

C6648988

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

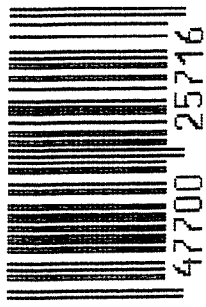
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6648988
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6648988

LPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6648988

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KH
600	Proof		7/24/91	KH
607	Check Headspace		7/24/91	KH
610	Dis-assemble Gun		7/24/91	KH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	GL
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/5/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/5/91	KH
	C) Inspect Ejector Hole for Chamfer		9/5/91	KH
	D) Oil Firing Pin Ass'y		9/5/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/91	977 -

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9-7-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9-7-91	DH
	H) Trigger Pull Test & Retainability						9/6/91	JH
	I) Firing Pin Indent	.020	.020	.020			9-7-91	DH
	J) Assemble Stock						9/11/91	KH
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						9/11/91	KH
	M) Iron Sight Alignment						9/11/91	KH
	N) Detach Front & Rear Sights & place in numbered container						9/11/91	KH
	O) Attach Scope to Rifle						9/11/91	KH
	P) Detach & Attach Scope 20 Times						9/11/91	KH
640	Gallery Target & Test						9-12-91	AC
	A) Time						9-12-91	AC
	B) Malfunctions						9-12-91	AC
	C) Pierced Primers						9-12-91	AC
	D) Optical Clarity of Scope						9-12-91	AC
645	Inspect for Live Ammo						9-12-91	AC
655	Final Inspection							
	A) Headspace						9-13-91	AC
	B) Trigger Pull	245	217	222	234	231	9-12-91	DH
	C) Function						9-13-91	AC
660	Pack						9-12-91	DH

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

SERIAL NO. C-6648988

DATE 9-6-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.23	2.30	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.24	2.33	2.17	
PULL #3	2.39	2.26	2.28	2.22	
PULL #4	2.43	2.26	2.20	2.34	
PULL #5	2.30	2.20	2.29	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.19		
PULL #2	3.21	3.23		
PULL #3	3.31	3.25		
PULL #4	3.23	3.20		
PULL #5	3.19	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.33		4.39
PULL #2	4.28	4.12		4.12
PULL #3	4.45	4.26		4.37
PULL #4	4.26	4.25		4.38
PULL #5	4.29	4.40		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648988
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.436986
1 TO	2	.476765
1 TO	3	.514262
1 TO	4	.396698
1 TO	5	.755479

1.4 <----POA

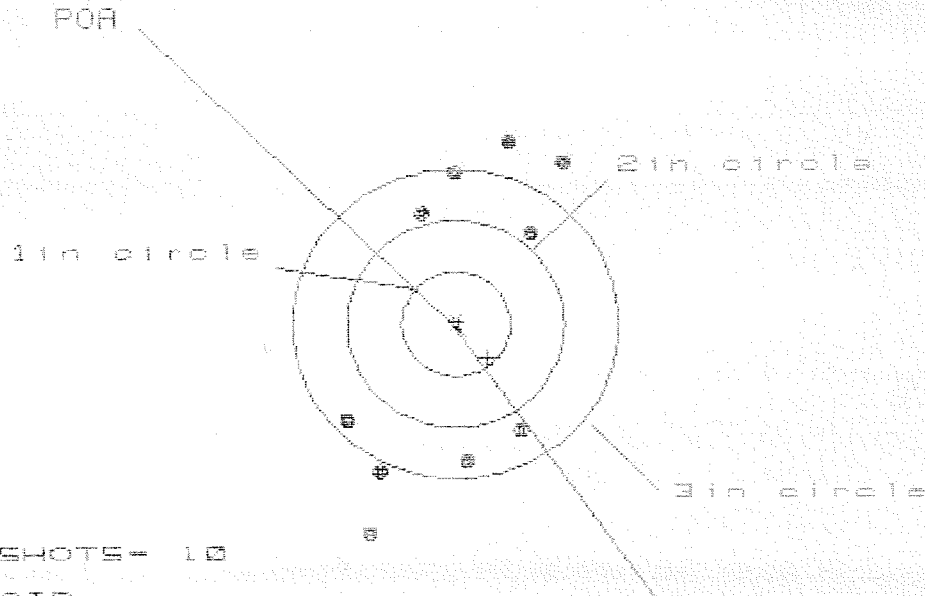
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0124
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .049
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0505446

THE AM FOR THIS RIFLE IS: 1.102

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB4B3B8

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 6

HS= 1.944

VS= 3.778

GS= 4.012

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.859	.749
MINIMUM X	-1.995	-1.085	-1.977
MAXIMUM Y	1.726	1.498	1.664
MINIMUM Y	-2.652	-1.650	-1.484
CENTROID X	-.291	-.201	-.309
CENTROID Y	.325	.554	.388
POA TO CENTROID in.	.437	.589	.496
MIN RADIUS	1.132	.983	1.088
MEAN RADIUS	1.498	1.390	1.367
MAX. RADIUS	2.206	1.838	1.730
HORIZONTAL SPREAD	1.944	1.944	1.726
VERTICAL SPREAD	3.778	3.148	3.148
EXTREME SPREAD	4.012	3.412	3.360
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	0	
NUMBER IN THREE INCH CIRCLE	=	6	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65463B8

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.520

VS = 3.223

GS = 3.231

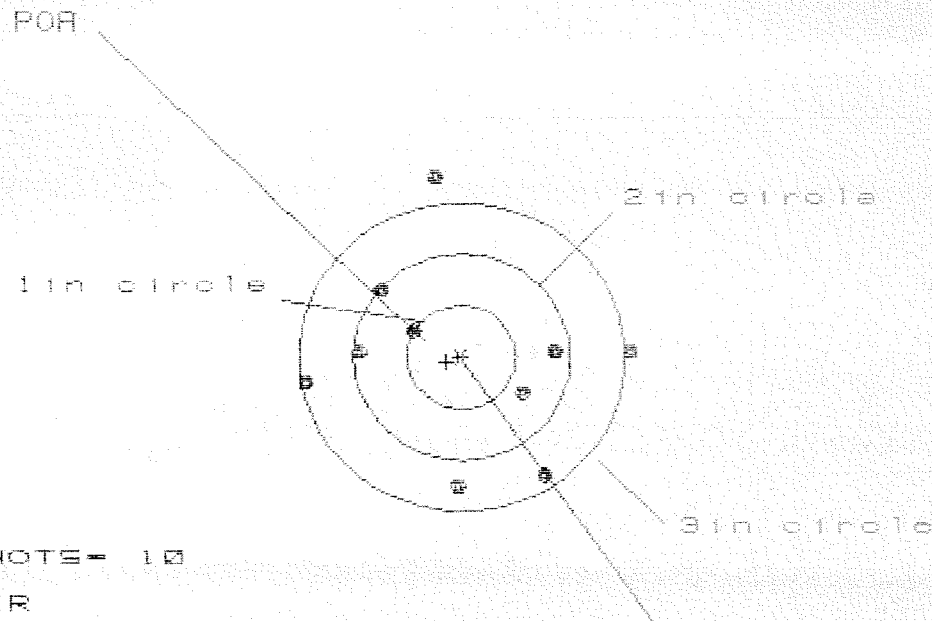
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.779	.782	.634
MINIMUM X	-.741	-.818	-.886
MAXIMUM Y	1.231	1.010	.945
MINIMUM Y	-1.992	-1.003	-1.077
CENTROID X	.106	.183	.251
CENTROID Y	.062	.283	.157
POA TO CENTROID in.	.122	.337	.296
MIN RADIUS	.275	.391	.248
MEAN RADIUS	.955	.817	.744
MAX RADIUS	2.109	1.147	1.150
HORIZONTAL SPREAD	1.520	1.520	1.520
VERTICAL SPREAD	3.223	2.013	1.022
EXTREME SPREAD	3.231	2.273	2.109
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6B46968

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 2.971

VS = 3.024

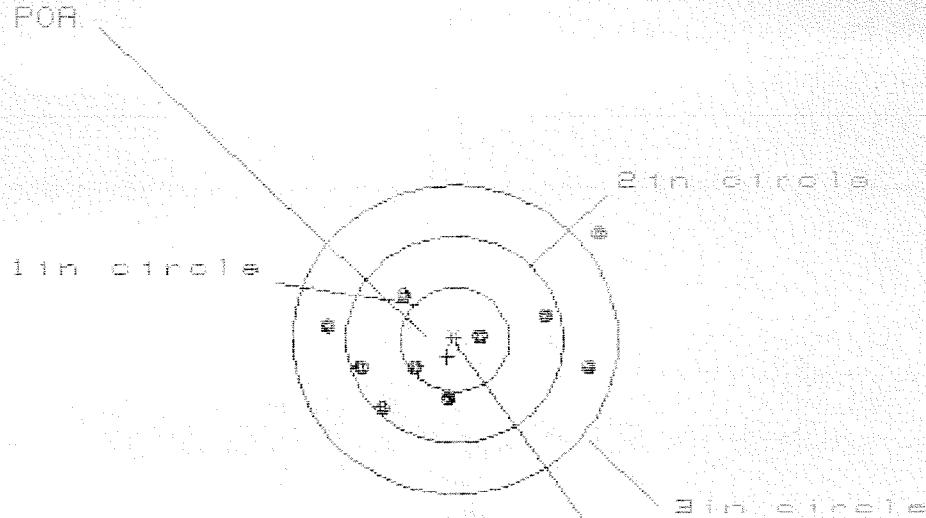
GS = 3.067

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.572	1.546	1.045
MINIMUM X	-1.399	-1.425	-1.231
MAXIMUM Y	1.790	.888	.919
MINIMUM Y	-1.234	-1.035	-1.004
CENTROID X	.141	.167	-.027
CENTROID Y	-.047	-.152	-.183
FOR TO CENTROID in.	.149	.226	.185
MIN RADIUS	.507	.548	.552
MEAN RADIUS	1.139	1.054	.979
MAX RADIUS	1.804	1.566	1.293
HORIZONTAL SPREAD	2.971	2.971	2.276
VERTICAL SPREAD	3.024	1.923	1.923
EXTREME SPREAD	3.067	2.989	2.384
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	0	4	4
NUMBER IN THREE INCH CIRCLE =	0	8	8

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648368

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.490

VS = 1.682

GS = 2.639

CENTROID *

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.322	1.382	1.131
MINIMUM X	-1.168	-1.021	-.848
MAXIMUM Y	1.038	.590	.575
MINIMUM Y	-.644	-.528	-.543
CENTROID X	.072	-.075	-.248
CENTROID Y	.166	.050	.065
POA TO CENTROID in.	.180	.090	.256
MIN RADIUS	.234	.292	.189
MEAN RADIUS	.868	.747	.641
MAX RADIUS	1.681	1.387	1.172
HORIZONTAL SPREAD	2.490	2.403	1.979
VERTICAL SPREAD	1.682	1.118	1.118
EXTREME SPREAD	2.639	2.436	1.979
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

