

C6636094

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

DUPONT

MODEL 700™ M24

SERIAL NO. C6636094

ORDER NO. 5716

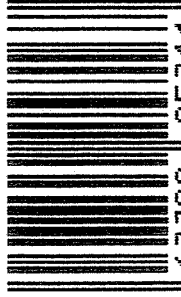
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636094

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636094

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action	APR 9 1991		KR
	Magnaflux Bolt	APR 9 1991		LC
615	Rollmark Caliber	APR 9 1991		LS.
617	Drill and Tap Sight Holes	APR 19 1991		LB
618	Polish Barrel	APR 19 1991		WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/28/91	JL

op. #	OP. NAME	BARBER M24 0037627	READINGS					DATE	INIT
625 cont.	F) Safety On Force		5	4 1/2	4 1/2			5-28-91	DH
	G) Safety Off Force		2	2	2			5-28-91	DH
	H) Trigger Pull Test & Retainability							5/28/91	SH
	I) Firing Pin Indent		.020	.020	.020			5-28-91	DH
	J) Assemble Stock							5/29/91	RW
	K) Assemble Swivel Studs							5-1-91	DH
	L) Attach Front and Rear Sight Assemblies							5/29/91	RW
	M) Iron Sight Alignment							5/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container							5/29/91	RW
	O) Attach Scope to Rifle							5/29/91	RW
	P) Detach & Attach Scope 20 Times							5/29/91	RW
640	Gallery Target & Test							5-31-91	DH
	A) Time							5-31-91	DH
	B) Malfunctions							5-31-91	DH
	C) Pierced Primers							5-31-91	DH
	D) Optical Clarity of Scope							5-31-91	DH
645	Inspect for Live Ammo							5-31-91	DH
655	Final Inspection								
	A) Headspace							6-1-91	DH
	B) Trigger Pull		2.18	2.15	2.20	2.21	2.20	6/1/91	SH
	C) Function							6-1-91	DH
660	Pack							6-20-91	RW

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636094

DATE 5/28/91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.43	2.46	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.24	2.49	2.15	
PULL #3	2.41	2.15	2.20	2.20	
PULL #4	2.31	2.57	2.58	2.21	
PULL #5	2.21	2.45	2.49	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.49		
PULL #2	3.32	3.43		
PULL #3	3.33	3.31		
PULL #4	3.37	3.39		
PULL #5	3.18	3.43		
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	4.44		4.38
PULL #2	4.44	4.39		4.26
PULL #3	4.50	4.44		4.33
PULL #4	4.37	4.40		4.33
PULL #5	4.38	4.48		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636094
31 May 1991

CENTROIDAL DISTANCES

0 TO	1	.395046
1 TO	2	.406185
1 TO	3	.538343
1 TO	4	.350051
1 TO	5	.349178

3
1 <----POA

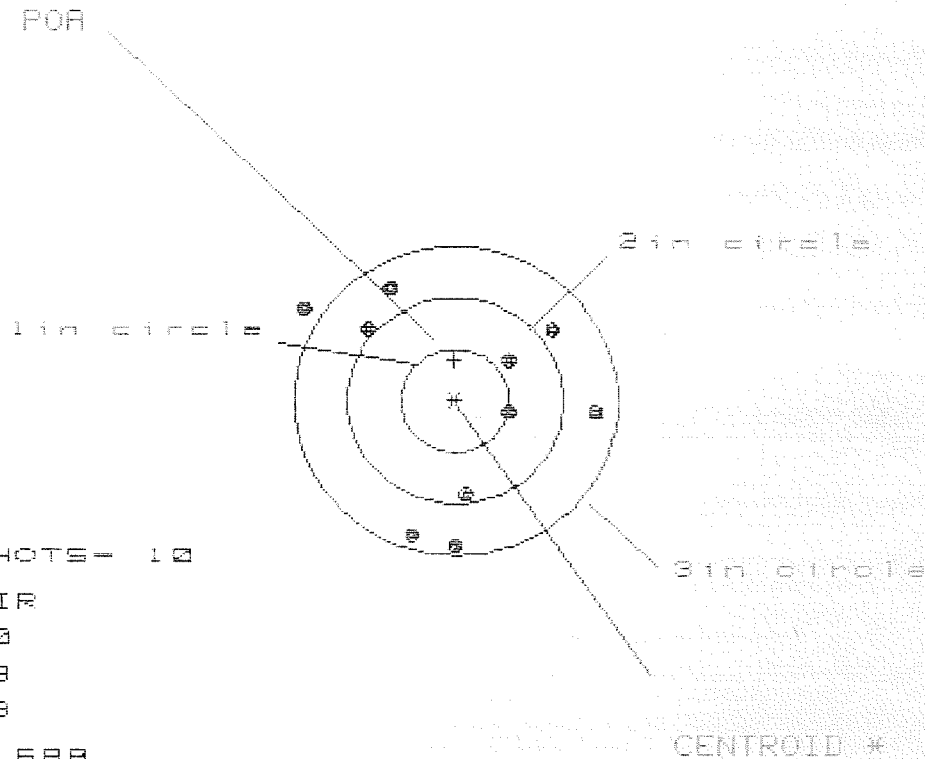
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0036
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0674
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0674961

THE AMR FOR THIS RIFLE IS: .9166

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06630084

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.688

VS= 2.573

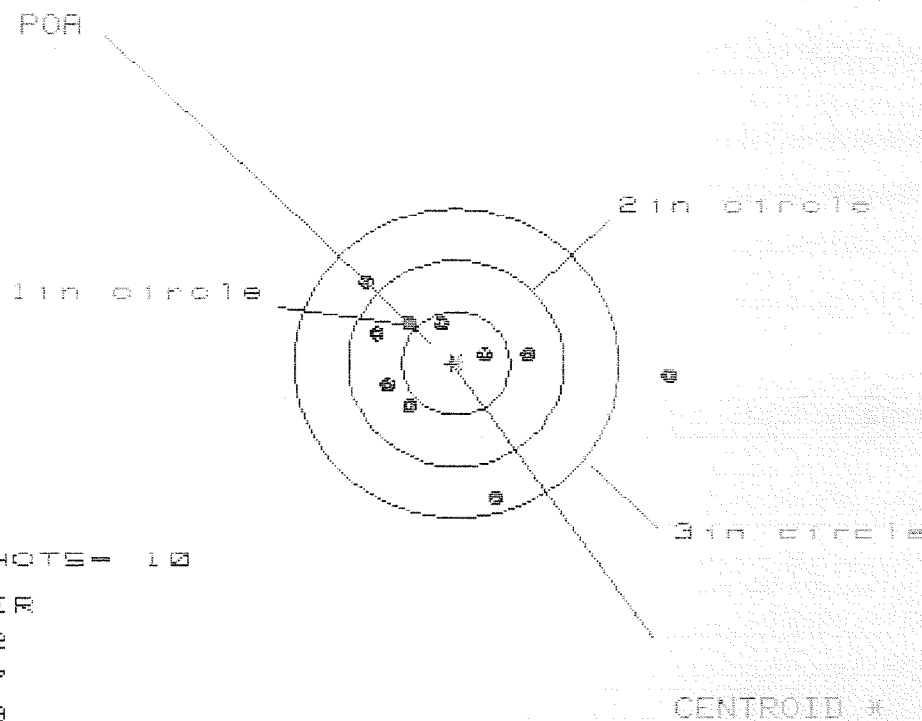
CS= 2.873

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.264	1.185	1.081
MINIMUM X	-1.424	-0.964	-0.989
MAXIMUM Y	1.130	1.234	1.067
MINIMUM Y	-1.443	-1.339	-1.320
CENTROID X	.006	.165	.190
CENTROID Y	-.395	-.499	-.332
POA TO CENTROID in.	.395	.525	.382
MIN RADIUS	.515	.340	.372
MEAN RADIUS	1.131	1.034	.977
MAX RADIUS	1.704	1.452	1.432
HORIZONTAL SPREAD	2.688	2.069	2.069
VERTICAL SPREAD	2.573	2.573	2.386
EXTREME SPREAD	2.873	2.635	2.397
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06536084

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.824

VS = 2.063

GS = 2.937

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.939
MINIMUM X	:	-1.895
MAXIMUM Y	:	.743
MINIMUM Y	:	-1.320
CENTROID X	:	.037
CENTROID Y	:	.010
POA TO CENTROID in.	:	.038
MIN RADIUS	:	.290
MEAN RADIUS	:	.852
MAX RADIUS	:	1.940
HORIZONTAL SPREAD	:	2.824
VERTICAL SPREAD	:	2.063
EXTREME SPREAD	:	2.937
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	7
NUMBER IN THREE INCH CIRCLE =	:	9

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836094

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.930

VS= 2.434

GS= 2.643

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.932
MINIMUM X	-.998
MAXIMUM Y	1.164
MINIMUM Y	-1.270
CENTROID X	-.032
CENTROID Y	.142
POR TO CENTROID in.	.145
MIN RADIUS	.282
MEAN RADIUS	.823
MAX RADIUS	1.575
HORIZONTAL SPREAD	1.930
VERTICAL SPREAD	2.434
EXTREME SPREAD	2.643
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C8636054

CENTERFIRE PATTERNS

4

POA

2in circle

1in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.931

VS= 2.399

GS= 2.399

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.901	.924	1.028
MINIMUM X	-1.030	-1.007	-1.903
MAXIMUM Y	1.033	.882	.963
MINIMUM Y	-1.366	-.642	-.561
CENTROID X	.012	-.011	-.115
CENTROID Y	-.045	.106	.025
POA TO CENTROID in.	.047	.107	.118
MIN RADIUS	.195	.348	.311
MEAN RADIUS	.861	.807	.756
MAX RADIUS	1.381	1.112	1.055
HORIZONTAL SPREAD	1.931	1.931	1.931
VERTICAL SPREAD	2.399	1.524	1.524
EXTREME SPREAD	2.399	2.171	1.997
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636094

CENTERFIRE PATTERNS # 5

POB

1 in circle =

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.8000

VS = 2.126

GS = 2.866

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.333
MINIMUM X	-1.467
MAXIMUM Y	1.379
MINIMUM Y	-1.747
CENTROID X	-.041
CENTROID Y	-.049
POB TO CENTROID in.	.064
MIN RADIUS	.422
MEAN RADIUS	.916
MAX RADIUS	1.482
HORIZONTAL SPREAD	2.800
VERTICAL SPREAD	2.126
EXTREME SPREAD	2.866
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10