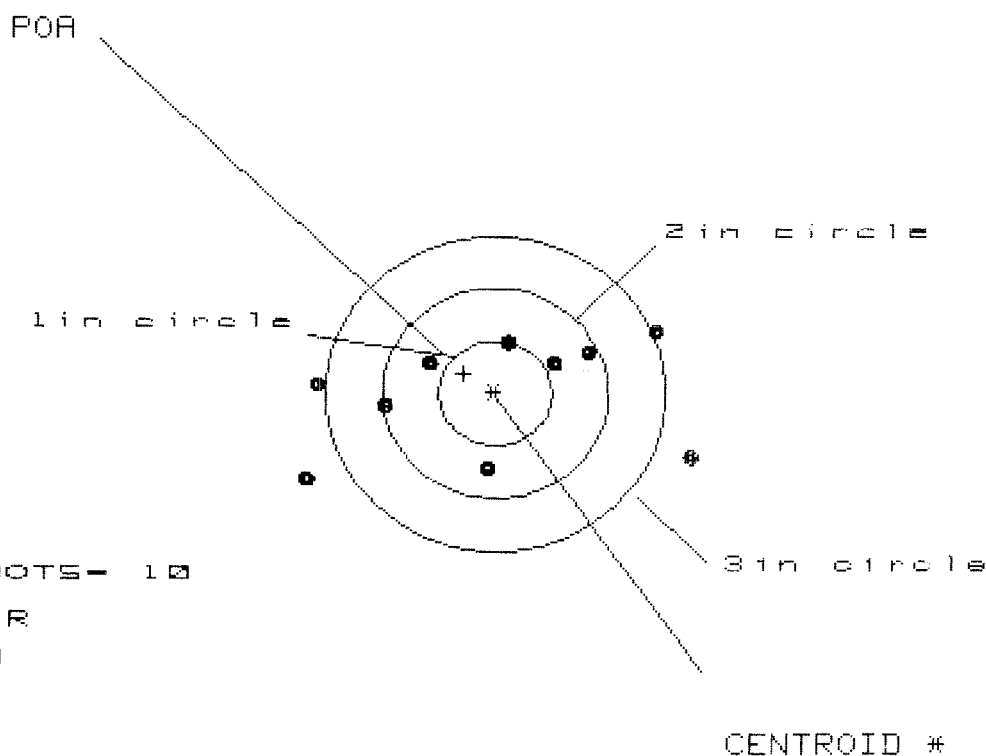
GS= 3.814

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.429	1.436	1.453
MINIMUM X	:	-1.019	-1.013	-.996
MAXIMUM Y	:	1.796	1.572	1.662
MINIMUM Y	:	-2.017	-1.166	-.969
CENTROID X	:	-.424	-.431	-.448
CENTROID Y	:	.113	.337	.140
POA TO CENTROID in.	:	.439	.547	.469
MIN RADIUS	:	.506	.388	.511
MEAN RADIUS	:	1.151	1.027	.955
MAX RADIUS	:	2.018	1.850	1.746
HORIZONTAL SPREAD	:	2.449	2.449	2.449
VERTICAL SPREAD	:	3.813	2.738	1.631
EXTREME SPREAD	:	3.814	3.033	2.742
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 6

3 in - 6

HS- 3.350

VS= 1.386

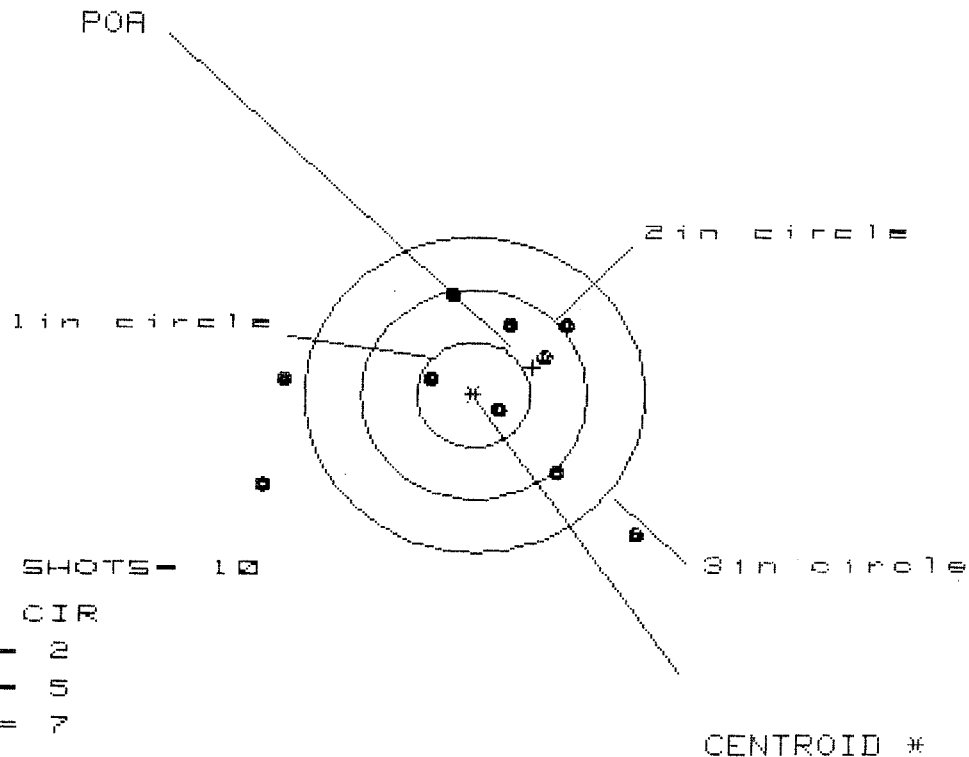
GS= 3.395

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.714	1.653	1.472
MINIMUM X	:	-1.636	-1.446	-1.546
MAXIMUM Y	:	.615	.543	.437
MINIMUM Y	:	-.771	-.843	-.873
CENTROID X	:	.277	.087	.268
CENTROID Y	:	-.191	-.119	-.013
POA TO CENTROID in.	:	.337	.147	.268
MIN RADIUS	:	.531	.427	.371
MEAN RADIUS	:	1.110	1.015	.908
MAX RADIUS	:	1.834	1.740	1.546
HORIZONTAL SPREAD	:	3.350	3.099	3.018
VERTICAL SPREAD	:	1.386	1.386	1.310
EXTREME SPREAD	:	3.395	3.395	3.057
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 7

HS- 3.217

VS- 2.352

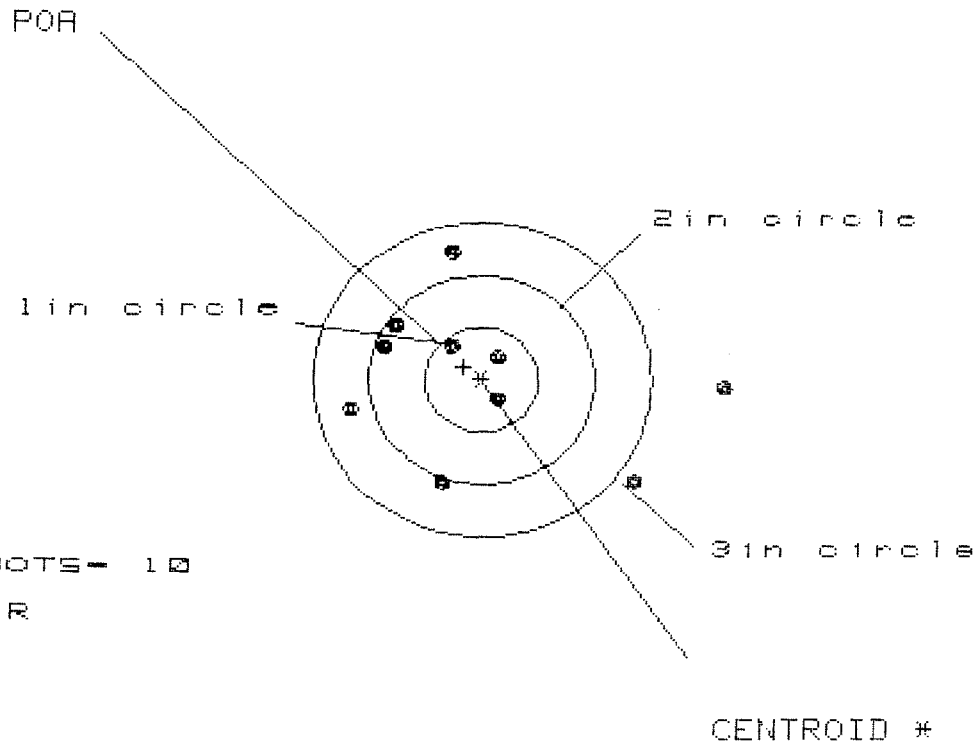
GS- 3.470

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.171	.757
MINIMUM X	:	-1.842	-1.927	-1.781
MAXIMUM Y	:	.972	.878	.694
MINIMUM Y	:	-1.380	-1.474	-.980
CENTROID X	:	-.521	-.317	-.463
CENTROID Y	:	-.258	-.164	.020
POA TO CENTROID in.	:	.582	.357	.463
MIN RADIUS	:	.281	.210	.413
MEAN RADIUS	:	1.087	.935	.807
MAX RADIUS	:	2.027	1.929	1.784
HORIZONTAL SPREAD	:	3.217	3.098	2.538
VERTICAL SPREAD	:	2.352	2.352	1.674
EXTREME SPREAD	:	3.470	3.470	2.592
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS # 5



PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.095	1.578	.577
MINIMUM X	-1.161	-.928	-.731
MAXIMUM Y	1.200	1.192	1.069
MINIMUM Y	-.995	-1.003	-1.126
CENTROID X	.159	-.074	-.271
CENTROID Y	-.125	-.117	.006
POA TO CENTROID in.	.202	.138	.271
MIN RADIUS	.212	.317	.222
MEAN RADIUS	.991	.838	.674
MAX RADIUS	2.096	1.858	1.127
HORIZONTAL SPREAD	3.256	2.506	1.308
VERTICAL SPREAD	2.195	2.195	2.195
EXTREME SPREAD	3.263	2.712	2.197
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611560
3 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.18932
1 TO	2	.0674166
1 TO	3	.349497
1 TO	4	.189423
1 TO	5	.22608

42g <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0472
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120435

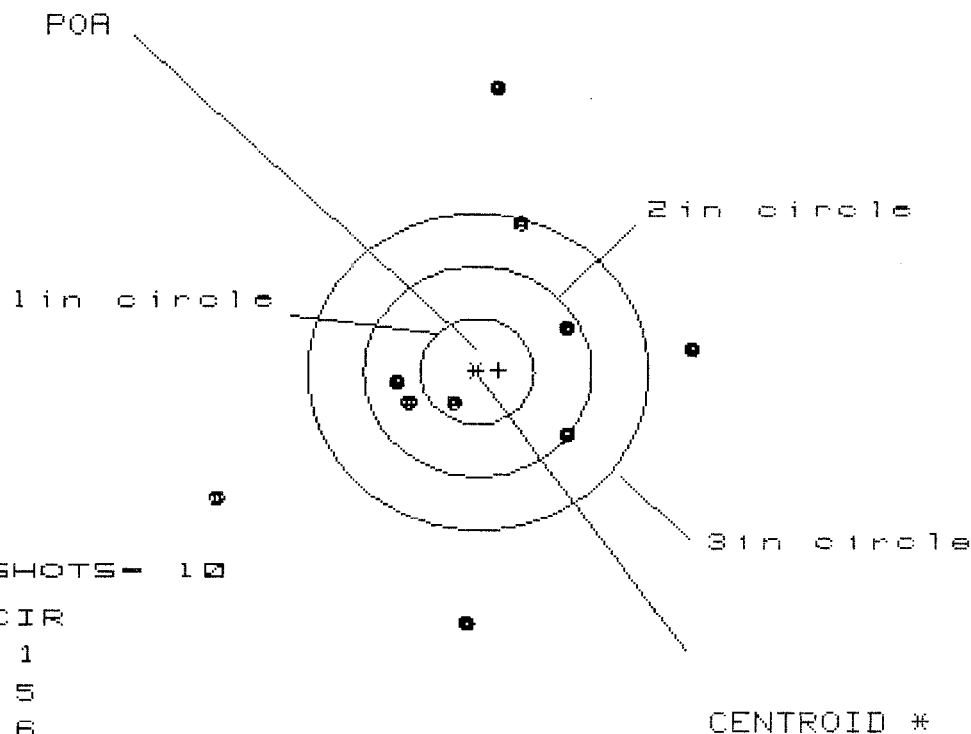
THE AMR FOR THIS RIFLE IS: 1.34

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811560

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in - 1

2in - 5

3in - 6

HS - 4.226

VS - 5.066

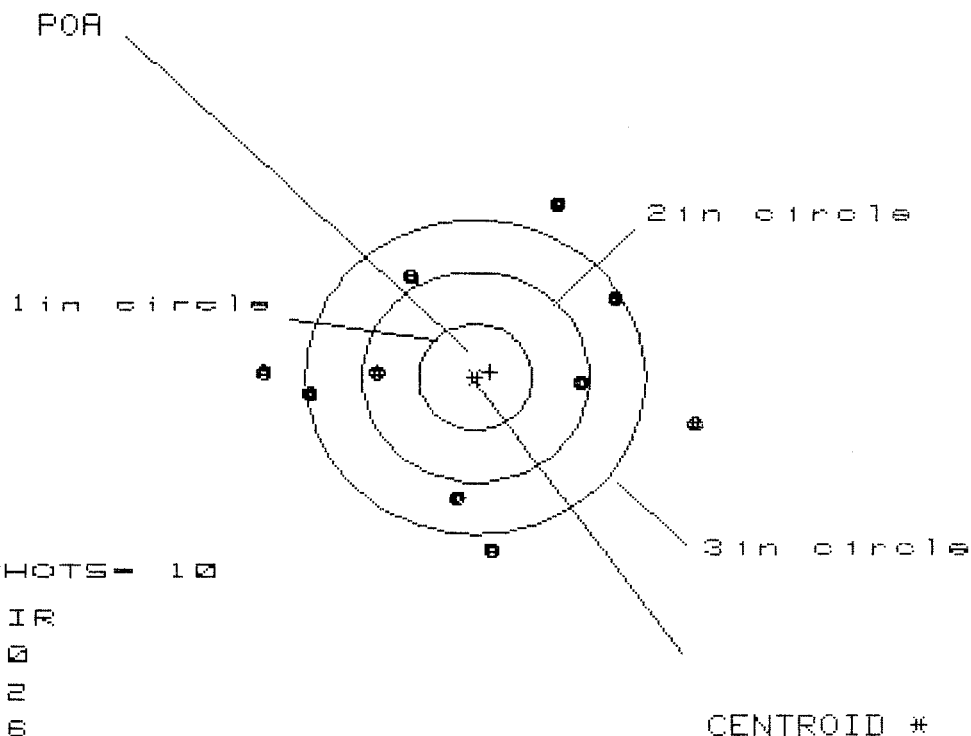
GS - 5.074

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.933	1.952	1.667
MINIMUM X	:	-2.293	-2.274	-.978
MAXIMUM Y	:	2.696	1.690	1.576
MINIMUM Y	:	-2.370	-2.071	-2.185
CENTROID X	:	-.189	-.208	.077
CENTROID Y	:	-.011	-.310	-.196
POA TO CENTROID in.	:	.189	.373	.210
MIN RADIUS	:	.325	.195	.477
MEAN RADIUS	:	1.464	1.304	1.166
MAX RADIUS	:	2.701	2.451	2.219
HORIZONTAL SPREAD	:	4.226	4.226	2.645
VERTICAL SPREAD	:	5.066	3.761	3.761
EXTREME SPREAD	:	5.074	4.472	3.792
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 0

2 in - 2

3 in - 6

HS - 3.865

VS - 3.294

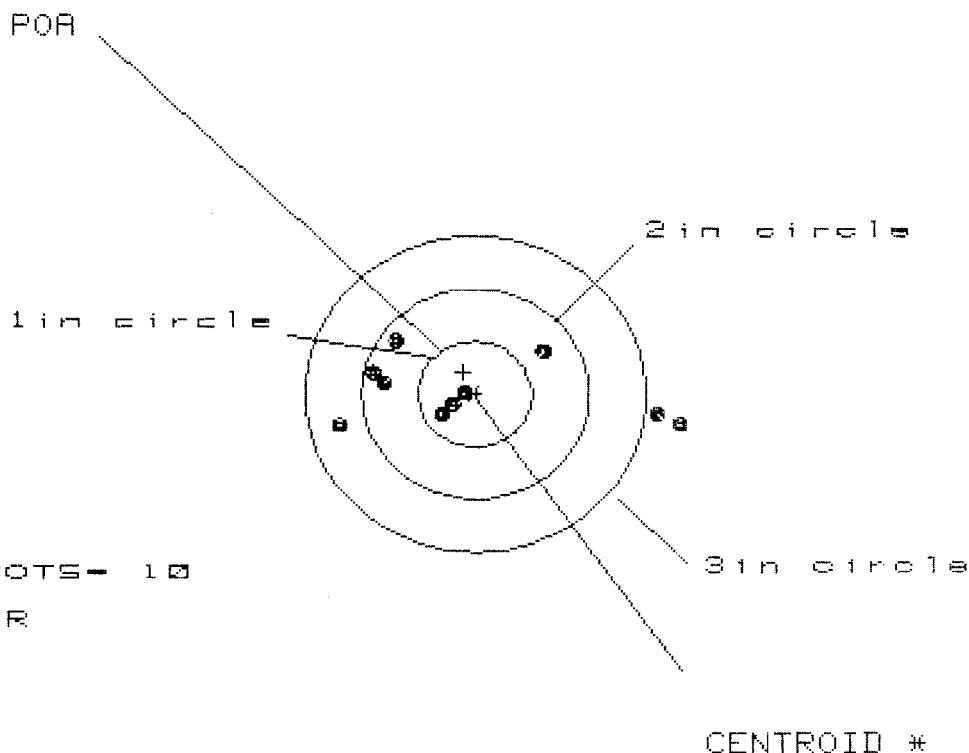
GS - 3.902

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.955	1.464	1.252
MINIMUM X	:	-1.910	-1.693	-1.475
MAXIMUM Y	:	1.675	1.620	1.617
MINIMUM Y	:	-1.619	-1.674	-1.677
CENTROID X	:	-.132	-.349	-.137
CENTROID Y	:	-.047	.008	.011
POA TO CENTROID in.	:	.140	.349	.138
MIN RADIUS	:	.851	.633	.845
MEAN RADIUS	:	1.440	1.349	1.307
MAX RADIUS	:	2.018	1.854	1.758
HORIZONTAL SPREAD	:	3.865	3.157	2.727
VERTICAL SPREAD	:	3.294	3.294	3.294
EXTREME SPREAD	:	3.902	3.334	3.334
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in = 8

HS= 3.002

VS= .857

GS= 3.002

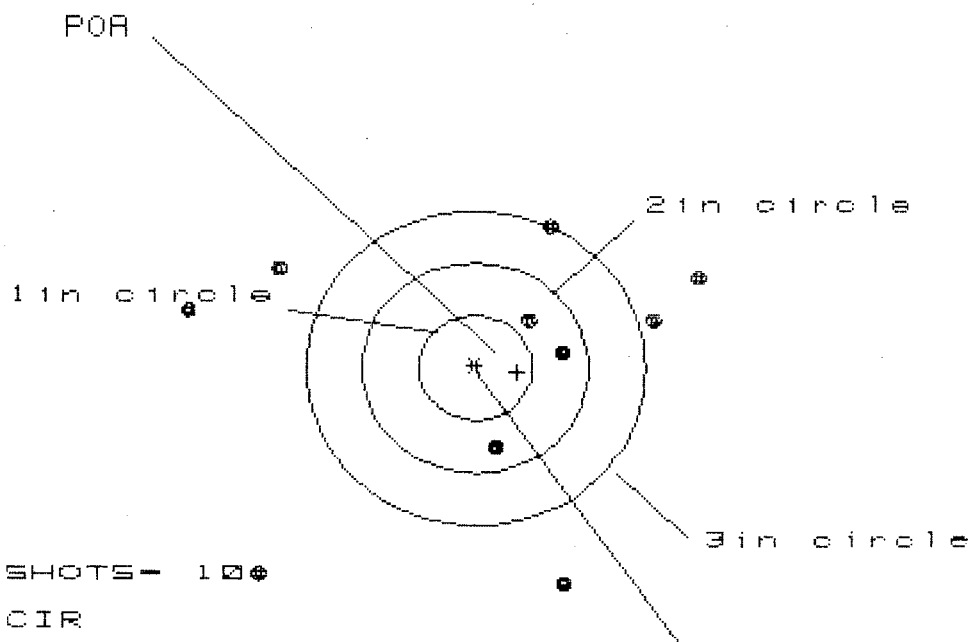
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.847	1.837	1.070
MINIMUM X	:	-1.155	-.950	-.720
MAXIMUM Y	:	.517	.485	.456
MINIMUM Y	:	-.340	-.372	-.401
CENTROID X	:	.099	-.106	-.336
CENTROID Y	:	-.209	-.177	-.148
POA TO CENTROID in.	:	.232	.206	.367
MIN RADIUS	:	.101	.110	.306
MEAN RADIUS	:	.871	.698	.532
MAX RADIUS	:	1.870	1.852	1.111
HORIZONTAL SPREAD	:	3.002	2.787	1.790
VERTICAL SPREAD	:	.857	.857	.857
EXTREME SPREAD	:	3.002	2.790	1.923
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in - 0

2in - 3

3in - 3

HS - 4.503

VS - 3.492

GS - 4.780

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.946	1.730	1.383
MINIMUM X	:	-2.557	-2.773	-2.333
MAXIMUM Y	:	1.399	1.185	1.224
MINIMUM Y	:	-2.093	-2.307	-2.268
CENTROID X	:	-.369	-.153	.193
CENTROID Y	:	.048	.262	.223
POA TO CENTROID in.	:	.372	.303	.295
MIN RADIUS	:	.611	.306	.247
MEAN RADIUS	:	1.701	1.507	1.254
MAX RADIUS	:	2.739	2.791	2.466
HORIZONTAL SPREAD	:	4.503	4.503	3.717
VERTICAL SPREAD	:	3.492	3.492	3.492
EXTREME SPREAD	:	4.780	4.514	3.995
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		3	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.338

VS= 3.203

GS= 4.004

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.398	1.498	1.322
MINIMUM X	:	-1.940	-1.840	-2.017
MAXIMUM Y	:	1.860	1.175	1.033
MINIMUM Y	:	-1.343	-1.136	-.993
CENTROID X	:	.037	-.063	.113
CENTROID Y	:	-.017	-.224	-.082
POA TO CENTROID in.	:	.041	.232	.140
MIN RADIUS	:	.298	.401	.214
MEAN RADIUS	:	1.225	1.133	1.003
MAX RADIUS	:	2.064	1.906	2.047
HORIZONTAL SPREAD	:	3.338	3.338	3.338
VERTICAL SPREAD	:	3.203	2.311	2.026
EXTREME SPREAD	:	4.004	3.599	3.599
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	