

C6649250

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®
R50 US PATENT OFF

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

MODEL 700™ M24

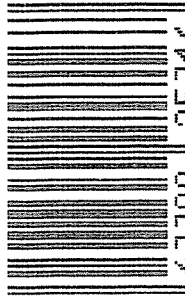
SERIAL NO.
C6649250

ORDER NO.
5716

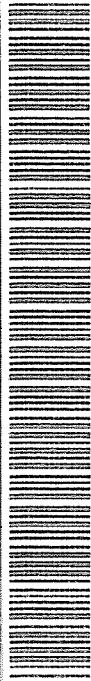
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20

LPC



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5716 C6649250

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649350

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	RW
	C) Inspect Ejector Hole for Chamfer		8/27/91	RW
	D) Oil Firing Pin Ass'y		8/27/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/91	JS

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/28/91	JH
	G) Safety Off Force	3	3	3			8/28/91	JH
	H) Trigger Pull Test & Retainability						8/27/91	JH
	I) Firing Pin Indent	.022	.021	.022			8/28/91	JH
	J) Assemble Stock						8/28/91	Rev
	K) Assemble Swivel Studs						8-28-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/28/91	Rev
	M) Iron Sight Alignment						8/28/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	Rev
	O) Attach Scope to Rifle						8/28/91	Rev
	P) Detach & Attach Scope 20 Times						8/28/91	Rev
640	Gallery Target & Test						8-28-91	AC
	A) Time						8-28-91	AC
	B) Malfunctions						8-28-91	AC
	C) Pierced Primers						8-28-91	AC
	D) Optical Clarity of Scope						8-28-91	AC
645	Inspect for Live Ammo						8-28-91	AC
655	Final Inspection							
	A) Headspace						8-28-91	D/H
	B) Trigger Pull	261	246	262	258	291	8-28-91	D/H
	C) Function						8-28-91	D/H
660	Pack						9-8-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#SERIAL NO. C-6649250DATE 8/27/91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.49	2.40	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.40	2.44	2.46	
PULL #3	2.41	2.38	2.46	2.62	
PULL #4	2.46	2.40	2.50	2.58	
PULL #5	2.44	2.37	2.42	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.41		
PULL #2	3.32	3.40		
PULL #3	3.41	3.40		
PULL #4	3.32	3.41		
PULL #5	3.43	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.47		4.51
PULL #2	4.49	4.47		4.48
PULL #3	4.40	4.54		4.37
PULL #4	4.25	4.37		4.38
PULL #5	4.31	4.56		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649250
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.131674
1 TO	2	.248163
1 TO	3	.298824
1 TO	4	.241597
1 TO	5	.394645

57 <----POA

THE X-COORDINATE FOR THIS RIFLE IS: -.0704
THE Y-COORDINATE FOR THIS RIFLE IS: .0658
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .0963629

THE POI FOR THIS RIFLE IS: .8596

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649250

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.039

VS = 2.792

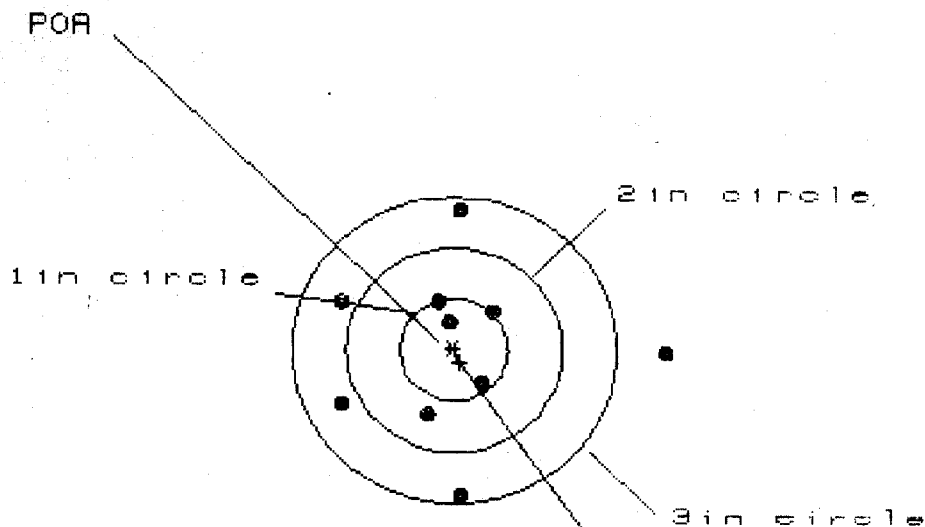
GS = 2.886

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.617	.663
MINIMUM X	:	-1.052	-.942	-.896
MAXIMUM Y	:	1.304	1.139	.636
MINIMUM Y	:	-1.488	-1.140	-.998
CENTROID X	:	-.047	-.157	-.203
CENTROID Y	:	-.123	.042	-.100
POA TO CENTROID in.	:	.132	.163	.226
MIN RADIUS	:	.257	.300	.394
MEAN RADIUS	:	.858	.736	.680
MAX RADIUS	:	1.786	1.196	.999
HORIZONTAL SPREAD	:	2.039	1.559	1.559
VERTICAL SPREAD	:	2.792	2.279	1.634
EXTREME SPREAD	:	2.886	2.308	1.694
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Aug 1931

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.991

VS= 2.707

GS= 3.035

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.917	.579	.610
MINIMUM X	:	-1.074	-.861	-.830
MAXIMUM Y	:	1.325	1.325	1.152
MINIMUM Y	:	-1.382	-1.382	-.794
CENTROID X	:	-.056	-.269	-.300
CENTROID Y	:	.125	.125	.298
POA TO CENTROID in.	:	.137	.296	.422
MIN RADIUS	:	.229	.303	.236
MEAN RADIUS	:	.933	.819	.726
MAX RADIUS	:	1.917	1.404	1.192
HORIZONTAL SPREAD	:	2.991	1.440	1.440
VERTICAL SPREAD	:	2.707	2.707	1.946
EXTREME SPREAD	:	3.035	2.707	2.160
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

28 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.820

VS = 1.771

GS = 2.846

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	1.351	1.204
MINIMUM X	:	-1.346	-1.183	-.993
MAXIMUM Y	:	.999	1.051	1.069
MINIMUM Y	:	-.772	-.720	-.702
CENTROID X	:	.093	-.070	.077
CENTROID Y	:	.141	.089	.071
POA TO CENTROID in.	:	.169	.114	.105
MIN RADIUS	:	.155	.307	.225
MEAN RADIUS	:	.884	.804	.744
MAX RADIUS	:	1.547	1.463	1.320
HORIZONTAL SPREAD	:	2.820	2.534	2.197
VERTICAL SPREAD	:	1.771	1.771	1.771
EXTREME SPREAD	:	2.846	2.630	2.346
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Aug 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 5

2in = 7

3in = 10

CENTROID *

HS= 1.895

VS= 2.367

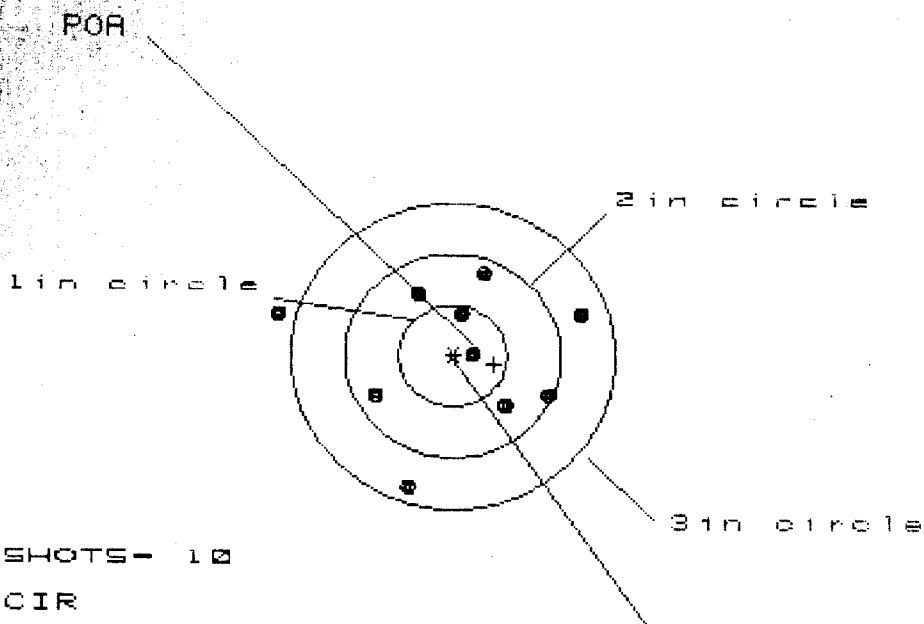
GS= 2.392

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	1.008	1.021
MINIMUM X	:	-.933	-.887	-.874
MAXIMUM Y	:	1.085	.942	.441
MINIMUM Y	:	-1.282	-.551	-.433
CENTROID X	:	.041	-.005	-.018
CENTROID Y	:	.102	.245	.127
POA TO CENTROID in.	:	.110	.245	.128
MIN RADIUS	:	.336	.302	.276
MEAN RADIUS	:	.738	.656	.615
MAX RADIUS	:	1.347	1.011	1.022
HORIZONTAL SPREAD	:	1.895	1.895	1.895
VERTICAL SPREAD	:	2.367	1.493	.874
EXTREME SPREAD	:	2.392	1.939	1.939
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Aug 1951

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.845

VS = 2.168

GS = 2.845

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.182	.997	.928
MINIMUM X	-1.663	-.910	-.979
MAXIMUM Y	.858	.899	.740
MINIMUM Y	-1.310	-1.269	-.643
CENTROID X	-.383	-.198	-.129
CENTROID Y	.084	.043	.202
FOR TO CENTROID in.	.392	.203	.239
MIN RADIUS	.175	.074	.118
MEAN RADIUS	.885	.767	.670
MAX RADIUS	1.704	1.385	1.107
HORIZONTAL SPREAD	2.845	1.907	1.907
VERTICAL SPREAD	2.168	2.168	1.384
EXTREME SPREAD	2.845	2.301	2.063
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		