

6611700

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Remington[®]


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

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

MODEL 700TM N24

SERIAL NO.
C6611700

ORDER NO.
5716

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

20



5716 C6611700



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611700

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	JS
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/4/91	RF
	G) Safety Off Force	3	3	3			3/4/91	RF
	H) Trigger Pull Test & Retainability						3/2/91	RF
	I) Firing Pin Indent	.022	.022	.022			3/4/91	RF
	J) Assemble Stock						3/5/91	RW
	K) Assemble Swivel Studs						3-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/5/91	RW
	M) Iron Sight Alignment						3/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	RW
	O) Attach Scope to Rifle						3/5/91	RW
	P) Detach & Attach Scope 20 Times						3/5/91	RW
640	Gallery Target & Test						3-5-91	NF
	A) Time							NF
	B) Malfunctions							NF
	C) Pierced Primers							NF
	D) Optical Clarity of Scope							NF
645	Inspect for Live Ammo						3-5-91	NF
655	Final Inspection							
	A) Headspace						3-8-91	D/H
	B) Trigger Pull	2.44	2.43	2.46	2.54	2.56	3/8/91	RF
	C) Function						3-8-91	D/H
660	Pack						3/5-91	D/H

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

SERIAL NO. C6611700DATE 3/2/91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.47	2.41	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.35	2.34	2.43	
PULL #3	2.23	2.33	2.31	2.46	
PULL #4	2.30	2.10	2.21	2.54	
PULL #5	2.29	2.30	2.28	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.41		
PULL #2	3.54	3.54		
PULL #3	3.52	3.40		
PULL #4	3.52	3.45		
PULL #5	3.35	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.29		4.21
PULL #2	4.28	4.23		4.24
PULL #3	4.31	4.30		4.19
PULL #4	4.25	4.28		4.28
PULL #5	4.34	4.22		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611700
6 Mar 1991

CENTROIDAL DISTANCES

Ø TO	1	.229
1 TO	2	.266648
1 TO	3	.472331
1 TO	4	.393742
1 TO	5	.196573

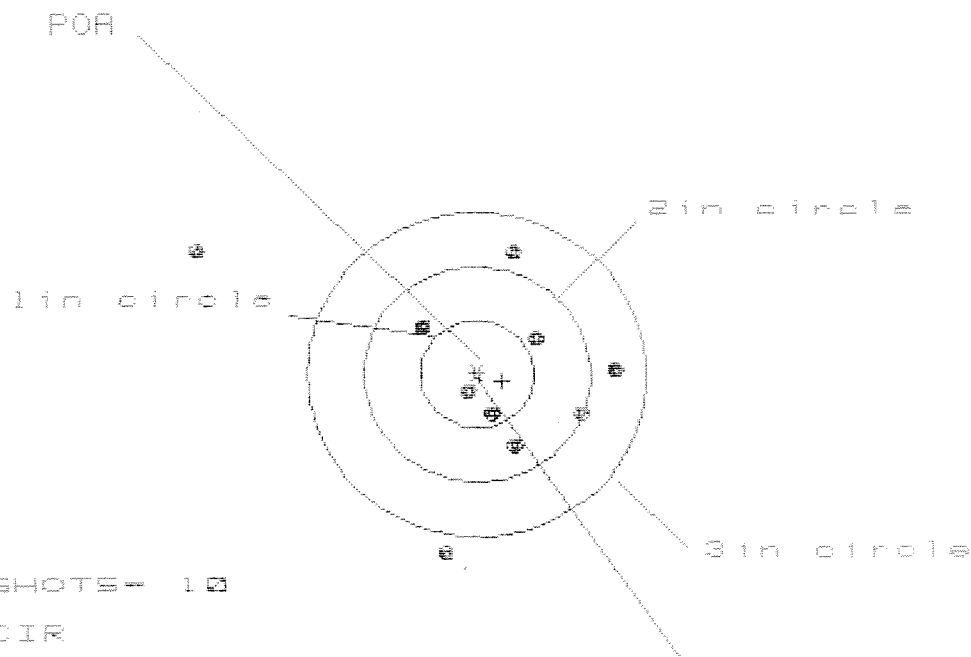
5a
7a <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120606
THE AMR FOR THIS RIFLE IS: .997

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C 6611700

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.666

VS= 2.817

GS= 3.835

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.183	.997	.843
MINIMUM X	-2.483	-.774	-.838
MAXIMUM Y	1.182	1.387	1.118
MINIMUM Y	-1.635	-1.510	-.717
CENTROID X	-.221	.055	.119
CENTROID Y	.060	-.065	.124
POA TO CENTROID in.	.229	.085	.171
MIN RADIUS	.161	.301	.327
MEAN RADIUS	1.033	.797	.699
MAX RADIUS	2.725	1.593	1.119
HORIZONTAL SPREAD	3.666	1.681	1.681
VERTICAL SPREAD	2.817	2.817	1.835
EXTREME SPREAD	3.835	2.866	1.835
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C 6811700

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.755

VS= 2.203

GS= 2.215

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.953	.853
MINIMUM X	:	-.815	-.802	-.799
MAXIMUM Y	:	1.085	.961	1.041
MINIMUM Y	:	-1.118	-.788	-.708
CENTROID X	:	.014	.001	.101
CENTROID Y	:	.186	.310	.230
POA TO CENTROID in.	:	.187	.310	.251
MIN RADIUS	:	.352	.380	.265
MEAN RADIUS	:	.844	.816	.772
MAX RADIUS	:	1.124	1.027	1.061
HORIZONTAL SPREAD	:	1.755	1.755	1.652
VERTICAL SPREAD	:	2.203	1.749	1.749
EXTREME SPREAD	:	2.215	1.921	1.826
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C 6611700

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 1.741

VS= 3.472

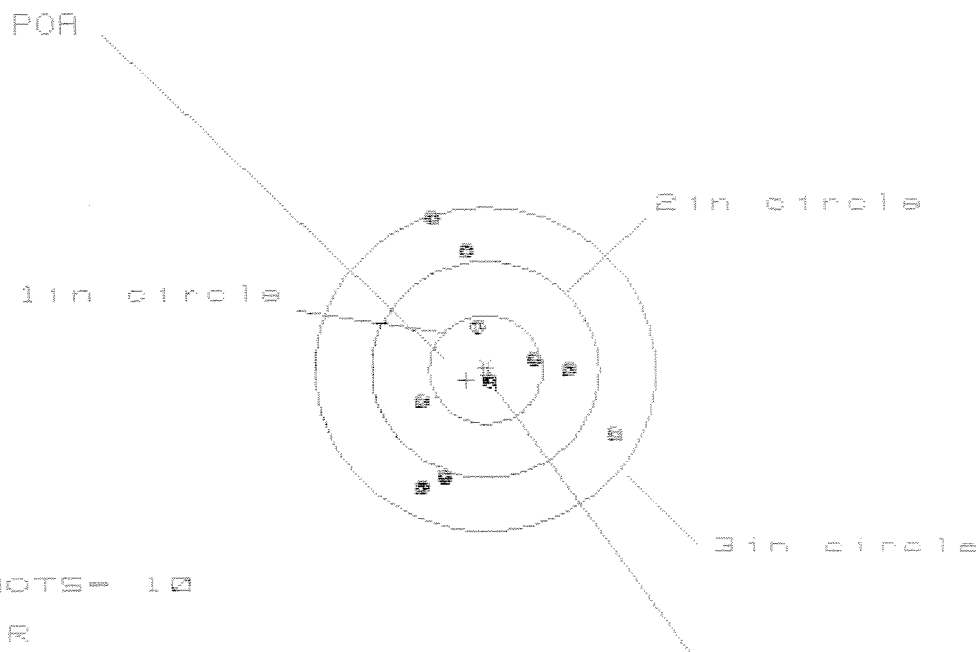
GS= 3.474

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.966	.973
MINIMUM X	:	-.770	-.775	-.768
MAXIMUM Y	:	1.560	1.348	.929
MINIMUM Y	:	-1.911	-1.543	-1.374
CENTROID X	:	.248	.253	.246
CENTROID Y	:	.004	.216	.047
POR TO CENTROID in.	:	.248	.333	.250
MIN RADIUS	:	.160	.060	.116
MEAN RADIUS	:	1.019	.868	.828
MAX RADIUS	:	1.912	1.588	1.423
HORIZONTAL SPREAD	:	1.741	1.741	1.741
VERTICAL SPREAD	:	3.472	2.891	2.303
EXTREME SPREAD	:	3.474	2.924	2.325
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C 6611700

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.665

VS= 2.494

GS= 2.513

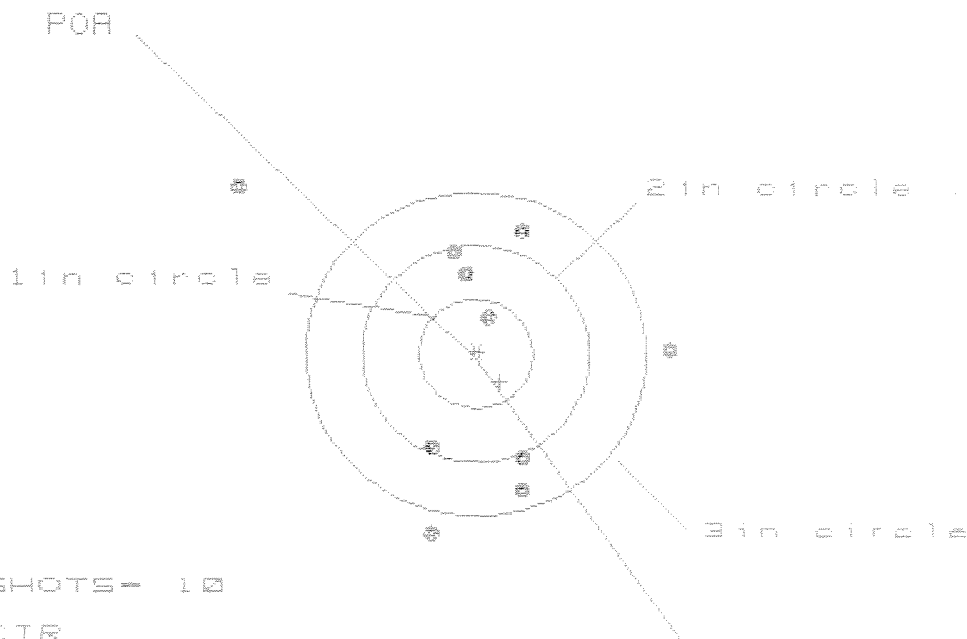
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	1.033	.780
MINIMUM X	-.582	-.632	-.502
MAXIMUM Y	1.424	1.278	1.227
MINIMUM Y	-1.070	-.912	-.963
CENTROID X	.171	.221	.091
CENTROID Y	.097	-.061	-.010
POA TO CENTROID in.	.196	.229	.092
MIN RADIUS	.066	.101	.104
MEAN RADIUS	.838	.764	.714
MAX RADIUS	1.493	1.303	1.234
HORIZONTAL SPREAD	1.665	1.665	1.282
VERTICAL SPREAD	2.494	2.190	2.190
EXTREME SPREAD	2.513	2.222	2.222
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C 6611700

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.849

VS= 3.174

GS= 4.112

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.750	1.517	.405
MINIMUM X	-2.099	-.591	-.402
MAXIMUM Y	1.527	1.304	1.335
MINIMUM Y	-1.647	-1.478	-1.447
CENTROID X	-.206	.027	-.162
CENTROID Y	.256	.087	.056
POA TO CENTROID in.	.329	.091	.172
MIN RADIUS	.345	.526	.537
MEAN RADIUS	1.251	1.097	1.024
MAX RADIUS	2.595	1.592	1.501
HORIZONTAL SPREAD	3.849	2.108	.807
VERTICAL SPREAD	3.174	2.782	2.782
EXTREME SPREAD	4.112	2.897	2.897
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611700

DATE 10-27-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.34	2.40		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.57	2.36		
PULL #3	2.59	2.61	2.31		
PULL #4	2.66	2.59	2.30		
PULL #5	2.41	2.44	2.30		
TOTAL	12.37	12.55	11.67		
AVG.	2.47	2.51	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	2.92		
PULL #2	3.07	2.98		
PULL #3	3.03	3.01		
PULL #4	3.05	2.97		
PULL #5	3.04	2.92		
TOTAL	15.41	14.80		
AVG.	3.08	2.96		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.03	3.97	
PULL #2	4.00	4.00	3.95	
PULL #3	4.03	4.20	3.98	
PULL #4	3.96	4.13	4.00	
PULL #5	4.09	4.14	4.02	
TOTAL	20.14	20.50	19.92	
AVG.	4.02	4.10	3.98	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611700

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			12/14	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			12/14	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.69	2.65	2.64	2.53	2.51	12/14	WB
	C) Function							
660	Pack							