

C6522211

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.



Clifford

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522211

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 8 2      | 90      | RW   |
| 600       | Proof                                                    | 8 2      | 90      | RW   |
| 607       | Check Headspace                                          | 8 2      |         | RW   |
| 610       | Dis-assemble Gun                                         |          |         | RW   |
| 612       | Magnaflux Barrel Action                                  |          | 8/7/90  | KR   |
|           | Magnaflux Bolt                                           |          | 8/7/90  | KR   |
| 615       | Rollmark Caliber                                         |          | 8/7/90  | SS   |
| 617       | Drill and Tap Sight Holes                                |          | 8/10/90 | LB   |
| 618       | Polish Barrel LB                                         |          | 8/14/90 | LB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 8-22-90 | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 8/24/90 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 8/24/90 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 8/24/90 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 8/24/90 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 8/28/90 | JA   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        | 4     | 4     |      |      | 8/28/90 | RW   |
|              | G) Safety Off Force                                         | 7 1/4    | 7 1/4 | 7 1/4 |      |      | 8/28/90 | RW   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/28/90 | RL   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 8/28/90 | RW   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 8/29/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 9/6/90  | JD   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/29/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/29/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/29/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/29/90 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/29/90 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 9/4/90  | AF   |
|              | A) Time                                                     |          |       |       |      |      | 9/4/90  | AF   |
|              | B) Malfunctions                                             |          |       |       |      |      | 9/4/90  | AF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 9/4/90  | AF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 9/4/90  | AF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 9/4/90  | AF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 9/6/90  | JD   |
|              | B) Trigger Pull                                             | 2.23     | 2.19  | 2.22  | 2.30 | 2.33 | 9-5-90  | RL   |
|              | C) Function                                                 |          |       |       |      |      | 9/6/90  | JD   |
| 660          | Pack                                                        |          |       |       |      |      | 9/20/90 | AF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522211

DATE 8/28/90

TESTER JEL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.45             | 2.31                     | 2.49                           | 2.23  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.49             | 2.33                     | 2.45                           | 2.19  |                                                                        |
| PULL #3 | 2.16             | 2.34                     | 2.50                           | 2.29  |                                                                        |
| PULL #4 | 2.42             | 2.29                     | 2.45                           | 2.30  |                                                                        |
| PULL #5 | 2.34             | 2.40                     | 2.35                           | 2.33  |                                                                        |
| TOTAL   | 11.86            | 11.67                    | 12.24                          | 11.34 |                                                                        |
| AVG.    | 2.372            | 2.334                    | 2.448                          | 2.268 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.12             | 3.30                     |  |          |
| PULL #2 | 3.19             | 3.26                     |  |          |
| PULL #3 | 3.26             | 3.22                     |  |          |
| PULL #4 | 3.27             | 3.22                     |  |          |
| PULL #5 | 3.21             | 3.32                     |  |          |
| TOTAL   | 16.05            | 16.32                    |  |          |
| AVG.    | 3.21             | 3.264                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.38             | 4.21                     |                                | 4.30                                 |
| PULL #2 | 4.40             | 4.25                     |                                | 4.17                                 |
| PULL #3 | 4.49             | 4.22                     |                                | 4.10                                 |
| PULL #4 | 4.12             | 4.24                     |                                | 4.16                                 |
| PULL #5 | 4.21             | 4.17                     |                                | 4.11                                 |
| TOTAL   | 21.60            | 21.09                    |                                | 20.84                                |
| AVG.    | 4.32             | 4.218                    |                                | 4.168                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06522211  
5 Sep 1990

CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .195028 |
| 1 | TO | 2 | .202062 |
| 1 | TO | 3 | .326034 |
| 1 | TO | 4 | .215615 |
| 1 | TO | 5 | .112272 |

9 <----POA

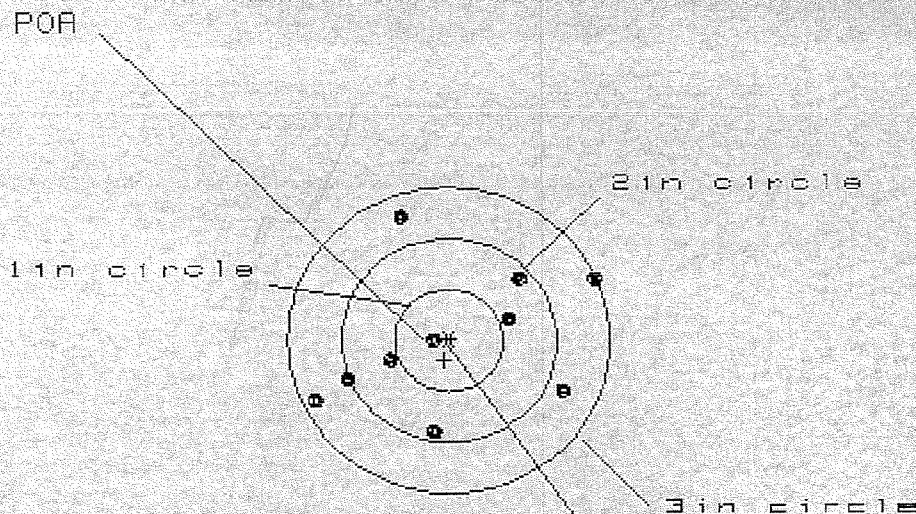
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0882  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1498  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173837  
THE AMR FOR THIS RIFLE IS: .9922



5 Sep 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/C65222(1)

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.631

VS= 2.046

GS= 2.866

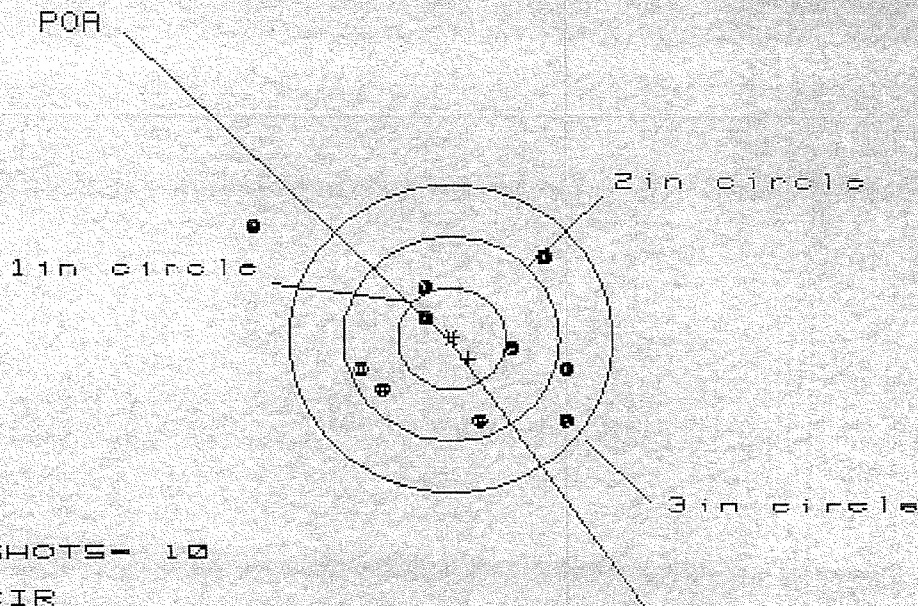
CENTROID #

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.344  | 1.175  | 1.032 |
| MINIMUM X                     | -1.287 | -1.137 | -.923 |
| MAXIMUM Y                     | 1.167  | 1.232  | 1.171 |
| MINIMUM Y                     | -.879  | -.814  | -.875 |
| CENTROID X                    | .044   | -.106  | .037  |
| CENTROID Y                    | .190   | .125   | .186  |
| POA TO CENTROID in.           | .195   | .164   | .190  |
| MIN RADIUS                    | .187   | .068   | .180  |
| MEAN RADIUS                   | .938   | .853   | .813  |
| MAX RADIUS                    | 1.466  | 1.264  | 1.246 |
| HORIZONTAL SPREAD             | 2.631  | 2.312  | 1.955 |
| VERTICAL SPREAD               | 2.046  | 2.046  | 2.046 |
| EXTREME SPREAD                | 2.866  | 2.312  | 2.220 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.835

VS= 1.931

GS= 3.396

CENTROID #

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.028  | .828   | .925  |
| MINIMUM X                   | : | -1.807 | -1.031 | -.928 |
| MAXIMUM Y                   | : | 1.123  | .906   | .829  |
| MINIMUM Y                   | : | -.808  | -.684  | -.761 |
| CENTROID X                  | : | -.158  | .042   | -.061 |
| CENTROID Y                  | : | .195   | .071   | .148  |
| POA TO CENTROID in.         | : | .251   | .082   | .160  |
| MIN RADIUS                  | : | .308   | .366   | .412  |
| MEAN RADIUS                 | : | .961   | .815   | .778  |
| MAX RADIUS                  | : | 2.127  | 1.132  | 1.139 |
| HORIZONTAL SPREAD           | : | 2.835  | 1.859  | 1.853 |
| VERTICAL SPREAD             | : | 1.931  | 1.590  | 1.590 |
| EXTREME SPREAD              | : | 3.396  | 2.002  | 2.002 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |



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# CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS- 10

# IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.751

VS= 2.298

GS= 2.600

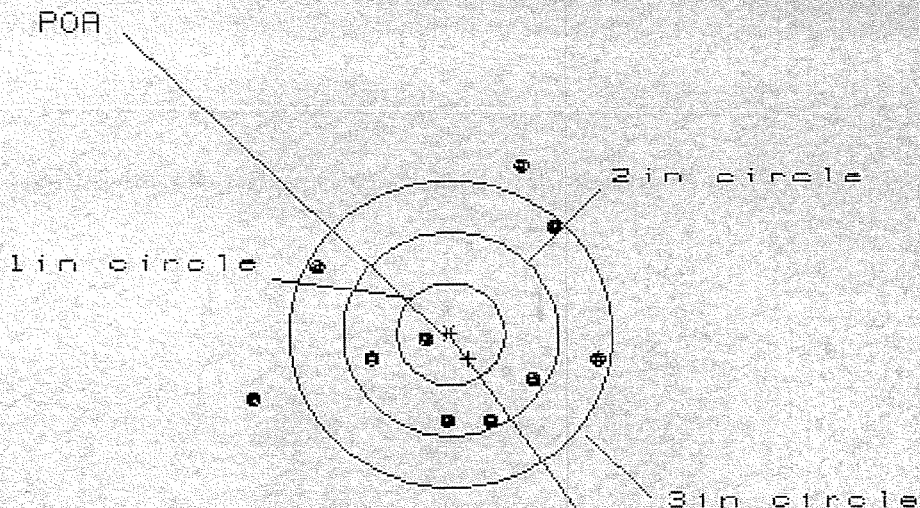
|                               |   |        |       |       |
|-------------------------------|---|--------|-------|-------|
| PATTERN #                     | : | 3      |       |       |
| SHOTS (BEST OF)               | : | 10     | 9     | 8     |
| MAXIMUM X                     | : | .661   | .540  | .541  |
| MINIMUM X                     | : | -1.090 | -.999 | -.998 |
| MAXIMUM Y                     | : | .983   | .836  | .517  |
| MINIMUM Y                     | : | -1.315 | -.708 | -.603 |
| CENTROID X                    | : | -.099  | .022  | .021  |
| CENTROID Y                    | : | -.103  | .044  | -.061 |
| POA TO CENTROID in.           | : | .143   | .049  | .065  |
| MIN RADIUS                    | : | .253   | .120  | .199  |
| MEAN RADIUS                   | : | .701   | .533  | .495  |
| MAX RADIUS                    | : | 1.708  | 1.071 | 1.037 |
| HORIZONTAL SPREAD             | : | 1.751  | 1.539 | 1.539 |
| VERTICAL SPREAD               | : | 2.298  | 1.544 | 1.120 |
| EXTREME SPREAD                | : | 2.600  | 1.582 | 1.572 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9     |       |



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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.220

VS= 2.564

GS= 3.494

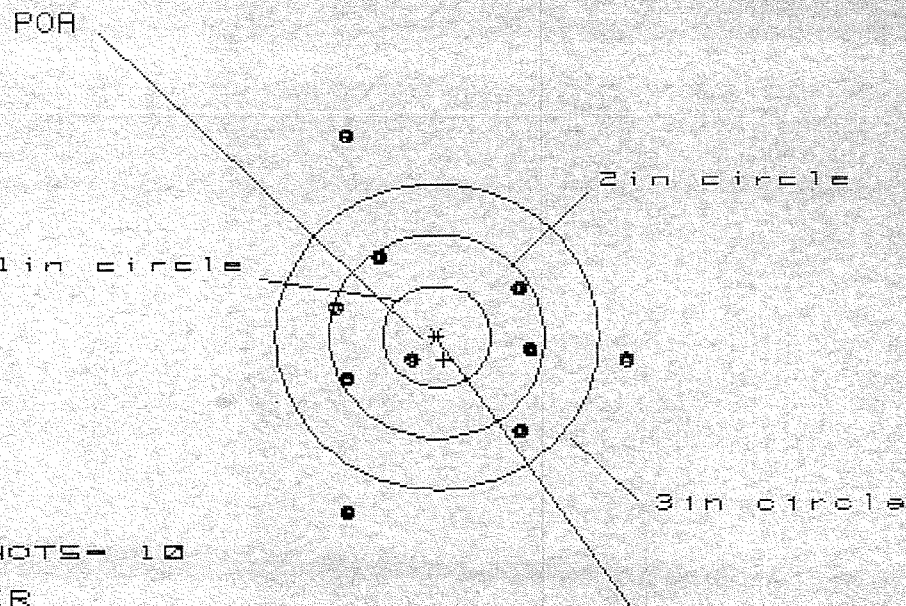
CENTROID \*

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.341  | 1.132  | 1.192  |
| MINIMUM X                   | : | -1.879 | -1.489 | -1.429 |
| MAXIMUM Y                   | : | 1.694  | 1.619  | 1.153  |
| MINIMUM Y                   | : | -.870  | -.945  | -.742  |
| CENTROID X                  | : | -.165  | .044   | -.017  |
| CENTROID Y                  | : | .243   | .318   | .115   |
| POA TO CENTROID in.         | : | .294   | .321   | .117   |
| MIN RADIUS                  | : | .216   | .433   | .383   |
| MEAN RADIUS                 | : | 1.176  | 1.094  | .972   |
| MAX RADIUS                  | : | 1.996  | 1.690  | 1.630  |
| HORIZONTAL SPREAD           | : | 3.220  | 2.621  | 2.621  |
| VERTICAL SPREAD             | : | 2.564  | 2.564  | 1.895  |
| EXTREME SPREAD              | : | 3.494  | 2.783  | 2.783  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 7

HS= 2.718

VS= 3.723

GS= 3.723

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.791  | 1.698  | 1.586  |
| MINIMUM X                   | : | -.927  | -1.020 | -1.132 |
| MAXIMUM Y                   | : | 1.968  | .980   | .788   |
| MINIMUM Y                   | : | -1.755 | -1.536 | -.849  |
| CENTROID X                  | : | -.063  | .030   | .142   |
| CENTROID Y                  | : | .224   | .005   | .197   |
| POA TO CENTROID in.         | : | .232   | .030   | .243   |
| MIN RADIUS                  | : | .306   | .344   | .479   |
| MEAN RADIUS                 | : | 1.185  | 1.074  | .972   |
| MAX RADIUS                  | : | 2.140  | 1.778  | 1.599  |
| HORIZONTAL SPREAD           | : | 2.718  | 2.718  | 2.718  |
| VERTICAL SPREAD             | : | 3.723  | 2.516  | 1.637  |
| EXTREME SPREAD              | : | 3.723  | 3.010  | 2.772  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

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

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

**MODEL 700™ M24**

**SERIAL NO. C6522211**

**ORDER NO. 5716**

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

Ø1



5716 C6522211

UPC



0 47700 25716 7

C6522210

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*