

06594545

MODEL 700™ M24

Model S&S™

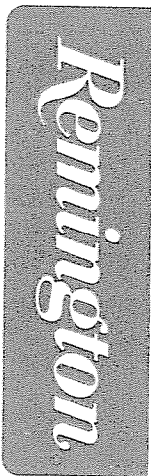
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



BARBER - M24 0018956

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

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

MODEL 700™ M24

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

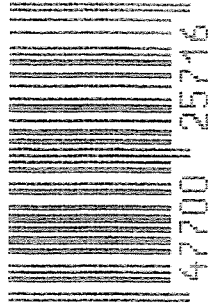
SERIAL NO. C6594545

ORDER NO. 5716

20

5716 C6594545

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C 6594545*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	<i>Kd</i>
600	Proof		10/30/90	<i>Kd</i>
607	Check Headspace		10/30/90	<i>Kd</i>
610	Dis-assemble Gun		10/30/90	<i>Kd</i>
612	Magnaflux Barrel Action		11/1/90	<i>KCR</i>
	Magnaflux Bolt		11/1/90	<i>KCR</i>
615	Rollmark Caliber		11/1/90	<i>GS</i>
617	Drill and Tap Sight Holes		11/6/90	<i>LSB</i>
618	Polish Barrel <i>AB</i>		11/7/90	<i>WSB</i>
620	Apply Coatings (Barrel Action)		11-20-90	<i>TA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/18/91	<i>KS</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/18/91	<i>KS</i>
	C) Inspect Ejector Hole for Chamfer		11/18/91	<i>KS</i>
	D) Oil Firing Pin Ass'y		11/18/91	<i>KS</i>
	E) Adjust Trigger Pull to Min Setting and Stake		11/21/91	<i>JS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4			1/21/91	WB
	G) Safety Off Force	8 1/4	2	2			1/21/91	WB
	H) Trigger Pull Test & Retainability						1/21/91	JM
	I) Firing Pin Indent	.020	.0205	.0205			1/21/91	WB
	J) Assemble Stock						1/21/91	KS
	K) Assemble Swivel Studs						2-4-91	A
	L) Attach Front and Rear Sight Assemblies						1/21/91	KS
	M) Iron Sight Alignment						1/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/21/91	KS
	O) Attach Scope to Rifle						1/21/91	KS
	P) Detach & Attach Scope 20 Times						1/21/91	KS
640	Gallery Target & Test						1-22-91	DH
	A) Time						1-22-91	DH
	B) Malfunctions						1-22-91	DH
	C) Pierced Primers						1-22-91	DH
	D) Optical Clarity of Scope						1-22-91	DH
645	Inspect for Live Ammo						1-22-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	A
	B) Trigger Pull	2.17	2.15	2.20	2.15	2.14	1/29/90	JM
	C) Function						2-4-91	AC
660	Pack						3-10-91	NF

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

SERIAL NO. C6594545DATE 1/21/91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.42	2.27	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.39	2.18	2.15	
PULL #3	2.37	2.37	2.36	2.20	
PULL #4	2.40	2.36	2.31	2.15	
PULL #5	2.45	2.35	2.38	2.14	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.34		
PULL #2	3.34	3.32		
PULL #3	3.33	3.34		
PULL #4	3.35	3.41		
PULL #5	3.29	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.29		4.18
PULL #2	4.32	4.22		4.24
PULL #3	4.30	4.31		4.21
PULL #4	4.30	4.18		4.24
PULL #5	4.27	4.30		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594545
23 Jan 1991

CENTROIDAL DISTANCES

Ø TO	1	.223833
1 TO	2	.370648
1 TO	3	.175183
1 TO	4	.214107
1 TO	5	.14734

2
3
4

<----POA

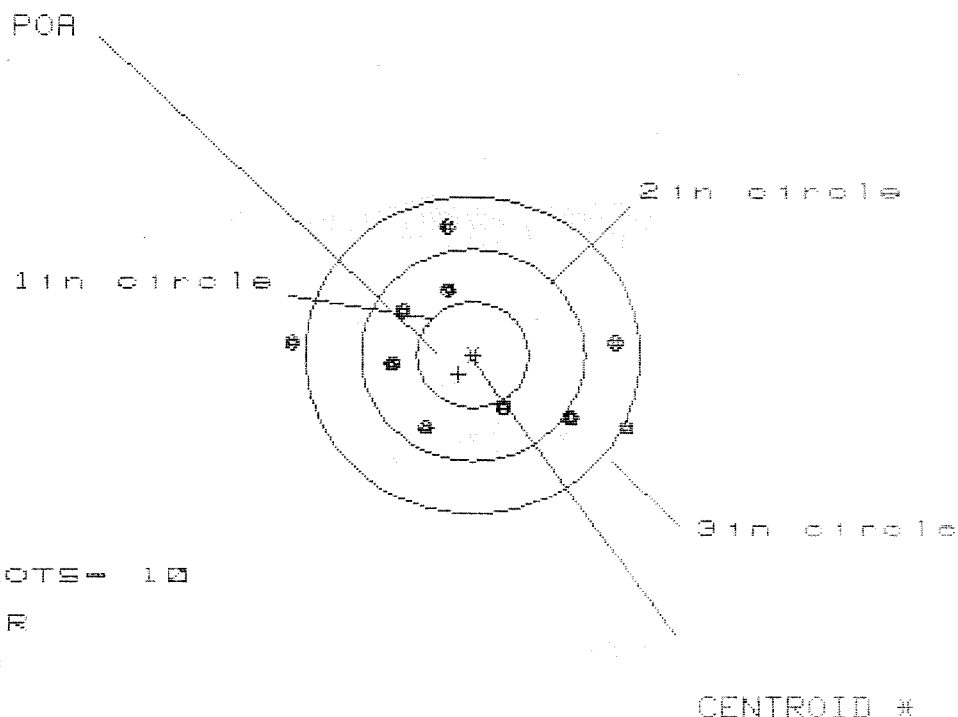
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0456
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1862
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191702

THE AMR FOR THIS RIFLE IS: .8338

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594545

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 9

HS = 2.913

VS = 1.866

GS = 3.007

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.324	1.148	1.246
MINIMUM X	-1.589	-.913	-.770
MAXIMUM Y	1.191	1.200	1.118
MINIMUM Y	-.675	-.666	-.748
CENTROID X	.126	.302	.159
CENTROID Y	.185	.176	.258
POA TO CENTROID in.	.224	.350	.303
MIN RADIUS	.536	.473	.589
MEAN RADIUS	1.010	.948	.881
MAX RADIUS	1.591	1.321	1.246
HORIZONTAL SPREAD	2.913	2.061	2.016
VERTICAL SPREAD	1.866	1.866	1.866
EXTREME SPREAD	3.007	2.396	2.082
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

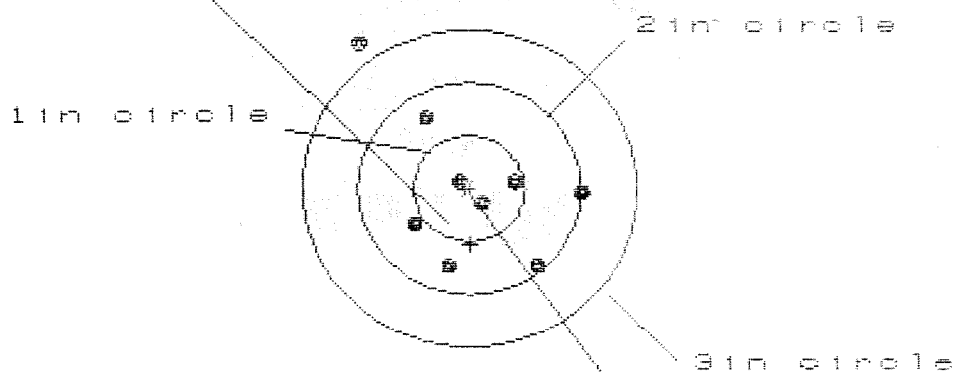
23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594545

CENTERFIRE PATTERNS

2

FOR



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.997

VS= 2.136

GS= 2.661

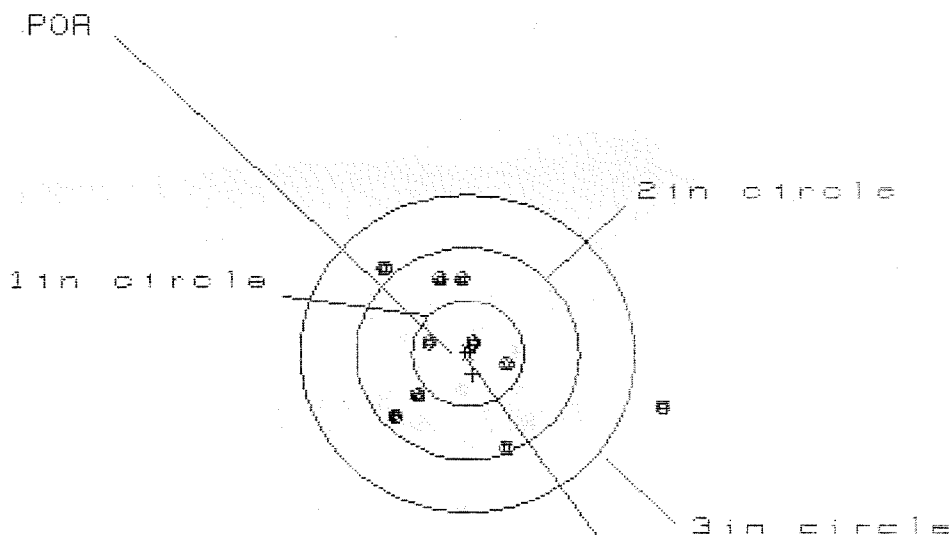
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.887	.588
MINIMUM X	:	-.999	-.584	-.473
MAXIMUM Y	:	1.392	.839	.848
MINIMUM Y	:	-.744	-.589	-.580
CENTROID X	:	-.012	.099	-.012
CENTROID Y	:	.529	.374	.365
POA TO CENTROID in.	:	.529	.387	.365
MIN RADIUS	:	.129	.029	.073
MEAN RADIUS	:	.664	.509	.466
MAX RADIUS	:	1.713	.988	.943
HORIZONTAL SPREAD	:	1.997	1.471	1.061
VERTICAL SPREAD	:	2.136	1.428	1.428
EXTREME SPREAD	:	2.661	1.743	1.743
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534545

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.506

VS= 1.660

GS= 2.839

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.789	.585	.520
MINIMUM X	-.717	-.519	-.551
MAXIMUM Y	.812	.754	.785
MINIMUM Y	-.848	-.906	-.812
CENTROID X	-.049	-.247	-.182
CENTROID Y	.193	.251	.157
POR TO CENTROID in.	.199	.353	.241
MIN RADIUS	.149	.115	.219
MEAN RADIUS	.781	.635	.602
MAX RADIUS	1.864	1.046	.932
HORIZONTAL SPREAD	2.506	1.104	1.072
VERTICAL SPREAD	1.660	1.660	1.597
EXTREME SPREAD	2.839	1.959	1.714
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534545

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 1.902

VS= 2.261

GS= 2.408

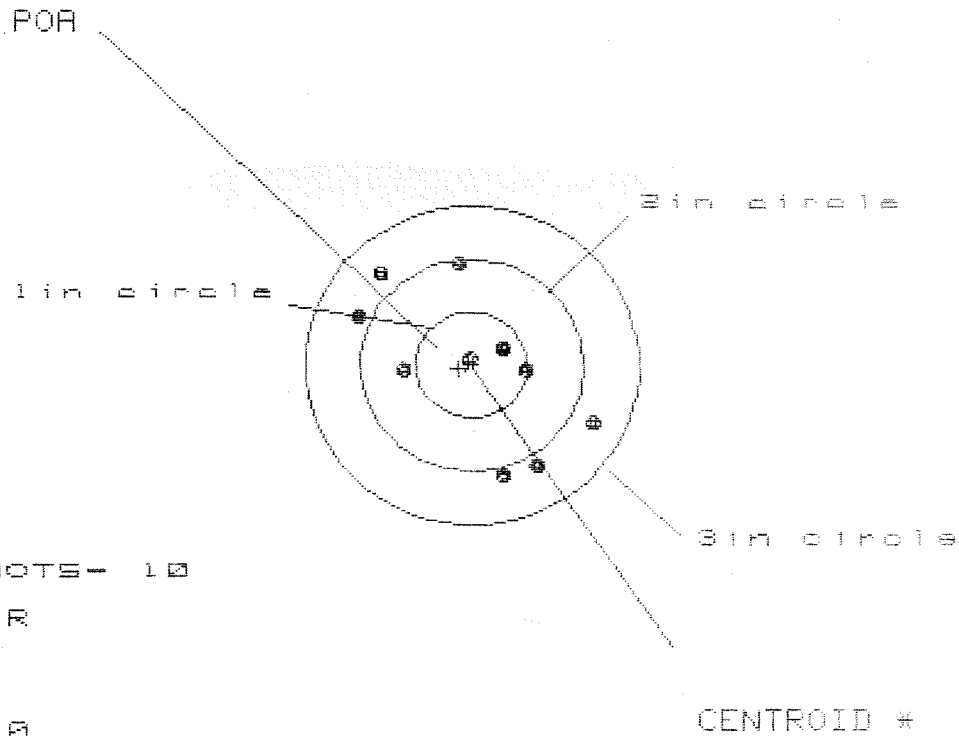
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.254	.574	.510
MINIMUM X	:	-.648	-.509	-.508
MAXIMUM Y	:	1.108	1.067	1.104
MINIMUM Y	:	-1.153	-1.194	-1.061
CENTROID X	:	.047	-.092	-.029
CENTROID Y	:	-.014	.027	-.106
POR TO CENTROID in.	:	.049	.096	.110
MIN RADIUS	:	.559	.547	.456
MEAN RADIUS	:	.907	.855	.809
MAX RADIUS	:	1.307	1.235	1.176
HORIZONTAL SPREAD	:	1.902	1.083	1.018
VERTICAL SPREAD	:	2.261	2.261	2.165
EXTREME SPREAD	:	2.408	2.324	2.311
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534545

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.138

VS= 2.036

GS= 2.333

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.113	.661	.575
MINIMUM X	:	-1.025	-.901	-.987
MAXIMUM Y	:	.981	.927	1.024
MINIMUM Y	:	-1.055	-1.109	-1.012
CENTROID X	:	.116	-.008	.078
CENTROID Y	:	.038	.092	-.005
POA TO CENTROID in.	:	.122	.092	.078
MIN RADIUS	:	.114	.101	.150
MEAN RADIUS	:	.807	.757	.719
MAX RADIUS	:	1.216	1.168	1.090
HORIZONTAL SPREAD	:	2.138	1.562	1.562
VERTICAL SPREAD	:	2.036	2.036	2.036
EXTREME SPREAD	:	2.333	2.196	2.070
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	