

C6594672

MODEL 700™ M24

Model **S&S**™

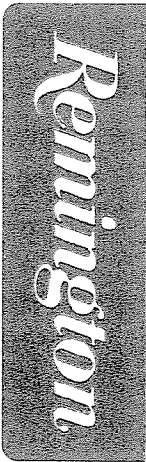
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700TM M24

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

SERIAL NO.
C6594672

ORDER NO.
5716

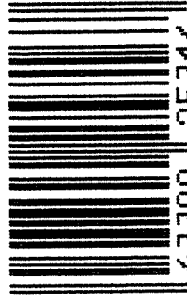
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6594672

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594672

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18 91		KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		SS
617	Drill and Tap Sight Holes	1 24 91		FB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly		3/8/91	KL
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KL
	C) Inspect Ejector Hole for Chamfer		3/8/91	KL
	D) Oil Firing Pin Ass'y		3/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		3/27/91	KL

op. #	BARBER - M24 0021542 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/27/91	JH
	G) Safety Off Force	2	2	2			3/27/91	JH
	H) Trigger Pull Test & Retainability						3/27/91	JH
	I) Firing Pin Indent	020	020	020			3/27/91	JH
	J) Assemble Stock						4-1-91	KS
	K) Assemble Swivel Studs						4-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4-1-91	KS
	M) Iron Sight Alignment						4-1-91	KS
	N) Detach Front & Rear Sights & place in numbered container						4-1-91	KS
	O) Attach Scope to Rifle						4-1-91	KS
	P) Detach & Attach Scope 20 Times						4-1-91	KS
640	Gallery Target & Test						4-3-91	DH
	A) Time						4-3-91	DH
	B) Malfunctions						4-3-91	DH
	C) Pierced Primers						4-3-91	DH
	D) Optical Clarity of Scope						4-3-91	DH
645	Inspect for Live Ammo						4-3-91	DH
655	Final Inspection							
	A) Headspace						4-8-91	DH
	B) Trigger Pull	2.39	2.21	2.32	2.35	2.20	4/5/91	JH
	C) Function						4-8-91	DH
660	Pack						6-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594672

DATE 3/27/91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.42	2.47	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.55	2.49	2.21	
PULL #3	2.20	2.48	2.50	2.37	
PULL #4	2.32	2.53	2.52	2.35	
PULL #5	2.28	2.49	2.52	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.51		
PULL #2	3.42	3.41		
PULL #3	3.26	3.47		
PULL #4	3.50	3.46		
PULL #5	3.49	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.40		4.39
PULL #2	4.40	4.49		4.46
PULL #3	4.44	4.47		4.62
PULL #4	4.46	4.37		4.49
PULL #5	4.50	4.50		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594672
3 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.633818
1 TO	2	.66583
1 TO	3	.309477
1 TO	4	.62824
1 TO	5	.471246

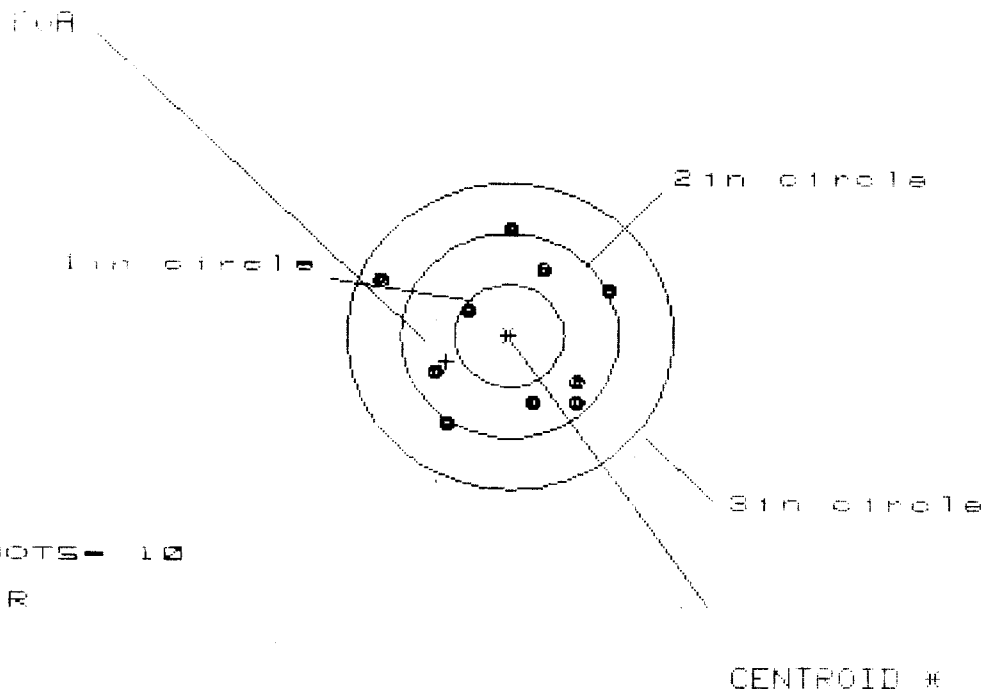
$\frac{31}{254}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2838
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .286862
THE AMR FOR THIS RIFLE IS: 1.065

7/21/84

FILE:/PATTERNING/CENTERFIRE_PATT/C6594672

CENTERFIRE PATTERNS # 1



+ OF SHOTS - 10

IN CIR

1in - 1

2in - 6

3in = 10

HS - 2.114

VS = 1.949

GS = 2.215

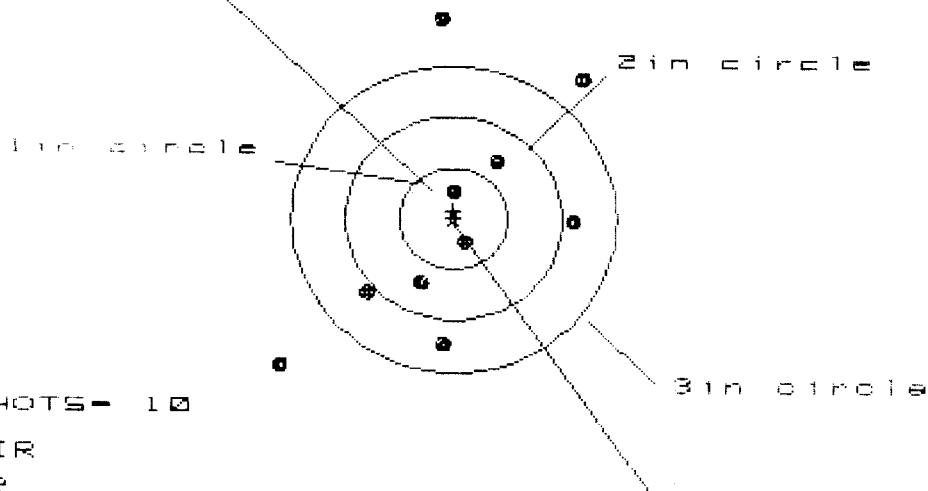
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.936	.805	.711
MINIMUM X	-1.178	-.768	-.862
MAXIMUM Y	1.068	1.128	1.025
MINIMUM Y	-.881	-.821	-.735
CENTROID X	.582	.713	.807
CENTROID Y	.251	.191	.294
POA TO CENTROID in.	.634	.738	.859
MIN RADIUS	.437	.563	.573
MEAN RADIUS	.872	.812	.767
MAX RADIUS	1.294	1.132	1.044
HORIZONTAL SPREAD	2.114	1.573	1.573
VERTICAL SPREAD	1.949	1.949	1.760
EXTREME SPREAD	2.215	2.056	1.872
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

3 Apr 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.757

VS = 3.388

GS = 3.942

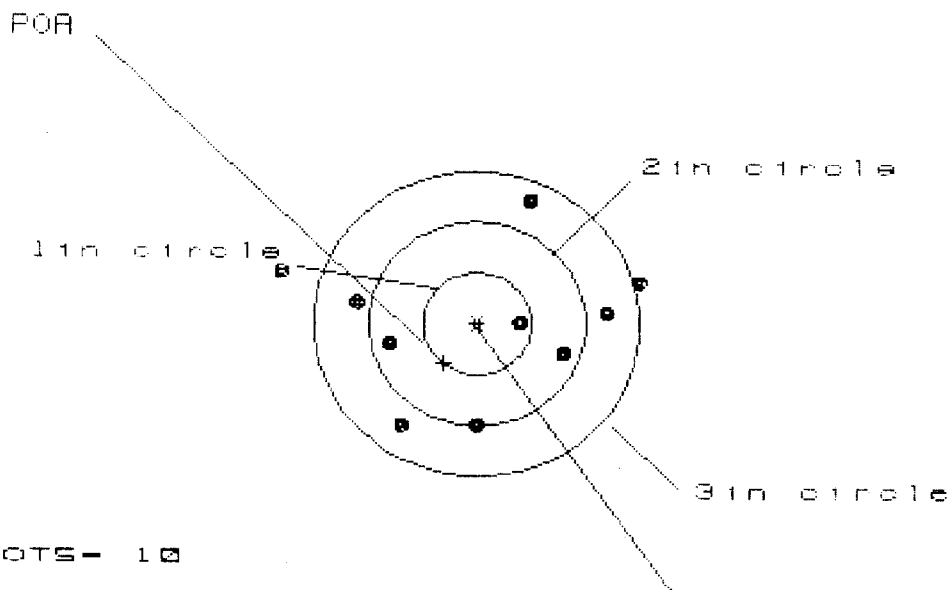
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	.996	.962
MINIMUM X	-1.585	-.972	-1.006
MAXIMUM Y	1.935	1.773	1.424
MINIMUM Y	-1.453	-1.342	-1.120
CENTROID X	.002	.178	.212
CENTROID Y	-.076	.086	-.136
POA TO CENTROID in.	.076	.198	.252
MIN RADIUS	.222	.194	.135
MEAN RADIUS	1.117	.992	.869
MAX RADIUS	2.150	1.794	1.718
HORIZONTAL SPREAD	2.757	1.968	1.968
VERTICAL SPREAD	3.388	3.115	2.544
EXTREME SPREAD	3.942	3.115	2.844
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.269

VS = 2.190

GS = 3.270

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.473	1.274	1.181
MINIMUM X	:	-1.796	-1.336	-1.177
MAXIMUM Y	:	1.192	1.247	1.307
MINIMUM Y	:	-.998	-.943	-.883
CENTROID X	:	.306	.505	.346
CENTROID Y	:	.391	.335	.275
POA TO CENTROID in.	:	.496	.606	.442
MIN RADIUS	:	.403	.217	.387
MEAN RADIUS	:	1.136	1.019	.981
MAX RADIUS	:	1.864	1.369	1.376
HORIZONTAL SPREAD	:	3.269	2.610	2.358
VERTICAL SPREAD	:	2.190	2.190	2.190
EXTREME SPREAD	:	3.270	2.617	2.475
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.328

VS = 3.015

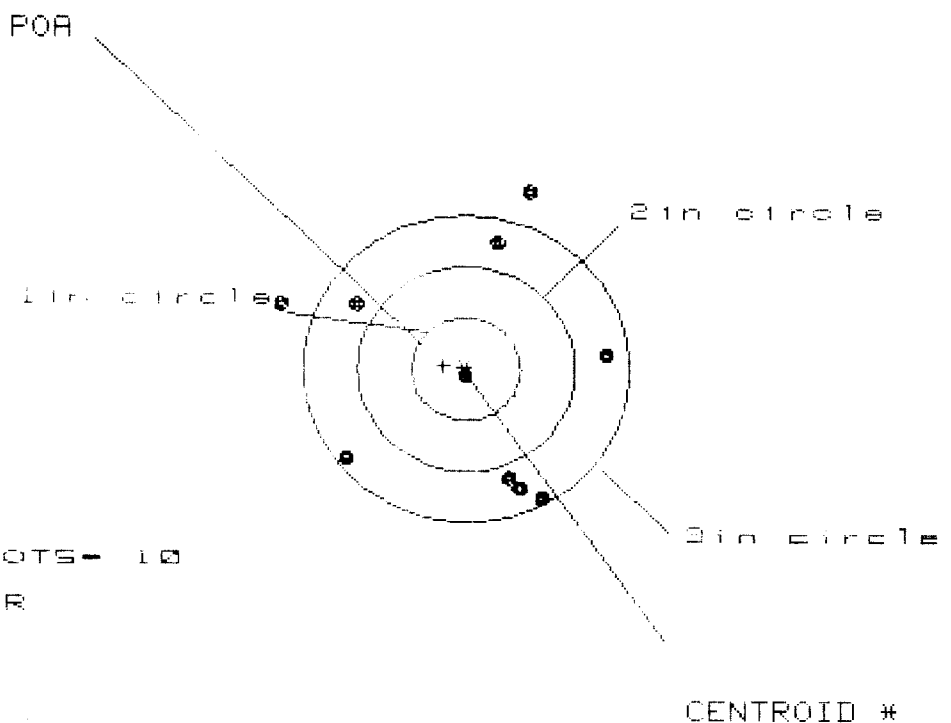
GS = 3.038

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.135	1.214	1.074
MINIMUM X	:	-1.193	-1.114	-.842
MAXIMUM Y	:	1.355	1.170	1.052
MINIMUM Y	:	-1.660	-.948	-.633
CENTROID X	:	.320	.241	.381
CENTROID Y	:	-.320	-.135	-.017
POA TO CENTROID in.	:	.453	.277	.381
MIN RADIUS	:	.075	.192	.183
MEAN RADIUS	:	.929	.811	.731
MAX RADIUS	:	1.806	1.463	1.158
HORIZONTAL SPREAD	:	2.328	2.328	1.916
VERTICAL SPREAD	:	3.015	2.118	1.685
EXTREME SPREAD	:	3.038	2.612	2.060
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 1

2in - 1

3in = 8

HS = 2.922

VS = 2.998

SS = 3.168

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.254	1.323	1.123
MINIMUM X	:	-1.668	-1.599	-1.239
MAXIMUM Y	:	1.748	1.413	1.522
MINIMUM Y	:	-1.250	-1.056	.947
CENTROID X	:	.209	.140	.340
CENTROID Y	:	-.037	-.231	-.340
POA TO CENTROID in.	:	.212	.271	.481
MIN RADIUS	:	.086	.153	.243
MEAN RADIUS	:	1.273	1.195	1.089
MAX RADIUS	:	1.854	1.819	1.529
HORIZONTAL SPREAD	:	2.922	2.922	2.362
VERTICAL SPREAD	:	2.998	2.469	2.469
EXTREME SPREAD	:	3.168	3.044	2.593
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		8	

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