

C5611809

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



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.
C6611809

ORDER NO.
5716

46



5716 C6611809



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611809

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	Y
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	RY

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	7	7			4-22-91	D/H
	G) Safety Off Force	3	3 1/2	3			4-22-91	D/H
	H) Trigger Pull Test & Retainability						4/22/91	RU
	I) Firing Pin Indent	.022	.021	.022			4-22-91	D/H
	J) Assemble Stock						4/23/91	RW
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/23/91	RW
	M) Iron Sight Alignment						4/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/91	RW
	O) Attach Scope to Rifle						4/23/91	RW
	P) Detach & Attach Scope 20 Times						4/23/91	RW
640	Gallery Target & Test						4-24-91	D/H
	A) Time						4-24-91	D/H
	B) Malfunctions						4-24-91	D/H
	C) Pierced Primers						4-24-91	D/H
	D) Optical Clarity of Scope						4-24-91	D/H
645	Inspect for Live Ammo						4-24-91	D/H
655	Final Inspection							
	A) Headspace						5-2-91	D/H
	B) Trigger Pull	2.15	2.12	2.14	2.21	2.24	4/26/91	RU
	C) Function						5-2-91	D/H
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611809

DATE 4/22/91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.44	2.20	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.28	2.25	2.12	
PULL #3	2.42	2.19	2.33	2.14	
PULL #4	2.40	2.21	2.20	2.21	
PULL #5	2.12	2.18	2.22	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.14		
PULL #2	3.42	3.22		
PULL #3	3.36	3.20		
PULL #4	3.35	3.19		
PULL #5	3.34	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.48		4.46
PULL #2	4.59	4.30		4.50
PULL #3	4.33	4.47		4.52
PULL #4	4.51	4.41		4.23
PULL #5	4.49	4.49		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611809
24 Apr 1991

CENTROIDAL DISTANCES

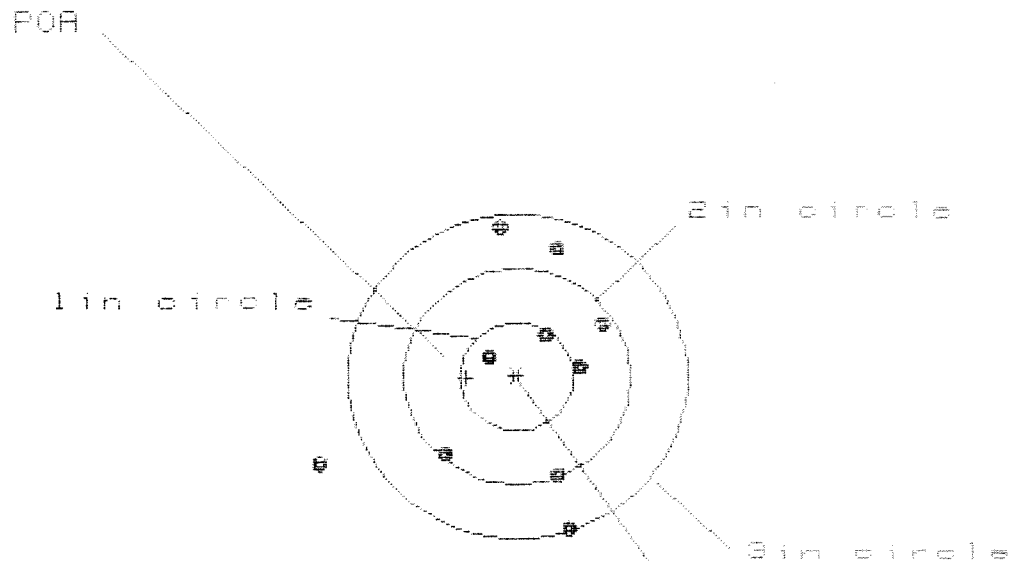
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1 TO 3	.839177
1 TO 4	1.17046
1 TO 5	.582168

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611889

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.503

VS = 2.799

GS = 2.949

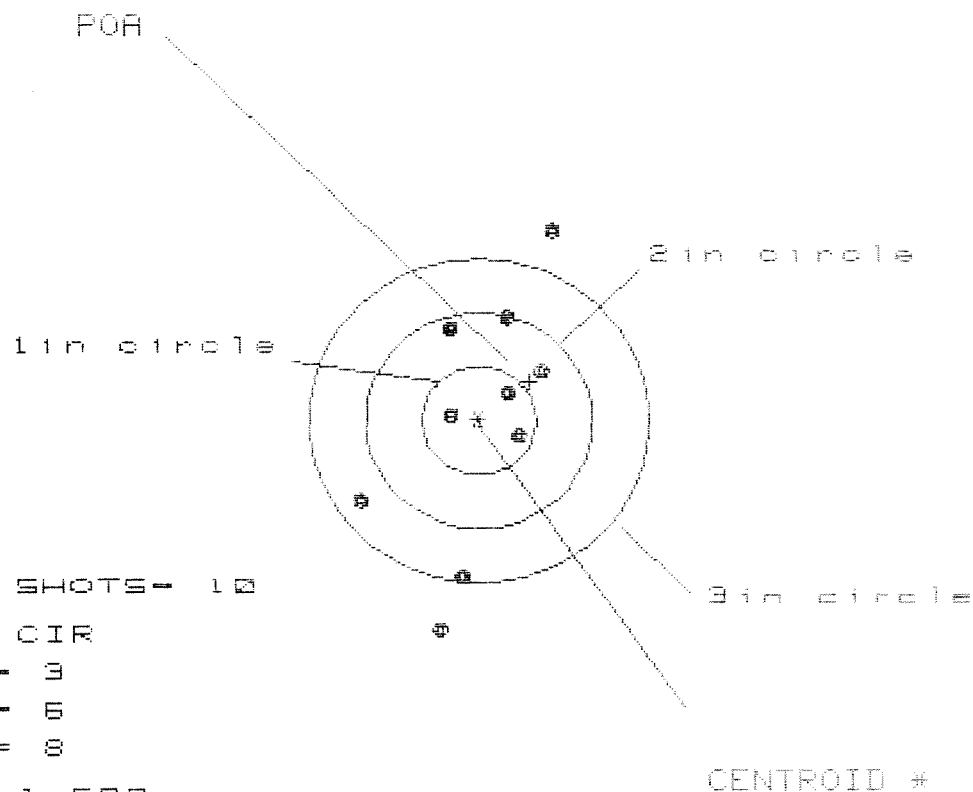
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.538	.564
MINIMUM X	:	-1.769	-.801	-.775
MAXIMUM Y	:	1.396	1.307	1.120
MINIMUM Y	:	-1.403	-1.492	-1.188
CENTROID X	:	.447	.643	.617
CENTROID Y	:	.012	.101	.288
POA TO CENTROID in.	:	.447	.651	.681
MIN RADIUS	:	.317	.319	.164
MEAN RADIUS	:	1.021	.879	.771
MAX RADIUS	:	1.942	1.507	1.232
HORIZONTAL SPREAD	:	2.503	1.339	1.339
VERTICAL SPREAD	:	2.799	2.799	2.308
EXTREME SPREAD	:	2.949	2.846	2.363
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=			9

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in - 8

HS= 1.699

VS= 3.638

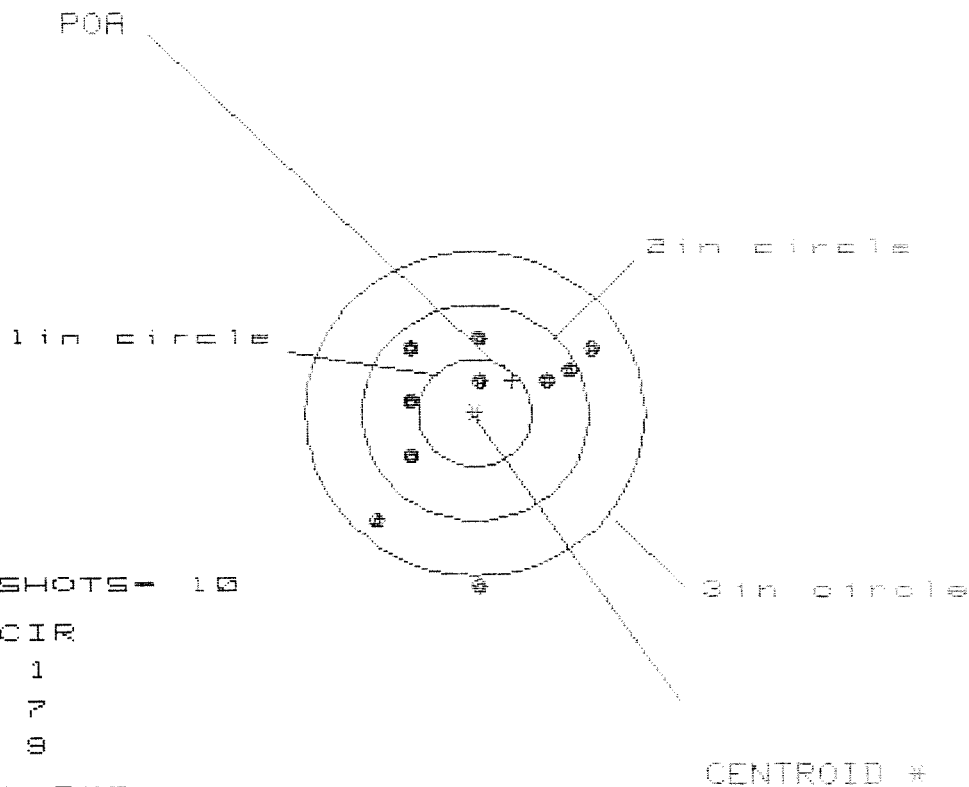
GS= 3.764

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.637	.601	.635
MINIMUM X	:	-1.062	-1.098	-1.023
MAXIMUM Y	:	1.719	1.506	.890
MINIMUM Y	:	-1.919	-1.668	-1.479
CENTROID X	:	-.449	-.413	-.488
CENTROID Y	:	-.358	-.145	-.334
POA TO CENTROID in.	:	.575	.438	.591
MIN RADIUS	:	.267	.197	.223
MEAN RADIUS	:	1.012	.870	.791
MAX RADIUS	:	1.947	1.680	1.485
HORIZONTAL SPREAD	:	1.699	1.699	1.658
VERTICAL SPREAD	:	3.638	3.174	2.369
EXTREME SPREAD	:	3.764	3.274	2.412
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.938

VS= 2.324

GS= 2.540

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.031	1.033	.920
MINIMUM X	:	-.907	-.905	-.680
MAXIMUM Y	:	.711	.531	.382
MINIMUM Y	:	-1.613	-1.194	-.729
CENTROID X	:	-.330	-.332	-.219
CENTROID Y	:	-.305	-.125	.024
POA TO CENTROID in.	:	.449	.355	.221
MIN RADIUS	:	.299	.125	.078
MEAN RADIUS	:	.888	.760	.637
MAX RADIUS	:	1.613	1.498	.991
HORIZONTAL SPREAD	:	1.938	1.938	1.600
VERTICAL SPREAD	:	2.324	1.725	1.111
EXTREME SPREAD	:	2.540	2.540	1.894
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 1.872

VS= 3.153

GS= 3.344

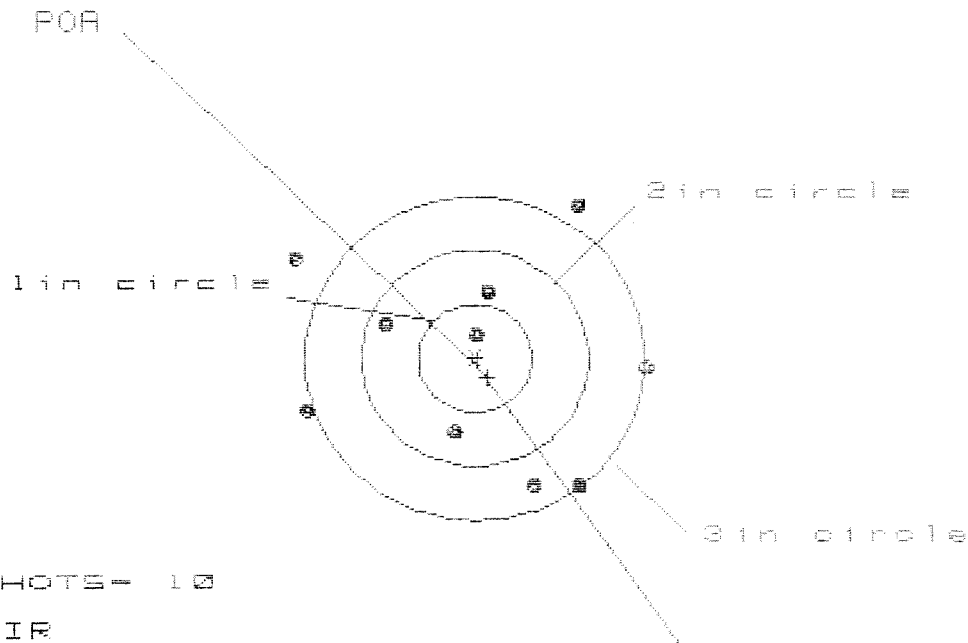
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.085	1.155	1.104
MINIMUM X	:	-.787	-.717	-.768
MAXIMUM Y	:	1.573	1.556	1.381
MINIMUM Y	:	-1.580	-1.405	-1.160
CENTROID X	:	-.211	-.281	-.238
CENTROID Y	:	-.956	-1.131	-.956
POA TO CENTROID in.	:	.979	1.166	.983
MIN RADIUS	:	.465	.581	.483
MEAN RADIUS	:	1.196	1.133	1.078
MAX RADIUS	:	1.695	1.575	1.412
HORIZONTAL SPREAD	:	1.872	1.872	1.872
VERTICAL SPREAD	:	3.153	2.961	2.541
EXTREME SPREAD	:	3.344	2.966	2.572
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 3.135

VS= 2.611

GS= 3.290

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.553	1.378	1.474
MINIMUM X	:	-1.582	-1.636	-1.540
MAXIMUM Y	:	1.415	1.517	.932
MINIMUM Y	:	-1.196	-1.094	-.904
CENTROID X	:	-.111	.064	-.032
CENTROID Y	:	.178	.076	-.114
POA TO CENTROID in.	:	.210	.099	.110
MIN RADIUS	:	.266	.423	.430
MEAN RADIUS	:	1.183	1.115	1.027
MAX RADIUS	:	1.831	1.700	1.552
HORIZONTAL SPREAD	:	3.135	3.014	3.014
VERTICAL SPREAD	:	2.611	2.611	1.836
EXTREME SPREAD	:	3.290	3.060	3.042
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	