

C6611439

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

**Remington**<sup>®</sup>

**MODEL 700<sup>TM</sup> N24**

**DU PONT**  
REG. U.S. PAT. & TM. OFF.

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

**SERIAL NO.**  
C6611439

**ORDER NO.**  
5716

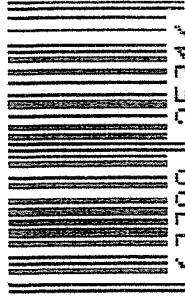
MADE IN ILLON, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611439

UPC



0 47700 25716 7

# INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611439

| OP. #     | OP. NAME                                                 | READINGS | DATE       | INIT |
|-----------|----------------------------------------------------------|----------|------------|------|
| 575 & 580 | Assemble Action and Stock                                | 3 25 91  |            | RW   |
| 600       | Proof                                                    | 3 25 91  |            | RW   |
| 607       | Check Headspace                                          | 3 25 91  |            | RW   |
| 610       | Dis-assemble Gun                                         | 3 25 91  |            | RW   |
| 612       | Magnaflux Barrel Action                                  | 3 28 91  |            | KR   |
|           | Magnaflux Bolt                                           | 3 28 91  |            | "    |
| 615       | Rollmark Caliber                                         | 3 28 91  |            | SS   |
| 617       | Drill and Tap Sight Holes                                |          | APR 3 1991 | LB   |
| 618       | Polish Barrel                                            |          | APR 3 1991 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 4-11-91    | TA   |
|           | Apply Coating (Bolt)                                     |          |            |      |
| 625       | Final Assembly                                           |          |            |      |
|           | A) Clean inside of Bolt Assembly                         |          | 4/16/91    | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 4/16/91    | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 4/16/91    | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 4/16/91    | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 5-14-91    | TA   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |      |      | 5-15-91 | DH   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/2 | 2 1/2 |      |      | 5-15-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 5/14/91 | JH   |
|              | I) Firing Pin Indent                                        | .021     | .021  | .021  |      |      | 5-15-91 | DH   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 5/15/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 5-20-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 5/15/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 5/15/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 5/15/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 5/15/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 5/15/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 5-15-91 | NF   |
|              | A) Time                                                     |          |       |       |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 5-15-91 | NF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 5-20-91 | AC   |
|              | B) Trigger Pull                                             | 2.16     | 2.14  | 2.12  | 2.14 | 2.12 | 5/20/91 | JH   |
|              | C) Function                                                 |          |       |       |      |      | 5-20-91 | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 6-19-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. \_\_\_\_\_

DATE \_\_\_\_\_

TESTER \_\_\_\_\_

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.26             | 2.26                     | 2.18                           | 2.16 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.30             | 2.21                     | 2.22                           | 2.14 |                                                                        |
| PULL #3 | 2.24             | 2.23                     | 2.20                           | 2.12 |                                                                        |
| PULL #4 | 2.14             | 2.15                     | 2.20                           | 2.14 |                                                                        |
| PULL #5 | 2.20             | 2.19                     | 2.19                           | 2.12 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.49             | 3.46                     |  |          |
| PULL #2 | 3.44             | 3.42                     |  |          |
| PULL #3 | 3.36             | 3.42                     |  |          |
| PULL #4 | 3.36             | 3.44                     |  |          |
| PULL #5 | 3.48             | 3.59                     |  |          |
| 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 | 4.39             | 4.40                     |                                | 4.58                                 |
| PULL #2 | 4.41             | 4.40                     |                                | 4.45                                 |
| PULL #3 | 4.41             | 4.56                     |                                | 4.48                                 |
| PULL #4 | 4.41             | 4.60                     |                                | 4.38                                 |
| PULL #5 | 4.49             | 4.50                     |                                | 4.42                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

# INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611439  
24 May 1991

## CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0926607 |
| 1 TO | 2 | .13448   |
| 1 TO | 3 | .202872  |
| 1 TO | 4 | .492311  |
| 1 TO | 5 | .445917  |

$\frac{1}{4 \times 5}$  (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.079  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.227  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240354  
THE AMR FOR THIS RIFLE IS: .8432

24 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611439.1

# CENTERFIRE PATTERNS

# 1

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.026

VS = 1.988

GS = 2.507

PATTERN #

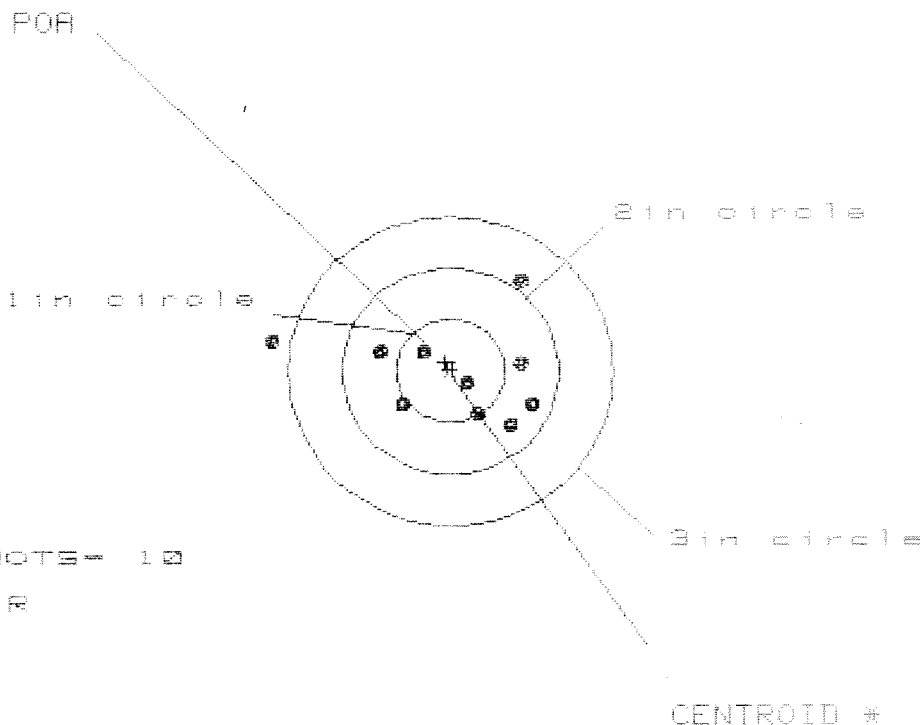
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| SHOTS (BEST OF)               | 10    | 9      | 8      |
|-------------------------------|-------|--------|--------|
| MAXIMUM X                     | 1.150 | 1.265  | .763   |
| MINIMUM X                     | -.875 | -.761  | -.603  |
| MAXIMUM Y                     | 1.000 | .895   | .830   |
| MINIMUM Y                     | -.987 | -1.093 | -1.158 |
| CENTROID X                    | -.081 | -.196  | -.354  |
| CENTROID Y                    | -.045 | .060   | .125   |
| POA TO CENTROID in.           | .093  | .205   | .375   |
| MIN RADIUS                    | .342  | .329   | .295   |
| MEAN RADIUS                   | .865  | .779   | .679   |
| MAX RADIUS                    | 1.402 | 1.365  | 1.164  |
| HORIZONTAL SPREAD             | 2.026 | 2.026  | 1.366  |
| VERTICAL SPREAD               | 1.988 | 1.988  | 1.988  |
| EXTREME SPREAD                | 2.507 | 2.219  | 1.992  |
| NUMBER IN ONE INCH CIRCLE =   |       | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |       | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |       | 10     |        |

24 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611439.1

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.405

VS= 1.376

CS= 2.499

| PATTERN #                     | 2      |       |       |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .755   | .572  | .629  |
| MINIMUM X                     | -1.650 | -.781 | -.724 |
| MAXIMUM Y                     | .901   | .936  | .360  |
| MINIMUM Y                     | -.475  | -.440 | -.323 |
| CENTROID X                    | .048   | .231  | .174  |
| CENTROID Y                    | -.093  | -.118 | -.235 |
| POA TO CENTROID in.           | .096   | .259  | .292  |
| MIN RADIUS                    | .168   | .070  | .063  |
| MEAN RADIUS                   | .715   | .579  | .505  |
| MAX RADIUS                    | 1.679  | 1.042 | .808  |
| HORIZONTAL SPREAD             | 2.405  | 1.353 | 1.353 |
| VERTICAL SPREAD               | 1.376  | 1.376 | .683  |
| EXTREME SPREAD                | 2.499  | 1.611 | 1.469 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |

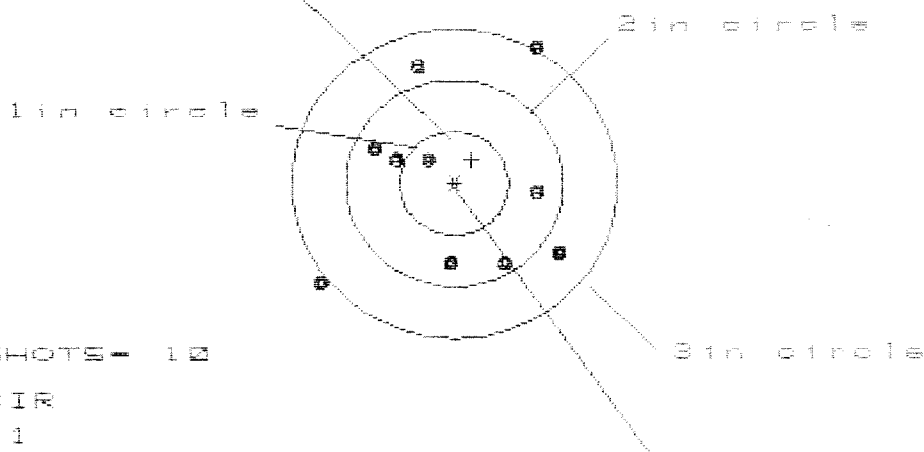
24 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06611439.1

# CENTERFIRE PATTERNS

# 3

POA



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.241

VS = 2.293

GS = 3.055

CENTROID #

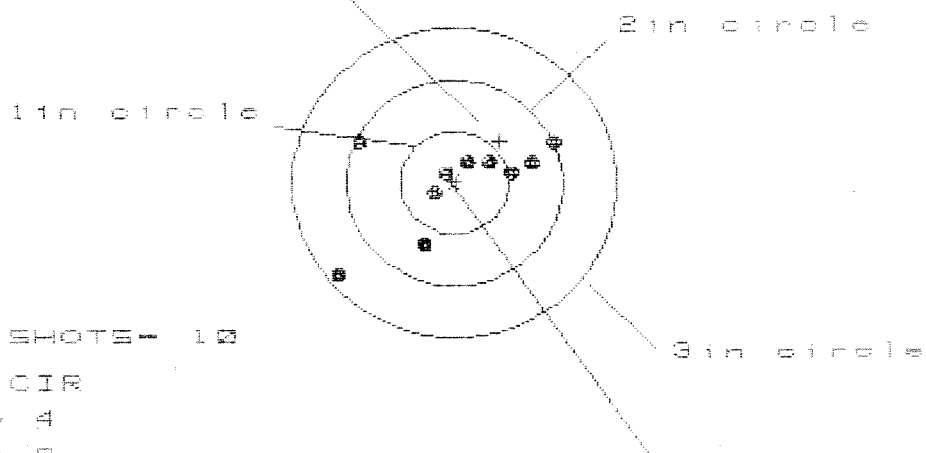
| PATTERN #                     | 3      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.003  |
| MINIMUM X                     | -1.238 |
| MAXIMUM Y                     | 1.371  |
| MINIMUM Y                     | -.922  |
| CENTROID X                    | -.162  |
| CENTROID Y                    | -.231  |
| POA TO CENTROID in.           | .282   |
| MIN RADIUS                    | .301   |
| MEAN RADIUS                   | .958   |
| MAX RADIUS                    | 1.578  |
| HORIZONTAL SPREAD             | 2.241  |
| VERTICAL SPREAD               | 2.293  |
| EXTREME SPREAD                | 3.055  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |
| NUMBER IN TWO INCH CIRCLE =   | 6      |
| NUMBER IN THREE INCH CIRCLE = | 8      |

24 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CGB11439.1

# CENTERFIRE PATTERNS # 4

POA



# OF SHOTS - 10

# IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.992

VS = 1.298

GS = 2.375

CENTROID #

PATTERN #

4

| SHOTS (BEST OF)               | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| MAXIMUM X                     | .952   | .837  | .691  |
| MINIMUM X                     | -1.040 | -.989 | -.885 |
| MAXIMUM Y                     | .364   | .260  | .292  |
| MINIMUM Y                     | -.934  | -.695 | -.663 |
| CENTROID X                    | -.420  | -.305 | -.410 |
| CENTROID Y                    | -.402  | -.298 | -.330 |
| POA TO CENTROID in.           | .582   | .426  | .526  |
| MIN RADIUS                    | .187   | .110  | .149  |
| MEAN RADIUS                   | .628   | .514  | .470  |
| MAX RADIUS                    | 1.398  | 1.023 | .931  |
| HORIZONTAL SPREAD             | 1.992  | 1.026 | 1.575 |
| VERTICAL SPREAD               | 1.298  | .955  | .955  |
| EXTREME SPREAD                | 2.375  | 1.826 | 1.584 |
| NUMBER IN ONE INCH CIRCLE =   |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |

24 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06611439.1

# CENTERFIRE PATTERNS

# 5

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.744

VS= 2.822

GS= 3.187

CENTROID #

PATTERN #

5

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | 1.163  | 1.254  | 1.068 |
| MINIMUM X                     | -1.581 | -1.490 | -.949 |
| MAXIMUM Y                     | 1.125  | .936   | .962  |
| MINIMUM Y                     | -1.697 | -.868  | -.842 |
| CENTROID X                    | .220   | .129   | .315  |
| CENTROID Y                    | -.374  | -.185  | -.211 |
| POA TO CENTROID in.           | .434   | .226   | .379  |
| MIN RADIUS                    | .490   | .615   | .427  |
| MEAN RADIUS                   | 1.050  | .949   | .855  |
| MAX RADIUS                    | 1.886  | 1.504  | 1.288 |
| HORIZONTAL SPREAD             | 2.744  | 2.744  | 2.017 |
| VERTICAL SPREAD               | 2.822  | 1.804  | 1.804 |
| EXTREME SPREAD                | 3.187  | 2.905  | 2.463 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611439  
15 May 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .178639 |
| 1 TO | 2 | .160851 |
| 1 TO | 3 | .273386 |
| 1 TO | 4 | .333098 |
| 1 TO | 5 | .186625 |

$\bar{x}_4$  <----POA

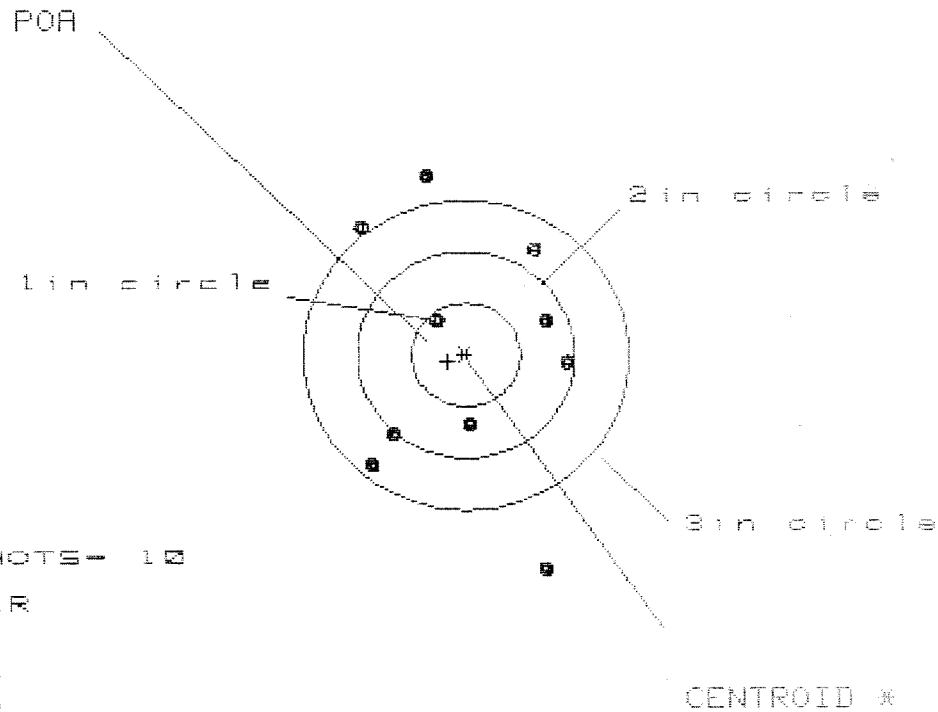
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1182  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0678  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136265  
THE AMR FOR THIS RIFLE IS: 1.047

15 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8811438

# CENTERFIRE PATTERNS

# 1



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 1.947

VS = 3.811

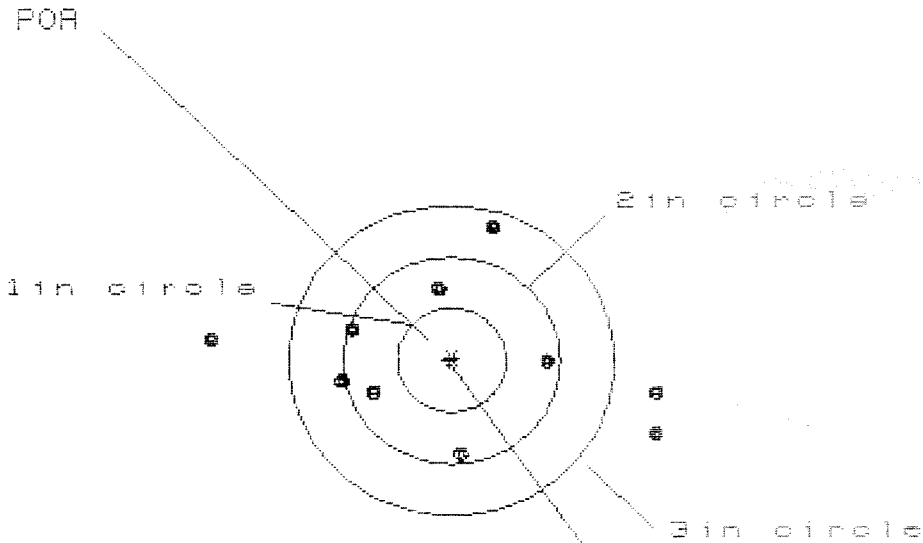
GS = 3.868

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .935   | 1.020  | .989   |
| MINIMUM X                     | -1.012 | -.927  | -.958  |
| MAXIMUM Y                     | 1.728  | 1.497  | 1.165  |
| MINIMUM Y                     | -2.083 | -1.316 | -1.129 |
| CENTROID X                    | .166   | .081   | .112   |
| CENTROID Y                    | .066   | .297   | .110   |
| POA TO CENTROID in.           | .179   | .308   | .157   |
| MIN RADIUS                    | .438   | .220   | .369   |
| MEAN RADIUS                   | 1.198  | 1.067  | 1.000  |
| MAX RADIUS                    | 2.221  | 1.518  | 1.508  |
| HORIZONTAL SPREAD             | 1.947  | 1.947  | 1.947  |
| VERTICAL SPREAD               | 3.811  | 2.813  | 2.294  |
| EXTREME SPREAD                | 3.968  | 2.859  | 2.579  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/06611439

# CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1in = 0

2in = 5

3in = 7

HS = 4.066

VS = 2.263

GS = 4.128

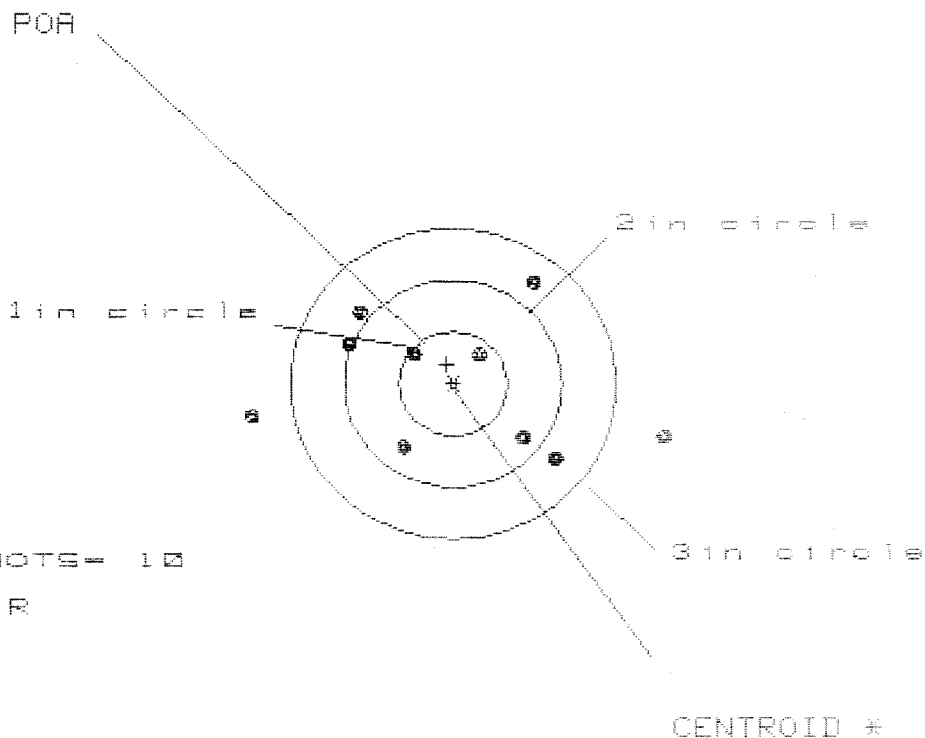
CENTROID #

| PATTERN #                   | 1      | 2      | 3      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.875  | 1.631  | 1.831  |
| MINIMUM X                   | -2.191 | -1.287 | -1.087 |
| MAXIMUM Y                   | 1.319  | 1.339  | 1.256  |
| MINIMUM Y                   | -0.944 | -0.924 | -1.007 |
| CENTROID X                  | .018   | .262   | .062   |
| CENTROID Y                  | .003   | -.017  | .067   |
| POA TO CENTROID in.         | .019   | .262   | .091   |
| MIN RADIUS                  | .715   | .596   | .661   |
| MEAN RADIUS                 | 1.276  | 1.178  | 1.076  |
| MAX RADIUS                  | 2.199  | 1.734  | 1.870  |
| HORIZONTAL SPREAD           | 4.066  | 2.918  | 2.918  |
| VERTICAL SPREAD             | 2.263  | 2.263  | 2.263  |
| EXTREME SPREAD              | 4.128  | 2.944  | 2.922  |
| NUMBER IN ONE INCH CIRCLE   | =      | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | =      | 5      |        |
| NUMBER IN THREE INCH CIRCLE | =      | 7      |        |

15 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611439

# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 1

2in = 4

3in = 5

HS = 3.784

VS = 1.731

GS = 3.789

| PATTERN #                     | 3      |        |       |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.911  | 1.200  | .992  |
| MINIMUM X                     | -1.873 | -1.660 | -.965 |
| MAXIMUM Y                     | 1.024  | .965   | .915  |
| MINIMUM Y                     | -.707  | -.766  | -.816 |
| CENTROID X                    | .060   | -.153  | .055  |
| CENTROID Y                    | -.186  | -.127  | -.077 |
| POA TO CENTROID in.           | .196   | .199   | .095  |
| MIN RADIUS                    | .364   | .318   | .298  |
| MEAN RADIUS                   | 1.098  | .978   | .873  |
| MAX RADIUS                    | 1.984  | 1.700  | 1.284 |
| HORIZONTAL SPREAD             | 3.784  | 2.860  | 1.957 |
| VERTICAL SPREAD               | 1.731  | 1.731  | 1.731 |
| EXTREME SPREAD                | 3.789  | 2.912  | 2.303 |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |       |

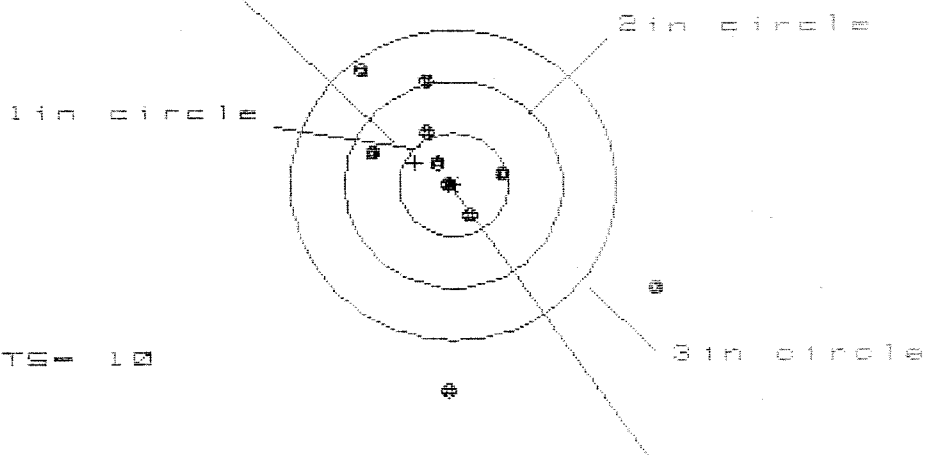
15 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06611439

# CENTERFIRE PATTERNS

# 4

POA



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.740

VS= 3.071

GS= 3.420

CENTROID #

PATTERN #

4

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | 1.849  | .608   | .629  |
| MINIMUM X                     | -.891  | -.685  | -.653 |
| MAXIMUM Y                     | 1.088  | .982   | .720  |
| MINIMUM Y                     | -1.983 | -2.089 | -.619 |
| CENTROID X                    | .351   | .145   | .123  |
| CENTROID Y                    | -.211  | -.105  | .157  |
| POA TO CENTROID in.           | .409   | .179   | .199  |
| MIN RADIUS                    | .036   | .136   | .131  |
| MEAN RADIUS                   | .891   | .735   | .534  |
| MAX RADIUS                    | 2.083  | 2.096  | .979  |
| HORIZONTAL SPREAD             | 2.740  | 1.293  | 1.293 |
| VERTICAL SPREAD               | 3.071  | 3.071  | 1.339 |
| EXTREME SPREAD                | 3.420  | 3.189  | 1.668 |
| NUMBER IN ONE INCH CIRCLE =   |        | 4      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |       |

15 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611439

# CENTERFIRE PATTERNS

# 5

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.857

VS= 2.116

GS= 2.931

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.182

.996

.264

MINIMUM X

-1.675

-.509

-.384

MAXIMUM Y

1.305

1.302

1.217

MINIMUM Y

-.811

-.814

-.899

CENTROID X

-.004

.182

.057

CENTROID Y

-.011

-.008

.077

POA TO CENTROID in.

.012

.182

.096

MIN RADIUS

.267

.140

.275

MEAN RADIUS

.771

.648

.585

MAX RADIUS

1.675

1.305

1.217

HORIZONTAL SPREAD

2.857

1.505

.648

VERTICAL SPREAD

2.116

2.116

2.116

EXTREME SPREAD

2.931

2.261

2.117

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9