

**C6348783**

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington.*

**Remington**



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

**MODEL 700™ H24**

SERIAL NO.  
C6348783

ORDER NO.  
**5716**

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

01



5716 C6348783

**UPC**



0 47700 25716 7

RC-10  
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348783

| OP. #     | OP. NAME                                                 | READINGS | DATE     | INIT |
|-----------|----------------------------------------------------------|----------|----------|------|
| 575 & 580 | Assemble Action and Stock                                | 10-9     | 89       | RW   |
| 600       | Proof                                                    | 10-9     | 89       | AC   |
| 607       | Check Headspace                                          | 10-9     | 89       | RW   |
| 610       | Dis-assemble Gun                                         |          |          | RW   |
| 612       | NEW Barrel 10/30/89<br>Magnaflux Barrel Action           | REJECT   | 10/13/89 | KCR  |
|           | Magnaflux Bolt                                           |          | 10/13/89 | KCR  |
| 615       | Rollmark Caliber                                         |          |          |      |
| 7         | Drill and Tap Sight Holes                                |          |          |      |
| 618       | Polish Barrel                                            |          |          |      |
| 620       | Apply Coatings (Barrel Action)                           |          |          |      |
|           | Apply Coating (Bolt)                                     |          |          |      |
| 625       | Final Assembly<br>A) Clean inside of Bolt Assembly       |          |          |      |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          |          |      |
|           | C) Inspect Ejector Hole for Chamfer                      |          |          |      |
|           | D) Oil Firing Pin Ass'y                                  |          |          |      |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          |          |      |

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

ATAC

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348783

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 11-2     | 89      | RW   |
| 600          | Proof                                                          | 11-2     | 89      | AE   |
| 607          | Check Headspace                                                | 11-2     | 89      | RW   |
| 610          | Dis-assemble Gun                                               | 11-2     | 89      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | 11-9     | 89      | KCR  |
|              | Magnaflux Bolt                                                 | 11-9     | 89      | KCR  |
| 615          | Rollmark Caliber                                               |          |         |      |
| 617          | Drill and Tap Sight Holes                                      | 11 9     | 89      | YB   |
| 618          | Polish Barrel <i>PB</i>                                        | 11 9     | 89      | BT   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 11-7-89 | TJA  |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 1/4/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 1/4/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 1/4/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 1/4/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 1-5-90  | GH   |

| op. #        | OP. NAME                                                    | READINGS |       |      |      |      | DATE      | INIT |
|--------------|-------------------------------------------------------------|----------|-------|------|------|------|-----------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        | 4     | 4    |      |      | 1-10-90   | gH   |
|              | G) Safety Off Force                                         | 3        | 3     | 3    |      |      | 1-10-90   | gH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |      |      |      | 1/31/90   | JH   |
|              | I) Firing Pin Indent                                        | .020     | .0205 | .020 |      |      | 1-10-90   | gH   |
|              | J) Assemble Stock                                           |          |       |      |      |      | 1/10/90   | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |      |      |      | 3/12/90   | WB   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |      |      |      | 1/10/90   | RW   |
|              | M) Iron Sight Alignment                                     |          |       |      |      |      | 1/10/90   | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |      |      |      | 1/10/90   | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |      |      |      | 3/11/90   | WB   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |      |      |      | 3/11/90   | WB   |
| 640          | Gallery Target & Test                                       |          |       |      |      |      | 3-2-90    | A    |
|              | A) Time                                                     |          |       |      |      |      | 3-2-90    | A    |
|              | B) Malfunctions                                             |          |       |      |      |      | 3-2-90    | A    |
|              | C) Pierced Primers                                          |          |       |      |      |      | 3-2-90    | A    |
|              | D) Optical Clarity of Scope                                 |          |       |      |      |      | 3-2-90    | A    |
| 645          | Inspect for Live Ammo                                       |          |       |      |      |      | 3-2-90    | A    |
| 655          | Final Inspection                                            |          |       |      |      |      | 3/12/90   | WB   |
|              | A) Headspace                                                |          |       |      |      |      |           |      |
|              | B) Trigger Pull                                             | 2.67     | 2.69  | 2.70 | 2.72 | 2.72 | 3/12/90   | GS   |
|              | C) Function                                                 |          |       |      |      |      | 3/12/90   | WB   |
| 660          | Pack                                                        |          |       |      |      |      | 19 MAR 90 | JB   |

SWS TRIGGER PULL TEST

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

SERIAL NO. 06348783

DATE 1-5-90

TESTER JLL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.46             | 2.20                     | 2.40                           | 2.67 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.50             | 2.16                     | 2.31                           | 2.69 |                                                                        |
| PULL #3 | 2.39             | 2.58                     | 2.43                           | 2.70 |                                                                        |
| PULL #4 | 2.40             | 2.39                     | 2.26                           | 2.72 |                                                                        |
| PULL #5 | 2.44             | 2.40                     | 2.20                           | 2.72 |                                                                        |
| TOTAL   | 12.19            | 11.73                    | 11.60                          |      |                                                                        |
| AVG.    | 2.438            | 2.346                    | 2.322                          |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.28             | 3.36                     |  |          |
| PULL #2 | 3.32             | 3.41                     |  |          |
| PULL #3 | 3.48             | 3.26                     |  |          |
| PULL #4 | 3.41             | 3.44                     |  |          |
| PULL #5 | 3.43             | 3.47                     |  |          |
| TOTAL   | 16.92            | 16.94                    |  |          |
| AVG.    | 3.384            | 3.388                    |  |          |

|         | 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 | 4.28             | 4.35                     |                                | 4.60                                 |
| PULL #2 | 3.92             | 4.13                     |                                | 4.03                                 |
| PULL #3 | 4.06             | 4.04                     |                                | 4.18                                 |
| PULL #4 | 4.14             | 4.12                     |                                | 4.27                                 |
| PULL #5 | 4.11             | 4.19                     |                                | 4.39                                 |
| TOTAL   | 20.51            | 20.83                    |                                | 20.84                                |
| AVG.    | 4.102            | 4.166                    |                                | 4.168                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06348783  
3 Mar 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .28181  |
| 1 TO | 2 | .175183 |
| 1 TO | 3 | .407339 |
| 1 TO | 4 | .609139 |
| 1 TO | 5 | .822908 |

129 <----POA  
45

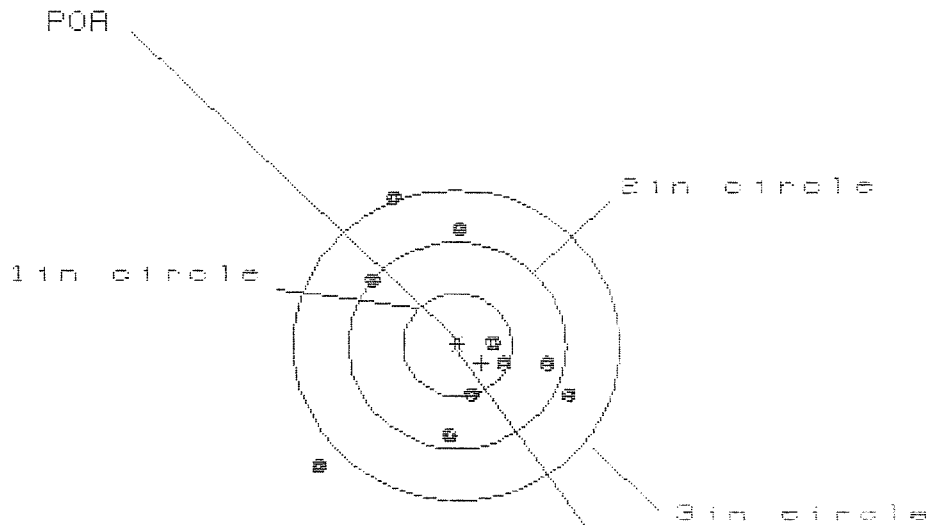
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.016  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1062  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107399  
THE AMR FOR THIS RIFLE IS: .9196



2 Mar 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8348783

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.356

VS= 2.610

GS= 2.702

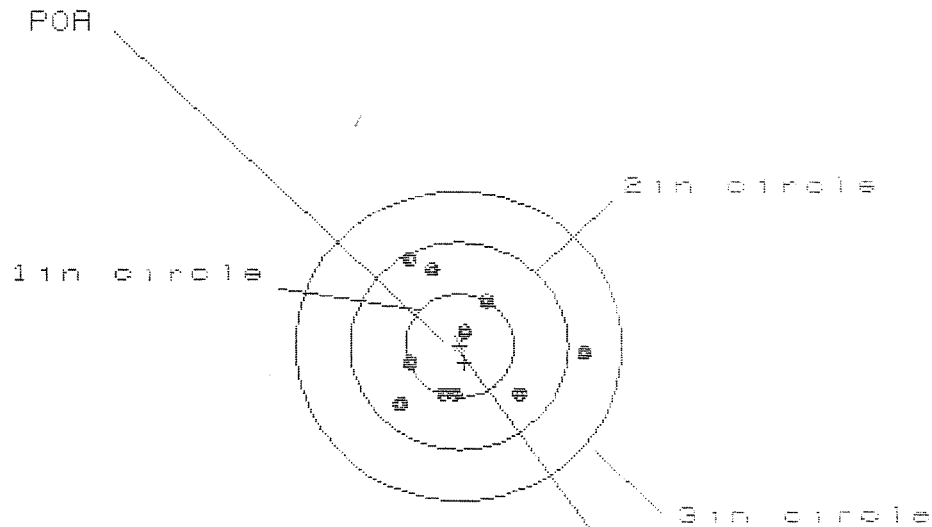
CENTROID #

| PATTERN #                   | : | 1      | 2     | 3      |
|-----------------------------|---|--------|-------|--------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8      |
| MAXIMUM X                   | : | 1.050  | .905  | .811   |
| MINIMUM X                   | : | -1.306 | -.945 | -1.039 |
| MAXIMUM Y                   | : | 1.449  | 1.320 | 1.198  |
| MINIMUM Y                   | : | -1.161 | -.997 | -.832  |
| CENTROID X                  | : | -.224  | -.079 | .015   |
| CENTROID Y                  | : | .171   | .300  | .135   |
| POA TO CENTROID in.         | : | .282   | .310  | .136   |
| MIN RADIUS                  | : | .377   | .239  | .162   |
| MEAN RADIUS                 | : | .965   | .855  | .712   |
| MAX RADIUS                  | : | 1.748  | 1.519 | 1.219  |
| HORIZONTAL SPREAD           | : | 2.356  | 1.850 | 1.850  |
| VERTICAL SPREAD             | : | 2.610  | 2.317 | 2.030  |
| EXTREME SPREAD              | : | 2.702  | 2.539 | 2.129  |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |       |        |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |       |        |
| NUMBER IN THREE INCH CIRCLE | = | 8      |       |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.751

VS= 1.332

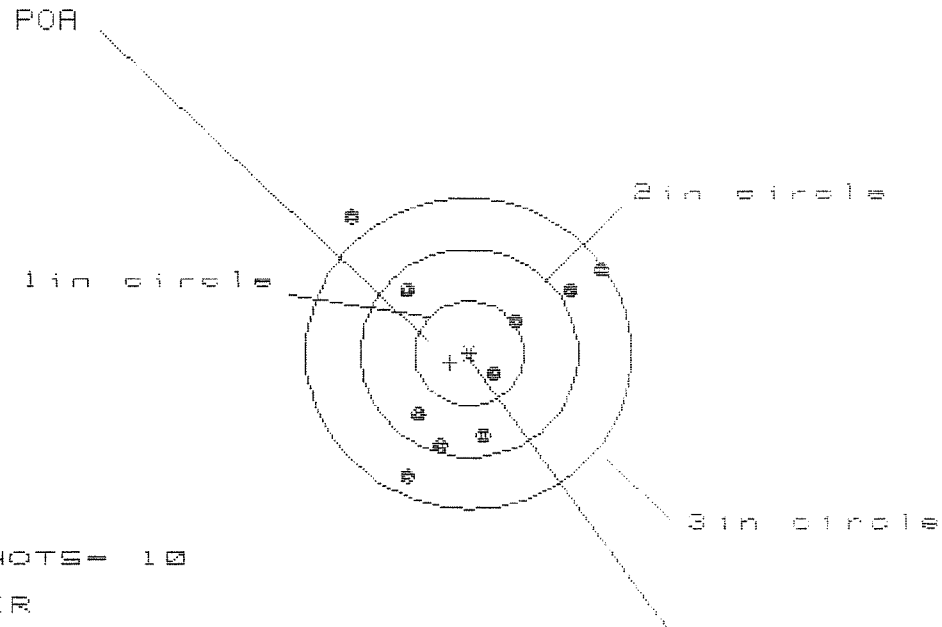
GS= 1.825

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 2     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | 1.161 | .710  | .671  |
| MINIMUM X                   | : | -.591 | -.462 | -.501 |
| MAXIMUM Y                   | : | .795  | .793  | .821  |
| MINIMUM Y                   | : | -.536 | -.539 | -.440 |
| CENTROID X                  | : | -.049 | -.177 | -.138 |
| CENTROID Y                  | : | .163  | .165  | .066  |
| POA TO CENTROID in.         | : | .170  | .242  | .153  |
| MIN RADIUS                  | : | .168  | .218  | .204  |
| MEAN RADIUS                 | : | .649  | .583  | .537  |
| MAX RADIUS                  | : | 1.161 | .872  | .839  |
| HORIZONTAL SPREAD           | : | 1.751 | 1.172 | 1.172 |
| VERTICAL SPREAD             | : | 1.332 | 1.332 | 1.261 |
| EXTREME SPREAD              | : | 1.825 | 1.656 | 1.489 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.336

VS= 2.467

GS= 2.682

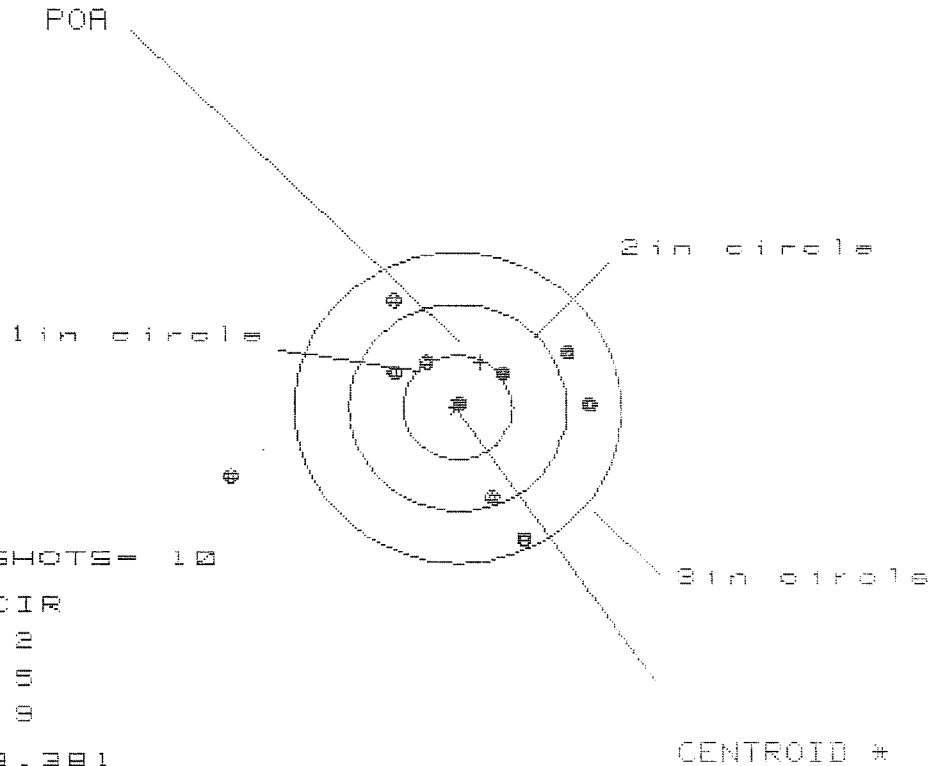
CENTROID #

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.228  | 1.105  | .978  |
| MINIMUM X                   | : | -1.108 | -.738  | -.600 |
| MAXIMUM Y                   | : | 1.281  | .905   | .890  |
| MINIMUM Y                   | : | -1.186 | -1.044 | -.981 |
| CENTROID X                  | : | .175   | .298   | .160  |
| CENTROID Y                  | : | .089   | -.053  | -.166 |
| POA TO CENTROID in.         | : | .196   | .302   | .230  |
| MIN RADIUS                  | : | .297   | .126   | .276  |
| MEAN RADIUS                 | : | .974   | .860   | .778  |
| MAX RADIUS                  | : | 1.693  | 1.428  | 1.323 |
| HORIZONTAL SPREAD           | : | 2.336  | 1.843  | 1.578 |
| VERTICAL SPREAD             | : | 2.467  | 1.949  | 1.821 |
| EXTREME SPREAD              | : | 2.682  | 2.682  | 2.410 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.381

VS= 2.289

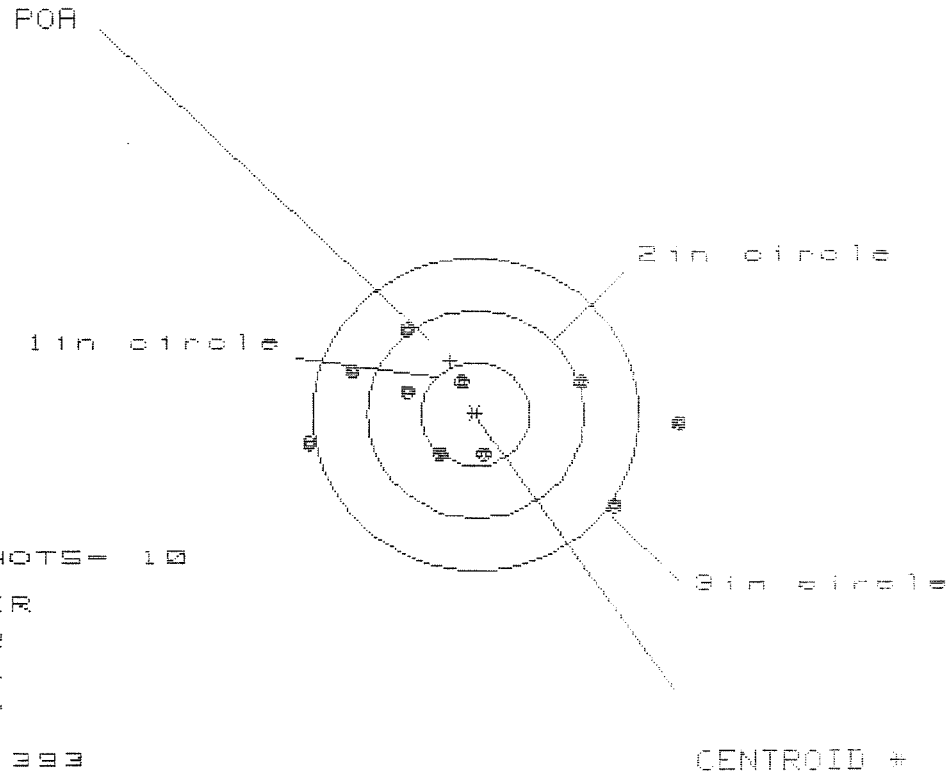
ES= 3.458

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.249  | 1.012  | 1.055  |
| MINIMUM X                   | : | -2.132 | -.866  | -.813  |
| MAXIMUM Y                   | : | 1.008  | .929   | .759   |
| MINIMUM Y                   | : | -1.281 | -1.360 | -1.079 |
| CENTROID X                  | : | -.211  | .026   | -.027  |
| CENTROID Y                  | : | -.438  | -.359  | -.190  |
| POA TO CENTROID in.         | : | .486   | .360   | .191   |
| MIN RADIUS                  | : | .100   | .190   | .194   |
| MEAN RADIUS                 | : | 1.002  | .840   | .740   |
| MAX RADIUS                  | : | 2.247  | 1.424  | 1.112  |
| HORIZONTAL SPREAD           | : | 3.381  | 1.878  | 1.878  |
| VERTICAL SPREAD             | : | 2.289  | 2.289  | 1.838  |
| EXTREME SPREAD              | : | 3.458  | 2.626  | 2.123  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.393

VS = 1.691

GS = 3.397

| PATTERN #                     | 5      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.899  |
| MINIMUM X                     | -1.494 |
| MAXIMUM Y                     | .798   |
| MINIMUM Y                     | -.893  |
| CENTROID X                    | .229   |
| CENTROID Y                    | -.516  |
| POA TO CENTROID in.           | .564   |
| MIN RADIUS                    | .337   |
| MEAN RADIUS                   | 1.008  |
| MAX RADIUS                    | 1.902  |
| HORIZONTAL SPREAD             | 3.393  |
| VERTICAL SPREAD               | 1.691  |
| EXTREME SPREAD                | 3.397  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |
| NUMBER IN TWO INCH CIRCLE =   | 4      |
| NUMBER IN THREE INCH CIRCLE = | 7      |