

C6587739

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

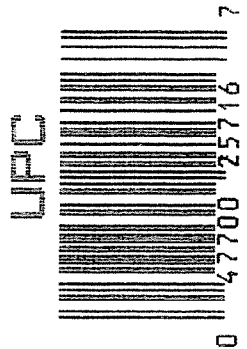
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

MODEL 700™ M24

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

SERIAL NO. C6587739	ORDER NO. 5716
-------------------------------	---------------------------------

01



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587739

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KS
600	Proof		10/18/90	KS
607	Check Headspace		10/18/90	KS
610	Dis-assemble Gun		10/18/90	KS
612	Magnaflux Barrel Action		10/22	KR
	Magnaflux Bolt		10/22	KR
615	Rollmark Caliber		10/22	KS
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11-6-90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	KS
	C) Inspect Ejector Hole for Chamfer		11-6-90	KS
	D) Oil Firing Pin Ass'y		11-6-90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/13/90	GS

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5.0	4.3/4	4.3/4	11/7/90	KS		
	G) Safety Off Force	2.3/4	3.0	3.1/4	11/7/90	KS		
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.022	.023	11/7/90	KS		
	J) Assemble Stock				11/13/90	KS		
	K) Assemble Swivel Studs				11-19-90	DH		
	L) Attach Front and Rear Sight Assemblies				11/13/90	KS		
	M) Iron Sight Alignment				11/13/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				11/13/90	KS		
	O) Attach Scope to Rifle				11/13/90	KS		
	P) Detach & Attach Scope 20 Times				11/13/90	KS		
640	Gallery Target & Test				11-14-90	KT		
	A) Time				11-14-90	KT		
	B) Malfunctions				11-14-90	KT		
	C) Pierced Primers				11-14-90	KT		
	D) Optical Clarity of Scope				11-14-90	KT		
645	Inspect for Live Ammo				11-14-90	KT		
655	Final Inspection							
	A) Headspace				11-19-90	DH		
	B) Trigger Pull	2.61	2.65	2.69	2.65	2.71	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12/18/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587739

DATE 13/NOV/90

TESTER Q28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	235	232	284	261	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	243	239	268	265	
PULL #3	235	253	278	269	
PULL #4	240	255	263	265	
PULL #5	234	245	260	271	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	295	318		
PULL #2	301	307		
PULL #3	303	299		
PULL #4	317	307		
PULL #5	299	297		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.00		4.16
PULL #2	4.10	4.03		4.13
PULL #3	4.05	4.08		4.14
PULL #4	4.05	4.02		4.13
PULL #5	3.98	4.04		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587739
15 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.302513
1 TO	2	.372839
1 TO	3	.460926
1 TO	4	.297108
1 TO	5	.367147

41 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0086
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0130384

THE AMR FOR THIS RIFLE IS: 1.01

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.876

VS = 2.627

GS = 3.686

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.087	1.002	.960
MINIMUM X	-.789	-.557	-.599
MAXIMUM Y	1.428	1.163	1.041
MINIMUM Y	-1.199	-1.040	-1.162
CENTROID X	.295	.063	.105
CENTROID Y	.067	-.092	.030
POA TO CENTROID in.	.303	.111	.109
MIN RADIUS	.297	.423	.450
MEAN RADIUS	1.004	.800	.757
MAX RADIUS	2.529	1.163	1.173
HORIZONTAL SPREAD	2.876	1.559	1.559
VERTICAL SPREAD	2.627	2.203	2.203
EXTREME SPREAD	3.686	2.206	2.206
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

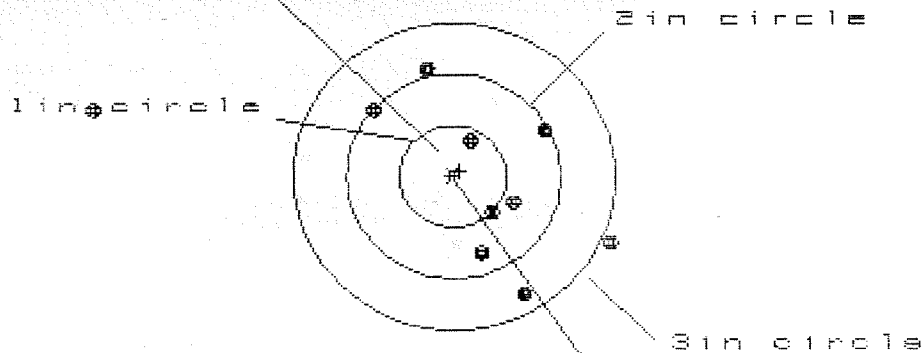
15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 4.769

VS = 2.191

GS = 4.978

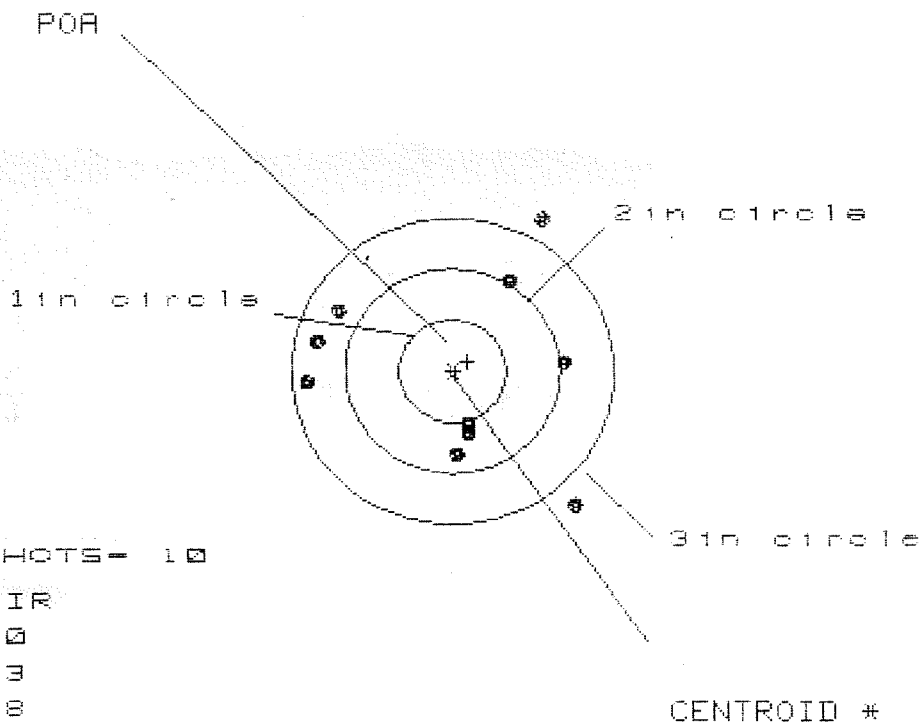
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.464	1.095	.592
MINIMUM X	-3.325	-1.077	-.940
MAXIMUM Y	1.016	1.091	1.016
MINIMUM Y	-1.175	-1.100	-1.175
CENTROID X	-.058	.311	.174
CENTROID Y	-.053	-.128	-.053
POA TO CENTROID in.	.079	.337	.182
MIN RADIUS	.327	.226	.326
MEAN RADIUS	1.151	.806	.759
MAX RADIUS	3.393	1.304	1.268
HORIZONTAL SPREAD	4.789	2.172	1.532
VERTICAL SPREAD	2.191	2.191	2.191
EXTREME SPREAD	4.978	2.553	2.385
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.437

VS = 2.855

CS = 2.910

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.091
MINIMUM X	-1.346
MAXIMUM Y	1.507
MINIMUM Y	-1.348
CENTROID X	-0.138
CENTROID Y	-0.091
POA TO CENTROID in.	.166
MIN RADIUS	.509
MEAN RADIUS	1.139
MAX RADIUS	1.734
HORIZONTAL SPREAD	2.437
VERTICAL SPREAD	2.855
EXTREME SPREAD	2.910
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587739

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.294

VS = 4.055

CS = 4.074

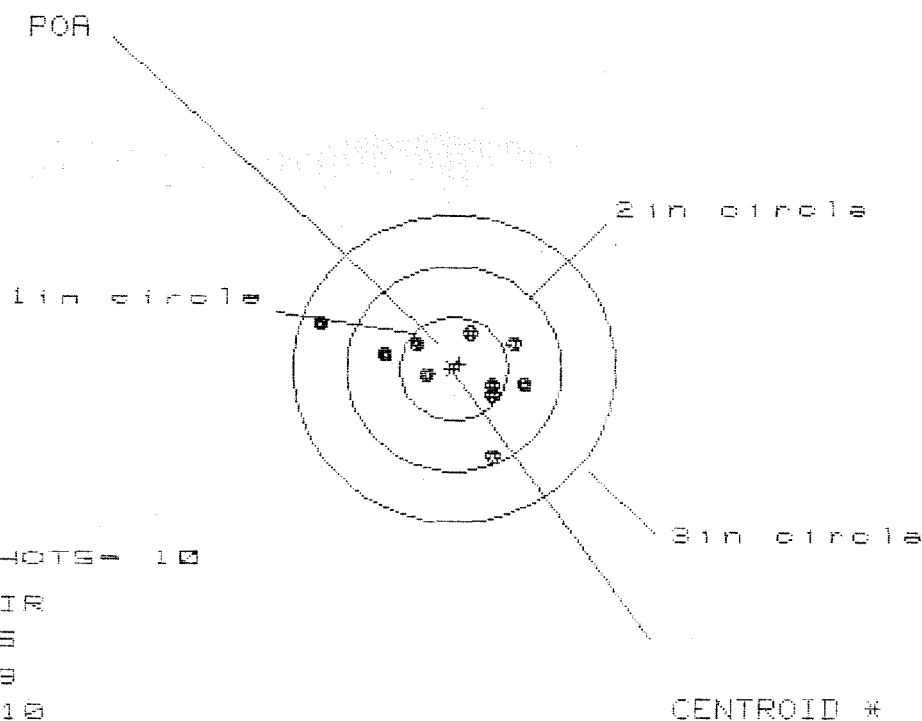
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.423	1.326	.723
MINIMUM X	-.871	-.930	-.764
MAXIMUM Y	1.169	.848	.795
MINIMUM Y	-2.886	-1.375	-1.428
CENTROID X	-.002	.095	-.071
CENTROID Y	.075	.396	.449
POA TO CENTROID in.	.075	.407	.455
MIN RADIUS	.199	.245	.203
MEAN RADIUS	1.146	.864	.771
MAX RADIUS	3.015	1.392	1.428
HORIZONTAL SPREAD	2.294	2.256	1.487
VERTICAL SPREAD	4.055	2.223	2.223
EXTREME SPREAD	4.074	2.452	2.257
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = 1.939

VS = 1.295

GS = 2.078

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.691	.552	.582
MINIMUM X	-1.248	-.771	-.741
MAXIMUM Y	.441	.411	.310
MINIMUM Y	-.854	-.805	-.272
CENTROID X	-.054	.085	.055
CENTROID Y	-.047	-.096	.085
POA TO CENTROID in.	.071	.128	.055
MIN RADIUS	.295	.249	.317
MEAN RADIUS	.609	.508	.462
MAX RADIUS	1.324	.840	.745
HORIZONTAL SPREAD	1.939	1.323	1.323
VERTICAL SPREAD	1.295	1.216	.582
EXTREME SPREAD	2.078	1.408	1.354
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		