

C6522337

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

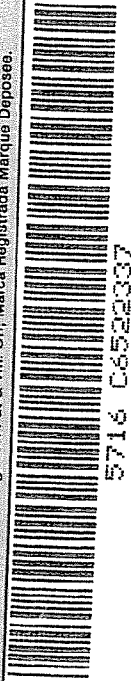
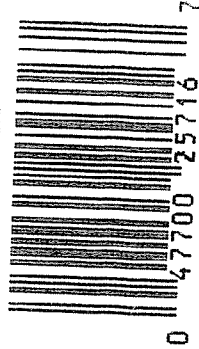
SERIAL NO. C6522337

ORDER NO. 5716

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

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

UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522337
13 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	1.05943
1 TO	2	.293411
1 TO	3	.221461
1 TO	4	.907827
1 TO	5	1.47153

5
+ 4 <----POA
3
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .7906
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3072
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .848186
THE AMR FOR THIS RIFLE IS: .6428

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522337

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 10

HS= 1.263

VS= 1.339

GS= 2.255

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.719	.581	.653
MINIMUM X	-1.244	-.640	-.568
MAXIMUM Y	.569	.609	.518
MINIMUM Y	-.770	-.730	-.427
CENTROID X	.735	.873	.801
CENTROID Y	-.763	-.803	-.712
POR TO CENTROID in.	1.059	1.186	1.072
MIN RADIUS	.109	.034	.059
MEAN RADIUS	.530	.428	.359
MAX RADIUS	1.294	.927	.833
HORIZONTAL SPREAD	1.963	1.221	1.221
VERTICAL SPREAD	1.339	1.339	.945
EXTREME SPREAD	2.255	1.498	1.304
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 6

2in = 10

3in = 10

HS= .742

VS= 1.524

GS= 1.559

CENTROID *

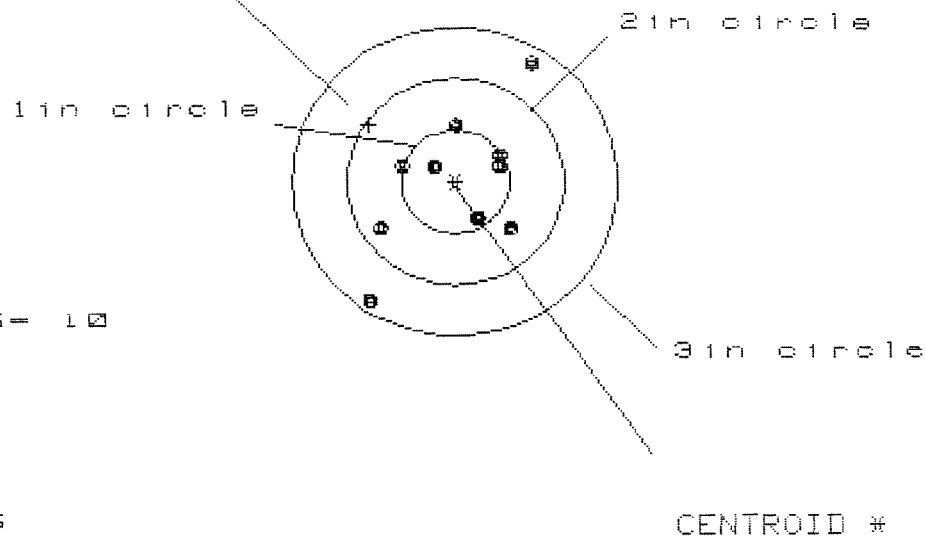
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.353	.343	.293
MINIMUM X	:	-.389	-.399	-.319
MAXIMUM Y	:	.600	.498	.402
MINIMUM Y	:	-.924	-.764	-.558
CENTROID X	:	.674	.684	.734
CENTROID Y	:	-1.050	-.948	-.852
POA TO CENTROID in.	:	1.248	1.169	1.125
MIN RADIUS	:	.256	.197	.163
MEAN RADIUS	:	.507	.438	.361
MAX RADIUS	:	.928	.862	.640
HORIZONTAL SPREAD	:	.742	.742	.612
VERTICAL SPREAD	:	1.524	1.262	.960
EXTREME SPREAD	:	1.559	1.435	1.106
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			10	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.495

VS= 2.317

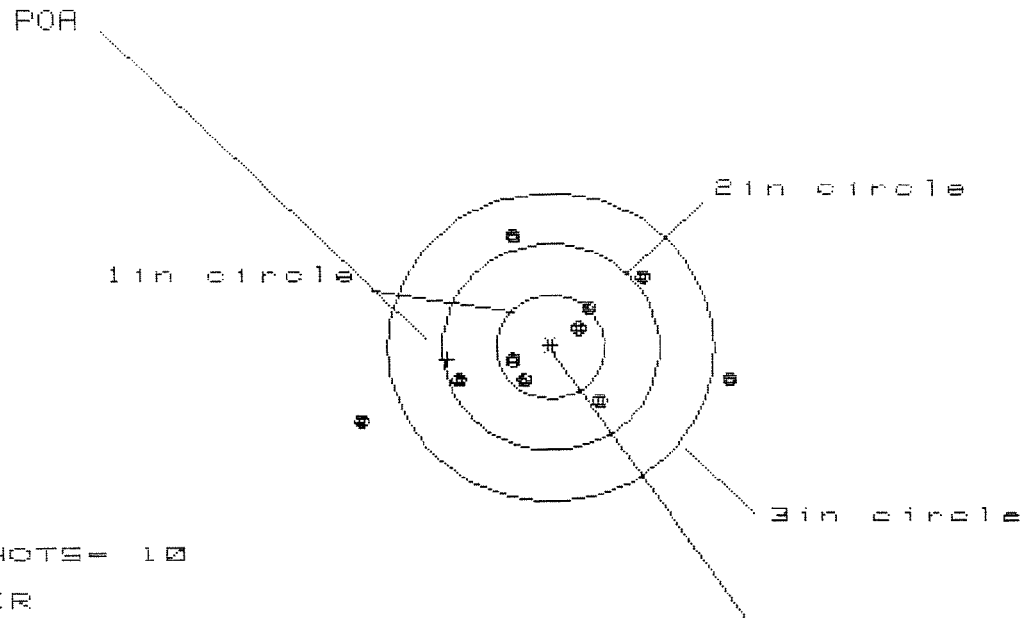
GS= 2.758

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.731	.646	.504
MINIMUM X	:	-.765	-.826	-.745
MAXIMUM Y	:	1.132	1.001	.551
MINIMUM Y	:	-1.185	-.624	-.499
CENTROID X	:	.792	.877	.796
CENTROID Y	:	-.549	-.418	-.543
POA TO CENTROID in.	:	.964	.971	.964
MIN RADIUS	:	.261	.299	.261
MEAN RADIUS	:	.692	.594	.519
MAX RADIUS	:	1.410	1.191	.897
HORIZONTAL SPREAD	:	1.496	1.472	1.249
VERTICAL SPREAD	:	2.317	1.625	1.050
EXTREME SPREAD	:	2.758	2.193	1.368
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.414

VS= 1.742

GS= 3.428

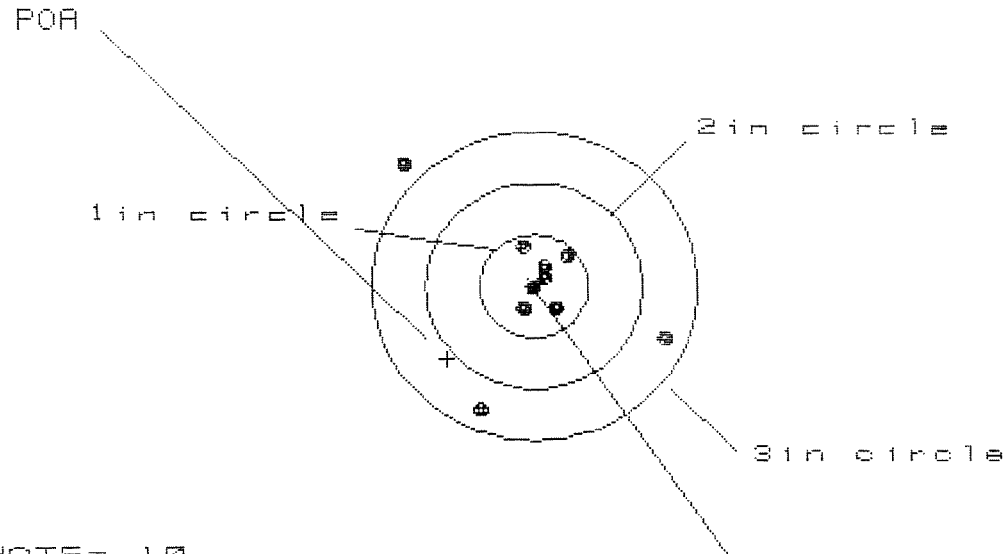
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.696	1.505	.828
MINIMUM X	:	-1.718	-1.047	-.858
MAXIMUM Y	:	1.068	.993	.939
MINIMUM Y	:	-.674	-.590	-.644
CENTROID X	:	.950	1.141	.952
CENTROID Y	:	.119	.194	.248
POA TO CENTROID in.	:	.957	1.157	.984
MIN RADIUS	:	.248	.063	.205
MEAN RADIUS	:	.894	.772	.668
MAX RADIUS	:	1.845	1.567	1.012
HORIZONTAL SPREAD	:	3.414	2.552	1.686
VERTICAL SPREAD	:	1.742	1.583	1.583
EXTREME SPREAD	:	3.428	2.552	1.983
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 7

2 in = 7

3 in = 9

HS= 2.406

VS= 2.387

GS= 2.949

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.231	1.101	.300
MINIMUM X	:	-1.175	-.636	-.498
MAXIMUM Y	:	1.228	.513	.471
MINIMUM Y	:	-1.159	-1.023	-1.065
CENTROID X	:	.802	.932	.794
CENTROID Y	:	.707	.571	.613
POA TO CENTROID in.	:	1.069	1.093	1.004
MIN RADIUS	:	.052	.124	.042
MEAN RADIUS	:	.591	.488	.375
MAX RADIUS	:	1.699	1.204	1.176
HORIZONTAL SPREAD	:	2.406	1.737	.798
VERTICAL SPREAD	:	2.387	1.536	1.536
EXTREME SPREAD	:	2.949	1.866	1.649
NUMBER IN ONE INCH CIRCLE	=		7	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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

SERIAL NO C6522337DATE 9-7-90TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.20	2.44	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.17	2.42	2.34	
PULL #3	2.22	2.37	2.40	2.37	
PULL #4	2.20	2.36	2.41	2.51	
PULL #5	2.19	2.39	2.48	2.25	
TOTAL	11.57	11.49	12.15	11.84	
AVG.	2.314	2.298	2.43	2.368	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.38		
PULL #2	3.35	3.37		
PULL #3	3.23	3.35		
PULL #4	3.33	3.34		
PULL #5	3.35	3.20		
TOTAL	16.53	16.64		
AVG.	3.306	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.36		4.39
PULL #2	4.13	4.36		4.39
PULL #3	4.29	4.33		4.46
PULL #4	4.32	4.31		4.39
PULL #5	4.43	4.20		4.43
TOTAL	21.37	21.56		22.06
AVG.	4.274	4.312		4.412

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522337

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	ES.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel AB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-12-90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-7-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/2/90	RL
	G) Safety Off Force	3	3	3			8/2/90	RL
	H) Trigger Pull Test & Retainability						9-7-90	RL
	I) Firing Pin Indent	.022	.0225	.0225			8/2/90	RL
	J) Assemble Stock						8/9/90	RW
	K) Assemble Swivel Studs						9/8/90	RL
	L) Attach Front and Rear Sight Assemblies						8/9/90	RW
	M) Iron Sight Alignment						8/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/90	RW
	O) Attach Scope to Rifle						8/9/90	RW
	P) Detach & Attach Scope 20 Times						8/9/90	RW
640	Gallery Target & Test						8-13-90	KI
	A) Time						8-13-90	KI
	B) Malfunctions						8-13-90	KI
	C) Pierced Primers						8-13-90	KI
	D) Optical Clarity of Scope						8-13-90	KI
645	Inspect for Live Ammo						8-13-90	KI
655	Final Inspection							
	A) Headspace						9/8/90	RL
	B) Trigger Pull	2.37	2.34	2.37	2.51	2.25	9-7-90	RL
	C) Function						9/8/90	RL
660	Pack						9-19-90	DA