

C6587561

MODEL 700™ M24

Model **SMS**™

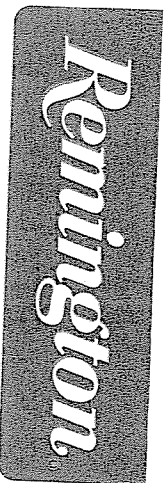
Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



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

**Remington®**

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

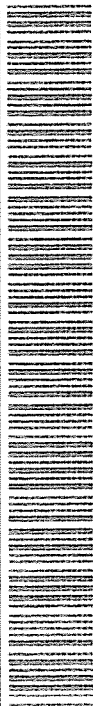
**DU PONT**

MODEL 700™ H24

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

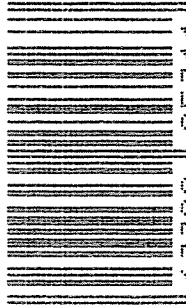
SERIAL NO.  
C6587561

ORDER NO.  
5716



5716 C6587561

LIPC



0 47700 25716 2

M-24

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C 6587561

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 10/24/90 | Kel  |
| 600          | Proof                                                          |          | 10/24/90 | Kel  |
| 607          | Check Headspace                                                |          | 10/24/90 | Kel  |
| 610          | Dis-assemble Gun                                               |          | 10/24/90 | Kel  |
| 612          | Magnaflux Barrel<br>Action                                     |          | 10/30/90 | KR   |
|              | Magnaflux Bolt                                                 |          | 10/30/90 | KR   |
| 615          | Rollmark Caliber                                               |          | 10/30/90 | DS   |
| 617          | Drill and Tap Sight Holes                                      |          | 11/6/90  | FB   |
| 618          | Polish Barrel AB                                               |          | 11/7/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 11/26/90 | JS   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 12/28/90 | K.S. |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 12/28/90 | K.S. |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 12/28/90 | K.S. |
|              | D) Oil Firing Pin Ass'y                                        |          | 12/28/90 | K.S. |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 1/4/91   | JS   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4.0      | 4.0  | 3.75 |      |      | 1/12/91 | KT   |
|              | G) Safety Off Force                                         | 2.5      | 2.5  | 2.5  |      |      |         |      |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 1/4/91  | JH   |
|              | I) Firing Pin Indent                                        | .020     | .020 | .021 |      |      | 1/2/91  | KT   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 1/15/91 | KA   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 1-17-91 | JH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 1/15/91 | KA   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 1/15/91 | KA   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 1/15/91 | JH   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 1/15/91 | KA   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 1/15/91 | KA   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 1/16/91 | KT   |
|              | A) Time                                                     |          |      |      |      |      | "       | KT   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | KT   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | KT   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | KT   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 1/16/91 | KA   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 1-17-91 | JH   |
|              | B) Trigger Pull                                             | 2.30     | 2.23 | 2.28 | 2.31 | 2.25 | 1-17-91 | JH   |
|              | C) Function                                                 |          |      |      |      |      | 1-17-91 | JH   |
| 660          | Pack                                                        |          |      |      |      |      | 3-19-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6587561

DATE 1/4/91

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.41             | 2.38                     | 2.44                           | 2.30 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.36             | 2.33                     | 2.40                           | 2.23 |                                                                        |
| PULL #3 | 2.37             | 2.48                     | 2.48                           | 2.28 |                                                                        |
| PULL #4 | 2.42             | 2.44                     | 2.40                           | 2.31 |                                                                        |
| PULL #5 | 2.41             | 2.29                     | 2.38                           | 2.25 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.47             | 3.19                     |  |          |
| PULL #2 | 3.32             | 3.34                     |  |          |
| PULL #3 | 3.27             | 3.35                     |  |          |
| PULL #4 | 3.31             | 3.28                     |  |          |
| PULL #5 | 3.34             | 3.22                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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 | 4.42             | 4.39                     |                                | 4.39                                 |
| PULL #2 | 4.37             | 4.40                     |                                | 4.40                                 |
| PULL #3 | 4.39             | 4.46                     |                                | 4.22                                 |
| PULL #4 | 4.43             | 4.31                     |                                | 4.36                                 |
| PULL #5 | 4.37             | 4.37                     |                                | 4.41                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6587561  
17 Jan 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .203494 |
| 1 TO | 2 | .216945 |
| 1 TO | 3 | .196987 |
| 1 TO | 4 | .262774 |
| 1 TO | 5 | .289664 |

5 <----POA

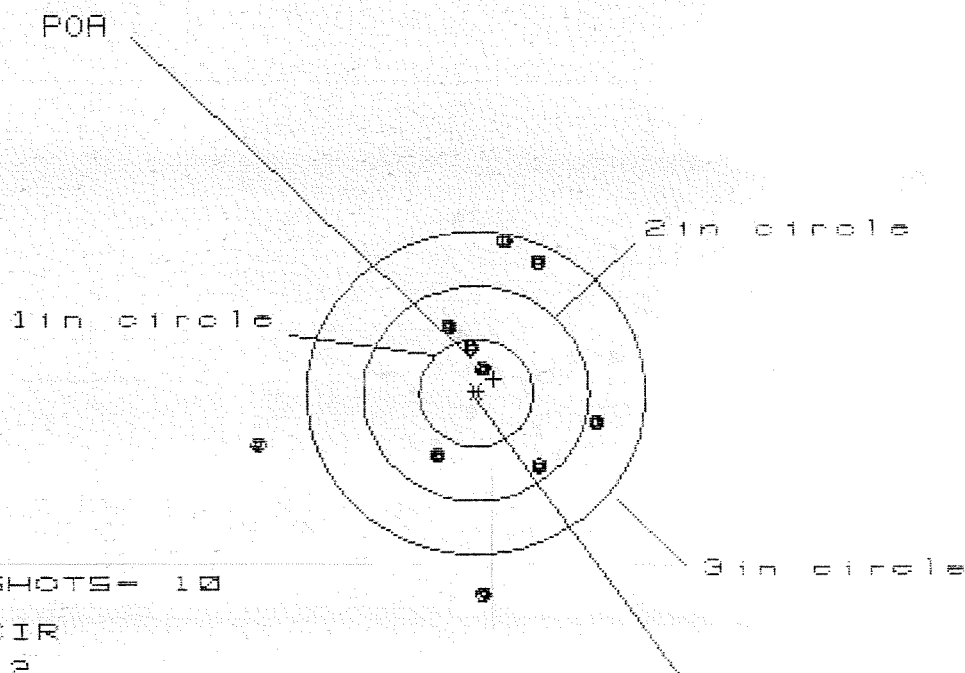
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.038  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0024  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0380757  
THE AMR FOR THIS RIFLE IS: .9076

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6587561

# CENTERFIRE PATTERNS

# 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.083

VS= 3.206

GS= 3.209

CENTROID #

| PATTERN #                   | : | 1      | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.093  | .872   | .853  |
| MINIMUM X                   | : | -1.990 | -.595  | -.614 |
| MAXIMUM Y                   | : | 1.382  | 1.334  | 1.100 |
| MINIMUM Y                   | : | -1.824 | -1.872 | -.966 |
| CENTROID X                  | : | -.159  | .062   | .081  |
| CENTROID Y                  | : | -.127  | -.079  | .155  |
| POA TO CENTROID in.         | : | .204   | .100   | .175  |
| MIN RADIUS                  | : | .189   | .219   | .215  |
| MEAN RADIUS                 | : | 1.059  | .935   | .782  |
| MAX RADIUS                  | : | 2.036  | 1.878  | 1.100 |
| HORIZONTAL SPREAD           | : | 3.083  | 1.467  | 1.467 |
| VERTICAL SPREAD             | : | 3.206  | 3.206  | 2.066 |
| EXTREME SPREAD              | : | 3.209  | 3.209  | 2.090 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

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# CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 4

2in = 8

3in = 10

CENTROID #

HS = 1.743

VS = 2.146

GS = 2.306

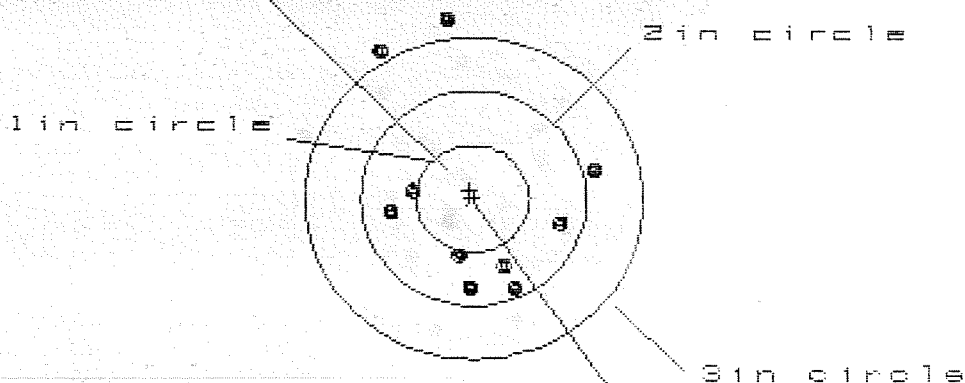
| PATTERN #                     | 1     | 2     | 3     |
|-------------------------------|-------|-------|-------|
| SHOTS (BEST OF)               | 10    | 9     | 8     |
| MAXIMUM X                     | 1.032 | .997  | .705  |
| MINIMUM X                     | -.711 | -.746 | -.621 |
| MAXIMUM Y                     | 1.387 | .444  | .480  |
| MINIMUM Y                     | -.759 | -.605 | -.569 |
| CENTROID X                    | .037  | .072  | -.053 |
| CENTROID Y                    | -.034 | -.188 | -.224 |
| POA TO CENTROID in.           | .050  | .201  | .230  |
| MIN RADIUS                    | .213  | .189  | .242  |
| MEAN RADIUS                   | .699  | .609  | .539  |
| MAX RADIUS                    | 1.422 | 1.038 | .843  |
| HORIZONTAL SPREAD             | 1.743 | 1.743 | 1.326 |
| VERTICAL SPREAD               | 2.146 | 1.049 | 1.049 |
| EXTREME SPREAD                | 2.306 | 1.800 | 1.464 |
| NUMBER IN ONE INCH CIRCLE =   |       | 4     |       |
| NUMBER IN TWO INCH CIRCLE =   |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |       | 10    |       |

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# CENTERFIRE PATTERNS # 3

POA



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 1.853

VS = 2.500

GS = 2.579

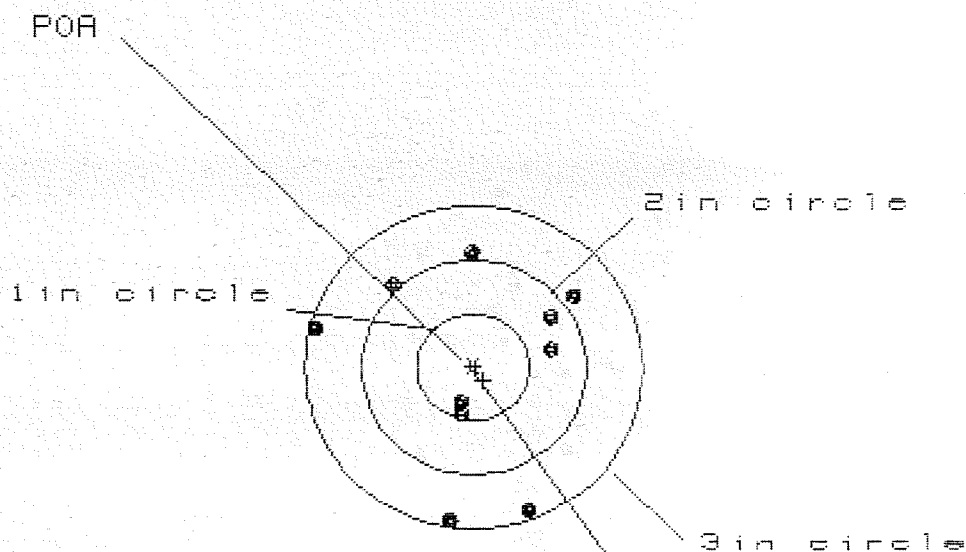
CENTROID #

| PATTERN #                   | : | 3     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | 1.071 | 1.040 | .938  |
| MINIMUM X                   | : | -.782 | -.813 | -.842 |
| MAXIMUM Y                   | : | 1.638 | 1.526 | .620  |
| MINIMUM Y                   | : | -.862 | -.680 | -.489 |
| CENTROID X                  | : | .031  | .062  | .164  |
| CENTROID Y                  | : | -.075 | -.257 | -.448 |
| POA TO CENTROID in.         | : | .081  | .264  | .477  |
| MIN RADIUS                  | : | .494  | .419  | .293  |
| MEAN RADIUS                 | : | .936  | .803  | .630  |
| MAX RADIUS                  | : | 1.662 | 1.729 | 1.124 |
| HORIZONTAL SPREAD           | : | 1.853 | 1.853 | 1.780 |
| VERTICAL SPREAD             | : | 2.500 | 2.206 | 1.109 |
| EXTREME SPREAD              | : | 2.579 | 2.481 | 1.812 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 8     |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.337

VS= 2.493

GS= 2.574

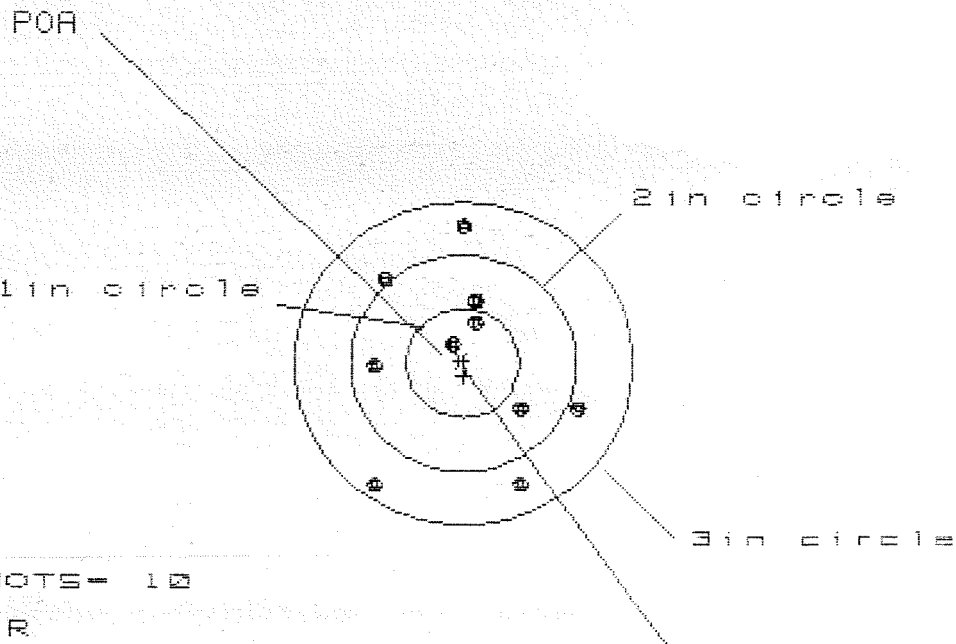
CENTROID #

| PATTERN #                     | 4      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .913   | .755   | .705   |
| MINIMUM X                     | -1.424 | -.907  | -.957  |
| MAXIMUM Y                     | 1.077  | 1.121  | .949   |
| MINIMUM Y                     | -1.415 | -1.372 | -1.456 |
| CENTROID X                    | -.088  | .070   | .120   |
| CENTROID Y                    | .126   | .083   | .255   |
| POA TO CENTROID in.           | .154   | .109   | .281   |
| MIN RADIUS                    | .359   | .417   | .441   |
| MEAN RADIUS                   | .988   | .920   | .841   |
| MAX RADIUS                    | 1.476  | 1.428  | 1.484  |
| HORIZONTAL SPREAD             | 2.337  | 1.662  | 1.662  |
| VERTICAL SPREAD               | 2.493  | 2.493  | 2.405  |
| EXTREME SPREAD                | 2.574  | 2.504  | 2.455  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.789

VS= 2.408

GS= 2.495

CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.024  | .940   | .931   |
| MINIMUM X                   | : | -.765  | -.849  | -.858  |
| MAXIMUM Y                   | : | 1.254  | 1.130  | .774   |
| MINIMUM Y                   | : | -1.154 | -1.278 | -1.137 |
| CENTROID X                  | : | -.011  | .073   | .082   |
| CENTROID Y                  | : | .122   | .246   | .105   |
| POA TO CENTROID in.         | : | .122   | .257   | .133   |
| MIN RADIUS                  | : | .226   | .215   | .298   |
| MEAN RADIUS                 | : | .856   | .773   | .746   |
| MAX RADIUS                  | : | 1.350  | 1.341  | 1.204  |
| HORIZONTAL SPREAD           | : | 1.789  | 1.789  | 1.789  |
| VERTICAL SPREAD             | : | 2.408  | 2.408  | 1.911  |
| EXTREME SPREAD              | : | 2.495  | 2.455  | 2.245  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |