

**C6523463**

MODEL 700<sup>TM</sup> M24

Model **SMS** <sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**<sup>®</sup>

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

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

MODEL 700<sup>TM</sup> M24

SERIAL NO.  
C6523463

ORDER NO.  
5716

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

Q1

  
5716 C6523463

UPC

  
0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523463

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 25     | 90       | RW   |
| 600          | Proof                                                          | 9 25     | 90       | RW   |
| 607          | Check Headspace                                                | 9 2      | 90       | RW   |
| 610          | Dis-assemble Gun                                               | 9 2      | 90       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 9/25/90  | KR   |
|              | Magnaflux Bolt                                                 |          | 9/26/90  | KR   |
| 615          | Rollmark Caliber                                               |          | 9/26/90  | JS   |
| 617          | Drill and Tap Sight Holes                                      |          | 9/26/90  | FB   |
| 618          | Polish Barrel <i>RB</i>                                        |          | 10/1/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-5-90  | TA   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/8/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/8/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/8/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/8/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/11/90 | JP   |

| op. #        | OP. NAME                                                    | READINGS |       |       | DATE     | INIT |          |     |
|--------------|-------------------------------------------------------------|----------|-------|-------|----------|------|----------|-----|
| 625<br>cont. | F) Safety On Force                                          | 4 1/2    | 4 1/2 | 4 1/2 | 10/11/90 | WB   |          |     |
|              | G) Safety Off Force                                         | 7 1/2    | 2 1/2 | 2 1/2 | 10/11/90 | WB   |          |     |
|              | H) Trigger Pull Test & Retainability                        |          |       |       | 10/11/90 | JM   |          |     |
|              | I) Firing Pin Indent                                        | .023     | .0235 | .0235 | 10/11/90 | WB   |          |     |
|              | J) Assemble Stock                                           |          |       |       | 10/11/90 | RW   |          |     |
|              | K) Assemble Swivel Studs                                    |          |       |       | 11-26-90 | 928  |          |     |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 10/11/90 | RW   |          |     |
|              | M) Iron Sight Alignment                                     |          |       |       | 10/11/90 | RW   |          |     |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 10/11/90 | RW   |          |     |
|              | O) Attach Scope to Rifle                                    |          |       |       | 10/15/90 | RW   |          |     |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       | 10/15/90 | RW   |          |     |
| 640          | Gallery Target & Test                                       |          |       |       | 10/16/90 | AF   |          |     |
|              | A) Time                                                     |          |       |       | "        | AF   |          |     |
|              | B) Malfunctions                                             |          |       |       | "        | AF   |          |     |
|              | C) Pierced Primers                                          |          |       |       | "        | AF   |          |     |
|              | D) Optical Clarity of Scope                                 |          |       |       | "        | AF   |          |     |
| 645          | Inspect for Live Ammo                                       |          |       |       | 10/16/90 | AF   |          |     |
| 655          | Final Inspection                                            |          |       |       | 11-20-90 | 928  |          |     |
|              | A) Headspace                                                |          |       |       |          |      |          |     |
|              | B) Trigger Pull                                             | 259      | 263   | 258   | 258      | 265  | 11-20-90 | 928 |
|              | C) Function                                                 |          |       |       |          |      | 11-26-90 | 928 |
| 660          | Pack                                                        |          |       |       | 12/15/90 | AF   |          |     |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523463

DATE 10/11/90

TESTER JEL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.43             | 2.26                     | 2.35                           | 2.59 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.43             | 2.32                     | 2.26                           | 2.63 |                                                                        |
| PULL #3 | 2.33             | 2.32                     | 2.30                           | 2.58 |                                                                        |
| PULL #4 | 2.11             | 2.28                     | 2.29                           | 2.58 |                                                                        |
| PULL #5 | 2.29             | 2.44                     | 2.38                           | 2.65 |                                                                        |
| TOTAL   | 11.59            | 11.62                    | 11.58                          |      |                                                                        |
| AVG.    | 2.318            | 2.324                    | 2.316                          |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.33             | 3.45                     |  |          |
| PULL #2 | 3.31             | 3.48                     |  |          |
| PULL #3 | 3.32             | 3.17                     |  |          |
| PULL #4 | 3.41             | 3.53                     |  |          |
| PULL #5 | 3.45             | 3.51                     |  |          |
| TOTAL   | 16.82            | 17.14                    |  |          |
| AVG.    | 3.364            | 3.428                    |  |          |

|         | 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 | 4.32             | 4.17                     |                                | 4.37                                 |
| PULL #2 | 4.40             | 4.19                     |                                | 4.43                                 |
| PULL #3 | 4.46             | 4.25                     |                                | 4.42                                 |
| PULL #4 | 4.26             | 4.26                     |                                | 4.52                                 |
| PULL #5 | 4.04             | 4.27                     |                                | 4.41                                 |
| TOTAL   | 21.48            | 21.14                    |                                | 22.15                                |
| AVG.    | 4.296            | 4.228                    |                                | 4.43                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523463  
17 Oct 1990

CENTROIDAL DISTANCES

0 TO 1 .22853  
1 TO 2 .252676  
1 TO 3 .161645  
1 TO 4 .1936  
1 TO 5 .50431

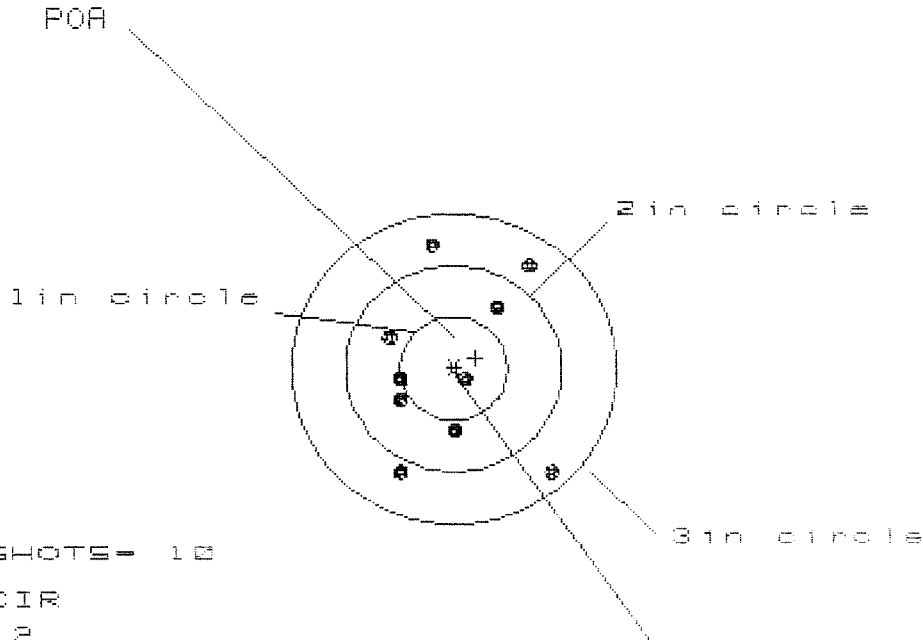
24<sup>3</sup>  
at <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1648  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0412  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159872  
THE AMR FOR THIS RIFLE IS: .7704

17 Oct 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523463

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.477

VS= 2.257

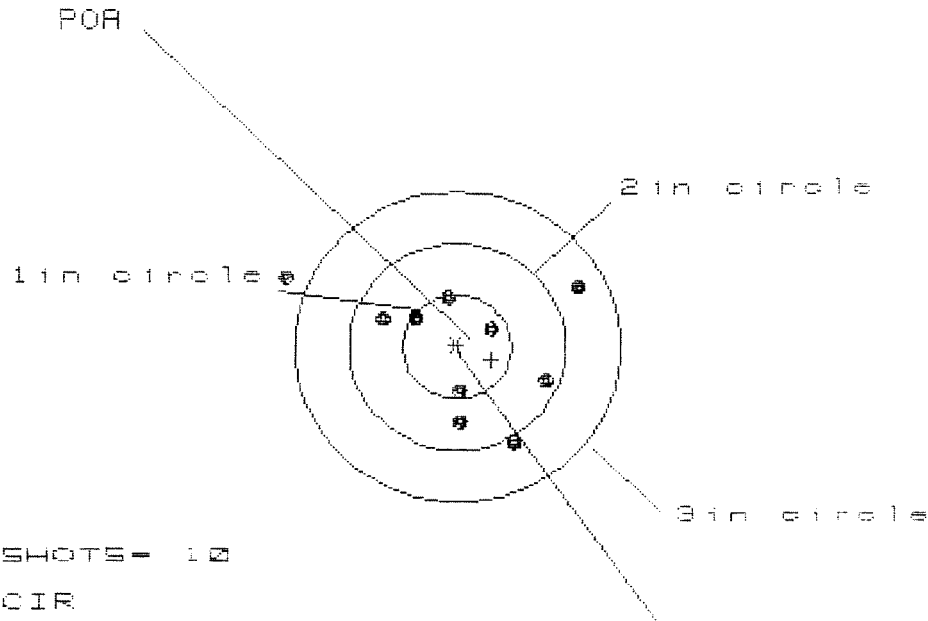
GS= 2.490

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .917   | .833   | .821  |
| MINIMUM X                     | -.560  | -.458  | -.470 |
| MAXIMUM Y                     | 1.240  | 1.131  | 1.048 |
| MINIMUM Y                     | -1.017 | -1.126 | -.985 |
| CENTROID X                    | -.205  | -.307  | -.295 |
| CENTROID Y                    | -.101  | .008   | -.133 |
| POA TO CENTROID in.           | .229   | .307   | .323  |
| MIN RADIUS                    | .127   | .277   | .190  |
| MEAN RADIUS                   | .808   | .745   | .670  |
| MAX RADIUS                    | 1.346  | 1.231  | 1.331 |
| HORIZONTAL SPREAD             | 1.477  | 1.291  | 1.291 |
| VERTICAL SPREAD               | 2.257  | 2.257  | 2.033 |
| EXTREME SPREAD                | 2.490  | 2.351  | 2.351 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.700

VS = 1.542

GS = 2.700

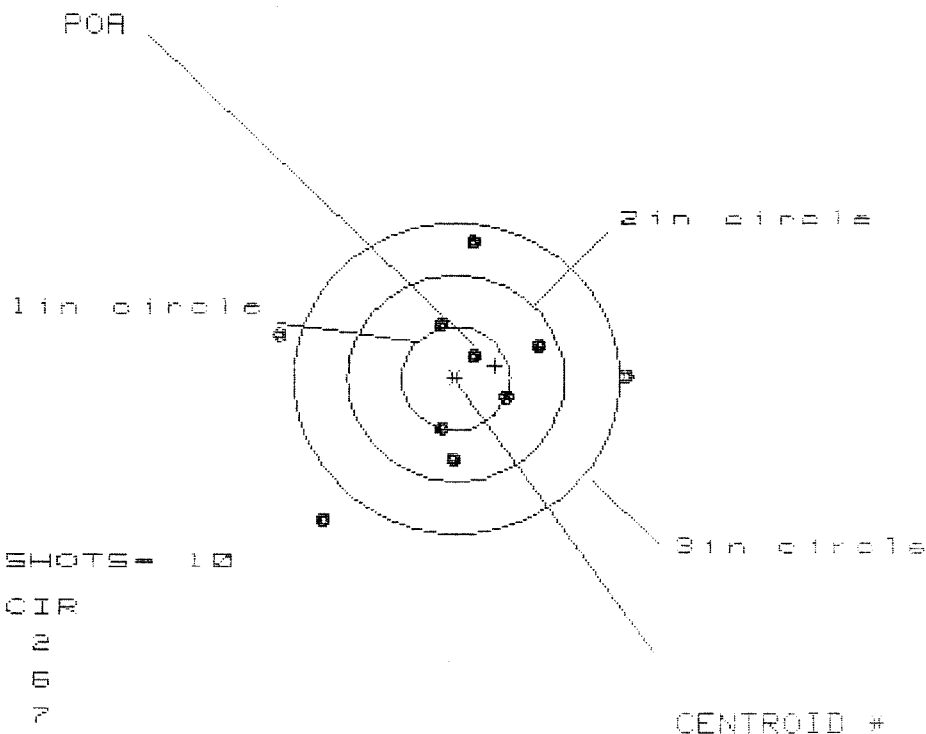
CENTROID \*

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.106  | .928  | .750  |
| MINIMUM X                   | : | -1.602 | -.843 | -.728 |
| MAXIMUM Y                   | : | .635   | .634  | .630  |
| MINIMUM Y                   | : | -.907  | -.836 | -.757 |
| CENTROID X                  | : | -.318  | -.140 | -.256 |
| CENTROID Y                  | : | .125   | .054  | -.025 |
| POR TO CENTROID in.         | : | .341   | .150  | .257  |
| MIN RADIUS                  | : | .347   | .246  | .234  |
| MEAN RADIUS                 | : | .806   | .690  | .625  |
| MAX RADIUS                  | : | 1.724  | 1.123 | .889  |
| HORIZONTAL SPREAD           | : | 2.708  | 1.771 | 1.478 |
| VERTICAL SPREAD             | : | 1.542  | 1.470 | 1.387 |
| EXTREME SPREAD              | : | 2.709  | 1.794 | 1.681 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.139

VS= 2.685

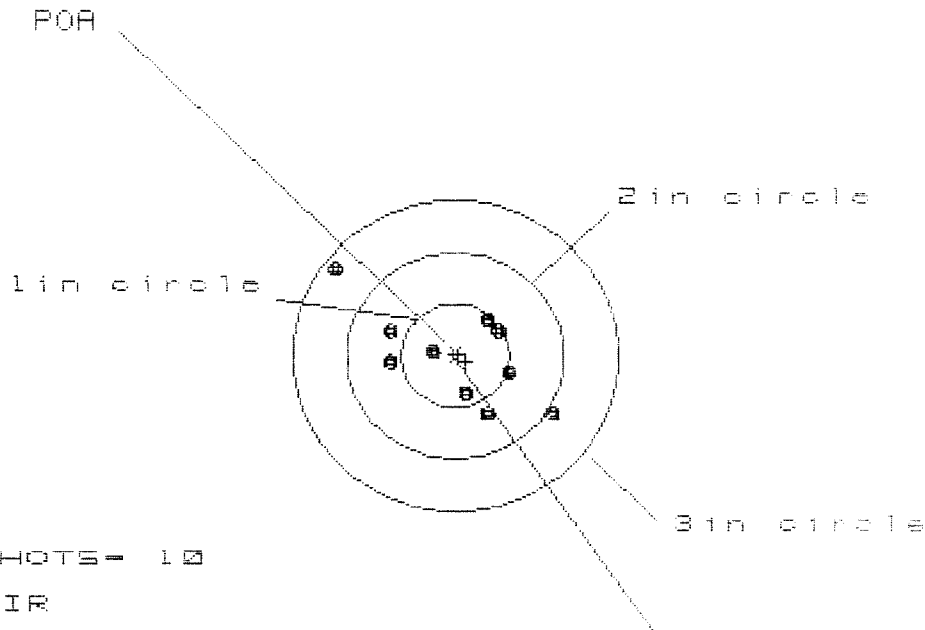
GS= 3.163

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 3      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.554  | 1.420  | 1.205  |
| MINIMUM X                   | : | -1.585 | -1.719 | -1.507 |
| MAXIMUM Y                   | : | 1.324  | 1.172  | 1.204  |
| MINIMUM Y                   | : | -1.361 | -1.902 | -1.870 |
| CENTROID X                  | : | -.365  | -.231  | -.016  |
| CENTROID Y                  | : | -.124  | .028   | -.004  |
| POA TO CENTROID in.         | : | .385   | .233   | .017   |
| MIN RADIUS                  | : | .290   | .091   | .214   |
| MEAN RADIUS                 | : | .972   | .844   | .724   |
| MAX RADIUS                  | : | 1.816  | 1.737  | 1.213  |
| HORIZONTAL SPREAD           | : | 3.139  | 3.139  | 1.712  |
| VERTICAL SPREAD             | : | 2.685  | 2.074  | 2.074  |
| EXTREME SPREAD              | : | 3.163  | 3.163  | 2.087  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS - 10

# IN CIR

1 in = 4

2 in = 8

3 in = 10

HO = 2.041

VO = 1.373

GO = 2.460

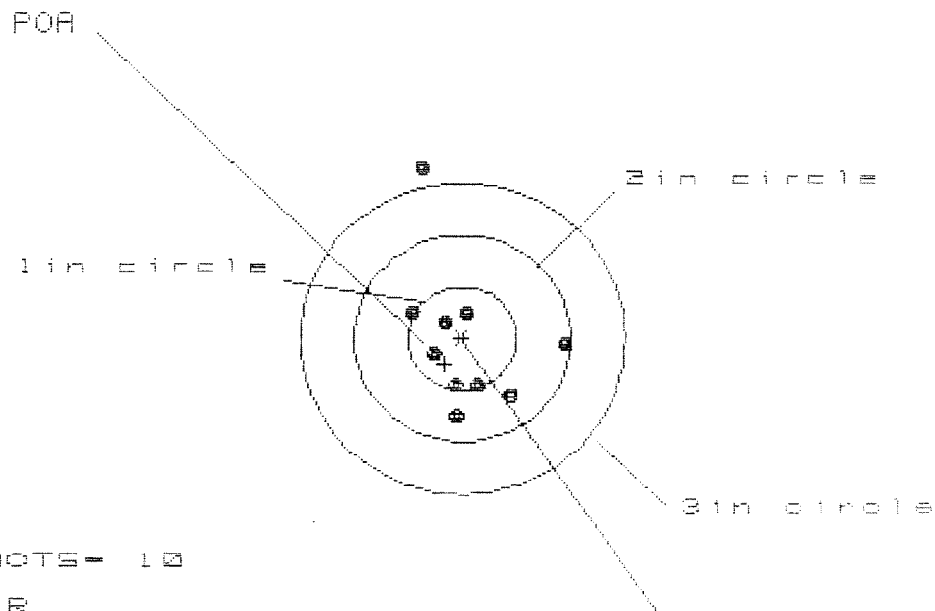
CENTROID \*

| PATTERN #                   | : | 4      | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .926   | .802  | .473  |
| MINIMUM X                   | : | -1.115 | -.722 | -.622 |
| MAXIMUM Y                   | : | .839   | .426  | .370  |
| MINIMUM Y                   | : | -.534  | -.441 | -.489 |
| CENTROID X                  | : | -.096  | .028  | -.072 |
| CENTROID Y                  | : | .059   | -.035 | .021  |
| POA TO CENTROID in.         | : | .112   | .045  | .075  |
| MIN RADIUS                  | : | .250   | .273  | .280  |
| MEAN RADIUS                 | : | .634   | .532  | .482  |
| MAX RADIUS                  | : | 1.395  | .915  | .659  |
| HORIZONTAL SPREAD           | : | 2.041  | 1.524 | 1.095 |
| VERTICAL SPREAD             | : | 1.373  | .867  | .860  |
| EXTREME SPREAD              | : | 2.460  | 1.688 | 1.153 |
| NUMBER IN ONE INCH CIRCLE   | = | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 10     |       |       |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1 in = 5

2 in = 9

3 in = 9

HS = 1.411

VS = 2.403

GS = 2.421

|                               |   |       |       |       |
|-------------------------------|---|-------|-------|-------|
| PATTERN #                     | : | 5     |       |       |
| SHOTS (BEST OF)               | : | 10    | 9     | 8     |
| MAXIMUM X                     | : | .913  | .877  | .503  |
| MINIMUM X                     | : | -.499 | -.534 | -.425 |
| MAXIMUM Y                     | : | 1.681 | .417  | .440  |
| MINIMUM Y                     | : | -.722 | -.535 | -.512 |
| CENTROID X                    | : | .160  | .195  | .086  |
| CENTROID Y                    | : | .247  | .060  | .037  |
| POA TO CENTROID in.           | : | .294  | .204  | .094  |
| MIN RADIUS                    | : | .267  | .260  | .205  |
| MEAN RADIUS                   | : | .632  | .496  | .416  |
| MAX RADIUS                    | : | 1.712 | .895  | .612  |
| HORIZONTAL SPREAD             | : | 1.411 | 1.411 | .928  |
| VERTICAL SPREAD               | : | 2.403 | .952  | .952  |
| EXTREME SPREAD                | : | 2.421 | 1.430 | 1.208 |
| NUMBER IN ONE INCH CIRCLE =   |   |       | 5     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |   |       | 9     |       |