

C6636302

MODEL 700™ M24

Model **S&S**™

Action

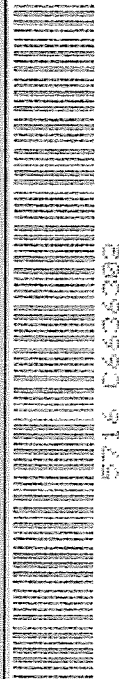
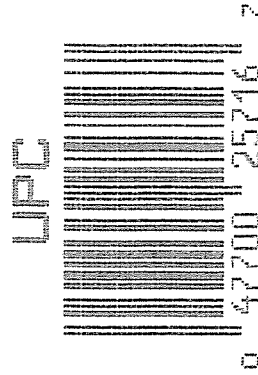
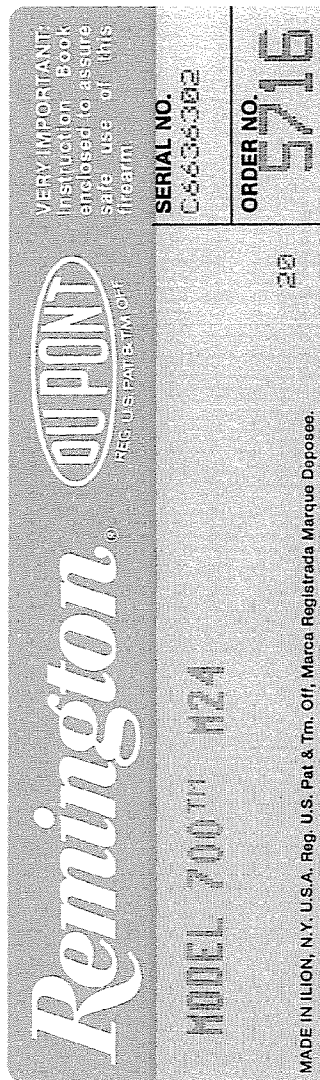
Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington®



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636302

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KL
600	Proof		6/25/91	KL
607	Check Headspace		6/25/91	KL
610	Dis-assemble Gun		6/25/91	KL
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	LS
	Apply Coating (Bolt)			LS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-30-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5.2	5			7-30-91	DH
	G) Safety Off Force	3.2	3.2	3.2			7-30-91	DH
	H) Trigger Pull Test & Retainability						7-30-91	84
	I) Firing Pin Indent	.021	.021	.022			7-30-91	11H
	J) Assemble Stock						7/30/91	KH
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/30/91	KH
	M) Iron Sight Alignment						7/30/91	KH
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	KH
	O) Attach Scope to Rifle						7/30/91	KH
	P) Detach & Attach Scope 20 Times						7/30/91	KH
640	Gallery Target & Test						7/30/91	KH
	A) Time							KH
	B) Malfunctions							KH
	C) Pierced Primers							KH
	D) Optical Clarity of Scope							KH
645	Inspect for Live Ammo						7/30/91	KH
655	Final Inspection							
	A) Headspace						8-5-91	AC
	B) Trigger Pull	2.33	2.20	2.28	2.32	2.33	8-5-91	JH
	C) Function						8-5-91	AC
660	Pack						9-11-91	AC

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

SERIAL NO. C-6636302DATE 7-30-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.65	2.20	2.54	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.54	2.50	2.20	
PULL #3	2.30	2.45	2.48	2.28	
PULL #4	2.18	2.47	2.50	2.32	
PULL #5	2.25	2.55	2.54	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.45		
PULL #2	3.44	3.43		
PULL #3	3.47	3.47		
PULL #4	3.46	3.47		
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	4.43	4.39		4.49
PULL #2	4.41	4.34		4.48
PULL #3	4.41	4.35		4.43
PULL #4	4.40	4.40		4.48
PULL #5	4.27	4.29		4.46
TOTAL				
AVG.				

DISTANCE CALCULATIONS

FILE # 06636302

(72)

SCIDAL DISTANCES

1	.168428
2	.12912
3	.272767
4	.348279
5	.224154

<----FOR

SCIDAL COORDINATE FOR THIS RIFLE IS: -.062

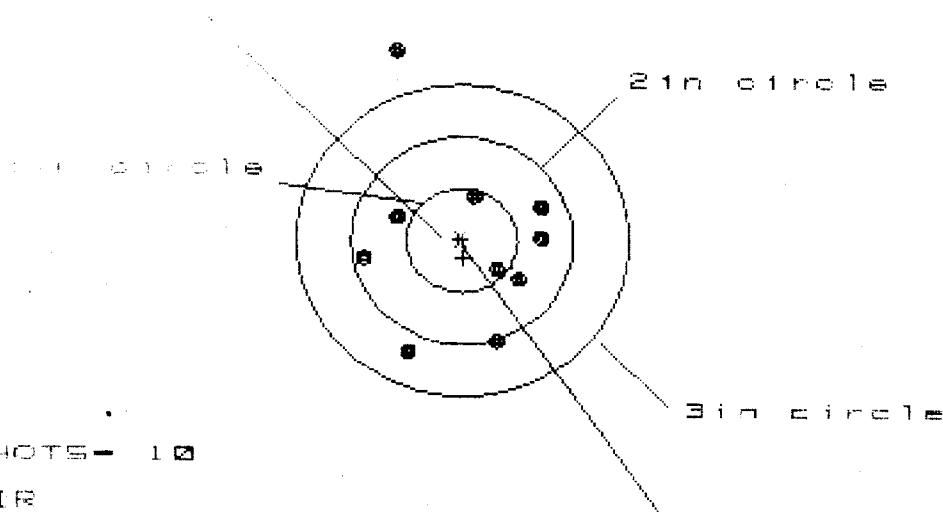
SCIDAL COORDINATE FOR THIS RIFLE IS: -.0062

SCIDAL AVERAGE POI RADIUS FOR THIS RIFLE IS: .0623092

SCIDAL FOR THIS RIFLE IS: .951

PATTERNING/CENTERFIRE_PATT/C6636302

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 8

3 in - 9

MEAN - 1.631

MS - 2.929

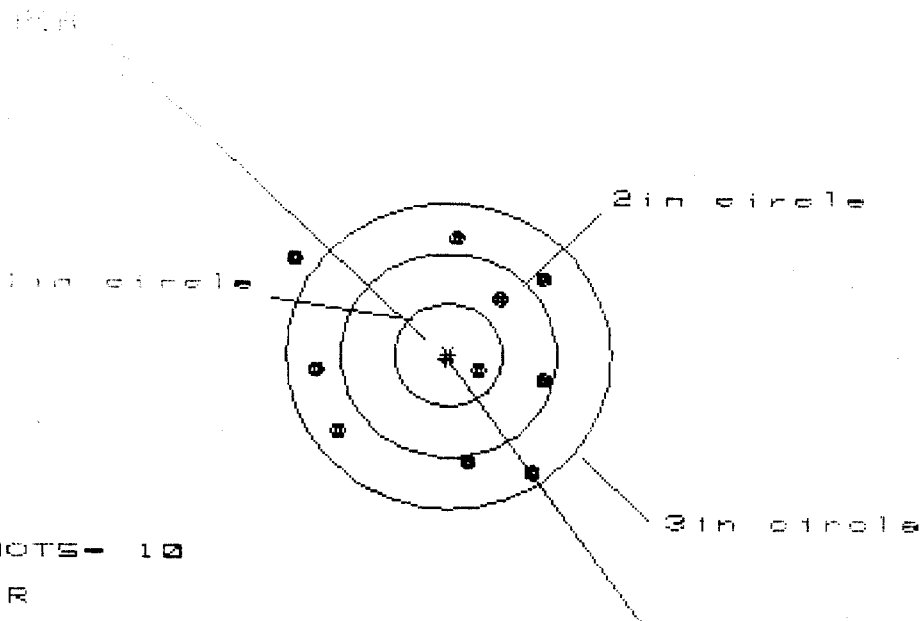
MS - 2.931

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.715	.646	.572
MINIMUM X	-.916	-.985	-1.059
MAXIMUM Y	1.812	.615	.500
MINIMUM Y	-1.117	-.916	-.840
CENTROID X	-.012	.057	.131
CENTROID Y	.168	-.033	.082
POA TO CENTROID in.	.169	.066	.154
1 in RADIUS	.419	.278	.253
MEAN RADIUS	.870	.727	.657
MS RADIUS	1.915	1.091	1.060
HORIZONTAL SPREAD	1.631	1.631	1.631
VERTICAL SPREAD	2.929	1.531	1.340
EXTREME SPREAD	2.931	1.912	1.699
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.323

VS= 2.341

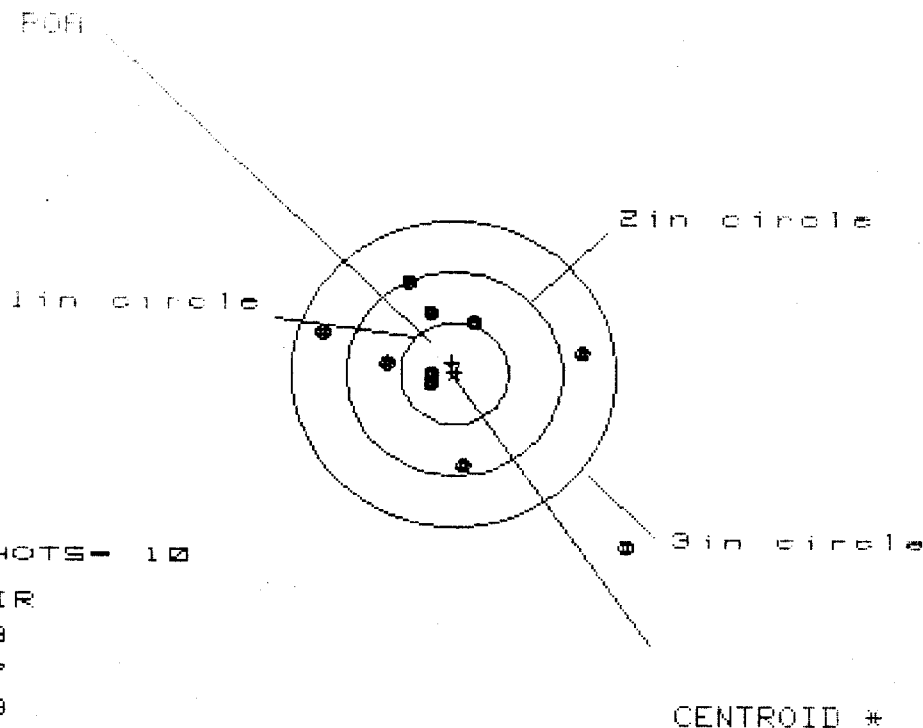
GS= 3.042

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.893	.735	.812
MINIMUM X	:	-1.430	-1.366	-1.289
MAXIMUM Y	:	1.203	1.309	1.180
MINIMUM Y	:	-1.138	-1.032	-1.105
CENTROID X	:	.024	.182	.105
CENTROID Y	:	.044	-.062	.067
PQR TO CENTROID in.	:	.050	.193	.124
MIN RADIUS	:	.293	.106	.237
MEAN RADIUS	:	1.098	.987	.969
MAX RADIUS	:	1.719	1.367	1.337
HORIZONTAL SPREAD	:	2.323	2.101	2.101
VERTICAL SPREAD	:	2.341	2.341	2.285
EXTREME SPREAD	:	3.042	2.431	2.430
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.771

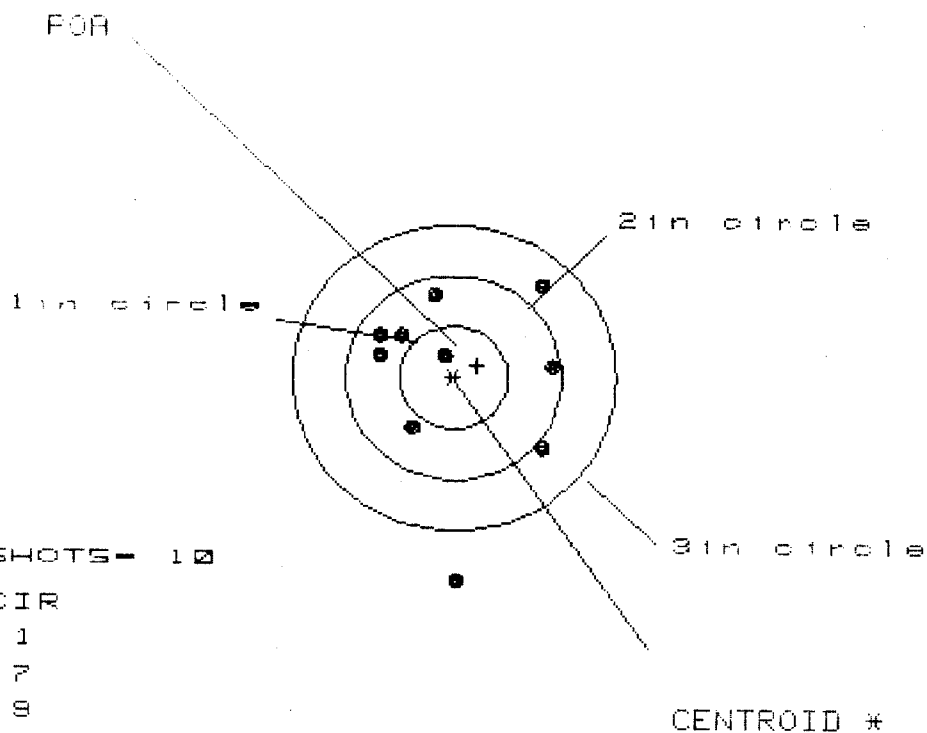
VS= 2.509

GS= 3.454

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.562	1.333	1.204
MINIMUM X	-1.209	-1.036	-.598
MAXIMUM Y	.859	.675	.704
MINIMUM Y	-1.650	-1.122	-1.093
CENTROID X	.019	-.154	-.025
CENTROID Y	-.103	.081	.052
POI TO CENTROID in.	.104	.174	.058
MIN RADIUS	.206	.168	.211
MEAN RADIUS	.889	.674	.637
MAX RADIUS	2.272	1.333	1.204
HORIZONTAL SPREAD	2.771	2.369	1.802
VERTICAL SPREAD	2.509	1.797	1.797
EXTREME SPREAD	3.454	2.381	1.865
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.662

VS= 2.913

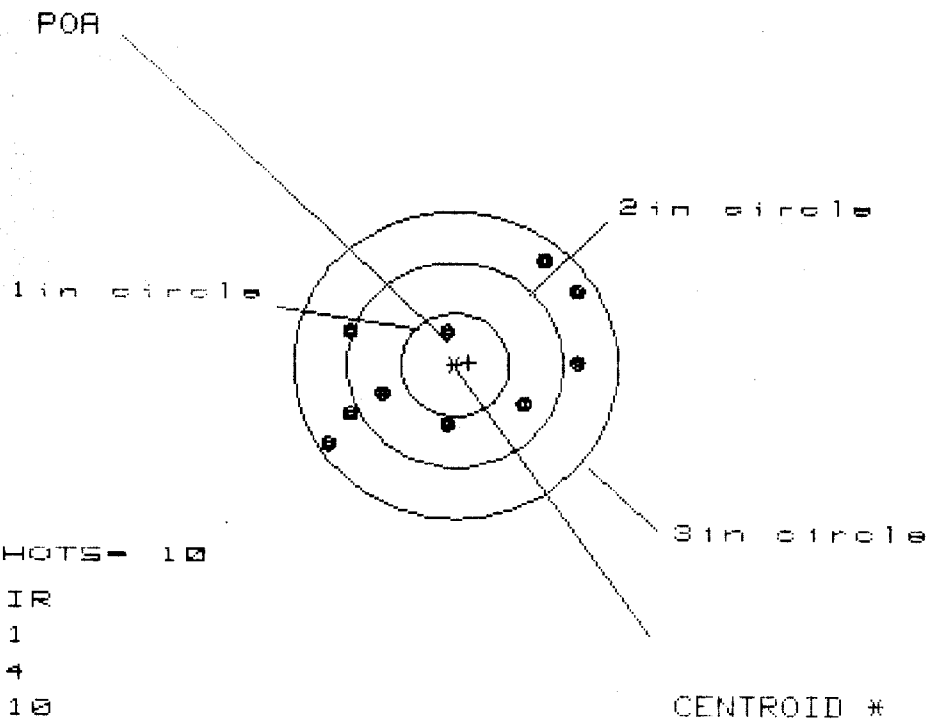
GS= 3.001

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.936	.942	1.040
MINIMUM X	-.726	-.720	-.622
MAXIMUM Y	.921	.700	.711
MINIMUM Y	-1.992	-.950	-.863
CENTROID X	-.215	-.221	-.319
CENTROID Y	-.115	.106	.019
POA TO CENTROID in.	.244	.245	.319
MIN RADIUS	.275	.092	.127
MEAN RADIUS	.930	.760	.710
MAX RADIUS	1.993	1.281	1.288
HORIZONTAL SPREAD	1.662	1.662	1.662
VERTICAL SPREAD	2.913	1.650	1.574
EXTREME SPREAD	3.001	1.967	1.967
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

30 Jul 1991

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CENTERFIRE PATTERNS # 5



HS= 2.316
 VS= 1.750
 GS= 2.726

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.173	1.046	1.177
MINIMUM X	-1.143	-1.089	-.958
MAXIMUM Y	.992	.908	.984
MINIMUM Y	-.758	-.618	-.542
CENTROID X	-.126	.001	-.130
CENTROID Y	-.025	.060	-.016
POR TO CENTROID in.	.129	.060	.131
MIN RADIUS	.359	.338	.350
MEAN RADIUS	.968	.924	.869
MAX RADIUS	1.371	1.204	1.318
HORIZONTAL SPREAD	2.316	2.135	2.135
VERTICAL SPREAD	1.750	1.526	1.526
EXTREME SPREAD	2.726	2.404	2.329
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		