

C6349062

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

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

MODEL 700™ M24

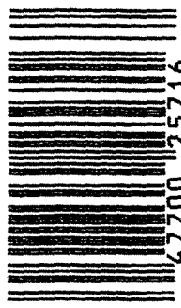
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6349062

ORDER NO.
5716

Ø1

UPC



0 47700 25716 7



5716 C6349062

C6349062

MOD. _____ GA. _____ GUN _____
 CAL. _____ # _____

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
1st			
WB	4/30/90	REAR SWIVEL STOCK HOLE STRIPPED REPLACE STOCK	
2nd			
		Per shot 5/3/90	
3rd			
			49 167 533
4th			

FUNCTION _____

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	$\begin{array}{r} 16 \\ 16 \\ \hline 32 \end{array}$ New Stock	51
TEST		11
TGT		90 RW
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

New Stock

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349062

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 30	90	RW
600	Proof	1 30	90	A
607	Check Headspace	1 30	90	A
610	Dis-assemble Gun	1 30	90	RW
612	Magnaflux Barrel Action	2-5-90		KCR
	Magnaflux Bolt	2-5-90		
615	Rollmark Caliber		2/3/90	GS
617	Drill and Tap Sight Holes		2/5/90	FB
618	Polish Barrel RB		2/5/90	WB
620	Apply Coatings (Barrel Action)		2-17-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/90	WB
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/20/90	94

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/23/90	JEL
	G) Safety Off Force	2	2	2			4/23/90	JEL
	H) Trigger Pull Test & Retainability						4/24/90	JEL
	I) Firing Pin Indent	.021	.021	.021			4/23/90	JEL
	J) Assemble Stock						4/25/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/25/90	RW
	M) Iron Sight Alignment						4/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/90	RW
	O) Attach Scope to Rifle						4/25/90	JEL
	P) Detach & Attach Scope 20 Times						4/25/90	JEL
640	Gallery Target & Test						4-25-90	DH
	A) Time						4-25-90	DH
	B) Malfunctions						4-25-90	DH
	C) Pierced Primers						4-25-90	DH
	D) Optical Clarity of Scope						4-25-90	DH
645	Inspect for Live Ammo						4-25-90	DH
655	Final Inspection A) Headspace						5/8/90	WB
	B) Trigger Pull	2.62	2.62	2.72	2.68	2.69	5/8/90	WB
	C) Function						5/8/90	WB
660	Pack						6-19-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 06349062

DATE 4/29/90

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.35	2.56	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.15	2.32	2.62	
PULL #3	2.48	2.48	2.47	2.72	
PULL #4	2.29	2.38	2.34	2.68	
PULL #5	2.24	2.32	2.33	2.69	
TOTAL	12.13	11.68	12.02		
AVG.	2.426	2.336	2.404		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.39		
PULL #2	3.33	3.37		
PULL #3	3.28	3.45		
PULL #4	3.30	3.35		
PULL #5	3.29	3.40		
TOTAL	16.47	16.96		
AVG.	3.294	3.392		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.33		4.51
PULL #2	4.20	4.32		4.43
PULL #3	4.06	4.37		4.41
PULL #4	4.34	4.35		4.37
PULL #5	4.32	4.33		4.39
TOTAL	21.15	21.70		22.11
AVG.	4.23	4.34		4.422

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349862
25 Apr 1998

CENTROIDAL DISTANCES

0 TO	1	.502479
1 TO	2	.635928
1 TO	3	.485845
1 TO	4	.514709
1 TO	5	.362746

$\frac{5}{3}1$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1522
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152234
THE AMR FOR THIS RIFLE IS: .801

25 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8949062

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.738

VS = 1.345

GS = 2.759

CENTROID #

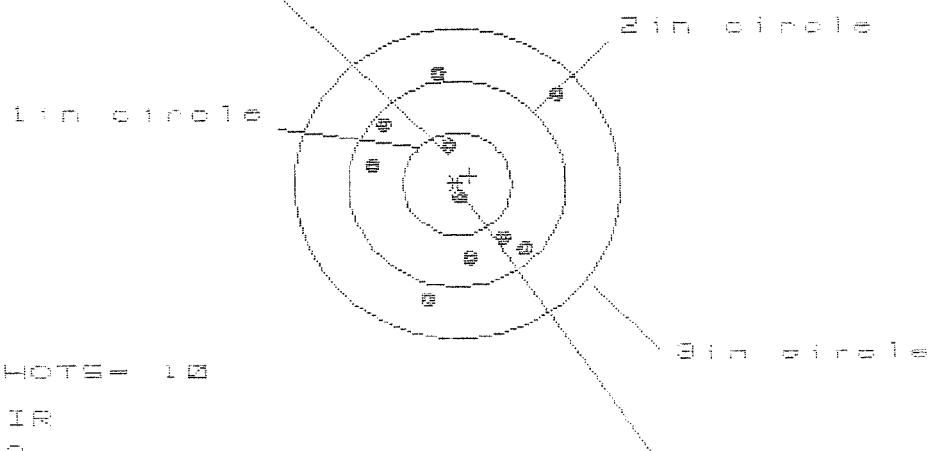
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.101	.919	.997
MINIMUM X	-1.637	-.922	-.845
MAXIMUM Y	.545	.588	.486
MINIMUM Y	-.800	-.765	-.859
CENTROID X	.497	.679	.602
CENTROID Y	.074	.039	.133
POA TO CENTROID in.	.502	.680	.616
MIN RADIUS	.190	.331	.213
MEAN RADIUS	.791	.699	.640
MAX RADIUS	1.667	1.029	1.000
HORIZONTAL SPREAD	2.738	1.841	1.841
VERTICAL SPREAD	1.345	1.345	1.345
EXTREME SPREAD	2.759	1.955	1.895
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

25 Apr 1998

FILE://PATTERNING/CENTERFIRE_PATT/08345062

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.680

VS= 2.135

GS= 2.247

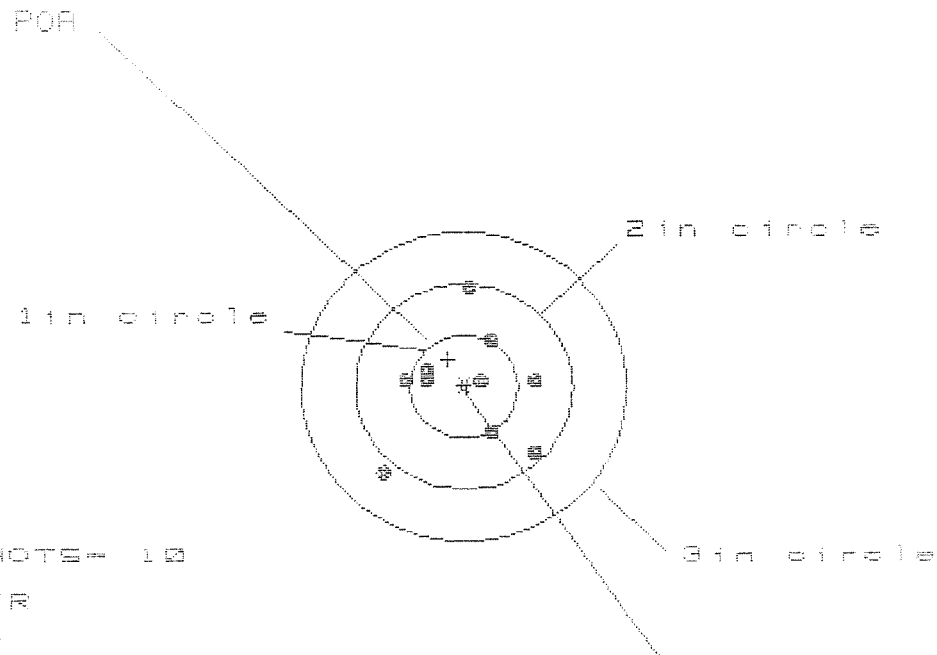
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.891	.759	.740
MINIMUM X	-.789	-.689	-.708
MAXIMUM Y	1.050	1.156	1.033
MINIMUM Y	-1.075	-.979	-.781
CENTROID X	-.120	-.220	-.201
CENTROID Y	-.080	-.176	-.053
FOR TO CENTROID in.	.145	.281	.208
MIN RADIUS	.094	.084	.136
MEAN RADIUS	.802	.743	.700
MAX RADIUS	1.240	1.159	1.038
HORIZONTAL SPREAD	1.680	1.448	1.448
VERTICAL SPREAD	2.135	2.135	1.814
EXTREME SPREAD	2.247	2.136	1.913
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

25 Apr 1998

FILE:\PATTERNING\CENTERFIRE_PATT\08349062

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.340

VS= 1.849

GS= 1.988

CENTROID #

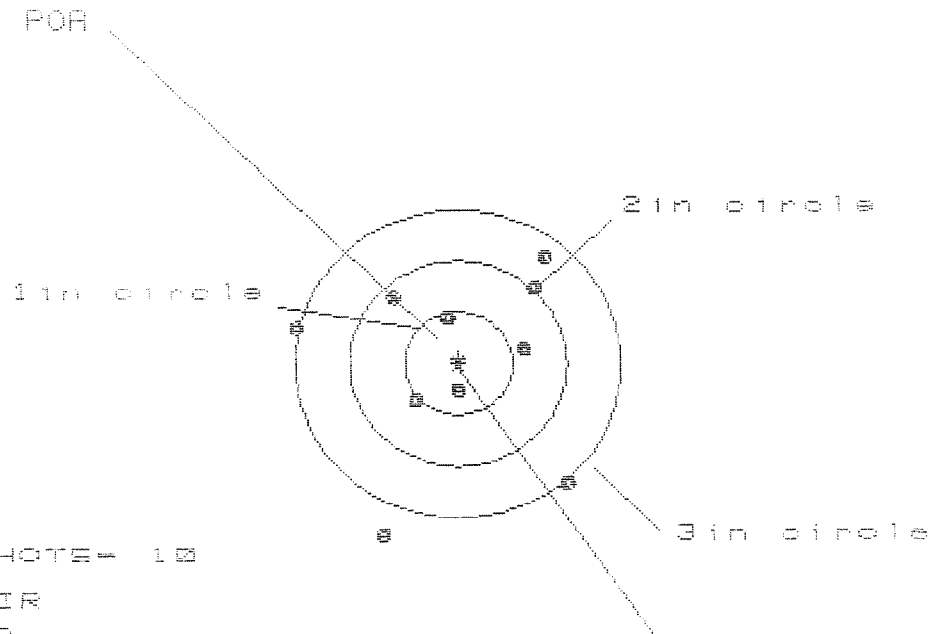
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.618	.538	.533
MINIMUM X	-.722	-.644	-.649
MAXIMUM Y	.988	.892	.490
MINIMUM Y	-.861	-.774	-.662
CENTROID X	.148	.228	.233
CENTROID Y	-.264	-.168	-.280
POB TO CENTROID in.	.302	.283	.364
MIN RADIUS	.191	.091	.133
MEAN RADIUS	.613	.542	.499
MAX RADIUS	1.124	.943	.850
HORIZONTAL SPREAD	1.340	1.182	1.182
VERTICAL SPREAD	1.849	1.666	1.152
EXTREME SPREAD	1.999	1.764	1.403
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

25 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349882

CENTERFIRE PATTERNS

4



* OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 2.526

VS = 2.670

GS = 3.026

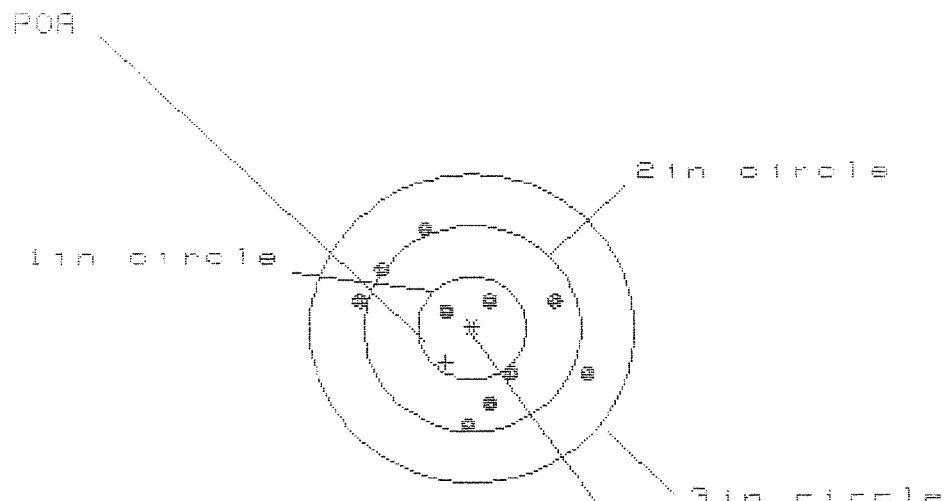
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.052	.979	.817
MINIMUM X	:	-1.474	-1.547	-1.424
MAXIMUM Y	:	1.039	.858	.696
MINIMUM Y	:	-1.631	-1.292	-.720
CENTROID X	:	-.004	.069	-.054
CENTROID Y	:	-.044	.137	.299
FOR TO CENTROID in.	:	.044	.153	.303
MIN RADIUS	:	.297	.267	.077
MEAN RADIUS	:	.989	.884	.773
MAX RADIUS	:	1.758	1.621	1.424
HORIZONTAL SPREAD	:	2.526	2.526	2.241
VERTICAL SPREAD	:	2.670	2.150	1.416
EXTREME SPREAD	:	3.026	2.926	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

25 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349062

CENTERFIRE PATTERNS # 5



OF SHOTS- 10
IN CIR
1in = 2
2in = 7
3in = 10
HS= 2.052
VS= 1.922
GS= 2.202

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	.897	.859
MINIMUM X	-1.018	-.902	-.940
MAXIMUM Y	.979	.927	.662
MINIMUM Y	-.943	-.995	-.879
CENTROID X	.240	.124	.162
CENTROID Y	.330	.382	.266
POA TO CENTROID in.	.408	.401	.311
MIN RADIUS	.321	.213	.320
MEAN RADIUS	.810	.763	.737
MAX RADIUS	1.142	1.001	1.012
HORIZONTAL SPREAD	2.062	1.799	1.799
VERTICAL SPREAD	1.922	1.922	1.541
EXTREME SPREAD	2.202	1.967	1.799
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349062
4 May 1990

CENTROIDAL DISTANCES

0 TO	1	.349178
1 TO	2	.223808
1 TO	3	.264367
1 TO	4	.284886
1 TO	5	.255163

50' <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .391407
THE AMR FOR THIS RIFLE IS: .9068

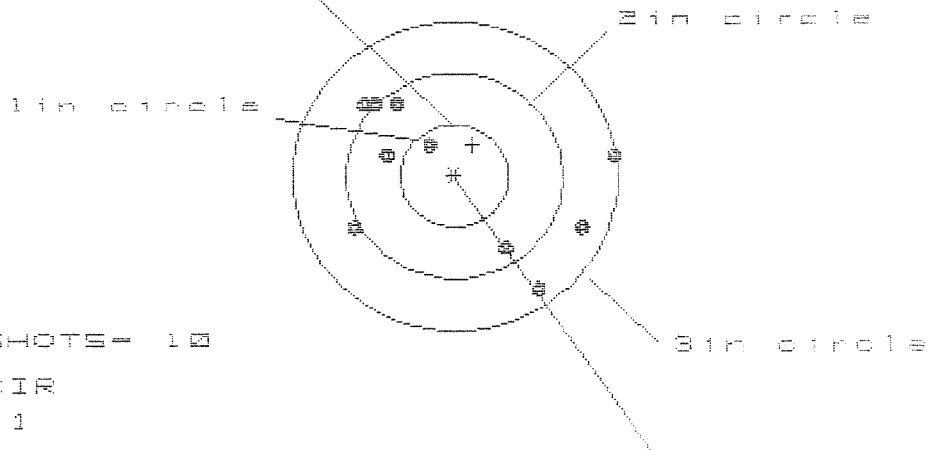
4 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349062.1

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.403

VS= 1.859

GS= 2.501

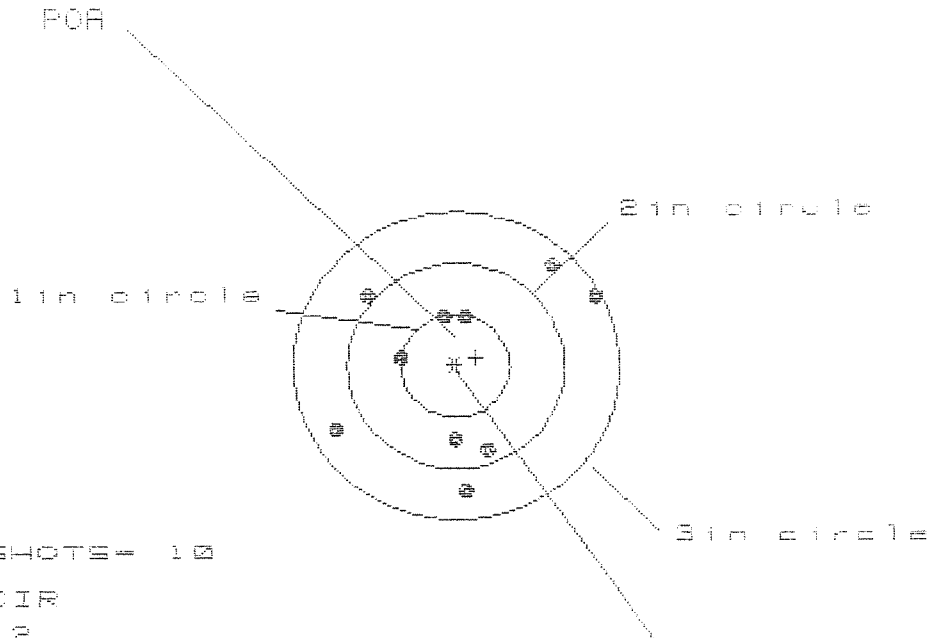
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.490	1.363	1.479
MINIMUM X	-.913	-.747	-.631
MAXIMUM Y	.733	.756	.618
MINIMUM Y	-1.126	-1.183	-.819
CENTROID X	-.178	-.336	-.452
CENTROID Y	-.385	-.328	-.196
POA TO CENTROID in.	.349	.469	.490
MIN RADIUS	.337	.299	.181
MEAN RADIUS	1.014	.927	.802
MAX RADIUS	1.504	1.456	1.615
HORIZONTAL SPREAD	2.403	2.110	2.110
VERTICAL SPREAD	1.859	1.859	1.437
EXTREME SPREAD	2.501	2.466	2.423
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

4 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349062.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.386

VS= 2.177

GS= 2.765

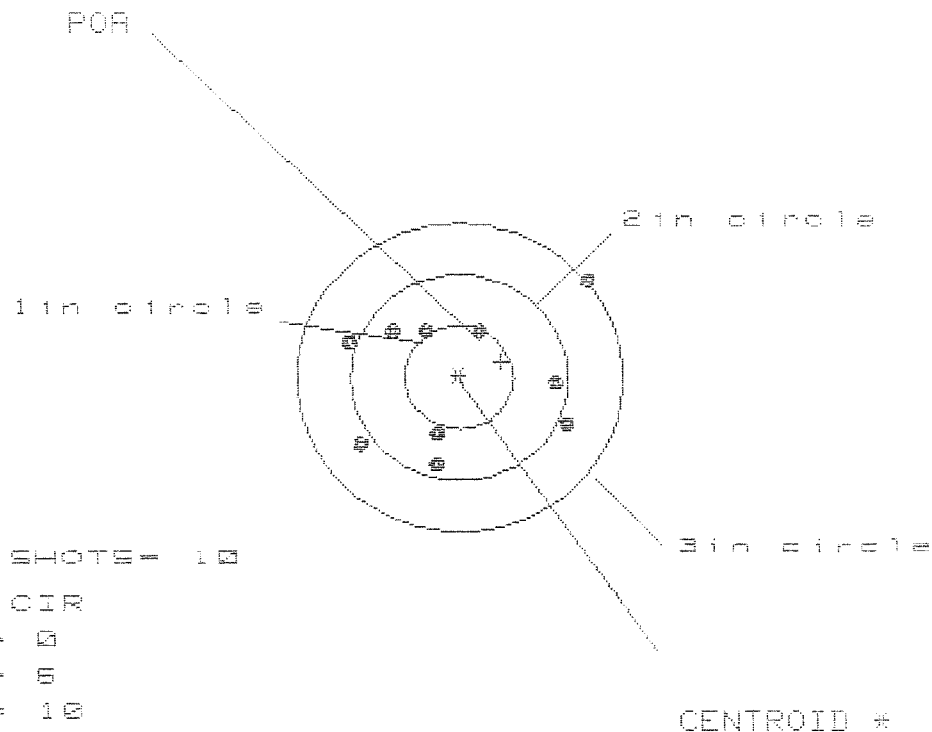
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.002	.510
MINIMUM X	:	-1.148	-1.009	-.884
MAXIMUM Y	:	1.007	1.087	.869
MINIMUM Y	:	-1.170	-1.090	-.954
CENTROID X	:	-.189	-.328	-.453
CENTROID Y	:	-.082	-.162	-.298
POA TO CENTROID in.	:	.206	.366	.542
MIN RADIUS	:	.476	.372	.339
MEAN RADIUS	:	.937	.866	.780
MAX RADIUS	:	1.439	1.478	1.021
HORIZONTAL SPREAD	:	2.396	2.011	1.394
VERTICAL SPREAD	:	2.177	2.177	1.823
EXTREME SPREAD	:	2.765	2.615	2.017
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

4 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349062.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.192

VS= 1.807

GS= 2.641

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	1.116	1.016
MINIMUM X	:	-1.027	-.898	-.998
MAXIMUM Y	:	.913	.599	.525
MINIMUM Y	:	-.894	-.793	-.867
CENTROID X	:	-.387	-.516	-.416
CENTROID Y	:	-.154	-.255	-.181
POA TO CENTROID in.	:	.416	.576	.454
MIN RADIUS	:	.515	.484	.552
MEAN RADIUS	:	.899	.823	.794
MAX RADIUS	:	1.488	1.165	1.094
HORIZONTAL SPREAD	:	2.192	2.014	2.014
VERTICAL SPREAD	:	1.807	1.392	1.392
EXTREME SPREAD	:	2.641	2.152	2.152
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

4 May 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6349062.1

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.961

VS = 1.979

GS = 2.178

CENTROID #

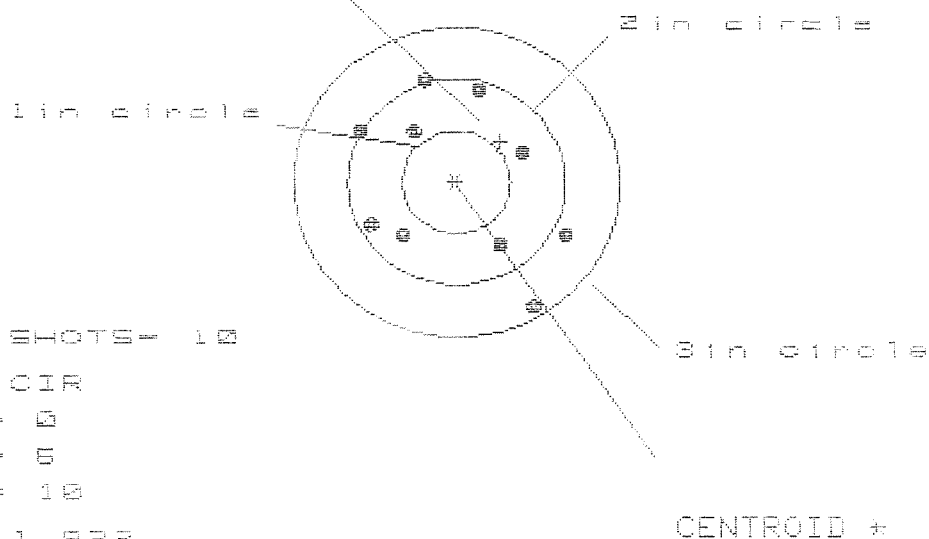
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.035	.991	.828
MINIMUM X	-.926	-.970	-.846
MAXIMUM Y	1.083	.579	.647
MINIMUM Y	-.896	-.776	-.708
CENTROID X	-.436	-.392	-.516
CENTROID Y	-.203	-.323	-.391
POR TO CENTROID in.	.481	.508	.647
MIN RADIUS	.197	.081	.132
MEAN RADIUS	.768	.706	.653
MAX RADIUS	1.154	1.131	.950
HORIZONTAL SPREAD	1.961	1.961	1.674
VERTICAL SPREAD	1.979	1.355	1.355
EXTREME SPREAD	2.178	1.985	1.867
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

4 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8345062.1

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 10

HS = 1.922

VS = 2.153

GS = 2.375

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.012	1.088	.843
MINIMUM X	:	-.910	-.834	-.698
MAXIMUM Y	:	.988	.859	.779
MINIMUM Y	:	-1.165	-.688	-.768
CENTROID X	:	-.408	-.484	-.620
CENTROID Y	:	-.397	-.268	-.188
FOR TO CENTROID in.	:	.569	.553	.648
MIN RADIUS	:	.604	.458	.308
MEAN RADIUS	:	.916	.849	.772
MAX RADIUS	:	1.351	1.261	1.008
HORIZONTAL SPREAD	:	1.922	1.922	1.541
VERTICAL SPREAD	:	2.153	1.547	1.547
EXTREME SPREAD	:	2.375	2.179	1.727
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	