

65594650

MODEL 700™ M24

Model S&S™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

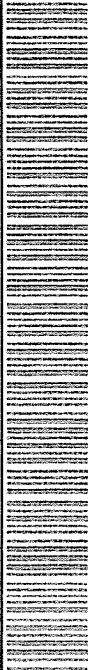
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6594650

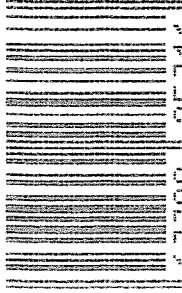
ORDER NO.
5716

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



5716 C6594650

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594650

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	KS
600	Proof		12/27/90	KS
607	Check Headspace		12/27/90	KS
610	Dis-assemble Gun		12/27/90	KS
612	Magnaflux Barrel Action		1-9-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-27-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/29/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/91	KS
	C) Inspect Ejector Hole for Chamfer		1/29/91	KS
	D) Oil Firing Pin Ass'y		1/29/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/10/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			1/30/91	WB
	G) Safety Off Force	3	3	3			1/30/91	WB
	H) Trigger Pull Test & Retainability						2/21/91	X
	I) Firing Pin Indent	.020	.020	.020			1/30/91	WB
	J) Assemble Stock						1/31/91	KS
	K) Assemble Swivel Studs						2-21-91	A
	L) Attach Front and Rear Sight Assemblies						1/31/91	KS
	M) Iron Sight Alignment						1/31/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/31/91	KS
	O) Attach Scope to Rifle						1/31/91	KS
	P) Detach & Attach Scope 20 Times						1/31/91	KS
640	Gallery Target & Test						1-31-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect. for Live Ammo						1-31-91	NF
655	Final Inspection							
	A) Headspace						2-21-91	A
	B) Trigger Pull	2.48	2.49	2.42	2.40	2.38	2/20/91	WB
	C) Function						2-21-91	A
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594658

DATE 2/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.31	2.26	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.29	2.24	2.49	
PULL #3	2.44	2.20	2.24	2.47	
PULL #4	2.42	2.24	2.25	2.40	
PULL #5	2.43	2.24	2.23	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.49		
PULL #2	3.16	3.43		
PULL #3	3.47	3.41		
PULL #4	3.44	3.44		
PULL #5	3.44	3.39		
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	4.21		4.14
PULL #2	4.19	4.18		4.16
PULL #3	4.20	4.20		4.17
PULL #4	4.20	4.22		4.18
PULL #5	4.20	4.17		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594650
31 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.184011
1 TO	2	.0451885
1 TO	3	.441328
1 TO	4	.206787
1 TO	5	.335622

15
4
3

<----POB

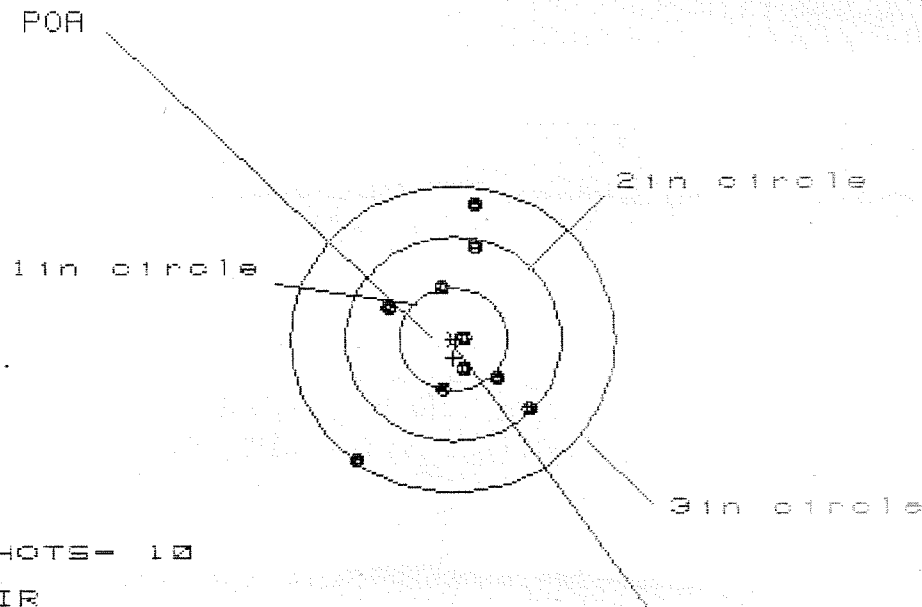
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0552
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133725

THE AMR FOR THIS RIFLE IS: .8472

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594650

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.610

VS= 2.443

GS= 2.677

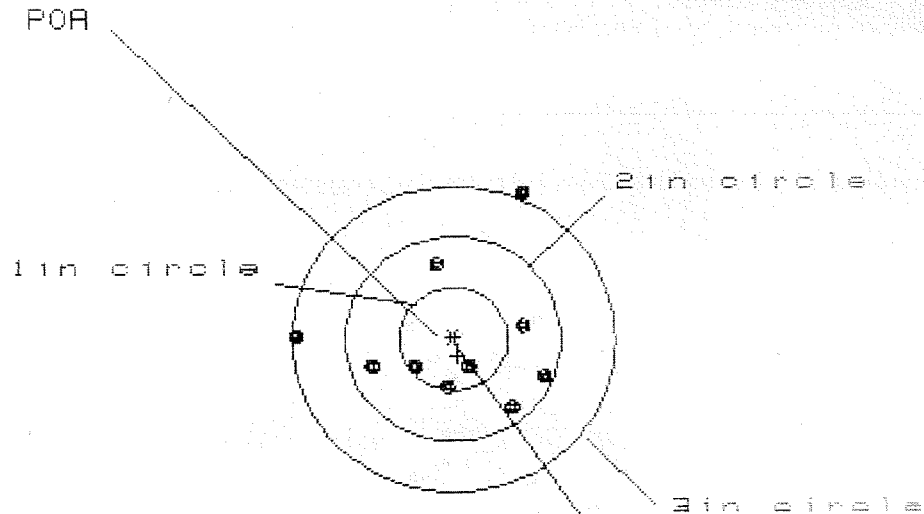
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.700	.599	.610
MINIMUM X	:	-.910	-.726	-.715
MAXIMUM Y	:	1.298	1.171	.943
MINIMUM Y	:	-1.145	-.803	-.656
CENTROID X	:	.002	.103	.092
CENTROID Y	:	.184	.311	.164
POA TO CENTROID in.	:	.184	.327	.188
MIN RADIUS	:	.134	.096	.067
MEAN RADIUS	:	.741	.659	.565
MAX RADIUS	:	1.462	1.174	.951
HORIZONTAL SPREAD	:	1.610	1.325	1.325
VERTICAL SPREAD	:	2.443	1.974	1.599
EXTREME SPREAD	:	2.677	2.040	1.670
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 8

3 in - 9

HS = 2.262

VS = 2.096

GS = 2.517

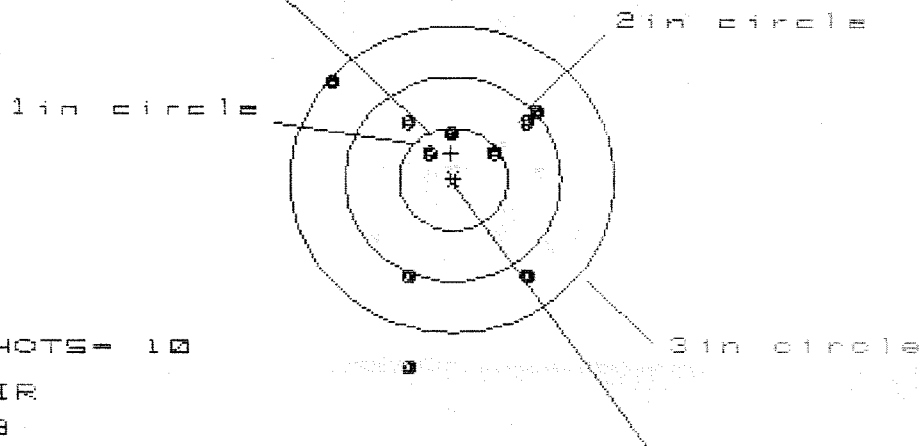
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.811	.880	.707
MINIMUM X	-1.451	-1.382	-.862
MAXIMUM Y	1.411	.924	.942
MINIMUM Y	-.685	-.528	-.510
CENTROID X	-.039	-.108	.065
CENTROID Y	.165	.008	-.010
POA TO CENTROID in.	.169	.108	.065
MIN RADIUS	.323	.228	.131
MEAN RADIUS	.823	.704	.602
MAX RADIUS	1.543	1.389	.976
HORIZONTAL SPREAD	2.262	2.262	1.569
VERTICAL SPREAD	2.096	1.452	1.452
EXTREME SPREAD	2.517	2.291	1.614
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

31 Jan 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.915

VS= 2.822

GS= 2.912

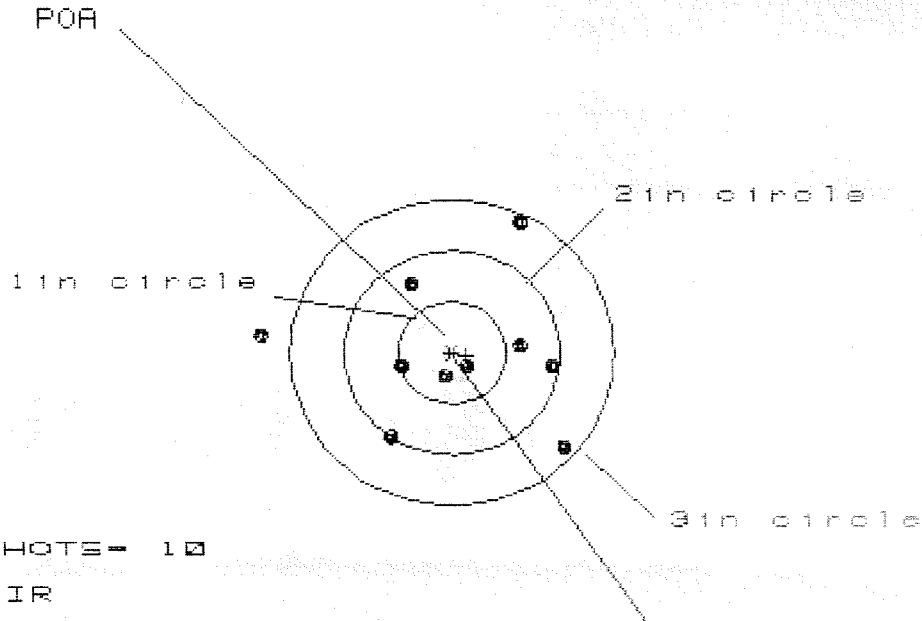
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.771	.724	.575
MINIMUM X	:	-1.145	-1.192	-.606
MAXIMUM Y	:	1.004	.802	.540
MINIMUM Y	:	-1.818	-1.175	-1.075
CENTROID X	:	.019	.066	.215
CENTROID Y	:	-.257	-.055	-.155
POA TO CENTROID in.	:	.258	.086	.265
MIN RADIUS	:	.342	.248	.279
MEAN RADIUS	:	.937	.771	.701
MAX RADIUS	:	1.867	1.436	1.198
HORIZONTAL SPREAD	:	1.916	1.916	1.181
VERTICAL SPREAD	:	2.822	1.977	1.615
EXTREME SPREAD	:	2.912	2.721	1.954
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

31 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.746

VS= 2.127

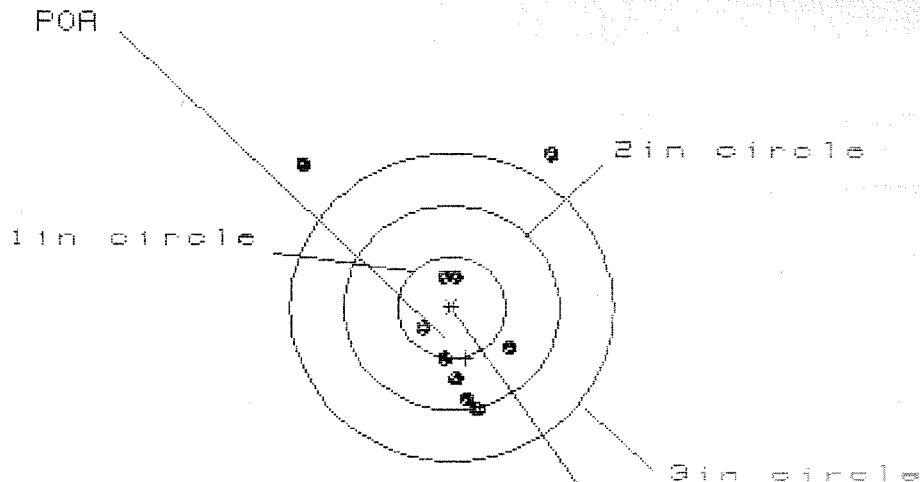
GS= 2.958

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.792	.846
MINIMUM X	:	-1.759	-.726	-.672
MAXIMUM Y	:	1.247	1.271	.895
MINIMUM Y	:	-.880	-.856	-.697
CENTROID X	:	-.129	.066	.012
CENTROID Y	:	.024	-.000	-.159
POA TO CENTROID in.	:	.131	.066	.159
MIN RADIUS	:	.148	.125	.086
MEAN RADIUS	:	.875	.766	.673
MAX RADIUS	:	1.773	1.343	1.096
HORIZONTAL SPREAD	:	2.746	1.518	1.518
VERTICAL SPREAD	:	2.127	2.127	1.592
EXTREME SPREAD	:	2.958	2.356	2.087
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HE= 2.384

VS= 2.544

GS= 2.927

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.814	.513
MINIMUM X	:	-1.413	-.466	-.364
MAXIMUM Y	:	1.544	1.705	.729
MINIMUM Y	:	-1.000	-.839	-.626
CENTROID X	:	-.129	.028	-.073
CENTROID Y	:	.493	.332	.119
POA TO CENTROID in.	:	.510	.333	.140
MIN RADIUS	:	.277	.433	.200
MEAN RADIUS	:	.860	.704	.490
MAX RADIUS	:	2.026	1.889	.732
HORIZONTAL SPREAD	:	2.384	1.280	.878
VERTICAL SPREAD	:	2.544	2.544	1.355
EXTREME SPREAD	:	2.927	2.663	1.368
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	