

C6498831

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498831

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	L.S.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/2/90	JH
	G) Safety Off Force	3	3	3			8/2/90	JH
	H) Trigger Pull Test & Retainability						8/17/90	JH
	I) Firing Pin Indent	.023	.023	.023			8/2/90	JH
	J) Assemble Stock						8/7/90	RW
	K) Assemble Swivel Studs						2/29/90	JH
	L) Attach Front and Rear Sight Assemblies						8/7/90	RW
	M) Iron Sight Alignment						8/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/90	RW
	O) Attach Scope to Rifle						8/7/90	RW
	P) Detach & Attach Scope 20 Times						8/7/90	RW
640	Gallery Target & Test						8-7-90	DH
	A) Time						8-7-90	DH
	B) Malfunctions						8-7-90	DH
	C) Pierced Primers						8-7-90	DH
	D) Optical Clarity of Scope						8-7-90	DH
645	Inspect for Live Ammo						8-7-90	DH
655	Final Inspection							
	A) Headspace						2/29/90	JH
	B) Trigger Pull	234	232	235	230	224	2/29/90	JH
	C) Function						2/29/90	JH
660	Pack						9/20/90	RF

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

SERIAL NO. C6498831DATE 8/17/90TESTER JY.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.41	2.40	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.46	2.46	2.32	
PULL #3	2.44	2.48	2.32	2.35	
PULL #4	2.48	2.49	2.50	2.24	
PULL #5	2.42	2.44	2.40	2.30	
TOTAL	12.16	12.28	12.08	11.55	
AVG.	2.432	2.456	2.416	2.31	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.28		
PULL #2	3.12	3.26		
PULL #3	3.15	3.32		
PULL #4	3.20	3.30		
PULL #5	3.21	3.26		
TOTAL	15.89	16.42		
AVG.	3.178	3.284		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.31		4.28
PULL #2	4.05	4.31		4.32
PULL #3	4.20	4.23		4.39
PULL #4	4.19	4.36		4.35
PULL #5	4.44	4.36		4.34
TOTAL	21.10	21.57		21.68
AVG.	4.22	4.314		4.336

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498831
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	1.19139
1 TO	2	1.14447
1 TO	3	.843152
1 TO	4	1.31526
1 TO	5	1.01433

$\frac{1}{5} \sum_{i=1}^5 x_i$ <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4186
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2316
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .478398
 THE AMR FOR THIS RIFLE IS: .8406

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498031

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 1.969

VS = 2.007

GS = 2.249

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	1.014	.895
MINIMUM X	:	-1.014	-.955	-.845
MAXIMUM Y	:	.922	.801	.730
MINIMUM Y	:	-1.085	-.584	-.655
CENTROID X	:	.538	.479	.598
CENTROID Y	:	-1.063	-.942	-.871
POR TO CENTROID in.	:	1.191	1.057	1.057
MIN RADIUS	:	.499	.465	.342
MEAN RADIUS	:	.831	.781	.723
MAX RADIUS	:	1.210	1.109	.907
HORIZONTAL SPREAD	:	1.969	1.969	1.740
VERTICAL SPREAD	:	2.007	1.385	1.385
EXTREME SPREAD	:	2.249	2.032	1.746
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Aug 1998

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.384

VS= 1.605

GS= 2.579

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.912	.748	.688
MINIMUM X	:	-1.472	-1.032	-.938
MAXIMUM Y	:	.764	.827	.655
MINIMUM Y	:	-.841	-.778	-.675
CENTROID X	:	.596	.760	.666
CENTROID Y	:	.080	.017	-.086
POA TO CENTROID in.	:	.602	.760	.672
MIN RADIUS	:	.171	.007	.133
MEAN RADIUS	:	.810	.685	.625
MAX RADIUS	:	1.577	1.139	1.106
HORIZONTAL SPREAD	:	2.384	1.780	1.626
VERTICAL SPREAD	:	1.605	1.605	1.330
EXTREME SPREAD	:	2.579	2.004	2.004
NUMBER IN ONE INCH CIRCLE	=		2	
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 = 2.485

VS = 3.208

GS = 3.252

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	1.031	1.003
MINIMUM X	:	-1.378	-1.454	-1.482
MAXIMUM Y	:	1.568	1.386	.683
MINIMUM Y	:	-1.640	-.729	-.556
CENTROID X	:	.554	.630	.658
CENTROID Y	:	-.220	-.038	-.211
POA TO CENTROID in.	:	.596	.631	.691
MIN RADIUS	:	.058	.139	.096
MEAN RADIUS	:	.861	.750	.640
MAX RADIUS	:	1.776	1.455	1.498
HORIZONTAL SPREAD	:	2.485	2.485	2.485
VERTICAL SPREAD	:	3.208	2.115	1.239
EXTREME SPREAD	:	3.252	2.538	2.538
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

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.665

VS= 3.090

GS= 3.448

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.690

.597

.603

MINIMUM X

-.975

-1.068

-.993

MAXIMUM Y

1.650

1.237

1.080

MINIMUM Y

-1.440

-1.256

-.672

CENTROID X

.400

.493

.418

CENTROID Y

.245

.062

.219

POA TO CENTROID in.

.469

.497

.472

MIN RADIUS

.303

.098

.271

MEAN RADIUS

.904

.753

.692

MAX RADIUS

1.851

1.391

1.183

HORIZONTAL SPREAD

1.665

1.665

1.596

VERTICAL SPREAD

3.090

2.493

1.752

EXTREME SPREAD

3.448

2.747

1.903

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

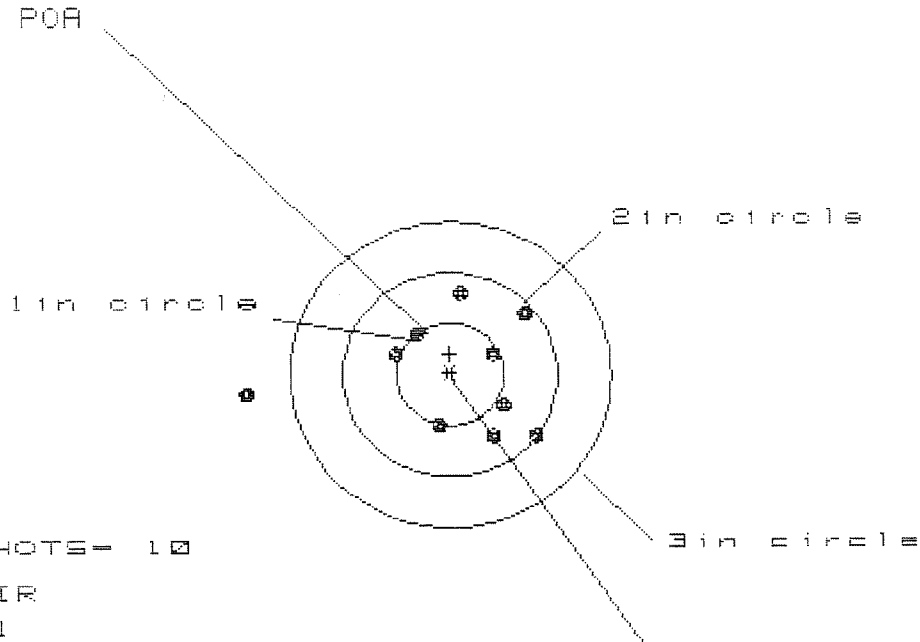
NUMBER IN THREE INCH CIRCLE =

8

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 9

3 in = 9

HS= 2.661

VS= 1.379

GS= 2.696

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.774	.564	.521
MINIMUM X	-1.887	-.762	-.691
MAXIMUM Y	.750	.733	.657
MINIMUM Y	-.629	-.646	-.722
CENTROID X	.005	.215	.144
CENTROID Y	-.200	-.183	-.107
POA TO CENTROID in.	.200	.282	.180
MIN RADIUS	.432	.241	.270
MEAN RADIUS	.797	.640	.615
MAX RADIUS	1.893	.826	.776
HORIZONTAL SPREAD	2.661	1.326	1.212
VERTICAL SPREAD	1.379	1.379	1.379
EXTREME SPREAD	2.696	1.548	1.416
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

Remington



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

MODEL 700TM M24

SERIAL NO.
C6498831

ORDER NO.
5716

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

01



5716 C6498831

UPC



0 47700 25716 7

BARBER - M24 0008507

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 000850708546