

C6636107

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700TM M24

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

DU PONT

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

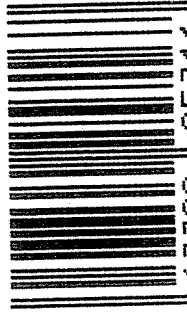
SERIAL NO.
C6636107

ORDER NO.
5716

20

5716 C6636107

UPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636107

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	K.R.
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	J.S.
617	Drill and Tap Sight Holes		APR 19 1991	L.B.
618	Polish Barrel		APR 19 1991	W.B.
620	Apply Coatings (Barrel Action)		5/10/91	J.S.
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/22/91	K.S.
	D) Oil Firing Pin Ass'y		5/22/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	J.S.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/24/91	SL
	G) Safety Off Force	3	3	3			5/24/91	SL
	H) Trigger Pull Test & Retainability						5/24/91	SL
	I) Firing Pin Indent	.0225	.0225	.0225			5/24/91	SL
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	KS
	M) Iron Sight Alignment						5/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	KS
	O) Attach Scope to Rifle						5/25/91	KS
	P) Detach & Attach Scope 20 Times						5/25/91	KS
640	Gallery Target & Test						6/1/91	KP
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/1/91	KT
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	2.40	2.27	2.29	2.29	2.29	6/3/91	SL
	C) Function						6-3-91	D/H
660	Pack						6-19-91	NE

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6636107

DATE 5/24/91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.28	2.27	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.30	2.33	2.27	
PULL #3	2.24	2.30	2.36	2.29	
PULL #4	2.28	2.35	2.44	2.29	
PULL #5	2.27	2.29	2.45	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.50		
PULL #2	3.26	3.33		
PULL #3	3.29	3.37		
PULL #4	3.30	3.30		
PULL #5	3.29	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.25		4.33
PULL #2	4.11	4.23		4.33
PULL #3	4.15	4.29		4.27
PULL #4	4.23	4.27		4.35
PULL #5	4.25	4.14		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636107
1 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.285351
1 TO 2	.494818
1 TO 3	.287253
1 TO 4	.380047
1 TO 5	.618606

3.4

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0376
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0422
THE RESULTING AVERAGE PO RADIUS FOR THIS RIFLE IS: .0565208

THE AMP FOR THIS RIFLE IS: 1.221

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635107

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 4.287

VS= 3.708

GS= 5.598

CENTROID *

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.544	1.136	.954
MINIMUM X	-1.743	-1.460	-1.356
MAXIMUM Y	2.402	1.398	1.282
MINIMUM Y	-1.305	-1.039	-1.155
CENTROID X	.124	-.159	.023
CENTROID Y	.257	-.010	.106
POA TO CENTROID in.	.285	.159	.108
MIN RADIUS	.128	.095	.136
MEAN RADIUS	.1271	.956	.848
MAX RADIUS	3.499	1.731	1.368
HORIZONTAL SPREAD	4.287	2.596	2.310
VERTICAL SPREAD	3.708	2.437	2.437
EXTREME SPREAD	5.598	3.186	2.643
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

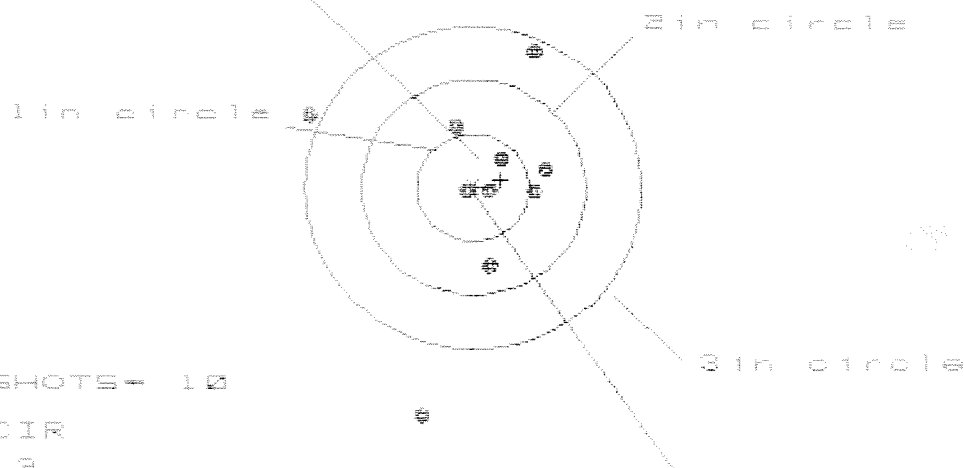
1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636107

CENTERFIRE PATTERNS

2

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.081

VS= 3.439

GS= 3.576

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X	.634	.581	.394
MINIMUM X	-1.447	-1.500	-.352
MAXIMUM Y	1.295	1.057	1.111
MINIMUM Y	-2.144	-.997	-.943
CENTROID X	-.242	-.189	-.002
CENTROID Y	-.076	.162	.108
POA TO CENTROID in.	.254	.249	.108
MIN RADIUS	.107	.201	.105
MEAN RADIUS	.828	.656	.505
MAX RADIUS	2.197	1.562	1.141
HORIZONTAL SPREAD	2.081	2.081	.746
VERTICAL SPREAD	3.439	2.054	2.054
EXTREME SPREAD	3.576	2.145	2.088
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

1 Jun 1991

FILE: PATTERNING/CENTERFIRE_PATT/C66361B7

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.971

VS= 3.221

GS= 3.388

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.567	1.513	.956
MINIMUM X	-1.404	-1.458	-1.269
MAXIMUM Y	1.263	1.046	1.107
MINIMUM Y	-1.958	-1.249	-1.188
CENTROID X	.041	.095	-.094
CENTROID Y	-.018	.199	.138
POA TO CENTROID in.	.045	.221	.167
MIN RADIUS	.257	.254	.061
MEAN RADIUS	1.101	.973	.868
MAX RADIUS	2.017	1.590	1.311
HORIZONTAL SPREAD	2.971	2.971	2.225
VERTICAL SPREAD	3.221	2.295	2.295
EXTREME SPREAD	3.388	3.050	2.528
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	8	8	8

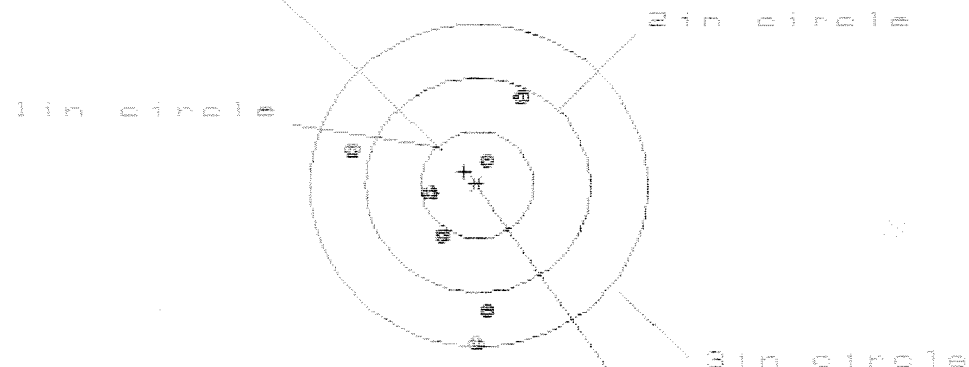
1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B36107

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 4.748

VS= 4.211

GS= 6.312

CENTROID *

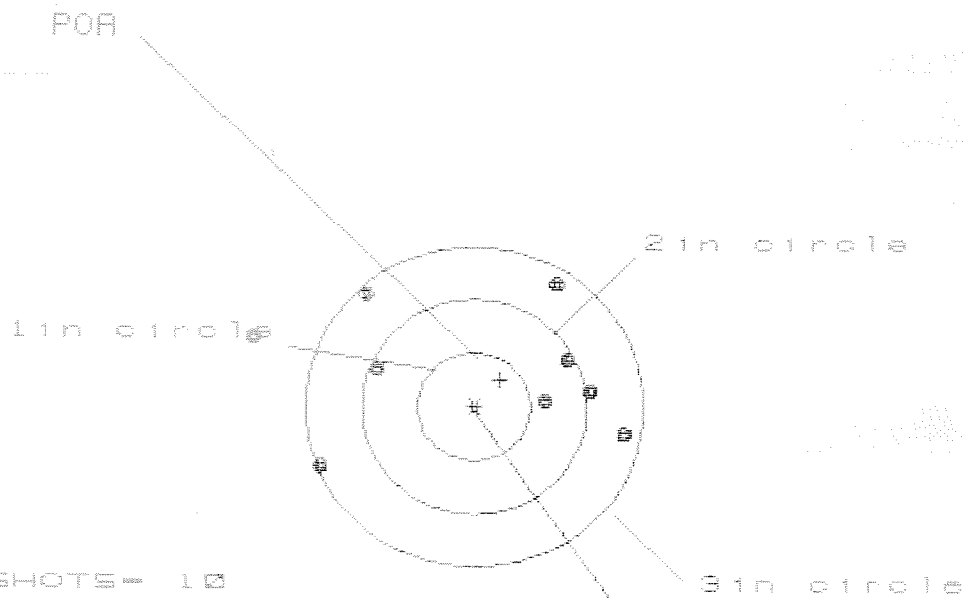
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	3.369	.721	.596
MINIMUM X	-1.379	-1.005	-.885
MAXIMUM Y	1.993	2.209	1.959
MINIMUM Y	-2.218	-2.002	-1.515
CENTROID X	.118	-.256	-.131
CENTROID Y	-.123	-.339	-.089
POA TO CENTROID in.	.171	.425	.158
MIN RADIUS	.258	.183	.182
MEAN RADIUS	1.458	1.128	.976
MAX RADIUS	3.888	2.240	2.001
HORIZONTAL SPREAD	4.748	1.726	1.481
VERTICAL SPREAD	4.211	4.211	3.474
EXTREME SPREAD	6.312	4.272	3.541
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636107

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.322

VS= 4.132

GS= 4.614

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.318	1.401	1.160
MINIMUM X	-2.004	-1.921	-1.572
MAXIMUM Y	1.101	.764	.806
MINIMUM Y	-3.031	-.932	-.890
CENTROID X	-.229	-.312	-.071
CENTROID Y	-.251	.086	.044
POA TO CENTROID in.	.339	.323	.084
MIN RADIUS	.656	.779	.540
MEAN RADIUS	1.449	1.223	1.079
MAX RADIUS	3.122	1.950	1.806
HORIZONTAL SPREAD	3.322	3.322	2.732
VERTICAL SPREAD	4.132	1.696	1.696
EXTREME SPREAD	4.614	3.453	2.751
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636107
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.195256
1 TO	2	.357687
1 TO	3	.437138
1 TO	4	.269358
1 TO	5	.338009

 (----POA

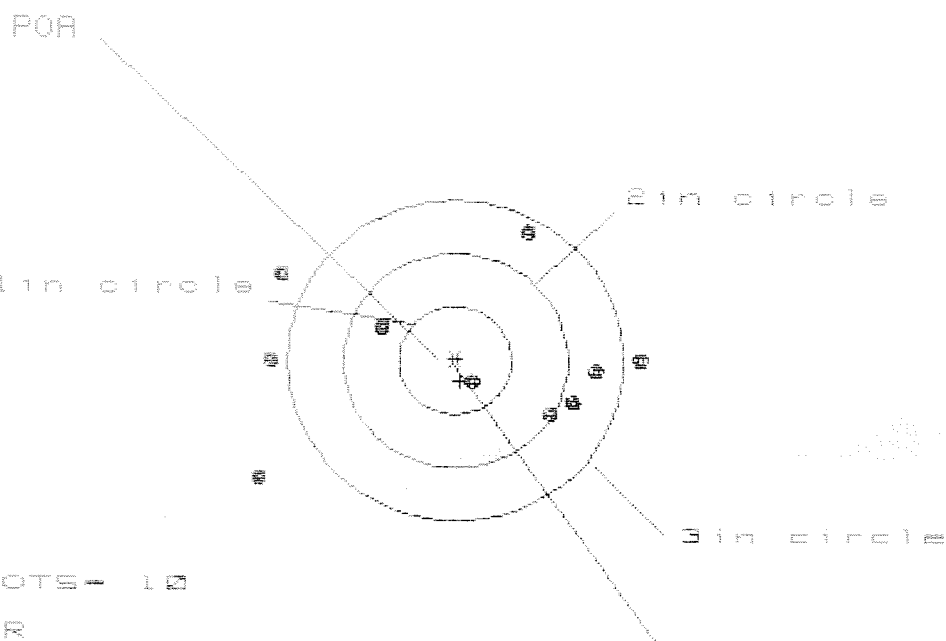
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1136
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114534

THE AMR FOR THIS RIFLE IS: 1.127

17 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636107.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 3.372

VS= 2.324

GS= 3.570

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.622	1.427	1.214
MINIMUM X	-1.750	-1.809	-2.022
MAXIMUM Y	1.200	1.075	1.155
MINIMUM Y	-1.124	-.641	-.561
CENTROID X	-.045	.150	.363
CENTROID Y	.190	.315	.235
POA TO CENTROID in.	.195	.349	.433
MIN RADIUS	.258	.313	.328
MEAN RADIUS	1.264	1.147	1.012
MAX RADIUS	2.080	1.820	2.024
HORIZONTAL SPREAD	3.372	3.236	3.236
VERTICAL SPREAD	2.324	1.716	1.716
EXTREME SPREAD	3.570	3.237	3.237
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =			6

17 Jun 1991

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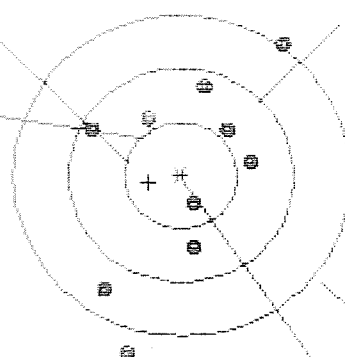
CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 1.761

VS = 2.897

GS = 3.255

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.952	.893	.637
MINIMUM X	-.809	-.868	-.757
MAXIMUM Y	1.264	1.082	.777
MINIMUM Y	-1.633	-1.274	-1.139
CENTROID X	.289	.348	.237
CENTROID Y	.062	.244	.108
POA TO CENTROID in.	.296	.425	.260
MIN RADIUS	.241	.412	.303
MEAN RADIUS	.902	.788	.716
MAX RADIUS	1.718	1.466	1.294
HORIZONTAL SPREAD	1.761	1.761	1.394
VERTICAL SPREAD	2.897	2.356	1.916
EXTREME SPREAD	3.255	2.859	2.089
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

(2 Jun 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C8636107.1

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.684

VS= 3.296

GS= 3.297

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.163	1.228	1.046
MINIMUM X	:	-1.522	-1.456	-1.513
MAXIMUM Y	:	1.291	1.069	1.072
MINIMUM Y	:	-2.005	-1.131	-1.128
CENTROID X	:	.028	-.037	.144
CENTROID Y	:	-.241	-.019	-.022
POA TO CENTROID in.	:	.243	.042	.146
MIN RADIUS	:	.334	.176	.311
MEAN RADIUS	:	1.054	.922	.833
MAX RADIUS	:	2.091	1.456	1.544
HORIZONTAL SPREAD	:	2.684	2.684	2.559
VERTICAL SPREAD	:	3.296	2.200	2.200
EXTREME SPREAD	:	3.297	2.684	2.573
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636107.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.939

VS= 1.981

GS= 3.038

CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.262	1.076	.848
MINIMUM X	:	-1.677	-1.821	-1.467
MAXIMUM Y	:	.679	.675	.721
MINIMUM Y	:	-1.302	-1.306	-1.260
CENTROID X	:	.100	.286	.514
CENTROID Y	:	-.037	-.033	-.079
POA TO CENTROID in.	:	.106	.288	.520
MIN RADIUS	:	.309	.146	.132
MEAN RADIUS	:	1.143	1.051	.916
MAX RADIUS	:	1.677	1.858	1.612
HORIZONTAL SPREAD	:	2.939	2.897	2.315
VERTICAL SPREAD	:	1.981	1.981	1.981
EXTREME SPREAD	:	3.038	3.038	2.593
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636J07.1

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 3.033

VS= 2.011

GS= 3.202

CENTROID: #55555

PATTERN #

0.3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.640	1.497	1.455
MINIMUM X	-1.393	-1.536	-1.349
MAXIMUM Y	1.246	1.364	1.358
MINIMUM Y	-1.765	-1.647	-1.653
CENTROID X	.196	.339	.151
CENTROID Y	-.047	-.165	-.159
POA TO CENTROID in.	.201	.377	.220
MIN RADIUS	.754	.613	.668
MEAN RADIUS	1.274	1.213	1.167
MAX RADIUS	1.670	1.536	1.554
HORIZONTAL SPREAD	3.033	3.033	2.803
VERTICAL SPREAD	2.011	2.011	2.011
EXTREME SPREAD	3.202	3.034	2.861
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		7	