

C6648966

MODEL 700TM M24

Model S&S TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

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

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

MODEL 700TM M24

SERIAL NO.
C6648966

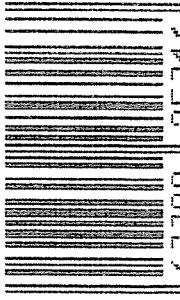
ORDER NO.
5716

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



5716 C6648966

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648966

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS.
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	AS
	Apply Coating (Bolt)		7-22-91	AS
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	HL

op. #	BARBER M24 0030083	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/20/91	JK
	G) Safety Off Force	3	3	3			8/20/91	JK
	H) Trigger Pull Test & Retainability						8/20/91	JK
	I) Firing Pin Indent	.0205	.0225	.0225			8/20/91	JK
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs						9-10-91	tc
	L) Attach Front and Rear Sight Assemblies						8/21/91	RW
	M) Iron Sight Alignment						8/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	RW
	O) Attach Scope to Rifle						8/21/91	RW
	P) Detach & Attach Scope 20 Times						8/21/91	RW
640	Gallery Target & Test						8-21-91	VF
	A) Time						9-5-91	DH
	B) Malfunctions						9-5-91	DH
	C) Pierced Primers						9-5-91	DH
	D) Optical Clarity of Scope						9-5-91	DH
645	Inspect for Live Ammo						9-5-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	K
	B) Trigger Pull	2.25	2.24	2.33	2.24	2.34	9-6-91	JK
	C) Function						9-10-91	K
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6648966
DATE 8/20/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.26	2.40	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.34	2.43	2.29	
PULL #3	2.21	2.32	2.30	2.33	
PULL #4	2.29	2.41	2.44	2.24	
PULL #5	2.25	2.38	2.39	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.40		
PULL #2	3.32	3.34		
PULL #3	3.27	3.25		
PULL #4	3.25	3.28		
PULL #5	3.23	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.31		4.39
PULL #2	4.53	4.38		4.37
PULL #3	4.47	4.37		4.41
PULL #4	4.49	4.37		4.38
PULL #5	4.47	4.40		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648966
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0550091
1 TO	2	.066468
1 TO	3	.180347
1 TO	4	.231625
1 TO	5	.292479

84 (----POB

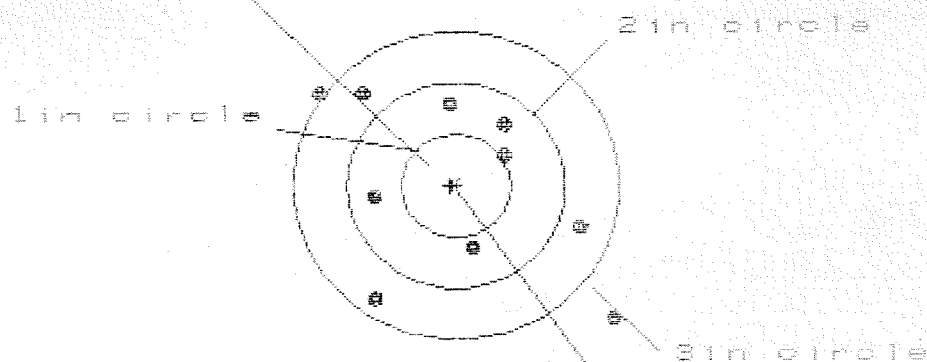
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0324
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .001
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0324154
THE AMP FOR THIS RIFLE IS: 1.011

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B489B6

CENTERFIRE PATTERNS # 1

POR



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.666

VS= 2.280

GS= 3.500

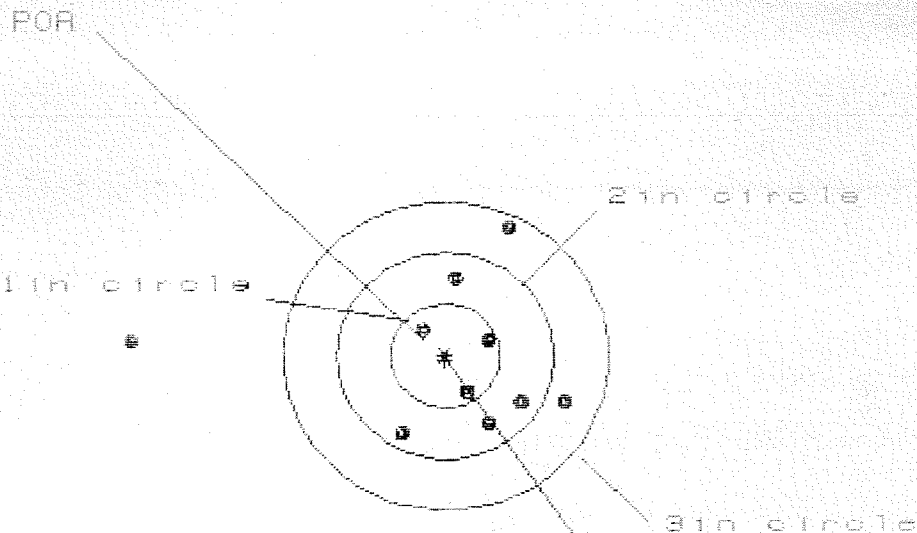
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.447	1.316	1.183
MINIMUM X	-1.219	-1.050	-1.795
MAXIMUM Y	.941	.792	.802
MINIMUM Y	-1.339	-1.226	-1.127
CENTROID X	.055	-.106	.027
CENTROID Y	-.001	.140	.049
POR TO CENTROID in.	.055	.182	.056
MIN RADIUS	.551	.639	.551
MEAN RADIUS	1.070	.953	.896
MAX RADIUS	1.972	1.418	1.348
HORIZONTAL SPREAD	2.666	2.374	1.979
VERTICAL SPREAD	2.280	2.018	1.929
EXTREME SPREAD	3.500	2.717	2.331
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B48366

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 4.002

VS = 1.962

GS = 4.036

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	.817	.847
MINIMUM X	-2.967	-.679	-.649
MAXIMUM Y	1.251	1.265	.896
MINIMUM Y	-.711	-.697	-.539
CENTROID X	.008	.326	.296
CENTROID Y	.046	.032	-.126
POR TO CENTROID in.	.046	.328	.322
MIN RADIUS	.374	.203	.225
MEAN RADIUS	.975	.704	.610
MAX RADIUS	2.869	1.288	.915
HORIZONTAL SPREAD	4.002	1.496	1.496
VERTICAL SPREAD	1.962	1.962	1.435
EXTREME SPREAD	4.036	2.167	1.528
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B966

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.698

VS= 1.757

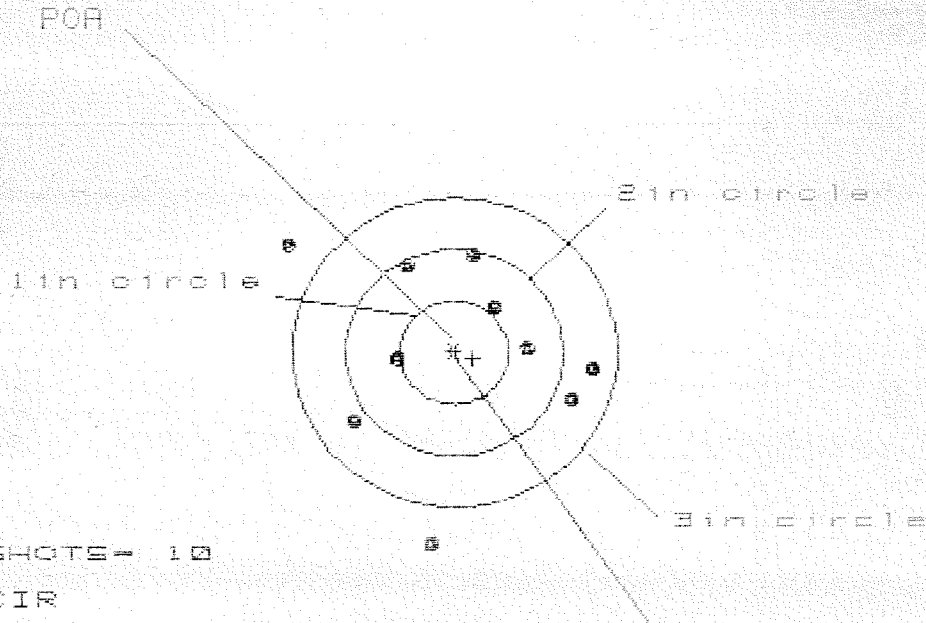
GS= 1.924

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.930
MINIMUM X	-.768
MAXIMUM Y	.868
MINIMUM Y	-.889
CENTROID X	.180
CENTROID Y	-.131
POA TO CENTROID in.	.222
MIN RADIUS	.175
MEAN RADIUS	.728
MAX RADIUS	1.133
HORIZONTAL SPREAD	1.698
VERTICAL SPREAD	1.757
EXTREME SPREAD	1.924
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10

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FILE:/PATTERNING/CENTERFIRE_PATT/C6646366

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.818

VS = 2.842

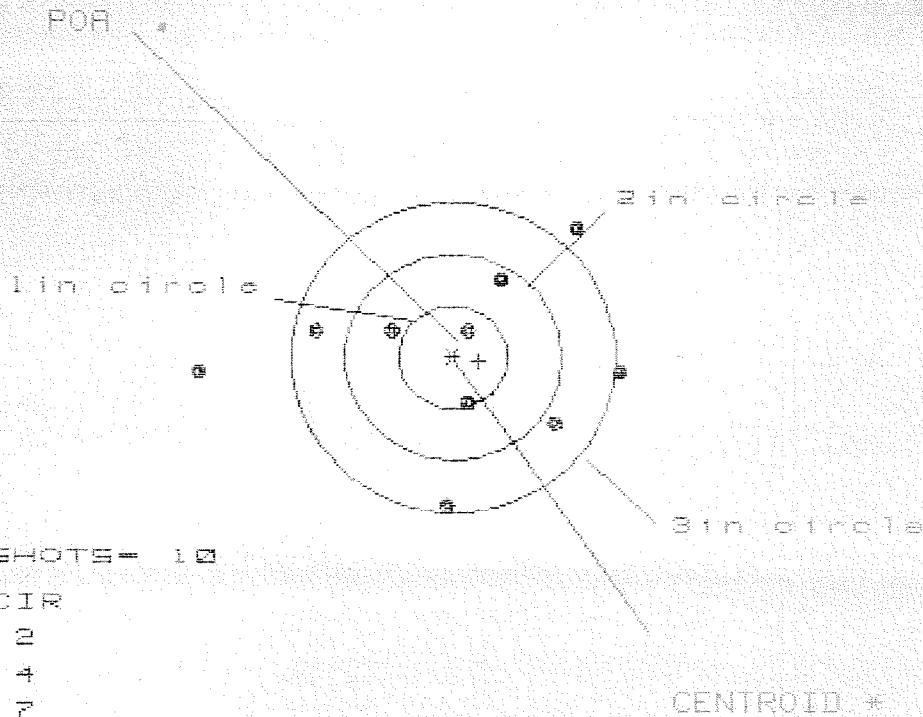
GS = 3.117

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.313	1.288	1.092
MINIMUM X	-1.505	-1.538	-1.171
MAXIMUM Y	1.017	.815	.801
MINIMUM Y	-1.825	-.904	-.803
CENTROID X	-.170	-.145	.046
CENTROID Y	.054	.256	.155
POA TO CENTROID in.	.178	.295	.161
MIN RADIUS	.520	.425	.363
MEAN RADIUS	1.094	.980	.864
MAX RADIUS	1.838	1.733	1.420
HORIZONTAL SPREAD	2.818	2.818	2.268
VERTICAL SPREAD	2.842	1.719	1.604
EXTREME SPREAD	3.117	3.040	2.341
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C884B966

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 3.949

VS = 2.666

GS = 3.950

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.551
MINIMUM X	-2.399
MAXIMUM Y	1.224
MINIMUM Y	-1.442
CENTROID X	-.235
CENTROID Y	.037
POA TO CENTROID in.	.238
MIN RADIUS	.325
MEAN RADIUS	1.189
MAX RADIUS	2.405
HORIZONTAL SPREAD	3.949
VERTICAL SPREAD	2.666
EXTREME SPREAD	3.950
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7