

C6587739

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.

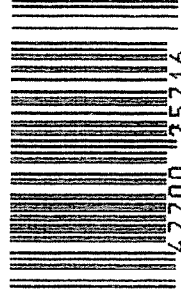
MODEL 700™ M24

SERIAL NO. C6587739

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6587739

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587739

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KS
600	Proof		10/18/90	KS
607	Check Headspace		10/18/90	KS
610	Dis-assemble Gun		10/18/90	KS
612	Magnaflux Barrel Action		10/22	KR
	Magnaflux Bolt		10/22	KR
615	Rollmark Caliber		10/22	KS
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		11/6/90	KS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11-6-90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	KS
	C) Inspect Ejector Hole for Chamfer		11-6-90	KS
	D) Oil Firing Pin Ass'y		11-6-90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/13/90	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5.0	4.3/4	4.3/4			11/7/90	KS
	G) Safety Off Force	2.3/4	3.0	3.1/4			11/7/90	KS
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.022	.023			11/7/90	KS
	J) Assemble Stock						11/13/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/13/90	KS
	M) Iron Sight Alignment						11/13/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/13/90	KS
	O) Attach Scope to Rifle						11/13/90	KS
	P) Detach & Attach Scope 20 Times						11/13/90	KS
640	Gallery Target & Test						11-14-90	KT
	A) Time						11-14-90	KT
	B) Malfunctions						11-14-90	KT
	C) Pierced Primers						11-14-90	KT
	D) Optical Clarity of Scope						11-14-90	KT
645	Inspect for Live Ammo						11-14-90	KT
655	Final Inspection						11-19-90	DH
	A) Headspace							
	B) Trigger Pull	261	265	269	265	271	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12/18/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587739
DATE 13/NOV/90
TESTER Q28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	235	232	284	261	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	243	239	268	265	
PULL #3	235	253	278	269	
PULL #4	240	255	263	265	
PULL #5	234	245	260	271	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	295	318		
PULL #2	301	307		
PULL #3	303	299		
PULL #4	317	307		
PULL #5	299	297		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	407	400		416
PULL #2	410	403		413
PULL #3	405	408		414
PULL #4	405	402		413
PULL #5	398	404		423
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587739
15 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.302513
1 TO 2	.372839
1 TO 3	.460926
1 TO 4	.297108
1 TO 5	.367147

41 <----POB

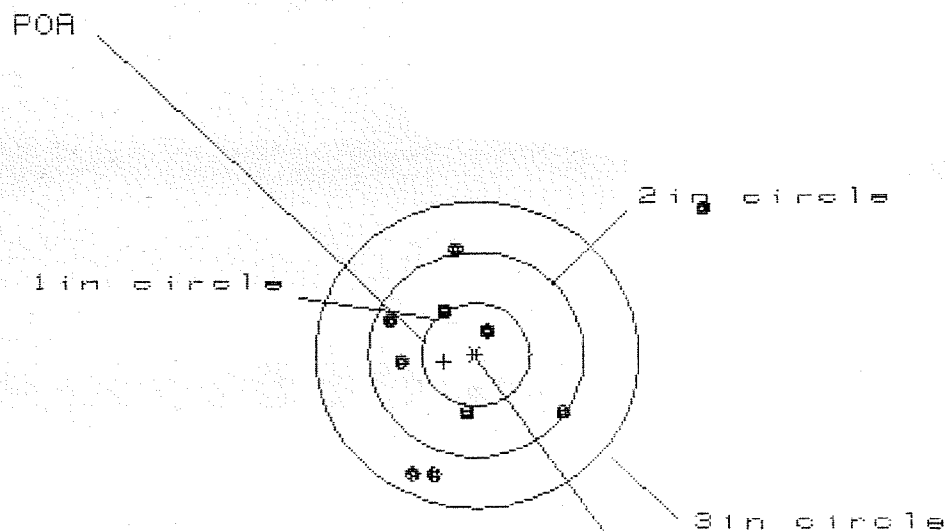
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0086
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0130384

THE AMR FOR THIS RIFLE IS: 1.01

15 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.876

VS = 2.627

GS = 3.686

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.087	1.002	.960
MINIMUM X	-.789	-.557	-.599
MAXIMUM Y	1.428	1.163	1.041
MINIMUM Y	-1.199	-1.040	-1.162
CENTROID X	.295	.063	.105
CENTROID Y	.067	-.092	.030
POA TO CENTROID in.	.303	.111	.109
MIN RADIUS	.297	.423	.450
MEAN RADIUS	1.004	.800	.757
MAX RADIUS	2.529	1.163	1.173
HORIZONTAL SPREAD	2.876	1.559	1.559
VERTICAL SPREAD	2.627	2.203	2.203
EXTREME SPREAD	3.686	2.206	2.206
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

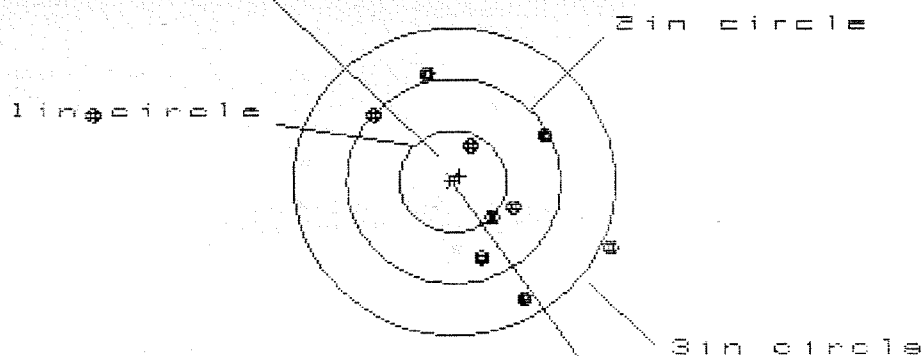
15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 4.769

VS = 2.191

GS = 4.978

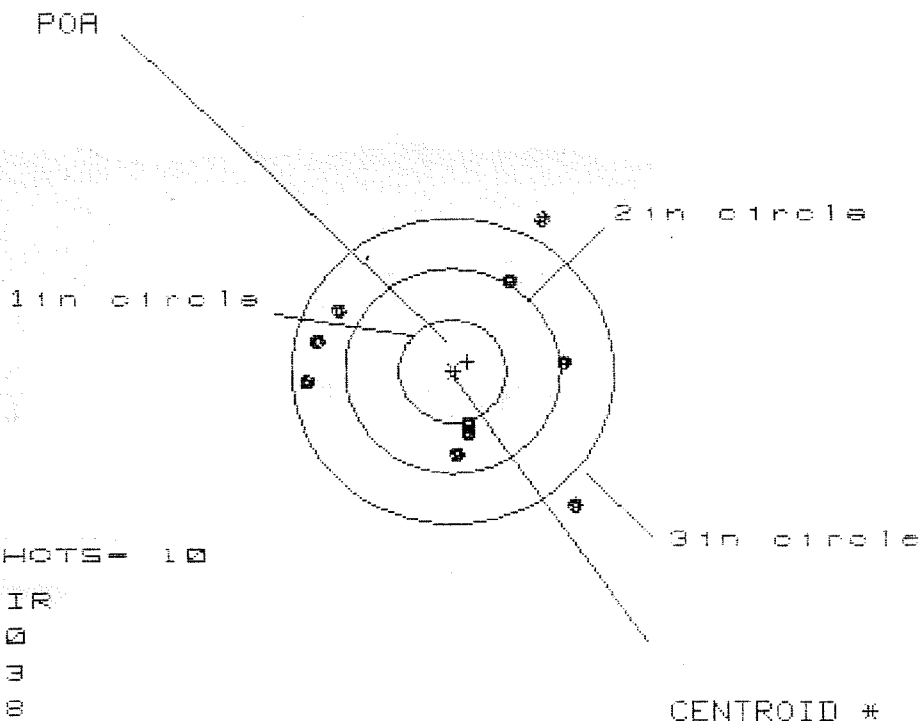
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.464
MINIMUM X	-3.325
MAXIMUM Y	1.016
MINIMUM Y	-1.175
CENTROID X	-.058
CENTROID Y	-.053
POA TO CENTROID in.	.079
MIN RADIUS	.327
MEAN RADIUS	1.151
MAX RADIUS	3.393
HORIZONTAL SPREAD	4.789
VERTICAL SPREAD	2.191
EXTREME SPREAD	4.978
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587739

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.437

VS= 2.855

CS= 2.910

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.091	1.116	1.232
MINIMUM X	-1.346	-1.224	-1.108
MAXIMUM Y	1.507	1.357	.923
MINIMUM Y	-1.348	-.960	-.790
CENTROID X	-.138	-.260	-.376
CENTROID Y	-.091	.059	-.111
POA TO CENTROID in.	.166	.266	.392
MIN RADIUS	.509	.685	.585
MEAN RADIUS	1.139	1.084	.982
MAX RADIUS	1.734	1.643	1.240
HORIZONTAL SPREAD	2.437	2.340	2.340
VERTICAL SPREAD	2.855	2.317	1.713
EXTREME SPREAD	2.910	2.707	2.354
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587739

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.294

VS= 4.055

CS= 4.074

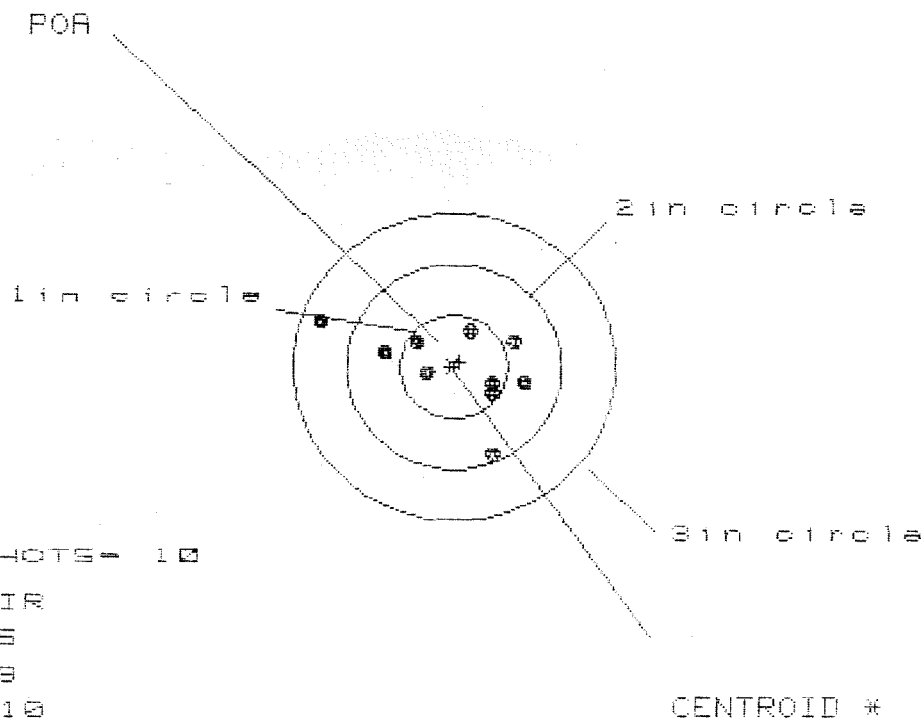
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.423	1.326	.723
MINIMUM X	:	-.871	-.930	-.764
MAXIMUM Y	:	1.169	.848	.795
MINIMUM Y	:	-2.886	-1.375	-1.428
CENTROID X	:	-.002	.095	-.071
CENTROID Y	:	.075	.396	.449
POA TO CENTROID in.	:	.075	.407	.455
MIN RADIUS	:	.199	.245	.203
MEAN RADIUS	:	1.146	.864	.771
MAX RADIUS	:	3.015	1.392	1.428
HORIZONTAL SPREAD	:	2.294	2.256	1.487
VERTICAL SPREAD	:	4.055	2.223	2.223
EXTREME SPREAD	:	4.074	2.452	2.257
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = 1.939

VS = 1.295

ES = 2.078

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.691	.552	.582
MINIMUM X	-1.248	-.771	-.741
MAXIMUM Y	.441	.411	.310
MINIMUM Y	-.854	-.805	-.272
CENTROID X	-.054	.085	.055
CENTROID Y	-.047	-.096	.085
POA TO CENTROID in.	.071	.128	.055
MIN RADIUS	.295	.249	.317
MEAN RADIUS	.609	.508	.462
MAX RADIUS	1.324	.840	.745
HORIZONTAL SPREAD	1.939	1.323	1.323
VERTICAL SPREAD	1.295	1.216	.582
EXTREME SPREAD	2.078	1.408	1.354
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		