

C6636191

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

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

SERIAL NO.
C6636191

ORDER NO.
5716

20



5716 C6636191

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636191

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/16/91	K.R.
	Magnaflux Bolt		4/16/91	U
615	Rollmark Caliber		4/16/91	GL
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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JA

op. #	BARBER - M24 0038737 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5	5	5	5/24/91	JK
	G) Safety Off Force	3	3	3	3	3	5/24/91	JK
	H) Trigger Pull Test & Retainability						5/24/91	JK
	I) Firing Pin Indent	.022	.022	.022	.022	.022	5/24/91	JK
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/24/91	KS
	M) Iron Sight Alignment						5/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	KS
	O) Attach Scope to Rifle						5/24/91	KS
P) Detach & Attach Scope 20 Times						5/24/91	KS	
640	Gallery Target & Test						5-28-91	DH
	A) Time						5-28-91	DH
	B) Malfunctions						5-28-91	DH
	C) Pierced Primers						5-28-91	DH
	D) Optical Clarity of Scope						5-28-91	DH
645	Inspect for Live Ammo						5-28-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.30	2.24	2.40	2.49	2.60	6/1/91	JK
	C) Function						6-1-91	DH
660	Pack						6-20-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636191DATE 5/24/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.55	2.40	2.50	MIN. SETTING,
PULL #2	2.55	2.48	2.48	2.24	NO AVG. OF 5
PULL #3	2.47	2.45	2.33	2.40	READINGS ACCEPT-
PULL #4	2.55	2.50	2.38	2.49	ABLE LESS THAN 2#
PULL #5	2.54	2.48	2.38	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.33		
PULL #2	3.36	3.25		
PULL #3	3.40	3.23		
PULL #4	3.34	3.20		
PULL #5	3.37	3.14		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.16		4.41
PULL #2	4.34	4.27		4.40
PULL #3	4.36	4.27		4.36
PULL #4	4.32	4.44		4.46
PULL #5	4.29	4.31		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636191
28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.053
1 TO	2	.365825
1 TO	3	.0680661
1 TO	4	.11183
1 TO	5	.394411

46 <----POA

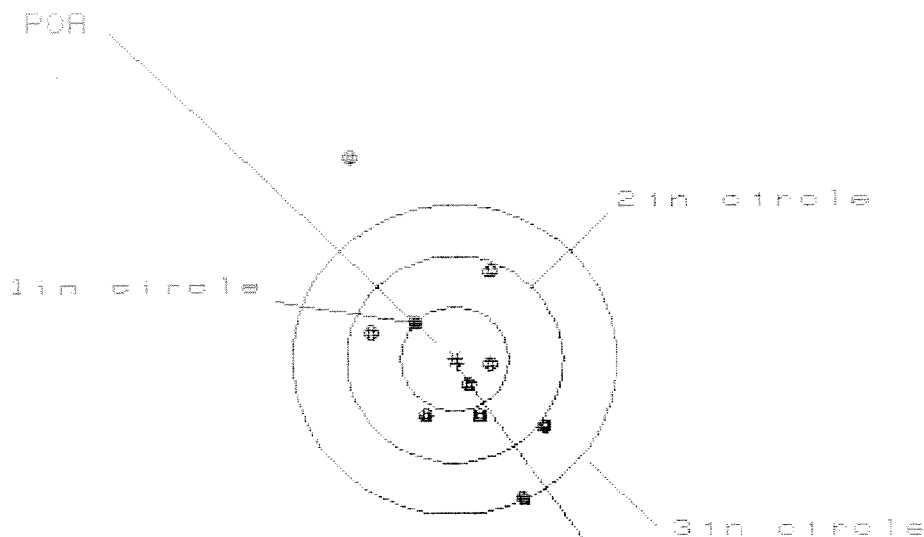
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0988
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112787

THE AMR FOR THIS RIFLE IS: .993

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636191

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.811

VS= 3.312

GS= 3.688

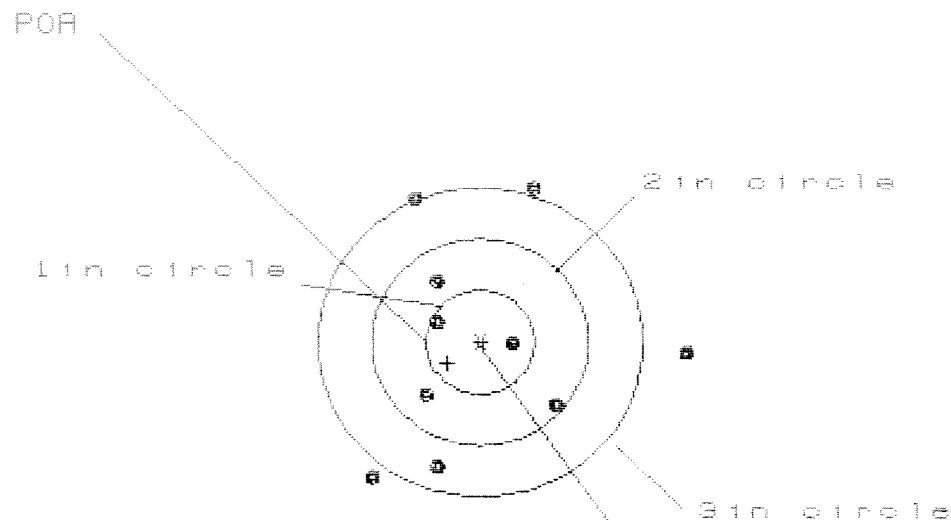
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.824	.715	.780
MINIMUM X	-.987	-.922	-.857
MAXIMUM Y	1.920	1.117	.970
MINIMUM Y	-1.392	-1.179	-.577
CENTROID X	-.028	.081	.016
CENTROID Y	.045	-.168	-.021
POA TO CENTROID in.	.053	.187	.026
MIN RADIUS	.236	.006	.158
MEAN RADIUS	.874	.676	.615
MAX RADIUS	2.159	1.291	1.015
HORIZONTAL SPREAD	1.811	1.637	1.637
VERTICAL SPREAD	3.312	2.296	1.547
EXTREME SPREAD	3.688	2.315	1.865
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

28 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 2.936

VS = 2.817

GS = 3.205

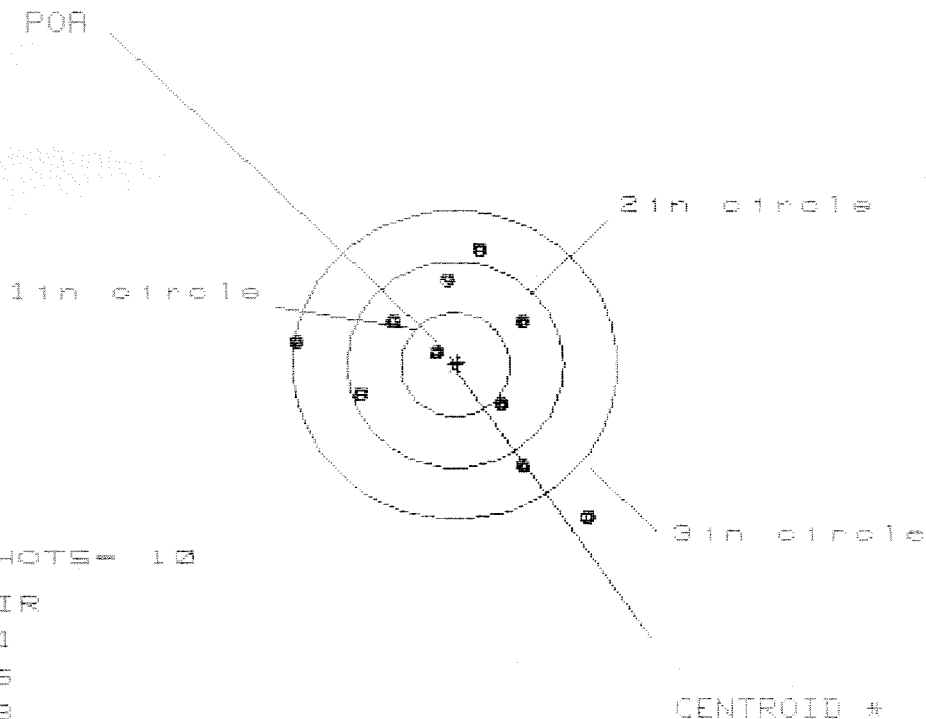
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.918	.946	.845
MINIMUM X	:	-1.018	-.805	-.495
MAXIMUM Y	:	1.474	1.468	1.299
MINIMUM Y	:	-1.343	-1.349	-1.362
CENTROID X	:	.300	.087	.188
CENTROID Y	:	.207	.213	.382
POA TO CENTROID in.	:	.365	.230	.425
MIN RADIUS	:	.308	.312	.323
MEAN RADIUS	:	1.111	1.001	.920
MAX RADIUS	:	1.919	1.614	1.419
HORIZONTAL SPREAD	:	2.936	1.751	1.340
VERTICAL SPREAD	:	2.817	2.817	2.661
EXTREME SPREAD	:	3.205	3.180	2.811
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.781

VS= 2.544

GS= 3.246

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.273	.763	.592
MINIMUM X	-1.508	-1.366	-.894
MAXIMUM Y	1.100	.940	.940
MINIMUM Y	-1.444	-1.111	-1.103
CENTROID X	-.025	-.167	.004
CENTROID Y	-.023	.137	.129
POA TO CENTROID in.	.034	.216	.129
MIN RADIUS	.156	.078	.175
MEAN RADIUS	.969	.830	.763
MAX RADIUS	1.925	1.368	1.244
HORIZONTAL SPREAD	2.781	2.129	1.486
VERTICAL SPREAD	2.544	2.051	2.051
EXTREME SPREAD	3.246	2.421	2.083
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 10

HS= 1.854

VS= 2.260

GS= 2.807

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.038	1.132	1.042
MINIMUM X	:	-.816	-.722	-.699
MAXIMUM Y	:	1.053	.918	1.024
MINIMUM Y	:	-1.207	-1.028	-.913
CENTROID X	:	-.119	-.213	-.123
CENTROID Y	:	-.020	.115	-.000
POA TO CENTROID in.	:	.121	.242	.123
MIN RADIUS	:	.328	.263	.344
MEAN RADIUS	:	.871	.777	.737
MAX RADIUS	:	1.476	1.356	1.219
HORIZONTAL SPREAD	:	1.854	1.854	1.741
VERTICAL SPREAD	:	2.260	1.946	1.937
EXTREME SPREAD	:	2.807	2.492	2.167
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 2

3in = 8

HS= 2.326

VS= 2.660

GS= 2.854

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.157	1.265
MINIMUM X	-1.276	-1.169	-1.061
MAXIMUM Y	1.337	1.447	1.593
MINIMUM Y	-1.323	-1.175	-0.994
CENTROID X	.366	.259	.151
CENTROID Y	.063	-.085	-.266
POA TO CENTROID in.	.372	.273	.306
MIN RADIUS	.084	.161	.067
MEAN RADIUS	1.140	1.053	.941
MAX RADIUS	1.649	1.686	1.619
HORIZONTAL SPREAD	2.326	2.326	2.326
VERTICAL SPREAD	2.660	2.622	2.587
EXTREME SPREAD	2.854	2.836	2.836
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	