

C6594520

MODEL 700TM M24

Model **S4S**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

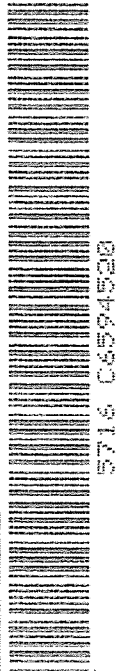
DUPONT

MODEL 700™ M24

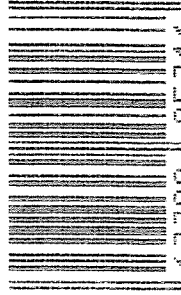
SERIAL NO. C6594520

ORDER NO. 5716

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



UPC



7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594520

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1	10 91	LB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-12-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	RM

BARBER - M24 0018524

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			2/4/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/4/91	WB
	H) Trigger Pull Test & Retainability						1/30/90	HL
	I) Firing Pin Indent	.0225	.022	.022			2/4/91	WB
	J) Assemble Stock						2/6/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/6/91	RW
	M) Iron Sight Alignment						2/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/6/91	RW
	O) Attach Scope to Rifle						2/6/91	RW
	P) Detach & Attach Scope 20 Times						2/6/91	RW
640	Gallery Target & Test						2/6/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						2/6/91	KS
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.37	2.26	2.15	2.11	2.34	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C 6594520

DATE 1-30-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.40	2.30	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.38	2.26	
PULL #3	2.47	2.31	2.30	2.15	
PULL #4	2.30	2.40	2.35	2.11	
PULL #5	2.41	2.33	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.34		
PULL #2	3.43	3.33		
PULL #3	3.30	3.11		
PULL #4	3.43	3.24		
PULL #5	3.39	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.34		4.27
PULL #2	4.44	4.28		4.49
PULL #3	4.25	4.22		4.38
PULL #4	4.40	4.23		4.15
PULL #5	4.27	4.20		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C659 **4520**
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.223647
1 TO	2	.106888
1 TO	3	.239353
1 TO	4	.0430465
1 TO	5	.173416

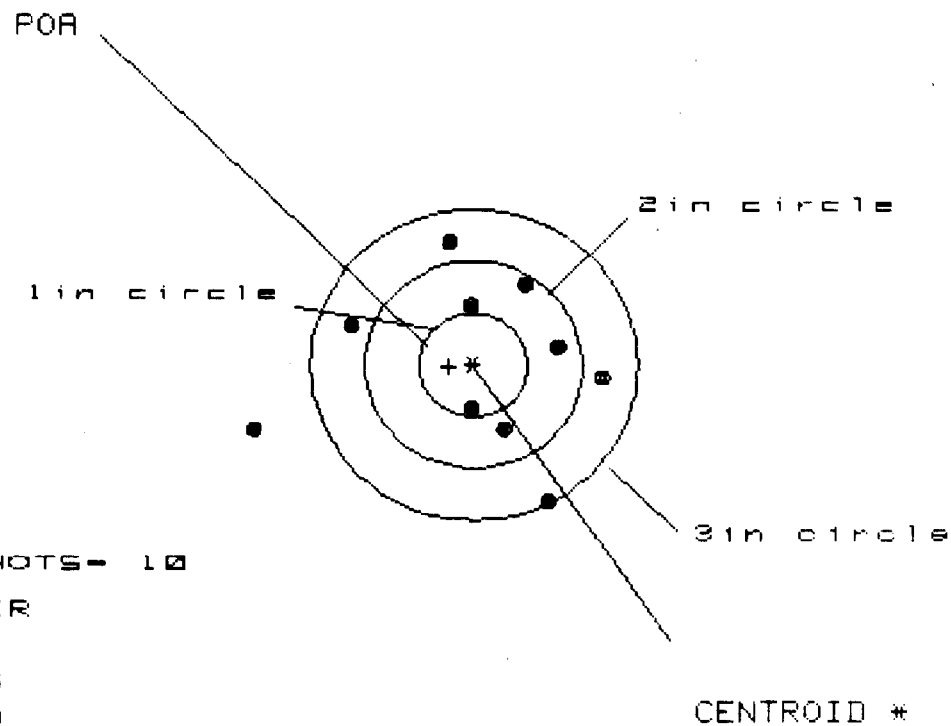
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0316
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162500
THE RMR FOR THIS RIFLE IS: .8866

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FILE:/PATTERNING/CENTERFIRE_PATT/ C6594520

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.169

VS= 2.511

GS= 3.201

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	.942	1.000
MINIMUM X	:	-2.004	-1.317	-1.259
MAXIMUM Y	:	1.185	1.119	.945
MINIMUM Y	:	-1.326	-1.392	-.870
CENTROID X	:	.223	.446	.388
CENTROID Y	:	.017	.083	.257
POA TO CENTROID in.	:	.224	.453	.466
MIN RADIUS	:	.461	.549	.402
MEAN RADIUS	:	1.053	.903	.817
MAX RADIUS	:	2.091	1.465	1.270
HORIZONTAL SPREAD	:	3.169	2.259	2.259
VERTICAL SPREAD	:	2.511	2.511	1.815

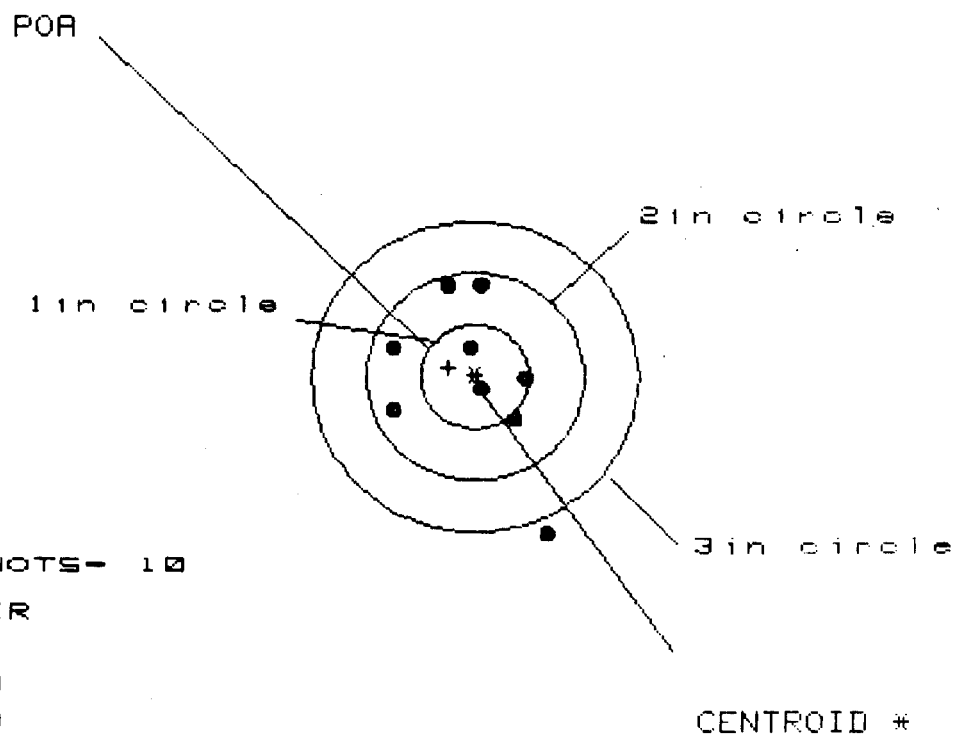
BARBER - M24 0018528

EXTREME	SPREAD :	3.201	2.654	2.325
NUMBER IN ONE	INCH CIRCLE	=	1	
NUMBER IN TWO	INCH CIRCLE	=	5	
NUMBER IN THREE	INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 9

HS= 1.401

VS= 2.375

GS= 2.547

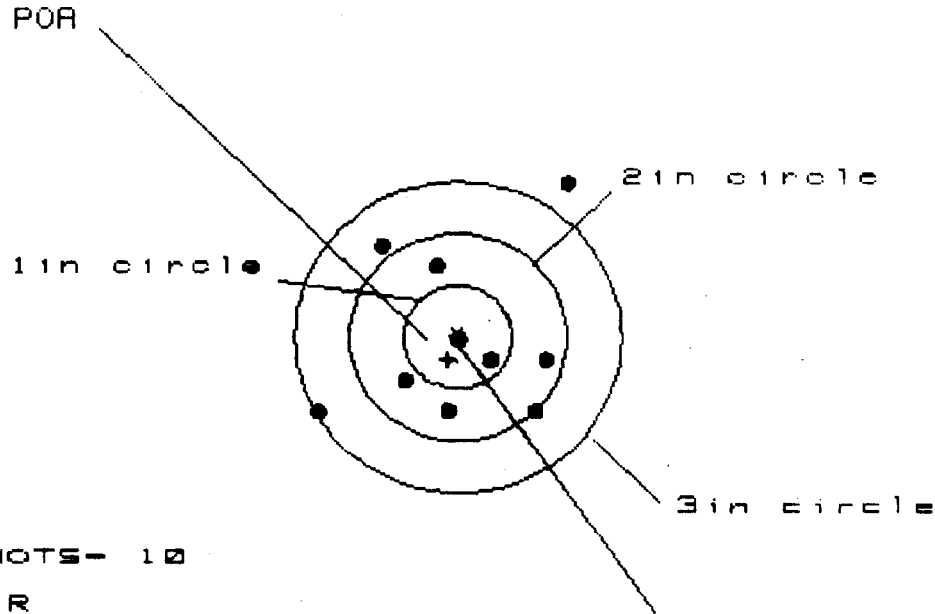
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.689	.548	.528
MINIMUM X	-.712	-.635	-.655
MAXIMUM Y	.897	.733	.791
MINIMUM Y	-1.478	-.577	-.486
CENTROID X	.243	.166	.186
CENTROID Y	-.088	.076	-.015
POR TO CENTROID in.	.258	.183	.186
MIN RADIUS	.098	.142	.190
MEAN RADIUS	.652	.547	.508
MAX RADIUS	1.631	.782	.797
HORIZONTAL SPREAD	1.401	1.183	1.183
VERTICAL SPREAD	2.375	1.310	1.277
EXTREME SPREAD	2.547	1.416	1.378
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.296

VS= 2.168

GS= 3.158

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.005	.878	.731
MINIMUM X	-1.291	-1.179	-.759
MAXIMUM Y	1.444	1.087	1.016
MINIMUM Y	-.724	-.563	-.604
CENTROID X	.090	-.022	.125
CENTROID Y	.216	.055	.126
POA TO CENTROID in.	.234	.060	.178
MIN RADIUS	.045	.200	.064
MEAN RADIUS	.865	.759	.662
MAX RADIUS	1.760	1.307	1.269
HORIZONTAL SPREAD	2.296	2.057	1.490
VERTICAL SPREAD	2.168	1.650	1.620
EXTREME SPREAD	3.158	2.171	2.171
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

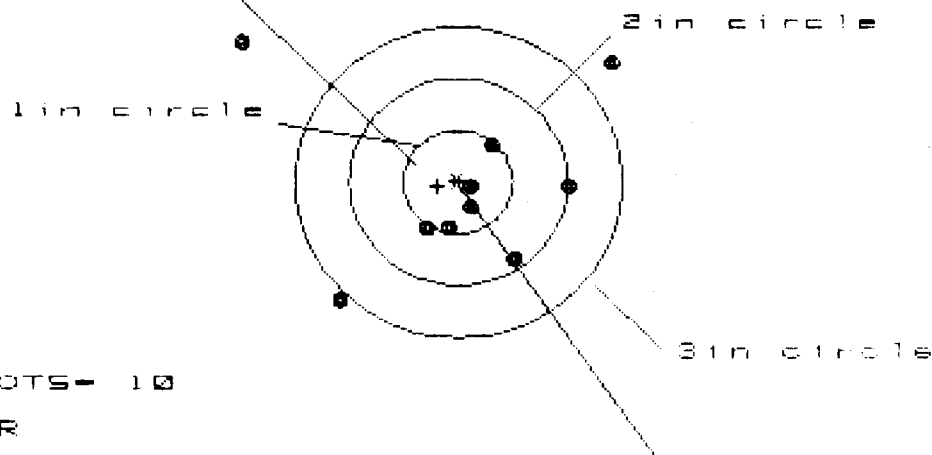
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CENTERFIRE PATTERNS

4

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

H0 = 3.330

V0 = 2.463

G0 = 3.330

CENTROID +

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.159	.962
MINIMUM X	:	-1.945	-1.303	-1.158
MAXIMUM Y	:	1.374	1.268	.715
MINIMUM Y	:	-1.089	-.937	-.778
CENTROID X	:	.186	.402	.257
CENTROID Y	:	.039	-.113	-.272
FOR TO CENTROID in.	:	.190	.418	.374
MIN RADIUS	:	.070	.150	.100
MEAN RADIUS	:	.937	.742	.589
MAX RADIUS	:	2.381	1.718	1.395
HORIZONTAL SPREAD	:	3.320	2.462	2.120
VERTICAL SPREAD	:	2.463	2.205	1.493
EXTREME SPREAD	:	3.330	3.305	2.382
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 10

CENTROID *

HS = 2.095

VS = 2.424

GS = 2.491

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.146	1.159	1.103
MINIMUM X	:	-.949	-.936	-.992
MAXIMUM Y	:	1.298	.895	.772
MINIMUM Y	:	-1.126	-.981	-.997
CENTROID X	:	.055	.042	.098
CENTROID Y	:	-.026	-.171	-.048
POA TO CENTROID in.	:	.061	.176	.110
MIN RADIUS	:	.250	.110	.244
MEAN RADIUS	:	.926	.854	.841
MAX RADIUS	:	1.303	1.267	1.164
HORIZONTAL SPREAD	:	2.095	2.095	2.095
VERTICAL SPREAD	:	2.424	1.876	1.769
EXTREME SPREAD	:	2.491	2.308	2.283
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	