

C6522347

MODEL 700™ M24

Model S&S™

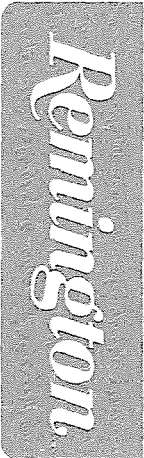
Action _____

Barrel Length _____

Capacity _____

Order No. 5716

* Includes 1 in chamber.



Remington[®]

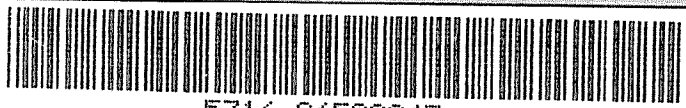

REG. U.S. PAT. & TM. OFF.

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

MODEL 700 TM M24	SERIAL NO. C6522347
	ORDER NO. 5716

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

01



5716 C6522347

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522347
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.735201
1 TO	2	1.38216
1 TO	3	1.20835
1 TO	4	1.58848
1 TO	5	.597164

$\begin{matrix} & & 1 \\ 3 & \nearrow & \\ 2 & & \end{matrix}$
 $\leftarrow$ POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0584
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1436
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155021
 THE AMR FOR THIS RIFLE IS: .9348

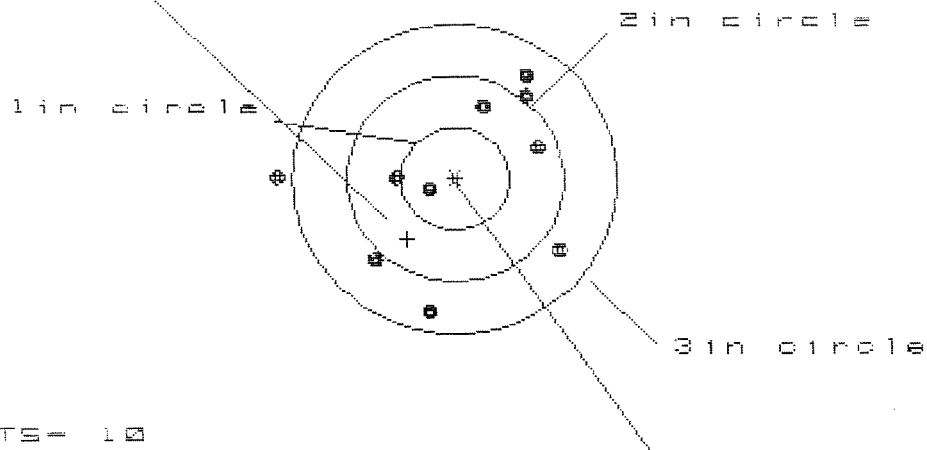
7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522347

CENTERFIRE PATTERNS

1

POR



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.598

VS = 2.278

GS = 2.678

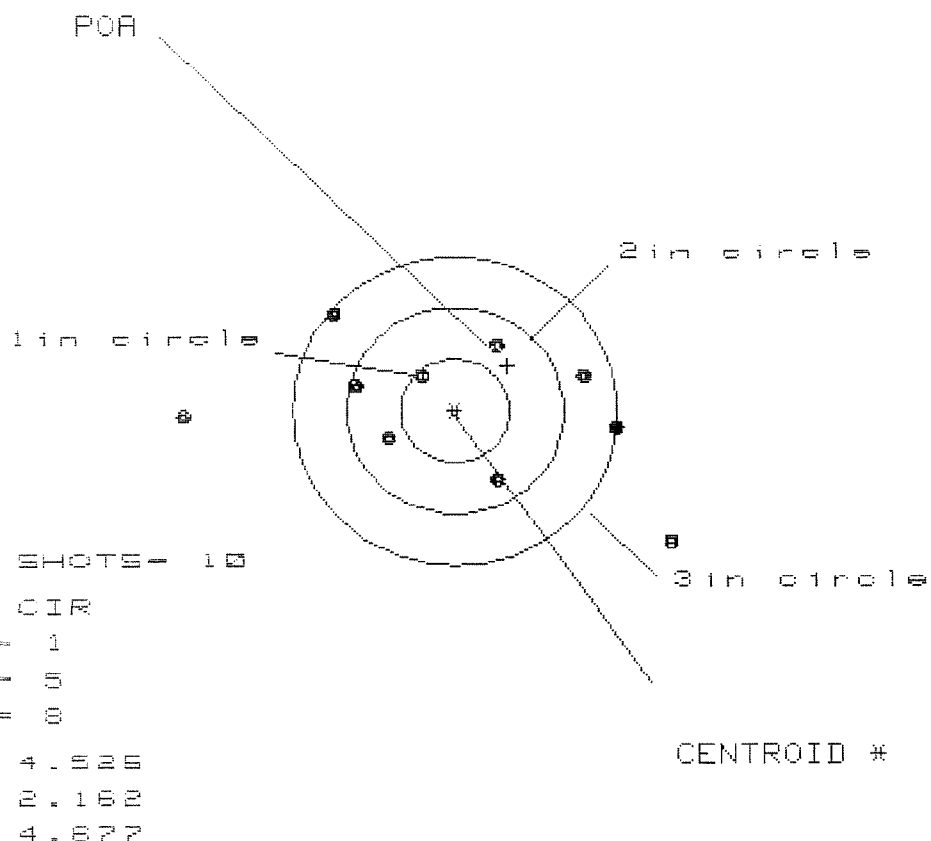
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.988	.810	.759
MINIMUM X	-1.610	-.918	-.969
MAXIMUM Y	.988	.984	.823
MINIMUM Y	-1.290	-1.294	-.923
CENTROID X	.440	.618	.669
CENTROID Y	.589	.593	.754
POR TO CENTROID in.	.735	.857	1.008
MIN RADIUS	.238	.402	.521
MEAN RADIUS	.969	.895	.812
MAX RADIUS	1.610	1.356	1.339
HORIZONTAL SPREAD	2.598	1.728	1.728
VERTICAL SPREAD	2.278	2.278	1.746
EXTREME SPREAD	2.678	2.432	2.216
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2

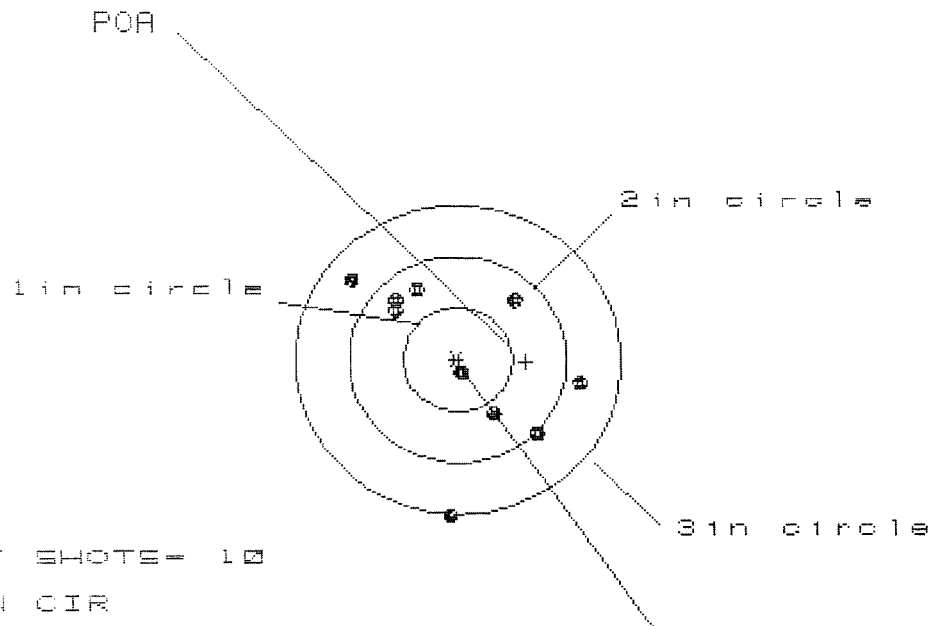


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.987	1.705	1.408
MINIMUM X	-2.539	-1.406	-1.193
MAXIMUM Y	.911	.903	.746
MINIMUM Y	-1.251	-1.259	-.832
CENTROID X	-.485	-.203	-.416
CENTROID Y	-.438	-.430	-.273
POA TO CENTROID in.	.654	.476	.497
MIN RADIUS	.417	.592	.376
MEAN RADIUS	1.251	1.108	.940
MAX RADIUS	2.540	2.119	1.447
HORIZONTAL SPREAD	4.526	3.111	2.601
VERTICAL SPREAD	2.162	2.162	1.578
EXTREME SPREAD	4.677	3.788	2.817
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.090

VS= 2.285

GS= 2.461

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.092
MINIMUM X	-.998
MAXIMUM Y	.768
MINIMUM Y	-1.517
CENTROID X	-.626
CENTROID Y	.020
POA TO CENTROID IN.	.626
MIN RADIUS	.110
MEAN RADIUS	.880
MAX RADIUS	1.520
HORIZONTAL SPREAD	2.090
VERTICAL SPREAD	2.285
EXTREME SPREAD	2.461
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	9

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CENTERFIRE PATTERNS # 4

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= 1.819

VS= 2.484

GS= 2.667

CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.813	.447	.467
MINIMUM X	-.806	-.694	-.674
MAXIMUM Y	1.324	1.195	.860
MINIMUM Y	-1.160	-1.228	-1.079
CENTROID X	.286	.174	.154
CENTROID Y	-.992	-.863	-1.012
POA TO CENTROID in.	1.032	.880	1.024
MIN RADIUS	.146	.198	.086
MEAN RADIUS	.743	.638	.556
MAX RADIUS	1.540	1.273	1.136
HORIZONTAL SPREAD	1.819	1.141	1.141
VERTICAL SPREAD	2.484	2.423	1.939
EXTREME SPREAD	2.667	2.430	1.941
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS = 2.040

VS = 2.328

GS = 2.559

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.284
MINIMUM X	-.756
MAXIMUM Y	.989
MINIMUM Y	-1.339
CENTROID X	.093
CENTROID Y	.103
POA TO CENTROID in.	.139
MIN RADIUS	.371
MEAN RADIUS	.831
MAX RADIUS	1.855
HORIZONTAL SPREAD	2.040
VERTICAL SPREAD	2.328
EXTREME SPREAD	2.559
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	8
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. C6522347

DATE 8/24/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.40	2.33	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.47	2.50	2.28	
PULL #3	2.33	2.50	2.41	2.27	
PULL #4	2.25	2.45	2.41	2.37	
PULL #5	2.41	2.43	2.46	2.31	
TOTAL	11.74	12.25	12.11	11.60	
AVG.	2.348	2.45	2.422	2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.23		
PULL #2	3.22	3.15		
PULL #3	3.21	3.31		
PULL #4	3.35	3.24		
PULL #5	3.28	3.30		
TOTAL	16.30	16.23		
AVG.	3.26	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.23		4.19
PULL #2	4.10	4.31		4.11
PULL #3	4.14	4.21		4.17
PULL #4	4.23	4.36		4.18
PULL #5	4.34	4.27		4.26
TOTAL	21.08	21.38		20.91
AVG.	4.216	4.276		4.182

M-24CONTRACT # DAAA21-87-C-0086GUN SERIAL # *C6522347*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	<i>RW</i>
600	Proof	6 29	90	<i>RW</i>
607	Check Headspace	6 29	90	<i>RW</i>
610	Dis-assemble Gun	6 29	90	<i>RW</i>
612	Magnaflux Barrel Action		7-12-90	<i>KR</i>
	Magnaflux Bolt		7-12-90	<i>KR</i>
615	Rollmark Caliber		7-12-90	<i>KR</i>
617	Drill and Tap Sight Holes		7/13/90	<i>FB</i>
618	Polish Barrel <i>RB</i>		7/16/90	<i>WB</i>
620	Apply Coatings (Barrel Action)		7-23-90	<i>TA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		7/25/90	<i>RW</i>
	D) Oil Firing Pin Ass'y		7/25/90	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/90	<i>GL</i>

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						8/24/90	RL
	I) Firing Pin Indent	.023	.023	.023			8/2/90	RL
	J) Assemble Stock						8/6/90	RW
	K) Assemble Swivel Studs						8/30/90	RL
	L) Attach Front and Rear Sight Assemblies						8/6/90	RW
	M) Iron Sight Alignment						8/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/90	RW
	O) Attach Scope to Rifle						8/6/90	RW
	P) Detach & Attach Scope 20 Times						8/6/90	RW
640	Gallery Target & Test						8-7-90	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8-7-90	KJ
655	Final Inspection							
	A) Headspace						8/30/90	RL
	B) Trigger Pull	2.38	2.28	2.27	2.37	2.31	8/24/90	RL
	C) Function						8/30/90	RL
660	Pack						9/19/90	RF