

06348859

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington.

M2400040016

CONFIDENTIAL -SUBJECT TO PROTECTIVE ORDER

Small
Sword

Remington[®]

MODEL 700[™] M24

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

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6348859

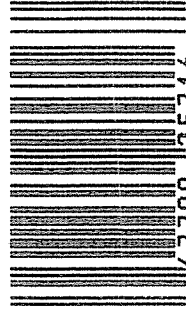
ORDER NO.
5716

Q1



5716 C6348859

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348859

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 11	89	RW
600	Proof		89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		7/13	KCK
	Magnaflux Bolt		7/13	KCK
615	Rollmark Caliber		7/13	DS.
617	Drill and Tap Sight Holes	7 13	89	
618	Polish Barrel <i>163</i>	7 13	89	
620	Apply Coatings (Barrel Action)		7/24/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/89	RW
	C) Inspect Ejector Hole for Chamfer		7/25/89	RW
	D) Oil Firing Pin Ass'y		7/25/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7/25/89	J.C.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/28/89	WB
	G) Safety Off Force	3	3	3			7/28/89	WB
	H) Trigger Pull Test & Retainability						7/28/89	JU
	I) Firing Pin Indent	.020	.0207	.0215			7/28/89	WB
	J) Assemble Stock						7/31/89	RW
	K) Assemble Swivel Studs						Aug 89	JS
	L) Attach Front and Rear Sight Assemblies						7/31/89	RW
	M) Iron Sight Alignment						7/31/89	RW
	N) Detach Front & Rear Sights & place in numbered container						7/31/89	RW
	O) Attach Scope to Rifle						8/1/89	WB
	P) Detach & Attach Scope 20 Times						8/1/89	WB
640	Gallery Target & Test	103R	49L				8-1-89	A
	A) Time						8-1-89	A
	B) Malfunctions						8-1-89	A
	C) Pierced Primers						8-1-89	A
	D) Optical Clarity of Scope						8-1-89	A
645	Inspect for Live Ammo						8-1-89	A
655	Final Inspection							
	A) Headspace						2 Aug 89	JS
	B) Trigger Pull	2.29	2.46	2.60	2.83	2.08	2 Aug 89	JS
	C) Function						2 Aug 89	JS
660	Pack						7/20/89	A

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 6348859

DATE 3-27-80

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.47	2.60		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.48	2.55		
PULL #3	2.43	2.50	2.51		
PULL #4	2.43	2.52	2.56		
PULL #5	2.48	2.54	2.52		
TOTAL	12.17	12.51	12.74		
AVG.	2.434	2.502	2.548		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.44		
PULL #2	3.37	3.40		
PULL #3	3.46	3.46		
PULL #4	3.45	3.39		
PULL #5	3.46	3.43		
TOTAL	17.00	17.12		
AVG.	3.4	3.424		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.54		
PULL #2	4.53	4.52		
PULL #3	4.51	4.35		
PULL #4	4.52	4.36		
PULL #5	4.55	4.36		
TOTAL	22.45	22.13		
AVG.	4.49	4.426		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348859
3 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.619397
1 TO	2	.721612
1 TO	3	.709612
1 TO	4	.521208
1 TO	5	.101356

$\frac{5}{2}$ <----FOR

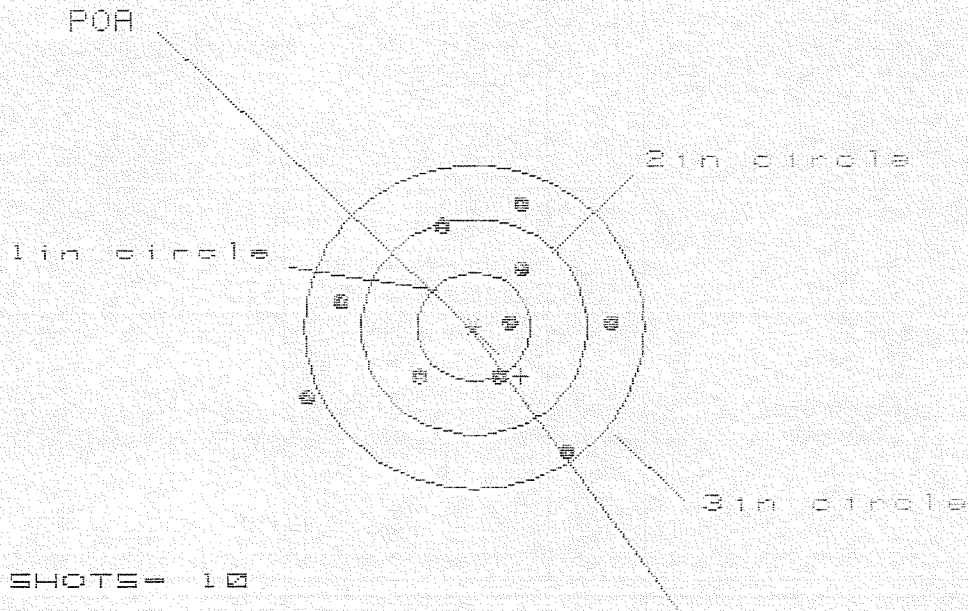
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .247342
THE AMR FOR THIS RIFLE IS: .834

2 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B859

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.729

VS= 2.294

GS= 2.833

CENTROID *

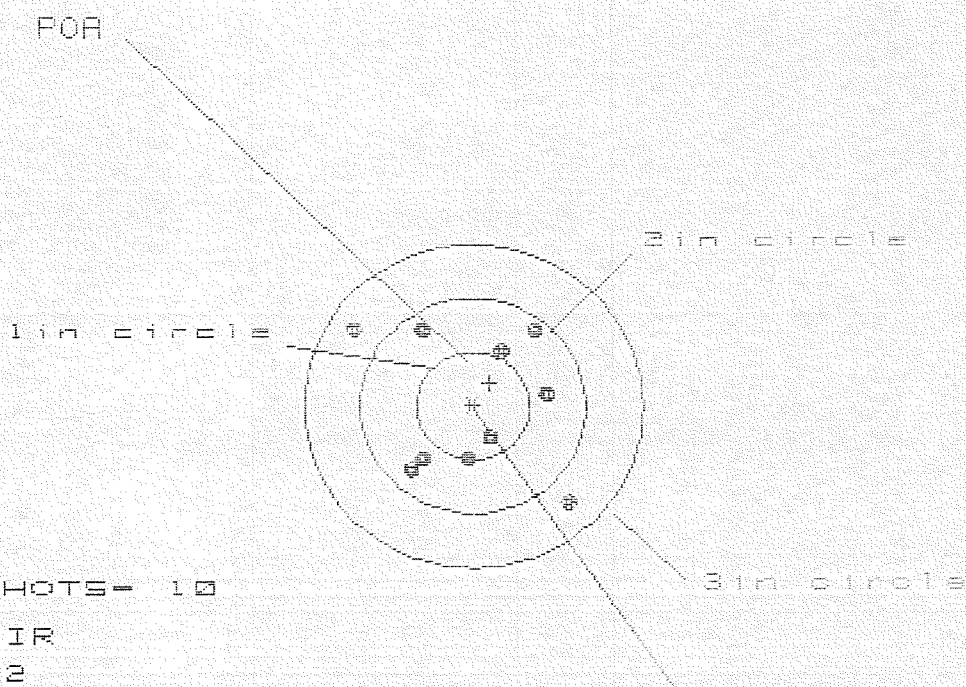
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.266	1.103	1.193
MINIMUM X	-1.463	-1.301	-1.221
MAXIMUM Y	1.117	1.039	.882
MINIMUM Y	-1.177	-1.255	-1.716
CENTROID X	-.417	-.254	-.334
CENTROID Y	.458	.536	.693
POA TO CENTROID in.	.619	.593	.769
MIN RADIUS	.311	.161	.317
MEAN RADIUS	.977	.877	.812
MAX RADIUS	1.625	1.408	1.221
HORIZONTAL SPREAD	2.729	2.404	2.404
VERTICAL SPREAD	2.294	2.294	1.598
EXTREME SPREAD	2.833	2.410	2.410
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

2 Aug 1989

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.900

VS= 1.632

GS= 2.462

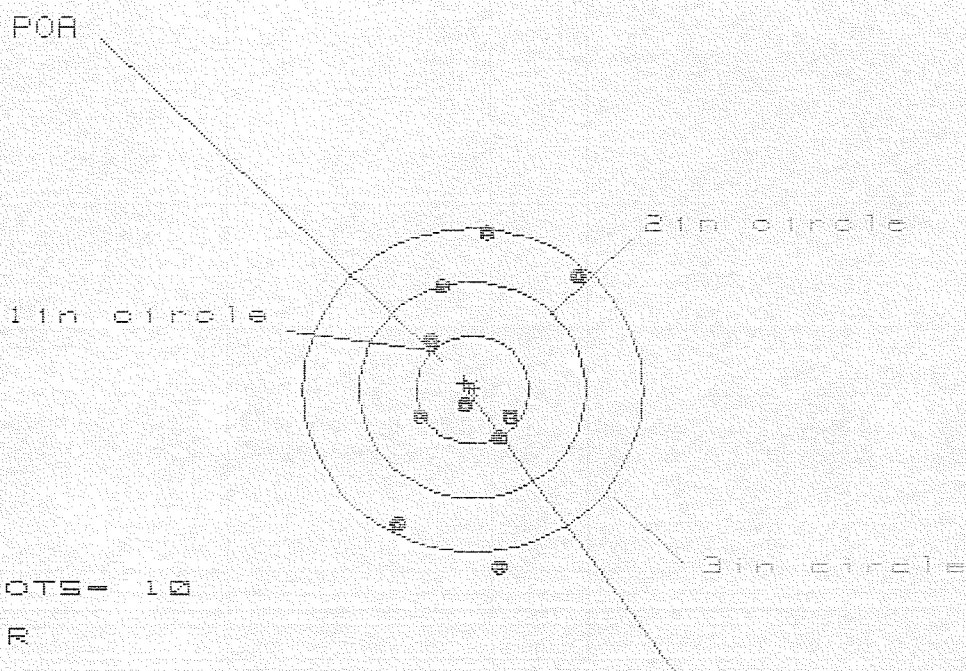
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.844	.726	.622
MINIMUM X	:	-1.056	-.642	-.551
MAXIMUM Y	:	.753	.830	.729
MINIMUM Y	:	-.879	-.902	-.635
CENTROID X	:	-.149	-.031	-.122
CENTROID Y	:	-.212	-.289	-.188
POA TO CENTROID in.	:	.259	.290	.224
MIN RADIUS	:	.305	.191	.315
MEAN RADIUS	:	.756	.692	.648
MAX RADIUS	:	1.260	1.082	.948
HORIZONTAL SPREAD	:	1.900	1.368	1.173
VERTICAL SPREAD	:	1.632	1.632	1.364
EXTREME SPREAD	:	2.462	2.056	1.677
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Aug 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 1.644

VS= 3.150

GS= 3.150

CENTROID #

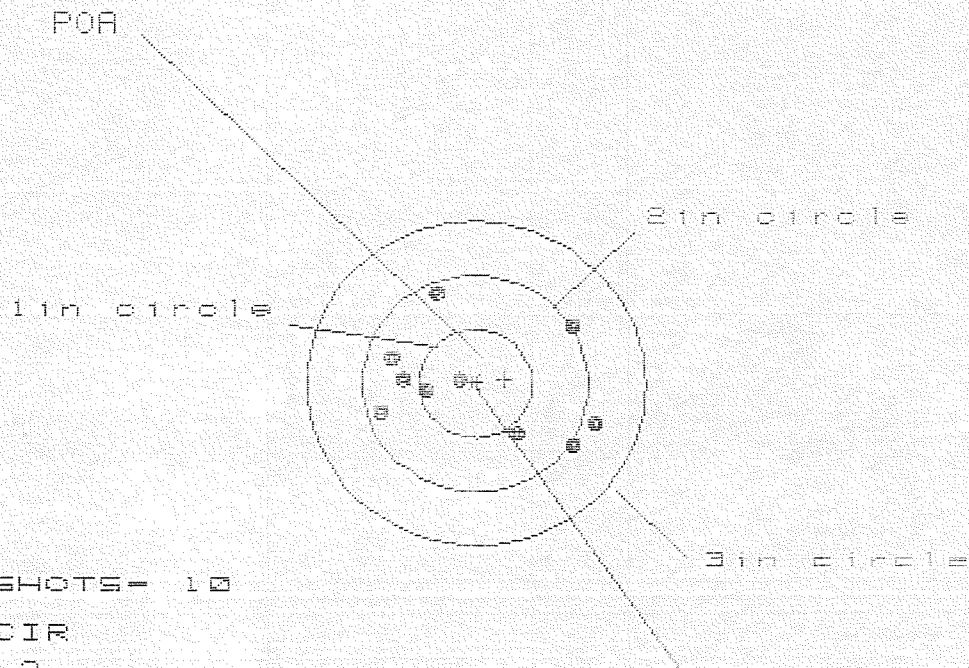
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.993	1.015
MINIMUM X	:	-.673	-.651	-.629
MAXIMUM Y	:	1.468	1.281	.987
MINIMUM Y	:	-1.682	-1.411	-1.251
CENTROID X	:	.063	.046	.024
CENTROID Y	:	-.060	.127	-.033
POA TO CENTROID in.	:	.091	.135	.040
MIN RADIUS	:	.120	.287	.126
MEAN RADIUS	:	.920	.846	.754
MAX RADIUS	:	1.694	1.554	1.416
HORIZONTAL SPREAD	:	1.644	1.644	1.644
VERTICAL SPREAD	:	3.150	2.692	2.238
EXTREME SPREAD	:	3.150	2.817	2.777
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Aug 1988

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.942

VS= 1.424

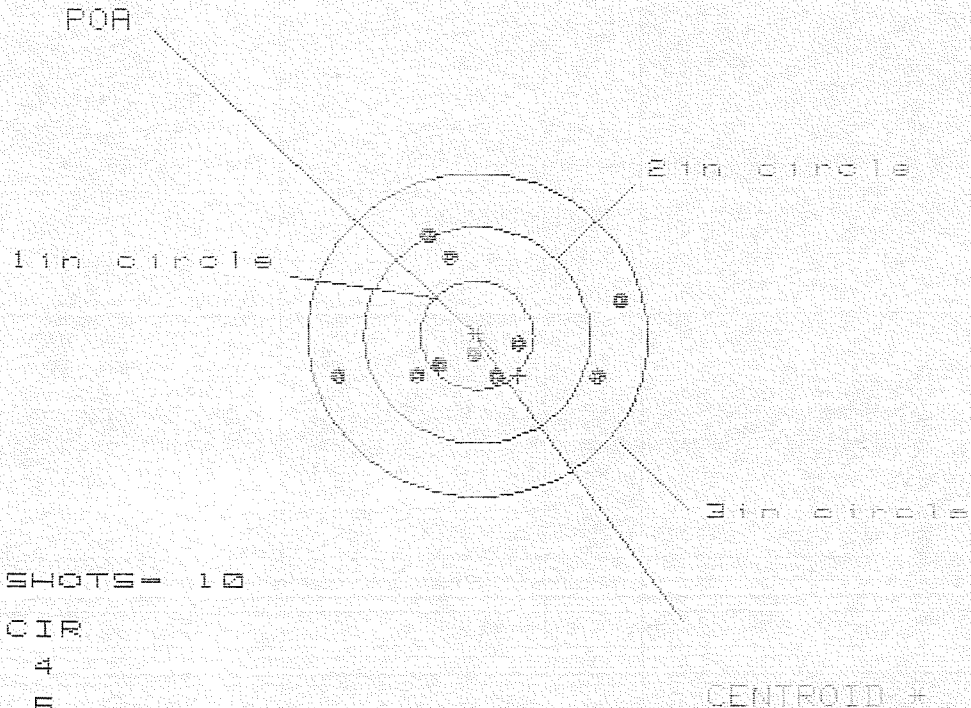
GS= 1.944

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	.962	1.051
MINIMUM X	:	-.864	-.745	-.624
MAXIMUM Y	:	.874	.833	.759
MINIMUM Y	:	-.550	-.591	-.558
CENTROID X	:	-.260	-.379	-.500
CENTROID Y	:	-.039	.002	.076
POA TO CENTROID in.:	:	.263	.379	.505
MIN RADIUS	:	.123	.041	.148
MEAN RADIUS	:	.753	.678	.603
MAX RADIUS	:	1.138	1.129	1.116
HORIZONTAL SPREAD	:	1.942	1.707	1.675
VERTICAL SPREAD	:	1.424	1.424	1.318
EXTREME SPREAD	:	1.944	1.849	1.847
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Aug 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 10

HS= 2.476

VS= 1.365

GS= 2.560

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.264	1.191	1.058
MINIMUM X	:	-1.212	-1.072	-1.532
MAXIMUM Y	:	.955	.989	.952
MINIMUM Y	:	-.410	-.376	-.413
CENTROID X	:	-.365	-.505	-.372
CENTROID Y	:	.371	.337	.374
POA TO CENTROID in.	:	.521	.607	.528
MIN RADIUS	:	.197	.178	.198
MEAN RADIUS	:	.754	.678	.623
MAX RADIUS	:	1.302	1.249	1.135
HORIZONTAL SPREAD	:	2.476	2.263	1.590
VERTICAL SPREAD	:	1.365	1.365	1.365
EXTREME SPREAD	:	2.560	2.264	2.045
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	