

C6522340

MODEL 700™ M24

Model **S&S**™

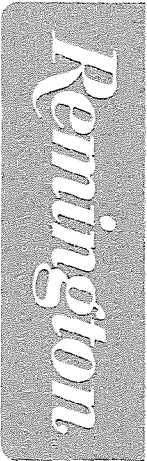
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington[®]

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

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

MODEL 700TM H24

SERIAL NO.
C6522340

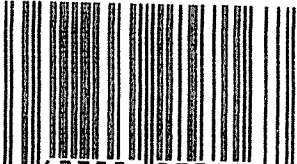
ORDER NO.
5716

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

01


5716 C6522340

UPC


0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522340
25 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.796097
1 TO	2	.896663
1 TO	3	.491451
1 TO	4	1.1473
1 TO	5	.874842

$\frac{5}{4}$
³
₄
¹
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2038
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0014
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .203805
 THE AMR FOR THIS RIFLE IS: .9052

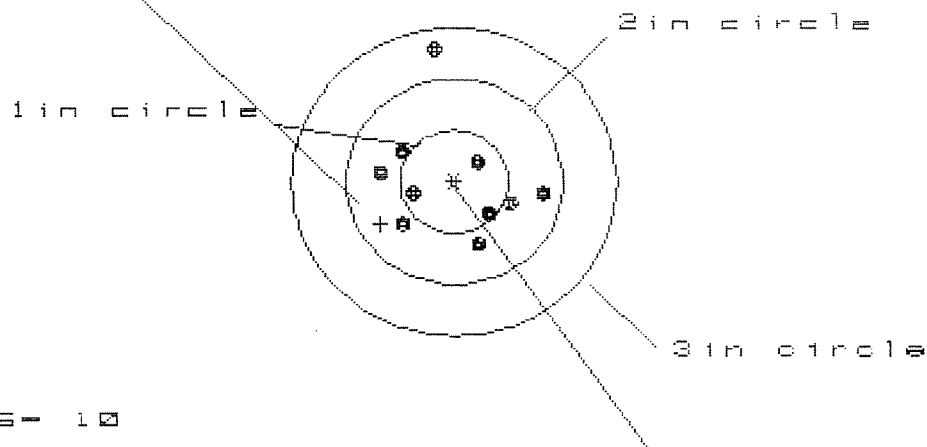
25 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522340

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.450

VS= 1.898

GS= 1.937

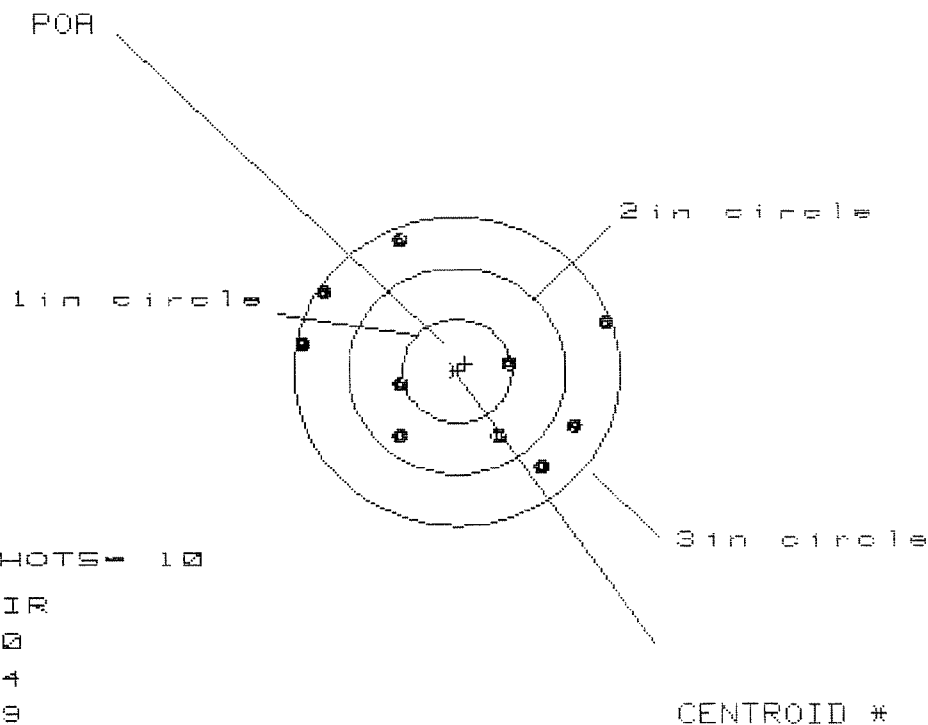
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.763	.642
MINIMUM X	:	-.668	-.687	-.591
MAXIMUM Y	:	1.243	.398	.404
MINIMUM Y	:	-.655	-.516	-.510
CENTROID X	:	.683	.702	.606
CENTROID Y	:	.409	.270	.264
POA TO CENTROID in.	:	.796	.752	.661
MIN RADIUS	:	.315	.339	.269
MEAN RADIUS	:	.626	.539	.503
MAX RADIUS	:	1.254	.765	.642
HORIZONTAL SPREAD	:	1.450	1.450	1.233
VERTICAL SPREAD	:	1.898	.914	.914
EXTREME SPREAD	:	1.937	1.458	1.254
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

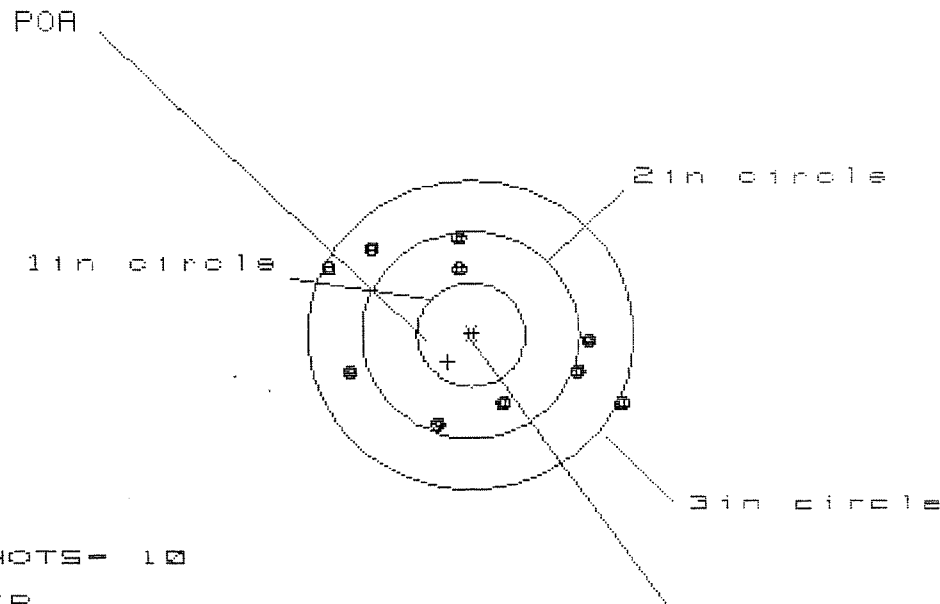


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.271	1.140
MINIMUM X	:	-1.406	-1.248	-1.379
MAXIMUM Y	:	1.220	1.277	1.381
MINIMUM Y	:	-.969	-.912	-.808
CENTROID X	:	-.075	-.233	-.102
CENTROID Y	:	-.070	-.127	-.231
POA TO CENTROID in.	:	.103	.265	.252
MIN RADIUS	:	.522	.359	.490
MEAN RADIUS	:	1.080	1.017	.958
MAX RADIUS	:	1.509	1.344	1.485
HORIZONTAL SPREAD	:	2.828	2.519	2.519
VERTICAL SPREAD	:	2.189	2.189	2.189
EXTREME SPREAD	:	2.840	2.660	2.625
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.613

VS= 1.815

GS= 2.920

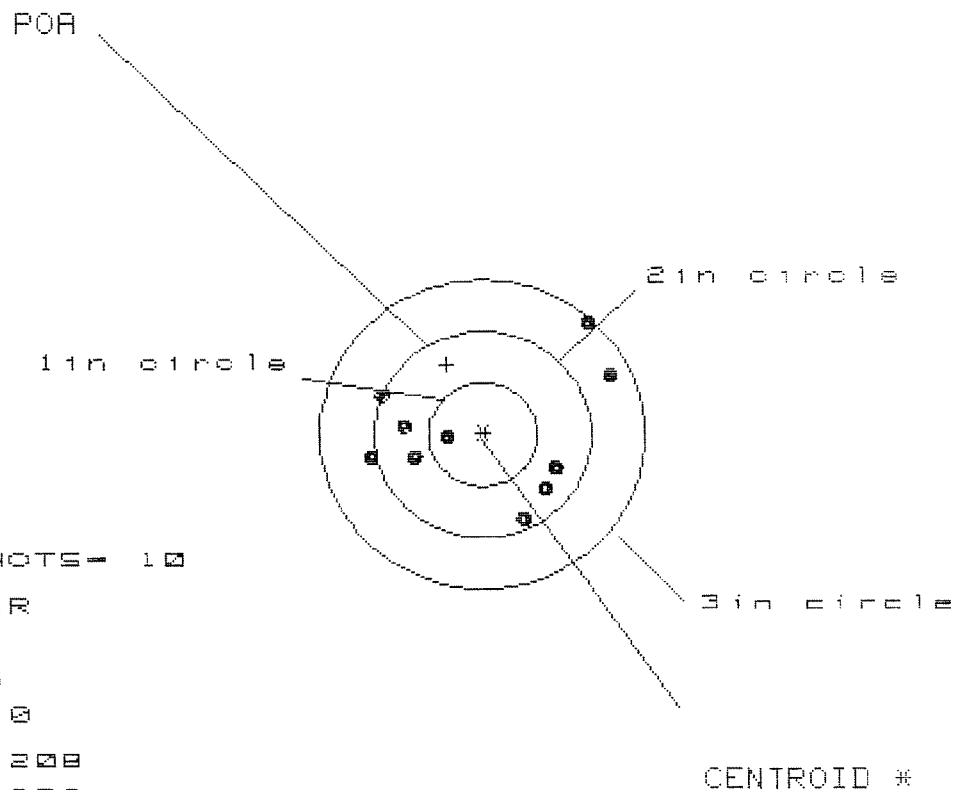
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.346	1.239	1.099
MINIMUM X	:	-1.267	-1.117	-1.067
MAXIMUM Y	:	.909	.834	.904
MINIMUM Y	:	-.906	-.981	-.910
CENTROID X	:	.215	.065	.205
CENTROID Y	:	.259	.334	.263
POA TO CENTROID in.	:	.337	.340	.334
MIN RADIUS	:	.616	.528	.610
MEAN RADIUS	:	1.069	1.009	.972
MAX RADIUS	:	1.503	1.250	1.229
HORIZONTAL SPREAD	:	2.613	2.356	2.167
VERTICAL SPREAD	:	1.815	1.815	1.815
EXTREME SPREAD	:	2.920	2.494	2.272
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.208

VS= 1.876

GS= 2.375

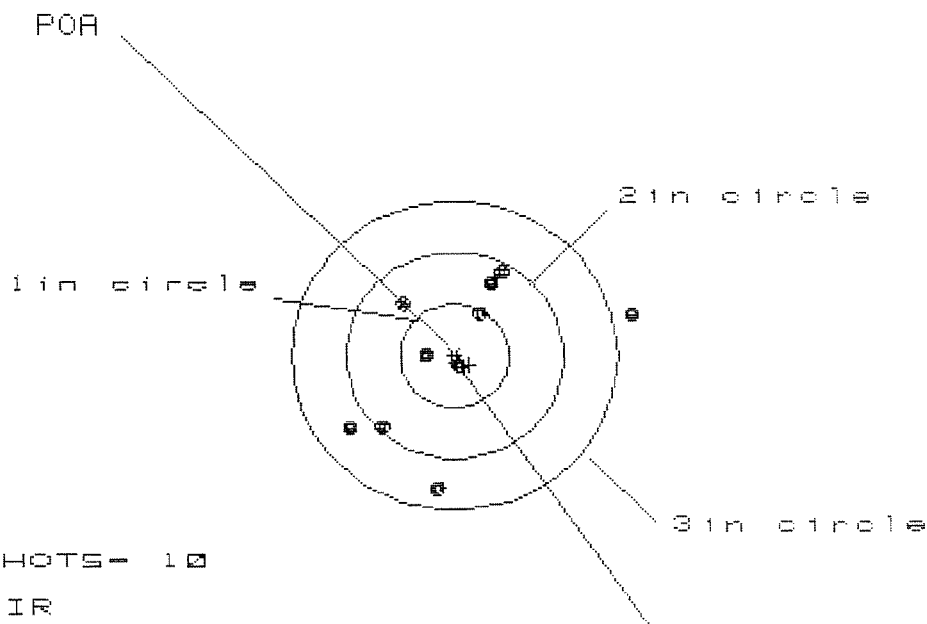
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.304	.894
MINIMUM X	:	-1.011	-.904	-.742
MAXIMUM Y	:	1.090	.677	.592
MINIMUM Y	:	-.786	-.665	-.580
CENTROID X	:	.328	.221	.058
CENTROID Y	:	-.682	-.803	-.888
POA TO CENTROID in.	:	.757	.833	.890
MIN RADIUS	:	.373	.300	.246
MEAN RADIUS	:	.895	.800	.679
MAX RADIUS	:	1.451	1.469	.922
HORIZONTAL SPREAD	:	2.208	2.208	1.636
VERTICAL SPREAD	:	1.876	1.342	1.172
EXTREME SPREAD	:	2.375	2.347	1.807
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.678

VS= 2.149

GS= 2.913

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.663	.631	.628
MINIMUM X	:	-1.015	-.830	-.833
MAXIMUM Y	:	.827	.874	.715
MINIMUM Y	:	-1.322	-1.275	-.834
CENTROID X	:	-.132	-.317	-.314
CENTROID Y	:	.091	.044	.203
POA TO CENTROID in.	:	.160	.320	.374
MIN RADIUS	:	.105	.123	.197
MEAN RADIUS	:	.856	.747	.668
MAX RADIUS	:	1.716	1.275	1.179
HORIZONTAL SPREAD	:	2.678	1.461	1.461
VERTICAL SPREAD	:	2.149	2.149	1.549
EXTREME SPREAD	:	2.913	2.246	2.129
NUMBER IN ONE INCH CIRCLE =			3	
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. C6522340

DATE 8/20/90

TESTER J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.35	2.36	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.37	2.34	2.16	
PULL #3	2.38	2.35	2.30	2.10	
PULL #4	2.37	2.37	2.32	2.05	
PULL #5	2.25	2.32	2.40	2.10	
TOTAL	11.60	11.76	11.72	10.64	
AVG.	2.32	2.352	2.344	2.128	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.30		
PULL #2	3.25	3.27		
PULL #3	3.23	3.33		
PULL #4	3.26	3.33		
PULL #5	3.21	3.30		
TOTAL	16.20	16.63		
AVG.	3.24	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.28		4.33
PULL #2	4.24	4.29		4.37
PULL #3	4.20	4.32		4.32
PULL #4	4.25	4.33		4.35
PULL #5	4.24	4.32		4.39
TOTAL	21.08	21.54		21.76
AVG.	4.216	4.308		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522340

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	LG
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	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		8/20/90	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/10/90	JK
	G) Safety Off Force	3	3	3			8/10/90	JK
	H) Trigger Pull Test & Retainability						8/20/90	JK
	I) Firing Pin Indent	.020	.021	.0205			8/10/90	JK
	J) Assemble Stock						8/25/90	RW
	K) Assemble Swivel Studs						8/17/90	JS
	L) Attach Front and Rear Sight Assemblies						8/25/90	RW
	M) Iron Sight Alignment						8/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/25/90	RW
	O) Attach Scope to Rifle						8/25/90	RW
	P) Detach & Attach Scope 20 Times						8/25/90	RW
640	Gallery Target & Test						8-25-90	DH
	A) Time						8-25-90	DH
	B) Malfunctions						8-25-90	DH
	C) Pierced Primers						8-25-90	DH
	D) Optical Clarity of Scope						8-25-90	DH
645	Inspect for Live Ammo						8-25-90	DH
655	Final Inspection						8/30/90	JS
	A) Headspace						8/30/90	JK
	B) Trigger Pull	2.23	2.16	2.10	2.05	2.10	8/30/90	JK
	C) Function						8/30/90	JS
660	Pack						9/20/90	NE