

C6594588

MODEL 700TM M24

Model S&S TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700™ M24

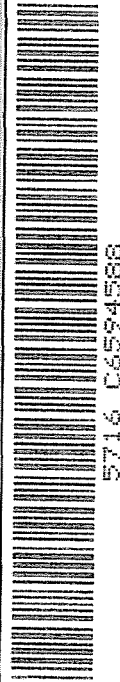
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

DU PONT
REG. U.S. PAT. & T.M. OFF.

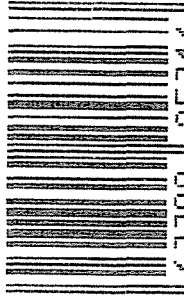
SERIAL NO.
C6594588

ORDER NO.
5716



5716 C6594588

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594588

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 1	91	LS
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		8-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/91	JH

op. #	BARBER M24 0019825	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	3/4/91	YH
	G) Safety Off Force	3	3	3	3/4/91	YH
	H) Trigger Pull Test & Retainability				3/2/91	YH
	I) Firing Pin Indent	.0215	.022	.022	3/4/91	YH
	J) Assemble Stock				3/5/91	RW
	K) Assemble Swivel Studs				3-8-91	D/H
	L) Attach Front and Rear Sight Assemblies				3/5/91	RW
	M) Iron Sight Alignment				3/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container				3/5/91	RW
	O) Attach Scope to Rifle				3/5/91	RW
	P) Detach & Attach Scope 20 Times				3/5/91	RW
640	Gallery Target & Test				3/5/91	RW
	A) Time					12
	B) Malfunctions					12
	C) Pierced Primers					12
	D) Optical Clarity of Scope					12
645	Inspect for Live Ammo				3/5/91	12
655	Final Inspection					
	A) Headspace				3-8-91	D/H
	B) Trigger Pull	2.33	2.38	2.49	3/8/91	YH
	C) Function				3-8-91	D/H
660	Pack				3-11-91	N

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

SERIAL NO. C6594588
DATE 3-2-91
TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.23	2.41	2.33	MIN. SETTING,
PULL #2	2.26	2.17	2.46	2.38	NO AVG. OF 5
PULL #3	2.28	2.23	2.29	2.49	READINGS ACCEP-
PULL #4	2.34	2.19	2.31	2.58	TABLE LESS THAN 2#
PULL #5	2.19	2.19	2.34	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.17		
PULL #2	3.29	3.32		
PULL #3	3.23	3.28		
PULL #4	3.29	3.14		
PULL #5	3.26	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.44		4.46
PULL #2	4.32	4.45		4.32
PULL #3	4.40	4.48		4.31
PULL #4	4.23	4.30		4.32
PULL #5	4.41	4.53		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594588
6 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0212603
1 TO	2	.205361
1 TO	3	.387156
1 TO	4	.0288617
1 TO	5	.290462

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45 <----FOR

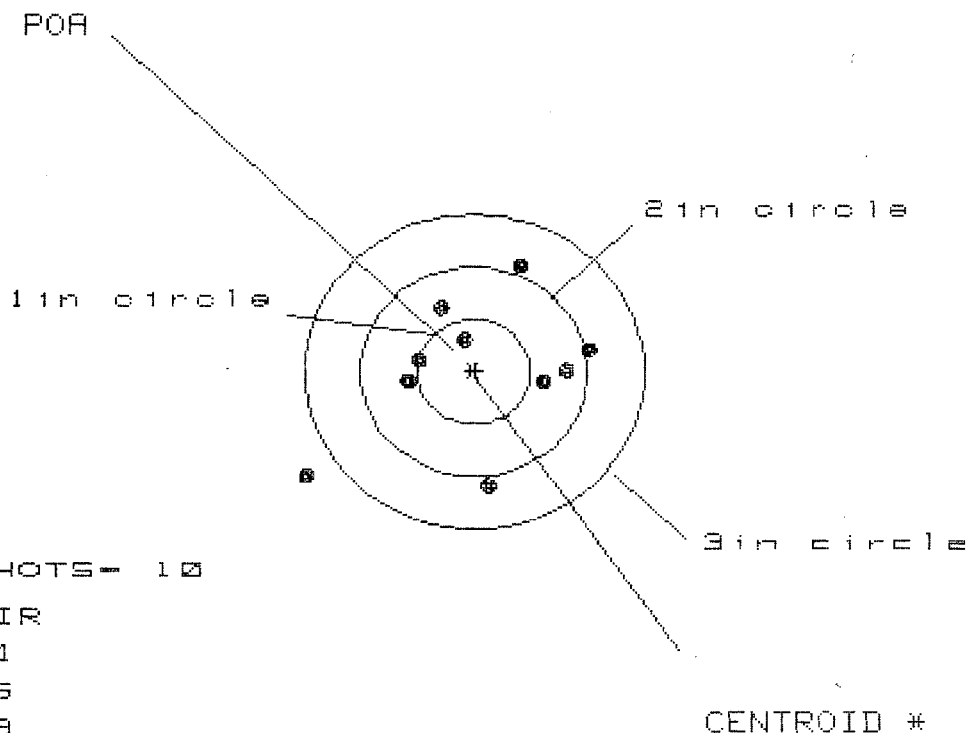
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0893505
THE AMR FOR THIS RIFLE IS: .9956

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C653945B8

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.489

VS= 2.101

GS= 2.732

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.846	.872
MINIMUM X	:	-1.479	-.699	-.673
MAXIMUM Y	:	1.057	.953	.622
MINIMUM Y	:	-1.044	-1.148	-1.029
CENTROID X	:	-.016	.148	.122
CENTROID Y	:	-.014	.090	-.029
POA TO CENTROID in.	:	.021	.173	.125
MIN RADIUS	:	.304	.322	.384
MEAN RADIUS	:	.850	.735	.704
MAX RADIUS	:	1.751	1.149	1.029
HORIZONTAL SPREAD	:	2.489	1.545	1.545
VERTICAL SPREAD	:	2.101	2.101	1.651
EXTREME SPREAD	:	2.732	2.118	1.706
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594588

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 1.704

VS= 3.249

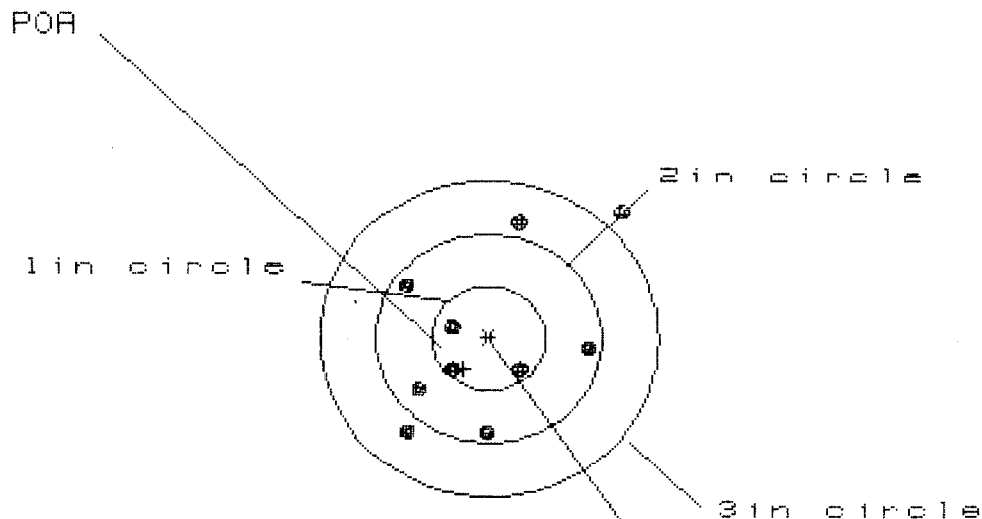
GS= 3.312

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.007	.979	.888
MINIMUM X	:	-.697	-.725	-.774
MAXIMUM Y	:	1.647	1.683	1.191
MINIMUM Y	:	-1.602	-1.419	-1.208
CENTROID X	:	.021	.049	.140
CENTROID Y	:	-.216	-.399	-.610
POA TO CENTROID in.	:	.217	.402	.625
MIN RADIUS	:	.169	.229	.395
MEAN RADIUS	:	1.085	1.017	.908
MAX RADIUS	:	1.666	1.833	1.238
HORIZONTAL SPREAD	:	1.704	1.704	1.662
VERTICAL SPREAD	:	3.249	3.102	2.399
EXTREME SPREAD	:	3.312	3.287	2.466
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594588

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.984

VS= 2.082

GS= 2.876

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	.994	.915
MINIMUM X	:	-.763	-.627	-.659
MAXIMUM Y	:	1.222	1.201	1.111
MINIMUM Y	:	-.860	-.724	-.814
CENTROID X	:	.225	.089	.168
CENTROID Y	:	.289	.153	.243
POA TO CENTROID in.	:	.366	.177	.296
MIN RADIUS	:	.292	.205	.259
MEAN RADIUS	:	.842	.698	.678
MAX RADIUS	:	1.728	1.275	1.164
HORIZONTAL SPREAD	:	1.984	1.621	1.574
VERTICAL SPREAD	:	2.082	1.925	1.925
EXTREME SPREAD	:	2.876	2.195	1.949
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594588

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.787

VS= 1.704

GS= 2.827

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.410	1.464	1.311
MINIMUM X	:	-1.377	-1.220	-.570
MAXIMUM Y	:	1.017	.941	.905
MINIMUM Y	:	-.687	-.682	-.718
CENTROID X	:	-.044	-.201	-.048
CENTROID Y	:	-.021	.055	.091
POA TO CENTROID in.	:	.049	.208	.103
MIN RADIUS	:	.283	.198	.331
MEAN RADIUS	:	.880	.774	.728
MAX RADIUS	:	1.568	1.464	1.311
HORIZONTAL SPREAD	:	2.787	2.684	1.881
VERTICAL SPREAD	:	1.704	1.623	1.623
EXTREME SPREAD	:	2.827	2.701	1.987
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Mar 1981

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 2.487

VS= 3.131

GS= 3.299

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	1.099	1.143
MINIMUM X	:	-1.488	-1.388	-1.344
MAXIMUM Y	:	1.393	1.221	.982
MINIMUM Y	:	-1.738	-1.910	-1.224
CENTROID X	:	.252	.152	.108
CENTROID Y	:	-.126	.046	.285
POA TO CENTROID in.	:	.282	.159	.305
MIN RADIUS	:	.777	.621	.558
MEAN RADIUS	:	1.321	1.250	1.136
MAX RADIUS	:	1.790	1.942	1.430
HORIZONTAL SPREAD	:	2.487	2.487	2.487
VERTICAL SPREAD	:	3.131	3.131	2.206
EXTREME SPREAD	:	3.299	3.189	2.769
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	