

C6522304

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522304

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	Ref
600	Proof		7/10/90	Ref
607	Check Headspace		7/10/90	Ref
610	Dis-assemble Gun		7/10/90	Ref
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	L.S.
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	KS
	C) Inspect Ejector Hole for Chamfer		8/16/90	KS
	D) Oil Firing Pin Ass'y		8/16/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/90	QU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/17/90 8/20/90	SL
	G) Safety Off Force	3	3	3			8/20/90	SL
	H) Trigger Pull Test & Retainability						8/21/90	SL
	I) Firing Pin Indent	.0205	.021	.0215			8/20/90	SL
	J) Assemble Stock						8/17/90	KS
	K) Assemble Swivel Studs						8/17/90 8/20/90	KS
	L) Attach Front and Rear Sight Assemblies						8/17/90	KS
	M) Iron Sight Alignment						8/17/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/17/90	KS
	O) Attach Scope to Rifle						8/17/90	KS
	P) Detach & Attach Scope 20 Times						8/17/90	KS
640	Gallery Target & Test						8/20/90	NF
	A) Time						8/20/90	NF
	B) Malfunctions						8/20/90	NF
	C) Pierced Primers						8/20/90	NF
	D) Optical Clarity of Scope						8/20/90	NF
645	Inspect for Live Ammo						8/20/90	NF
655	Final Inspection						8/20/90	SL
	A) Headspace						8/29/90	SL
	B) Trigger Pull	2.37	2.39	2.40	2.40	2.43	8/21/90	SL
	C) Function						8/29/90	SL
660	Pack						9/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522304

DATE 8/21/90

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21 ²	2.24 ²	2.42 ²	2.37 ¹	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.23	2.37	2.39	
PULL #3	2.19	2.24	2.43	2.40	
PULL #4	2.20	2.24	2.39	2.40	
PULL #5	2.19	2.28	2.40	2.43	
TOTAL	10.97	11.23	12.01	11.99	
AVG.	2.194	2.246	2.402	2.398	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19 ¹	3.21 ¹		
PULL #2	3.22	3.27		
PULL #3	3.25	3.24		
PULL #4	3.24	3.31		
PULL #5	3.25	3.32		
TOTAL	16.15	16.35		
AVG.	3.23	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48 ²	4.44 ²		4.47 ²
PULL #2	4.43	4.43		4.50
PULL #3	4.35	4.40		4.43
PULL #4	4.37	4.43		4.45
PULL #5	4.37	4.42		4.44
TOTAL	22.00	22.12		22.29
AVG.	4.4	4.424		4.458

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C522304
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.229009
1 TO	2	.200562
1 TO	3	.471985
1 TO	4	.317328
1 TO	5	.355857

POI (----POI)

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0548
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0754
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0932105
THE AMR FOR THIS RIFLE IS: .7844

20 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522304

CENTERFIRE PATTERNS

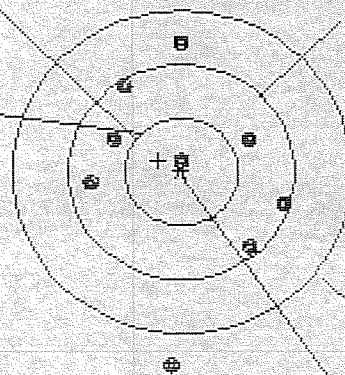
1

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.747

VS= 2.971

GS= 2.973

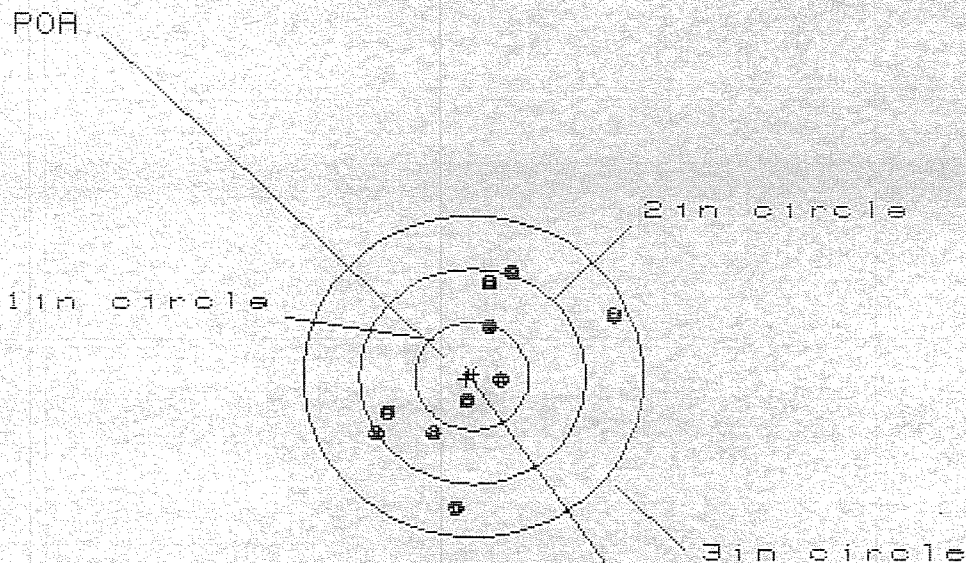
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.884	.883
MINIMUM X	-.850	-.863	-.864
MAXIMUM Y	1.182	.983	.684
MINIMUM Y	-1.789	-.874	-.751
CENTROID X	.203	.216	.217
CENTROID Y	-.106	.093	-.030
POA TO CENTROID in.	.229	.235	.219
MIN RADIUS	.109	.062	.037
MEAN RADIUS	.819	.678	.630
MAX RADIUS	1.793	1.027	.940
HORIZONTAL SPREAD	1.747	1.747	1.747
VERTICAL SPREAD	2.971	1.857	1.435
EXTREME SPREAD	2.973	1.937	1.789
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

28 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.140

VS = 2.177

GS = 2.403

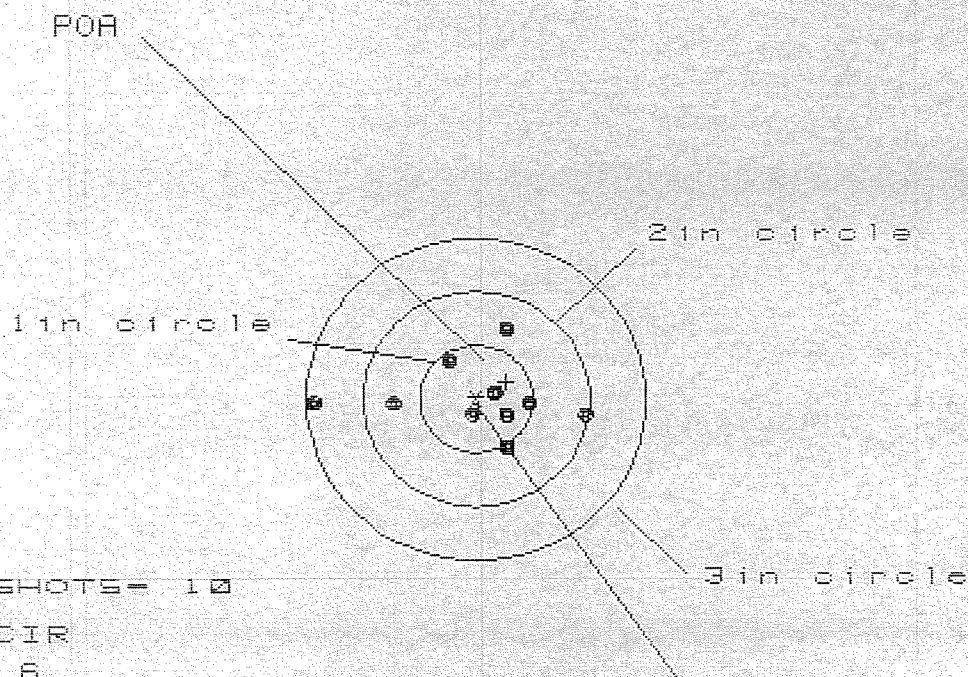
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	.502	.503
MINIMUM X	:	-.892	-.753	-.752
MAXIMUM Y	:	1.000	1.060	.921
MINIMUM Y	:	-1.177	-1.117	-.631
CENTROID X	:	.052	-.087	-.088
CENTROID Y	:	.026	-.034	.105
POA TO CENTROID in.	:	.058	.093	.137
MIN RADIUS	:	.214	.243	.371
MEAN RADIUS	:	.798	.727	.686
MAX RADIUS	:	1.361	1.173	1.049
HORIZONTAL SPREAD	:	2.140	1.255	1.255
VERTICAL SPREAD	:	2.177	2.177	1.552
EXTREME SPREAD	:	2.403	2.231	1.996
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 6

2in = 9

3in = 10

HS = 2.391

VS = 1.088

GS = 2.395

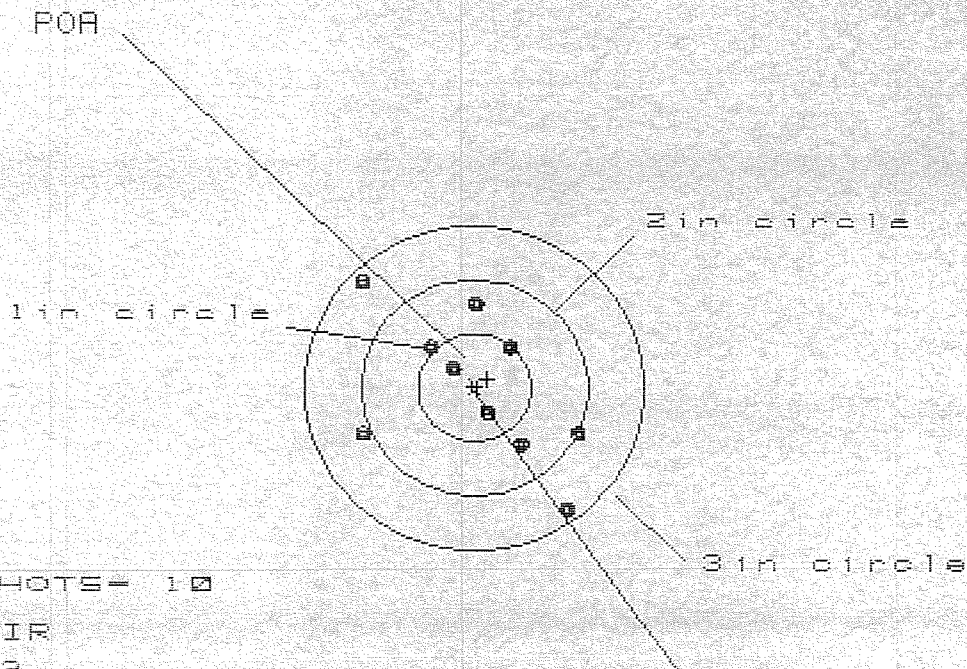
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.799	.365
MINIMUM X	-1.433	-.871	-.771
MAXIMUM Y	.678	.671	.647
MINIMUM Y	-.410	-.417	-.441
CENTROID X	-.266	-.107	-.207
CENTROID Y	-.159	-.152	-.128
POA TO CENTROID in.	.310	.186	.243
MIN RADIUS	.113	.075	.151
MEAN RADIUS	.578	.447	.412
MAX RADIUS	1.434	.874	.778
HORIZONTAL SPREAD	2.391	1.670	1.136
VERTICAL SPREAD	1.088	1.088	1.088
EXTREME SPREAD	2.395	1.674	1.206
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.886

VS = 2.125

GS = 2.792

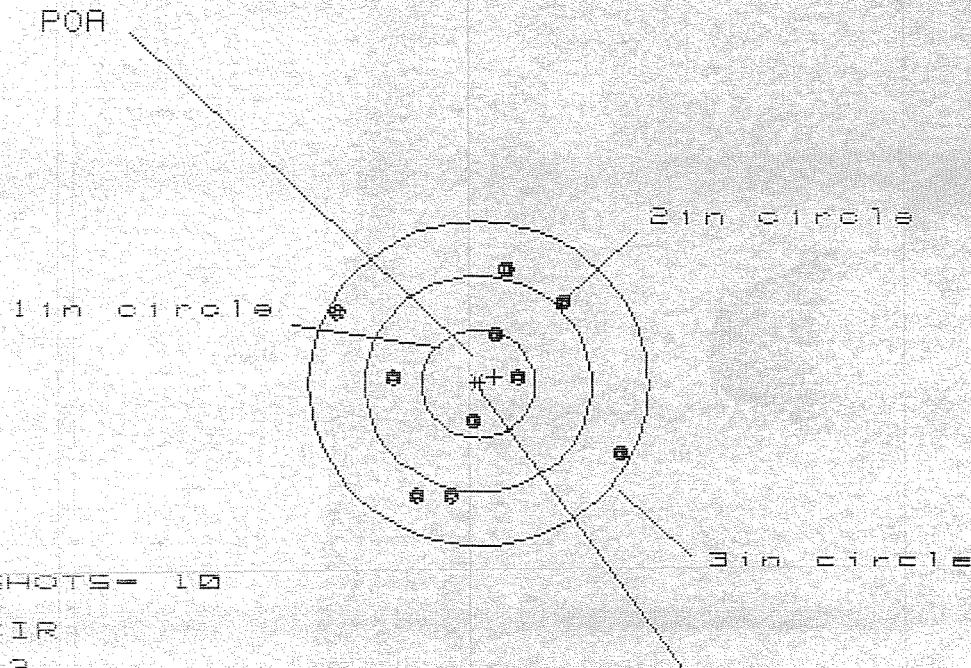
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.966	.859
MINIMUM X	:	-1.015	-.920	-1.027
MAXIMUM Y	:	1.004	.879	.767
MINIMUM Y	:	-1.121	-.677	-.567
CENTROID X	:	-.113	-.208	-.100
CENTROID Y	:	-.077	.048	-.062
POA TO CENTROID in.	:	.137	.213	.118
MIN RADIUS	:	.231	.082	.232
MEAN RADIUS	:	.796	.709	.645
MAX RADIUS	:	1.410	1.230	1.131
HORIZONTAL SPREAD	:	1.886	1.886	1.886
VERTICAL SPREAD	:	2.125	1.556	1.334
EXTREME SPREAD	:	2.792	2.297	1.887
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 10

HS = 2.487

VS = 2.148

GS = 2.887

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.273	.932	.798
MINIMUM X	:	-1.214	-1.072	-.730
MAXIMUM Y	:	1.107	1.033	1.103
MINIMUM Y	:	-1.041	-1.115	-1.045
CENTROID X	:	-.150	-.292	-.158
CENTROID Y	:	-.061	.013	-.057
POR TO CENTROID in.	:	.162	.292	.168
MIN RADIUS	:	.348	.475	.354
MEAN RADIUS	:	.931	.875	.813
MAX RADIUS	:	1.439	1.209	1.177
HORIZONTAL SPREAD	:	2.487	2.004	1.528
VERTICAL SPREAD	:	2.148	2.148	2.148
EXTREME SPREAD	:	2.887	2.284	2.284
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington®

MODEL 700™ H24

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

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

SERIAL NO.
C6522304

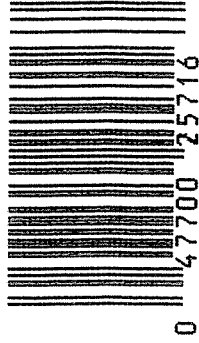
ORDER NO.
5716

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

Ø1



UPC



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