

C6648934

MODEL 700™ M24

Model **S4S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

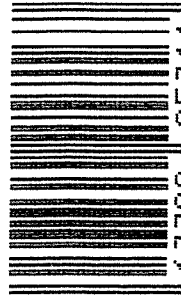
MODEL 700TM H24

SERIAL NO.
C6648934

ORDER NO.
5716

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

LPC



0 47700 25716 7



5716 C6648934

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648934

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	LB
	Apply Coating (Bolt)		8-23-91	LB
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	PM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	6			9/11/91	JH
	G) Safety Off Force	3	3	5			9/11/91	JH
	H) Trigger Pull Test & Retainability						9/11/91	JH
	I) Firing Pin Indent	.0215	.021	.021			9/11/91	JH
	J) Assemble Stock						9/12/91	RW
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						9/12/91	RW
	M) Iron Sight Alignment						9/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/14/91	RW
	O) Attach Scope to Rifle						9/12/91	RW
	P) Detach & Attach Scope 20 Times						9/12/91	RW
640	Gallery Target & Test						9/12/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/12/91	KT
655	Final Inspection							
	A) Headspace						9/13/91	JH
	B) Trigger Pull	2.17	2.24	2.32	2.36	2.34	9/13/91	JH
	C) Function						9/13/91	JH
660	Pack						9-19-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648934

DATE 9-11-98

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.55	2.54	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.35	2.48	2.29	
PULL #3	2.59	2.57	2.44	2.32	
PULL #4	2.59	2.59	2.60	2.36	
PULL #5	2.54	2.60	2.61	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.54		
PULL #2	3.44	3.50		
PULL #3	3.42	3.45		
PULL #4	3.46	3.52		
PULL #5	3.37	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	4.47	4.20		4.39
PULL #2	4.62	4.20		4.56
PULL #3	4.56	4.25		4.54
PULL #4	4.62	4.48		4.45
PULL #5	4.52	4.47		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648934
13 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0290689
1 TO	2	.103097
1 TO	3	.105081
1 TO	4	.0390512
1 TO	5	.123693

←----FOI

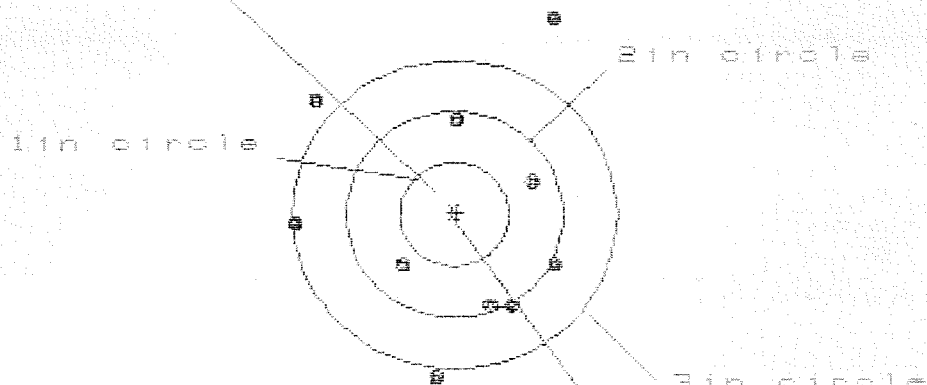
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0378
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0196
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .0425793
THE AMR FOR THIS RIFLE IS: 1.029

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648934

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 7

HE = 2.445

VS = 3.492

GS = 3.664

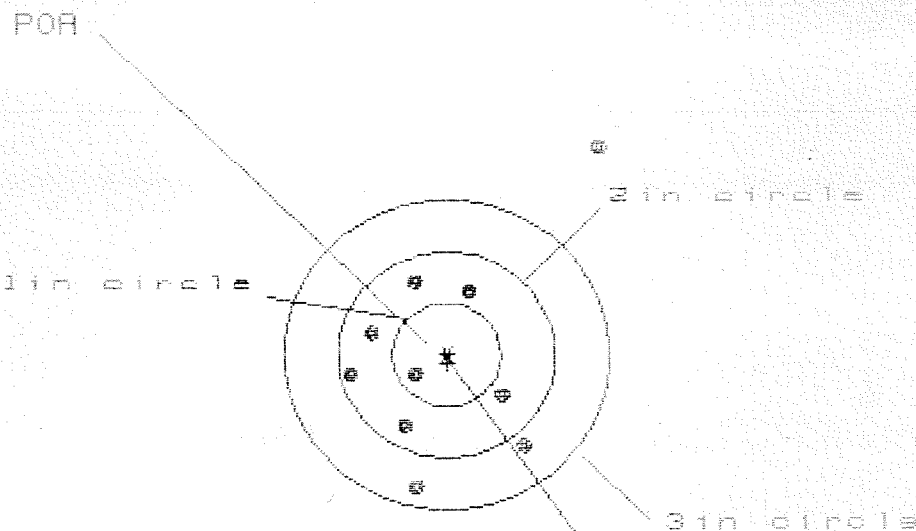
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.950	.987	.835
MINIMUM X	-1.495	-1.390	-1.542
MAXIMUM Y	1.950	1.341	1.288
MINIMUM Y	-1.542	-1.326	-1.158
CENTROID X	-.022	-.127	.025
CENTROID Y	-.019	-.235	-.403
POA TO CENTROID in.	.029	.268	.404
MIN RADIUS	.722	.502	.571
MEAN RADIUS	1.237	1.102	.967
MAX RADIUS	2.169	1.810	1.569
HORIZONTAL SPREAD	2.445	2.377	2.377
VERTICAL SPREAD	3.492	2.667	2.446
EXTREME SPREAD	3.664	2.909	2.456
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	7	7	7

12 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.256

VS= 3.249

GS= 3.654

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.412	.866	.853
MINIMUM X	:	-.844	-.687	-.700
MAXIMUM Y	:	2.000	.927	.799
MINIMUM Y	:	-1.249	-1.027	-.755
CENTROID X	:	-.087	-.164	-.151
CENTROID Y	:	.083	-.139	-.011
POA TO CENTROID in.	:	.083	.215	.152
MIN RADIUS	:	.382	.180	.211
MEAN RADIUS	:	.972	.752	.714
MAX RADIUS	:	2.448	1.069	1.139
HORIZONTAL SPREAD	:	2.256	1.553	1.553
VERTICAL SPREAD	:	3.249	1.954	1.554
EXTREME SPREAD	:	3.654	1.959	1.849
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 4.660

VS= 1.753

GS= 4.701

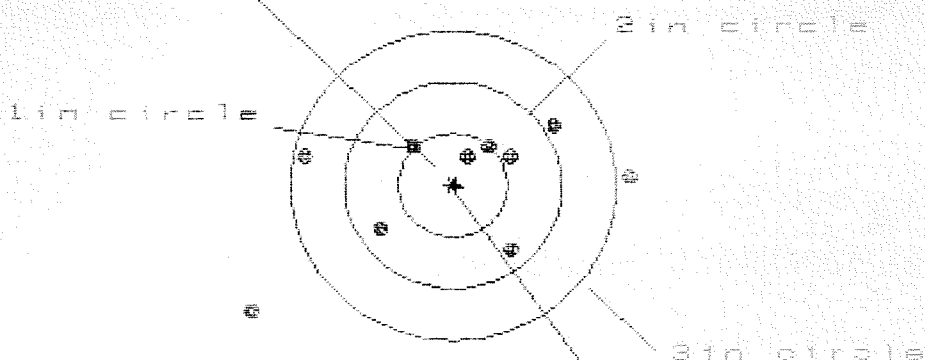
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.330	1.109	.851
MINIMUM X	-2.330	-2.072	-1.302
MAXIMUM Y	.763	.343	.371
MINIMUM Y	-.990	-.905	-.877
CENTROID X	.007	-.251	.008
CENTROID Y	.082	-.003	-.031
POA TO CENTROID in.	.083	.251	.032
MIN RADIUS	.248	.305	.228
MEAN RADIUS	.996	.868	.649
MAX RADIUS	2.451	2.084	1.304
HORIZONTAL SPREAD	4.660	3.181	2.153
VERTICAL SPREAD	1.753	1.248	1.248
EXTREME SPREAD	4.701	3.206	2.164
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.512

VS = 1.841

GS = 3.747

CENTROID #

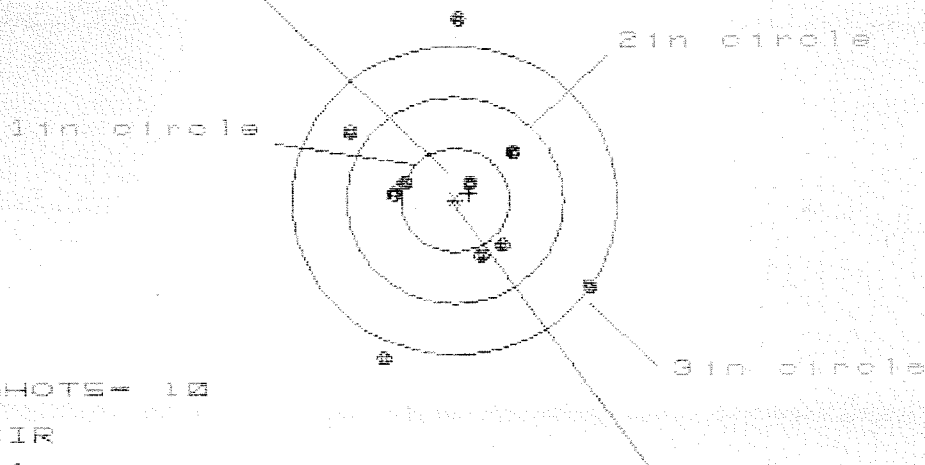
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.678	1.474	.915
MINIMUM X	-1.834	-1.535	-1.351
MAXIMUM Y	.618	.482	.475
MINIMUM Y	-1.223	-.787	-.794
CENTROID X	-.031	.173	-.011
CENTROID Y	.019	.155	.162
POA TO CENTROID in.	.036	.232	.162
MIN RADIUS	.334	.161	.207
MEAN RADIUS	1.000	.802	.730
MAX RADIUS	2.205	1.540	1.356
HORIZONTAL SPREAD	3.512	3.009	2.266
VERTICAL SPREAD	1.841	1.269	1.269
EXTREME SPREAD	3.747	3.014	2.295
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.175

VS = 3.374

GS = 3.448

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.218	1.223	1.142
MINIMUM X	:	-.957	-.952	-1.034
MAXIMUM Y	:	1.794	.903	.730
MINIMUM Y	:	-1.500	-1.300	-.935
CENTROID X	:	-.136	-.141	-.059
CENTROID Y	:	-.067	-.267	-.094
POA TO CENTROID in.	:	.152	.302	.111
MIN RADIUS	:	.164	.341	.152
MEAN RADIUS	:	.936	.846	.731
MAX RADIUS	:	1.795	1.528	1.414
HORIZONTAL SPREAD	:	2.175	2.175	2.175
VERTICAL SPREAD	:	3.374	2.283	1.565
EXTREME SPREAD	:	3.448	2.680	2.680
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		