

C6522180

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522180

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8-7-90	KR
	Magnaflux Bolt		8-7-90	KR
615	Rollmark Caliber		8-7-90	GL
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/90	KS
	C) Inspect Ejector Hole for Chamfer		8/23/90	KS
	D) Oil Firing Pin Ass'y		8/23/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/90	WB

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	5	5	5		8/30/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2		8/30/90	WB
	H) Trigger Pull Test & Retainability					8/29/90	WB
	I) Firing Pin Indent	.022 .024	.023 .024	.0225 .024		8/30/90	WB
	J) Assemble Stock					9/4/90	KS
	K) Assemble Swivel Studs					9/8/90	KS
	L) Attach Front and Rear Sight Assemblies					9/4/90	KS
	M) Iron Sight Alignment					9/4/90	KS
	N) Detach Front & Rear Sights & place in numbered container					9/4/90	KS
	O) Attach Scope to Rifle					9/4/90	KS
	P) Detach & Attach Scope 20 Times					9/4/90	KS
640	Gallery Target & Test					9/6/90	AF
	A) Time					9/6/90	AF
	B) Malfunctions					9/6/90	AF
	C) Pierced Primers					9/6/90	AF
	D) Optical Clarity of Scope					9/6/90	AF
645	Inspect for Live Ammo					9/6/90	AF
655	Final Inspection					9/8/90	KS
	A) Headspace						
	B) Trigger Pull	261	289	284	288	284	9/8/90
	C) Function					9/8/90	KS
660	Pack					9-18-90	KS

2.35

2.47

2.50

2.46

2.48

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522180

DATE 8/29/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.36	2.16	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.35	2.22	2.89	
PULL #3	2.32	2.33	2.23	2.84	
PULL #4	2.40	2.30	2.18	2.88	
PULL #5	2.40	2.33	2.18	2.84	
TOTAL	11.94	11.67	10.97		
AVG.	2.39	2.33	2.19		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	2.96		
PULL #2	3.13	2.95		
PULL #3	3.13	2.96		
PULL #4	3.04	2.96		
PULL #5	3.02	2.96		
TOTAL	15.38	14.79		
AVG.	3.08	2.96		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.17		4.02
PULL #2	4.19	4.13		4.06
PULL #3	4.17	4.14		4.07
PULL #4	4.21	4.07		4.07
PULL #5	4.22	4.07		4.12
TOTAL	20.98	20.58		20.34
AVG.	4.19	4.116		4.07

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522180
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.28194
1 TO	2	.109458
1 TO	3	.230083
1 TO	4	.171234
1 TO	5	.263894

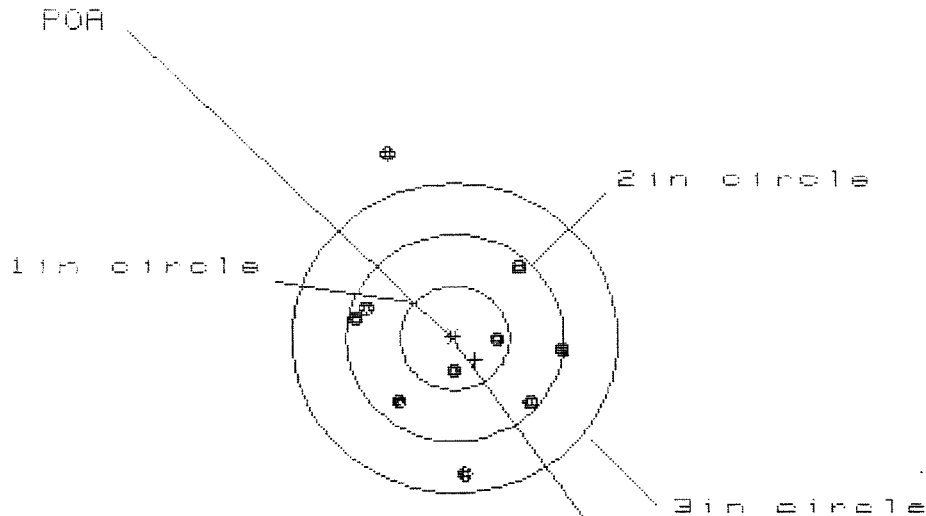
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0974
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140025
THE AMR FOR THIS RIFLE IS: 1.019

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B0

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.963

VS = 3.061

GS = 3.142

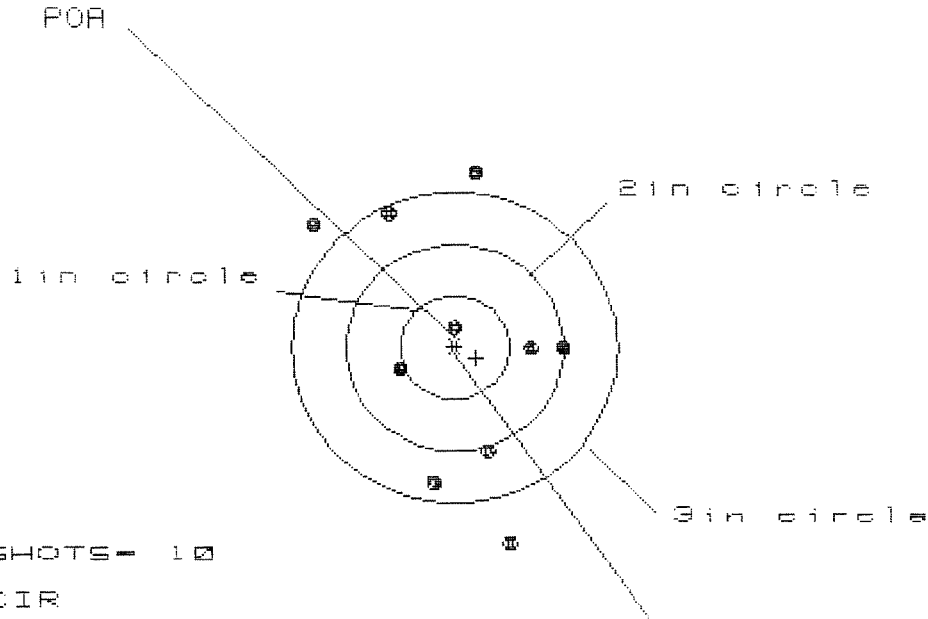
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	.947	.954
MINIMUM X	:	-.952	-1.016	-1.009
MAXIMUM Y	:	1.781	.907	.771
MINIMUM Y	:	-1.280	-1.082	-.567
CENTROID X	:	-.187	-.123	-.130
CENTROID Y	:	.211	.013	.149
POA TO CENTROID in.	:	.282	.123	.198
MIN RADIUS	:	.277	.110	.225
MEAN RADIUS	:	.933	.791	.758
MAX RADIUS	:	1.874	1.085	1.038
HORIZONTAL SPREAD	:	1.963	1.963	1.963
VERTICAL SPREAD	:	3.061	1.989	1.338
EXTREME SPREAD	:	3.142	2.053	1.989
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522160

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.275

VS= 3.615

GS= 3.623

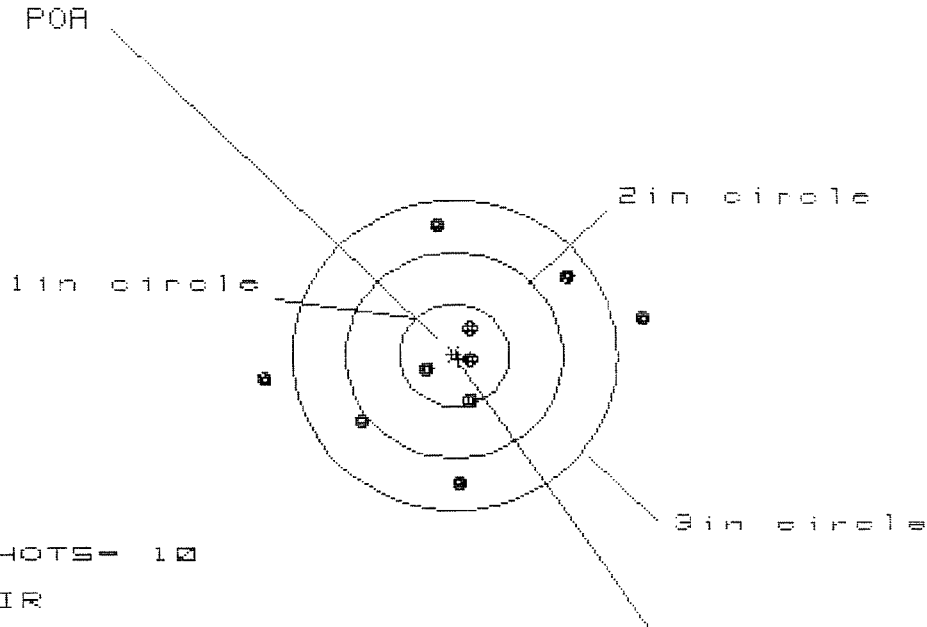
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.984	1.038	.883
MINIMUM X	:	-1.291	-1.237	-.733
MAXIMUM Y	:	1.744	1.537	1.664
MINIMUM Y	:	-1.871	-1.526	-1.399
CENTROID X	:	-.197	-.251	-.096
CENTROID Y	:	.102	.310	.183
POA TO CENTROID in.	:	.222	.399	.206
MIN RADIUS	:	.149	.067	.142
MEAN RADIUS	:	1.171	1.084	.995
MAX RADIUS	:	1.932	1.605	1.670
HORIZONTAL SPREAD	:	2.275	2.275	1.616
VERTICAL SPREAD	:	3.615	3.063	3.063
EXTREME SPREAD	:	3.623	3.095	3.095
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B0

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 4

2in = 4

3in = 8

HS = 3.457

VS = 2.459

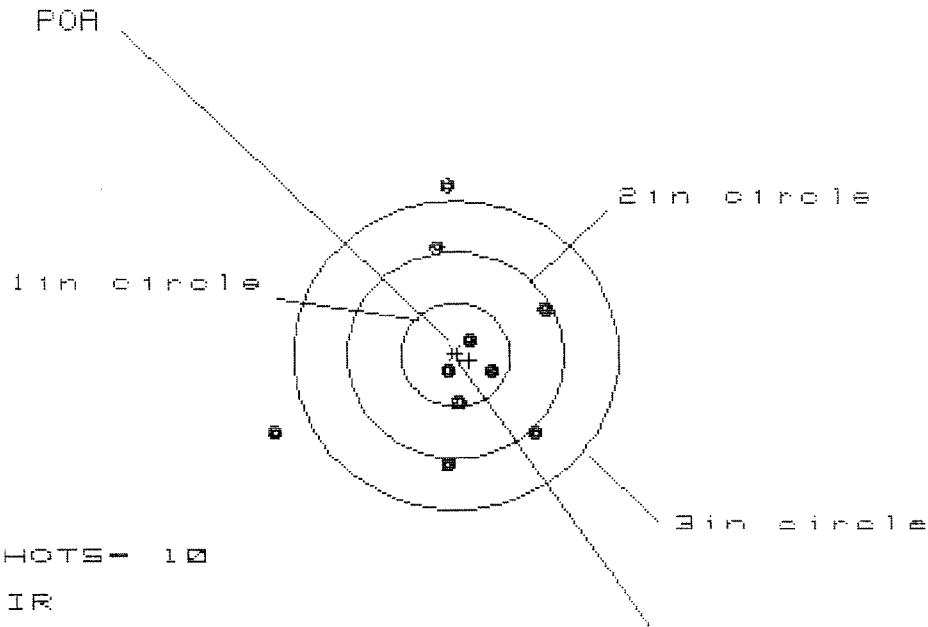
GS = 3.498

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.709	1.514	1.040
MINIMUM X	-1.748	-1.093	-.903
MAXIMUM Y	1.244	1.221	1.259
MINIMUM Y	-1.216	-1.238	-1.200
CENTROID X	-.040	.155	-.035
CENTROID Y	.034	.057	.019
POA TO CENTROID in.	.053	.165	.040
MIN RADIUS	.135	.112	.124
MEAN RADIUS	.955	.868	.754
MAX RADIUS	1.760	1.545	1.323
HORIZONTAL SPREAD	3.457	2.607	1.943
VERTICAL SPREAD	2.459	2.459	2.459
EXTREME SPREAD	3.498	2.768	2.467
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522180

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 2.522

VS= 2.624

GS= 2.788

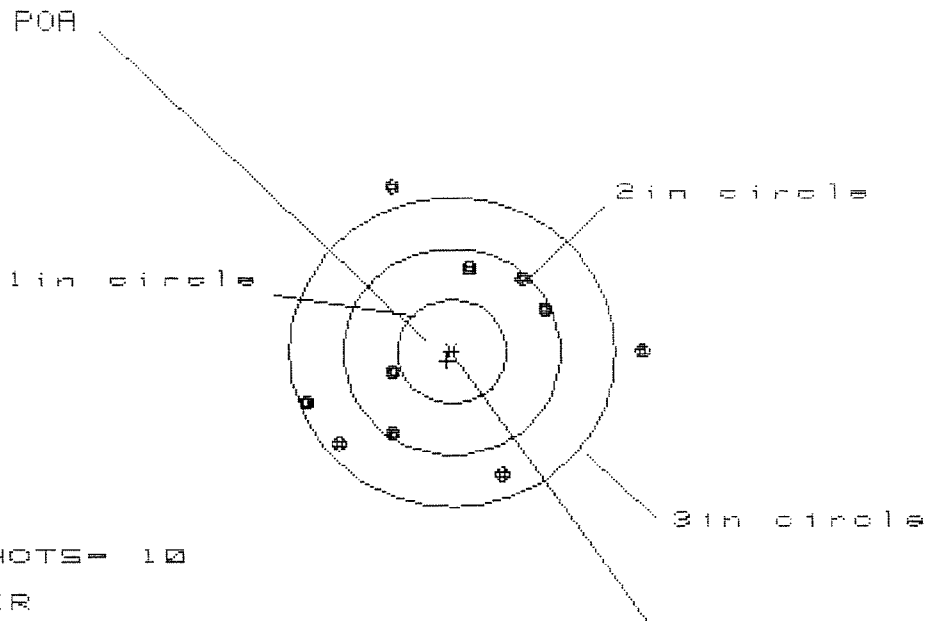
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.685	.654
MINIMUM X	-1.654	-.339	-.370
MAXIMUM Y	1.599	1.521	1.146
MINIMUM Y	-1.025	-1.103	-.912
CENTROID X	-.126	.057	.088
CENTROID Y	.051	.129	-.061
POA TO CENTROID in.	.136	.141	.107
MIN RADIUS	.195	.096	.071
MEAN RADIUS	.871	.751	.620
MAX RADIUS	1.796	1.541	1.205
HORIZONTAL SPREAD	2.522	1.024	1.024
VERTICAL SPREAD	2.624	2.624	2.059
EXTREME SPREAD	2.788	2.624	2.060
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522180

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.057

VS= 2.766

GS= 3.095

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.707	1.014	.975
MINIMUM X	:	-1.350	-1.160	-1.199
MAXIMUM Y	:	1.574	1.576	1.012
MINIMUM Y	:	-1.192	-1.190	-.993
CENTROID X	:	.047	-.143	-.104
CENTROID Y	:	.089	.087	-.110
POA TO CENTROID in.	:	.101	.167	.152
MIN RADIUS	:	.587	.415	.395
MEAN RADIUS	:	1.164	1.086	1.001
MAX RADIUS	:	1.707	1.606	1.227
HORIZONTAL SPREAD	:	3.057	2.174	2.174
VERTICAL SPREAD	:	2.766	2.766	2.005
EXTREME SPREAD	:	3.095	2.940	2.352
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522180
17 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.128004
1 TO	2	.212758
1 TO	3	.0680074
1 TO	4	.32131
1 TO	5	.148809

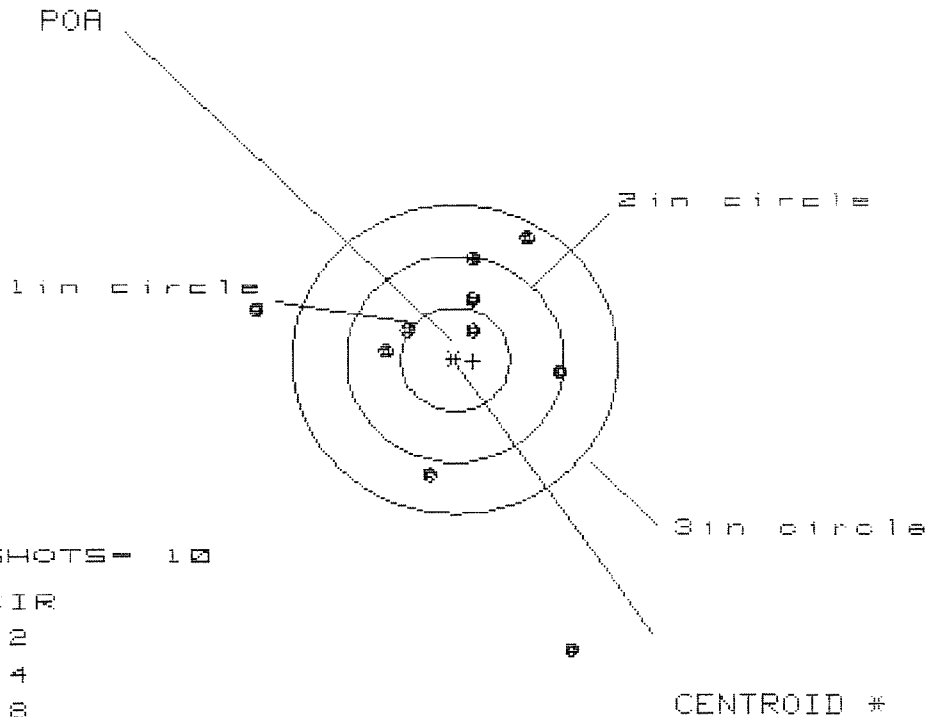
✱ (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0138
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0275115
THE AMR FOR THIS RIFLE IS: .9736

17 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522180.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.863

VS= 4.054

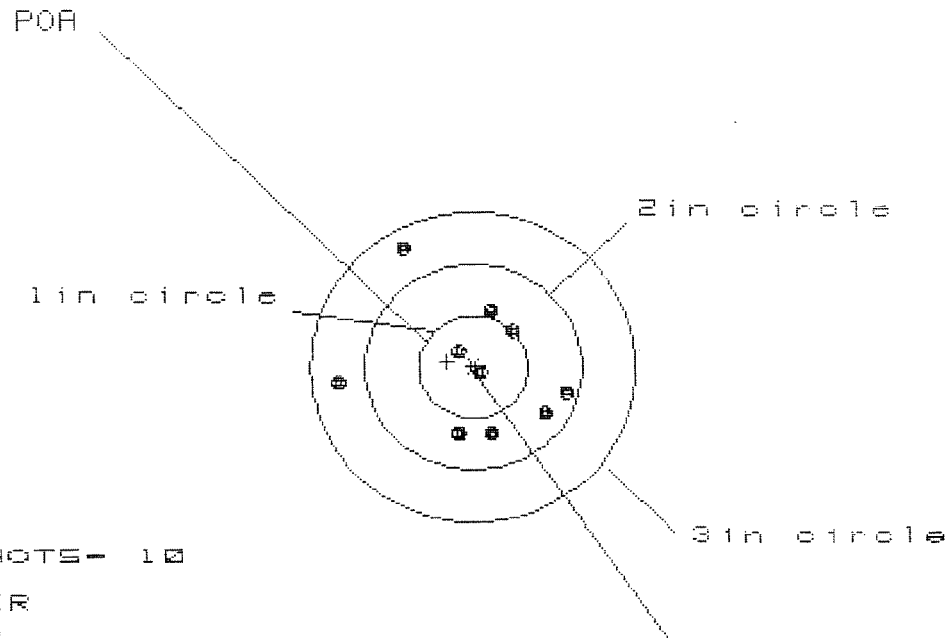
GS= 4.400

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	1.119	.902
MINIMUM X	:	-1.848	-1.735	-.739
MAXIMUM Y	:	1.218	.903	.926
MINIMUM Y	:	-2.836	-1.412	-1.389
CENTROID X	:	-.164	-.277	-.060
CENTROID Y	:	.017	.332	.309
POA TO CENTROID in.	:	.165	.433	.314
MIN RADIUS	:	.362	.280	.070
MEAN RADIUS	:	1.157	.869	.731
MAX RADIUS	:	3.012	1.745	1.439
HORIZONTAL SPREAD	:	2.863	2.854	1.641
VERTICAL SPREAD	:	4.054	2.315	2.315
EXTREME SPREAD	:	4.400	2.912	2.496
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522180.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.123

VS= 1.756

GS= 2.130

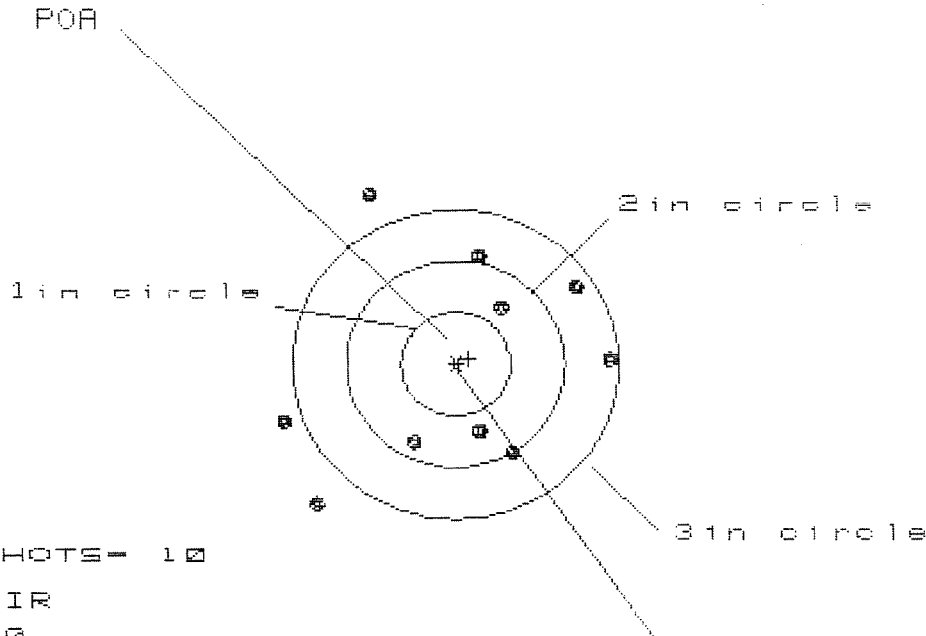
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.859	.787	.620
MINIMUM X	:	-1.264	-1.336	-.390
MAXIMUM Y	:	1.127	.685	.685
MINIMUM Y	:	-.629	-.503	-.503
CENTROID X	:	.242	.314	.481
CENTROID Y	:	-.057	-.182	-.182
POA TO CENTROID in.	:	.249	.363	.514
MIN RADIUS	:	.059	.087	.217
MEAN RADIUS	:	.686	.611	.520
MAX RADIUS	:	1.300	1.336	.694
HORIZONTAL SPREAD	:	2.123	2.123	1.010
VERTICAL SPREAD	:	1.756	1.188	1.188
EXTREME SPREAD	:	2.130	2.130	1.189
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/CS522180.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.959

VS= 2.984

GS= 3.114

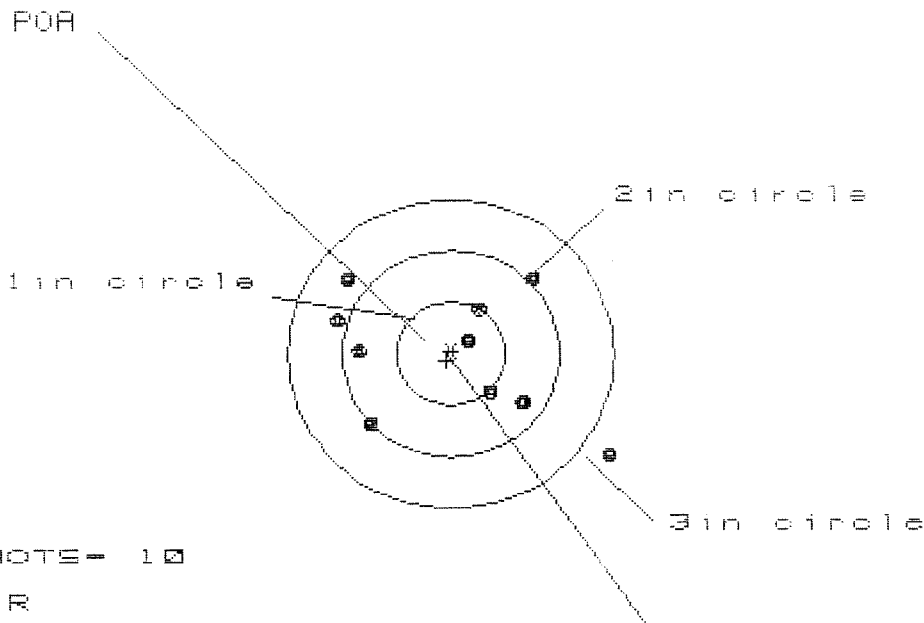
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.424	1.335	1.168
MINIMUM X	-1.535	-1.624	-1.791
MAXIMUM Y	1.673	1.255	1.114
MINIMUM Y	-1.311	-1.125	-0.773
CENTROID X	-0.116	-0.027	0.140
CENTROID Y	-0.048	-0.234	-0.093
POA TO CENTROID in.	0.125	0.235	0.168
MIN RADIUS	0.640	0.482	0.572
MEAN RADIUS	1.226	1.125	1.027
MAX RADIUS	1.854	1.747	1.862
HORIZONTAL SPREAD	2.959	2.959	2.959
VERTICAL SPREAD	2.984	2.380	1.887
EXTREME SPREAD	3.114	3.114	3.028
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65221B0.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.564

VS= 1.642

GS= 2.887

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	.909	.818
MINIMUM X	:	-1.076	-.911	-1.002
MAXIMUM Y	:	.715	.611	.686
MINIMUM Y	:	-.927	-.737	-.662
CENTROID X	:	.045	-.120	-.029
CENTROID Y	:	.072	.175	.100
POA TO CENTROID in.	:	.085	.212	.104
MIN RADIUS	:	.206	.314	.249
MEAN RADIUS	:	.893	.796	.761
MAX RADIUS	:	1.753	1.095	1.068
HORIZONTAL SPREAD	:	2.564	1.820	1.820
VERTICAL SPREAD	:	1.642	1.348	1.348
EXTREME SPREAD	:	2.887	2.004	2.004
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522180.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.833

VS= 2.859

GS= 2.988

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.849	.857	.735
MINIMUM X	:	-.984	-.976	-.589
MAXIMUM Y	:	1.739	1.273	1.164
MINIMUM Y	:	-1.120	-.927	-1.036
CENTROID X	:	-.076	-.085	.037
CENTROID Y	:	-.103	-.296	-.187
POA TO CENTROID in.	:	.128	.308	.191
MIN RADIUS	:	.300	.327	.412
MEAN RADIUS	:	.906	.785	.724
MAX RADIUS	:	1.741	1.451	1.298
HORIZONTAL SPREAD	:	1.833	1.833	1.324
VERTICAL SPREAD	:	2.859	2.200	2.200
EXTREME SPREAD	:	2.988	2.720	2.349
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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.

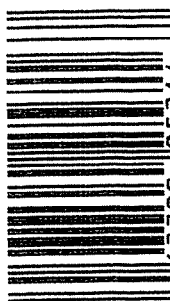
SERIAL NO.	C6522180
ORDER NO.	5716

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5716 C6522180

UPC



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