

C6649058

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

Remington®

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

DUPONT

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

MODEL 700™ H24

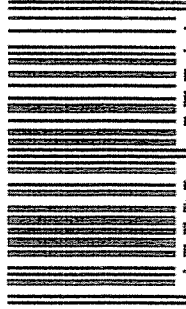
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

SERIAL NO.
C6649058

ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6649058

GUN SERIAL # C6649058

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25		RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GL
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	GL

Op. #	BARBER-M24 0031163	REMARKS						
625 cont.	F) Safety On Force	4 1/4	4	4	8/26/91	DH		
	G) Safety Off Force	2	2	2	8/26/91	DH		
	H) Trigger Pull Test & Retainability				8/26/91	JU		
	I) Firing Pin Indent	.021	.022	.021	8/26/91	DH		
	J) Assemble Stock							
	K) Assemble Swivel Studs				8-31-91	NH		
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test				8-31-91	DH		
	A) Time				8-31-91	NH		
	B) Malfunctions				8-31-91	NH		
	C) Pierced Primers				8-31-91	NH		
	D) Optical Clarity of Scope				8-31-91	NH		
645	Inspect for Live Ammo				8-31-91	NH		
655	Final Inspection				8-31-91	NH		
	A) Headspace							
	B) Trigger Pull	2.33	2.38	2.28	2.20	2.29	8/29/91	JU
	C) Function						8-31-91	DH
660	Pack						9-11-91	NH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649058

DATE 8-26-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.26	2.38	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.27	2.35	2.238	
PULL #3	2.56	2.23	2.26	2.28	
PULL #4	2.20	2.37	2.36	2.20	
PULL #5	2.32	2.34	2.40	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.35		
PULL #2	3.54	3.47		
PULL #3	3.35	3.53		
PULL #4	3.43	3.55		
PULL #5	3.48	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.32		4.29
PULL #2	4.33	4.35		4.34
PULL #3	4.44	4.27		4.16
PULL #4	4.30	4.24		4.23
PULL #5	4.35	4.28		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649050
27 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.474233
1 TO	2	.622896
1 TO	3	.681382
1 TO	4	.732719
1 TO	5	.294457

451
tc <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0548
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.04
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0678457
THE AMR FOR THIS RIFLE IS: .9782

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6549050

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 1.746

VS= 2.783

GS= 2.833

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.898	.863	.752
MINIMUM X	-.848	-.883	-.750
MAXIMUM Y	1.252	1.082	.767
MINIMUM Y	-1.531	-1.294	-1.159
CENTROID X	.376	.411	.522
CENTROID Y	.289	.459	.324
POA TO CENTROID in.	.474	.616	.614
MIN RADIUS	.024	.187	.174
MEAN RADIUS	.924	.848	.776
MAX RADIUS	1.564	1.426	1.258
HORIZONTAL SPREAD	1.746	1.746	1.502
VERTICAL SPREAD	2.783	2.376	1.926
EXTREME SPREAD	2.833	2.801	2.177
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

27 Aug 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 8

HS = 3.806

VS = 1.551

GS = 3.807

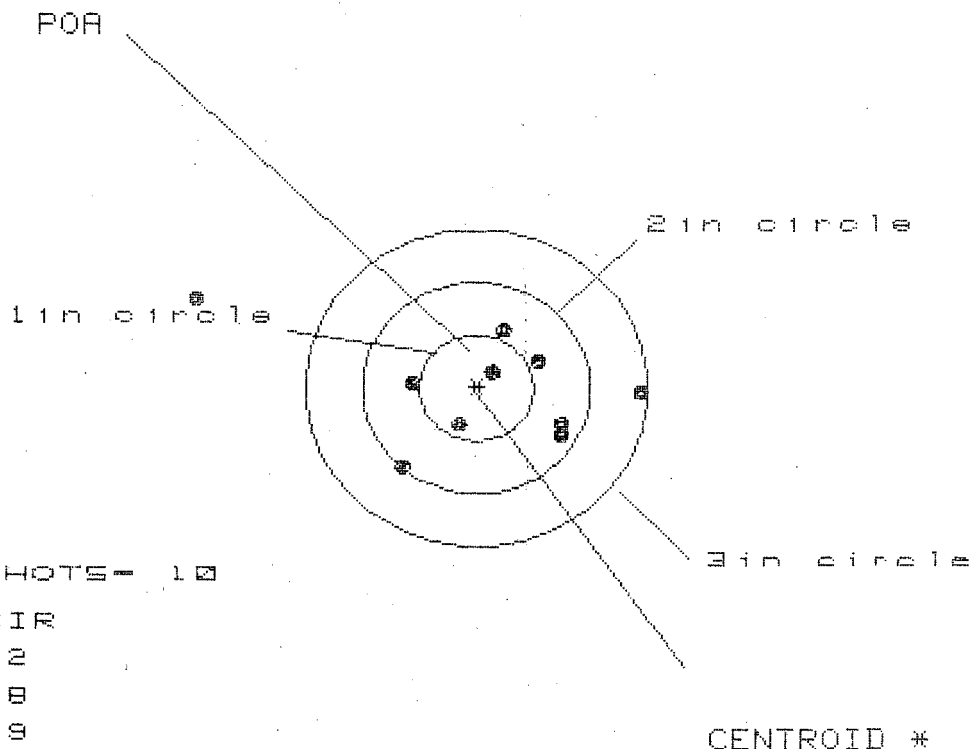
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.743	1.513	1.215
MINIMUM X	-2.063	-1.071	-.881
MAXIMUM Y	.840	.786	.705
MINIMUM Y	-.711	-.765	-.846
CENTROID X	.052	.282	.092
CENTROID Y	-.243	-.189	-.108
POA TO CENTROID in.	.248	.339	.142
MIN RADIUS	.205	.313	.145
MEAN RADIUS	.892	.781	.588
MAX RADIUS	2.120	1.645	1.225
HORIZONTAL SPREAD	3.806	2.584	2.096
VERTICAL SPREAD	1.551	1.551	1.551
EXTREME SPREAD	3.807	2.688	2.103
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

27 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 3.891

VS = 1.603

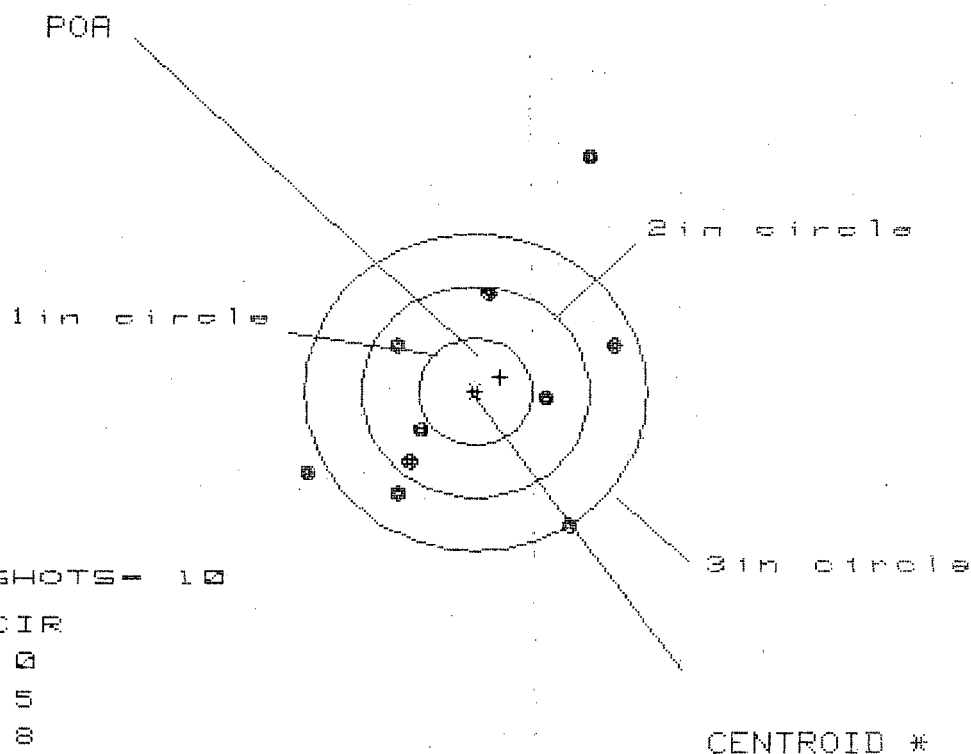
GS = 4.003

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.438
MINIMUM X	-2.453
MAXIMUM Y	.892
MINIMUM Y	-.711
CENTROID X	-.140
CENTROID Y	-.156
POA TO CENTROID in.	.210
MIN RADIUS	.237
MEAN RADIUS	.909
MAX RADIUS	2.610
HORIZONTAL SPREAD	3.891
VERTICAL SPREAD	1.603
EXTREME SPREAD	4.003
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

27 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.669

VS = 3.432

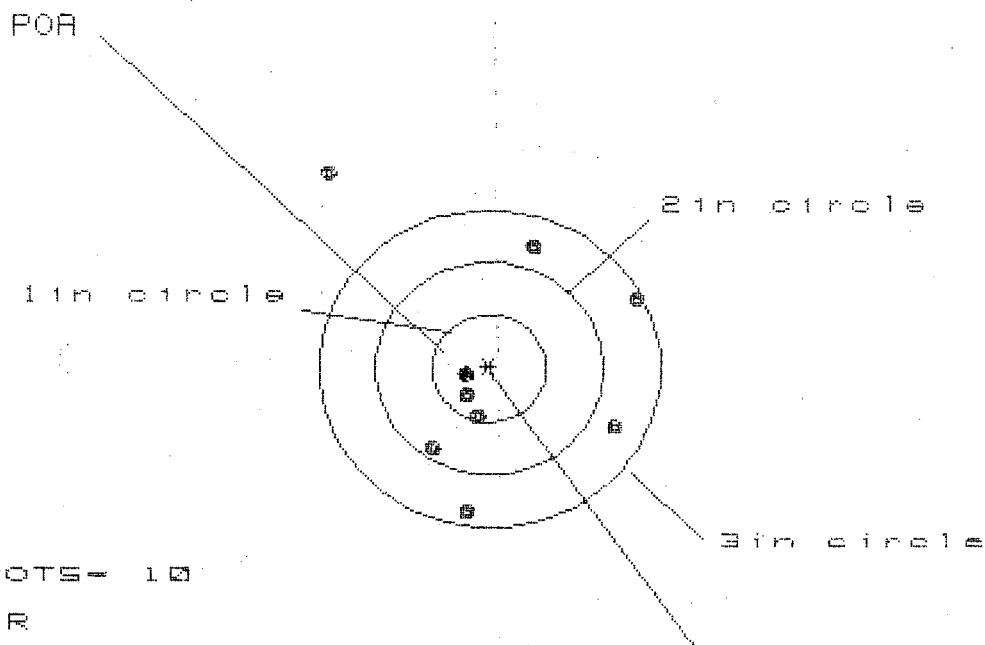
GS = 3.844

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.231	1.345	1.180
MINIMUM X	-1.438	-1.324	-0.713
MAXIMUM Y	2.220	1.152	1.092
MINIMUM Y	-1.212	-0.965	-1.025
CENTROID X	-0.218	-0.332	-0.167
CENTROID Y	-0.140	-0.387	-0.327
POA TO CENTROID in.	0.259	0.510	0.367
MIN RADIUS	0.608	0.382	0.558
MEAN RADIUS	1.181	0.997	0.955
MAX RADIUS	2.447	1.506	1.331
HORIZONTAL SPREAD	2.669	2.669	1.893
VERTICAL SPREAD	3.432	2.117	2.117
EXTREME SPREAD	3.844	2.909	2.373
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.343	1.190	1.116
MINIMUM X	-1.376	-.688	-.540
MAXIMUM Y	1.803	1.351	1.461
MINIMUM Y	-1.377	-1.177	-1.067
CENTROID X	.204	.357	.209
CENTROID Y	.050	-.150	-.260
POA TO CENTROID in.	.210	.387	.334
MIN RADIUS	.182	.356	.198
MEAN RADIUS	.985	.835	.683
MAX RADIUS	2.268	1.481	1.522
HORIZONTAL SPREAD	2.719	1.878	1.656
VERTICAL SPREAD	3.180	2.528	2.528
EXTREME SPREAD	3.463	2.607	2.607
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		