

C6649000

MODEL 700™ M24

Model **S&S**™

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.

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

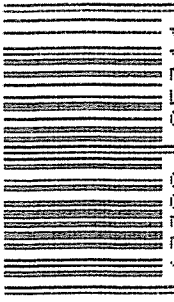
SERIAL NO.
C6649000

ORDER NO.
5716

20

5716 C6649000

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649000

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	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/2/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/2/91	RW
	C) Inspect Ejector Hole for Chamfer		8/2/91	RW
	D) Oil Firing Pin Ass'y		8/2/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	JS

BARBER - M24 0030483		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			8-19-91	JH
	G) Safety Off Force	3	3	3			8-19-91	JH
	H) Trigger Pull Test & Retainability						8-19-91	JH
	I) Firing Pin Indent	1022	10225	10225			8-19-91	JH
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs						8/22/91	JH
	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						8-22-91	AC
	A) Time						8-22-91	AC
	B) Malfunctions						8-22-91	AC
	C) Pierced Primers						8-22-91	AC
	D) Optical Clarity of Scope						8-22-91	AC
645	Inspect for Live Ammo						8-22-91	AC
655	Final Inspection						8-22-91	JH
	A) Headspace						8-22-91	JH
	B) Trigger Pull	259	262	250	250	245	8/22/91	JH
	C) Function						8-22-91	JH
660	Pack						7-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C-6649000DATE 8-19-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.65	2.58	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.65	2.64	2.62	
PULL #3	2.53	2.64	2.60	2.50	
PULL #4	2.60	2.63	2.59	2.50	
PULL #5	2.65	2.61	2.60	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.25		
PULL #2	3.46	3.21		
PULL #3	3.44	3.33		
PULL #4	3.37	3.34		
PULL #5	3.42	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	4.25	4.31		4.43
PULL #2	4.27	4.42		4.51
PULL #3	4.40	4.45		4.51
PULL #4	4.31	4.41		4.53
PULL #5	4.35	4.46		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6649800

22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.236072
1 TO	2	.421944
1 TO	3	.247111
1 TO	4	.849588
1 TO	5	.254443

4 <----POB

4

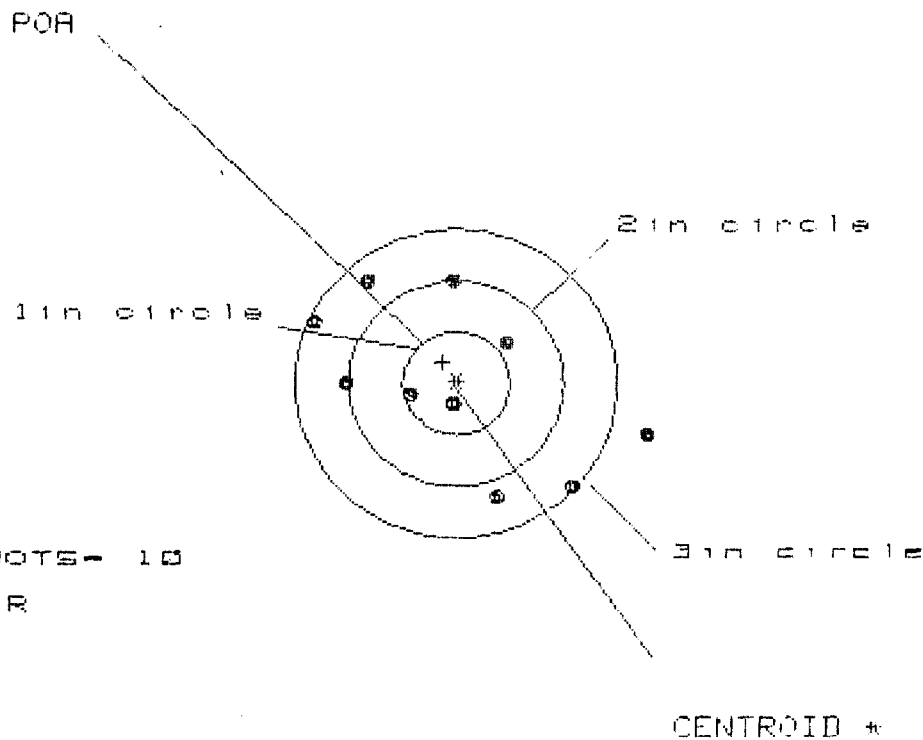
AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0738
 AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.147
 RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1744"

FOR THIS RIFLE : .9736

Fig. 133

FILE:/PATTERNING/CENTERFIRE_PATT/06649000

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 9

HS = 3.137

VS = 2.157

GS = 3.342

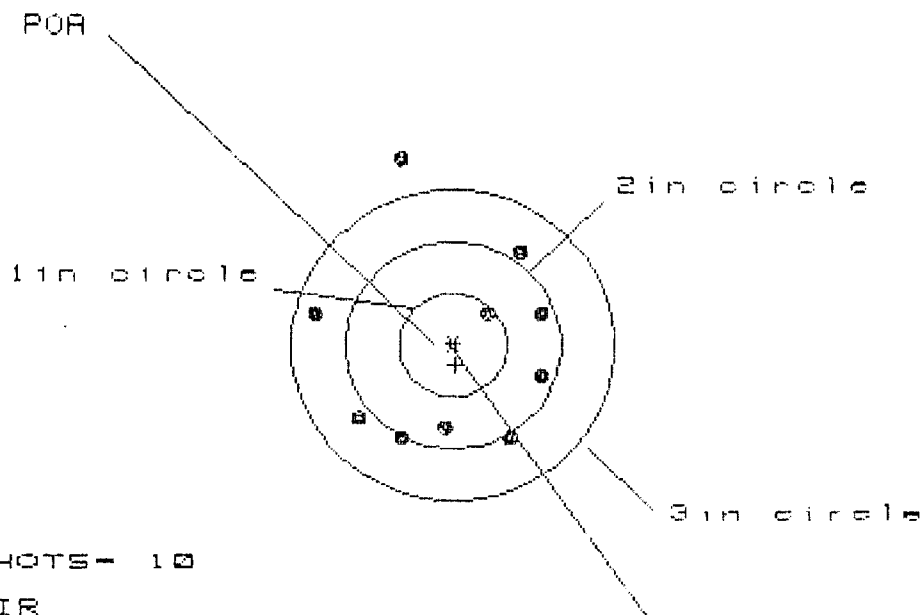
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.783	1.273	1.128
MINIMUM X	-1.354	-1.155	-1.998
MAXIMUM Y	1.021	.963	1.035
MINIMUM Y	-1.136	-1.194	-1.122
CENTROID X	.127	-.072	.073
CENTROID Y	-.199	-.141	-.213
POA TO CENTROID in.	.236	.158	.225
1 IN. RADIUS	.212	.333	.205
2 IN. RADIUS	1.064	.956	.906
3 IN. RADIUS	1.858	1.639	1.482
HORIZONTAL SPREAD	3.137	2.428	2.128
VERTICAL SPREAD	2.157	2.157	2.157
DIAGONAL SPREAD	3.342	2.910	2.720
SHOTS IN ONE INCH CIRCLE =	2	2	2
SHOTS IN TWO INCH CIRCLE =	3	3	3
SHOTS IN THREE INCH CIRCLE =	9	9	9

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.086

VS = 2.709

GS = 2.832

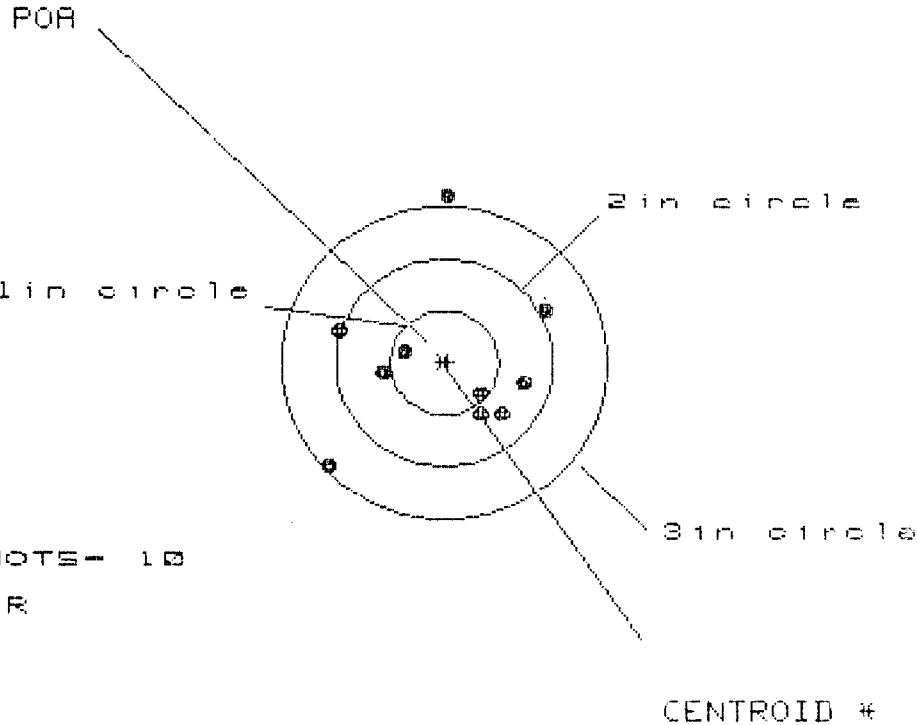
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.804	.643
MINIMUM X	:	-1.226	-1.282	-1.087
MAXIMUM Y	:	1.791	1.142	1.204
MINIMUM Y	:	-.918	-.719	-.657
CENTROID X	:	-.024	.032	.192
CENTROID Y	:	.195	-.004	-.066
POA TO CENTROID in.	:	.196	.032	.203
MIN RADIUS	:	.457	.567	.558
MEAN RADIUS	:	1.043	.920	.836
MAX RADIUS	:	1.861	1.374	1.259
HORIZONTAL SPREAD	:	2.086	2.086	1.730
VERTICAL SPREAD	:	2.709	1.861	1.861
EXTREME SPREAD	:	2.832	2.167	2.166
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



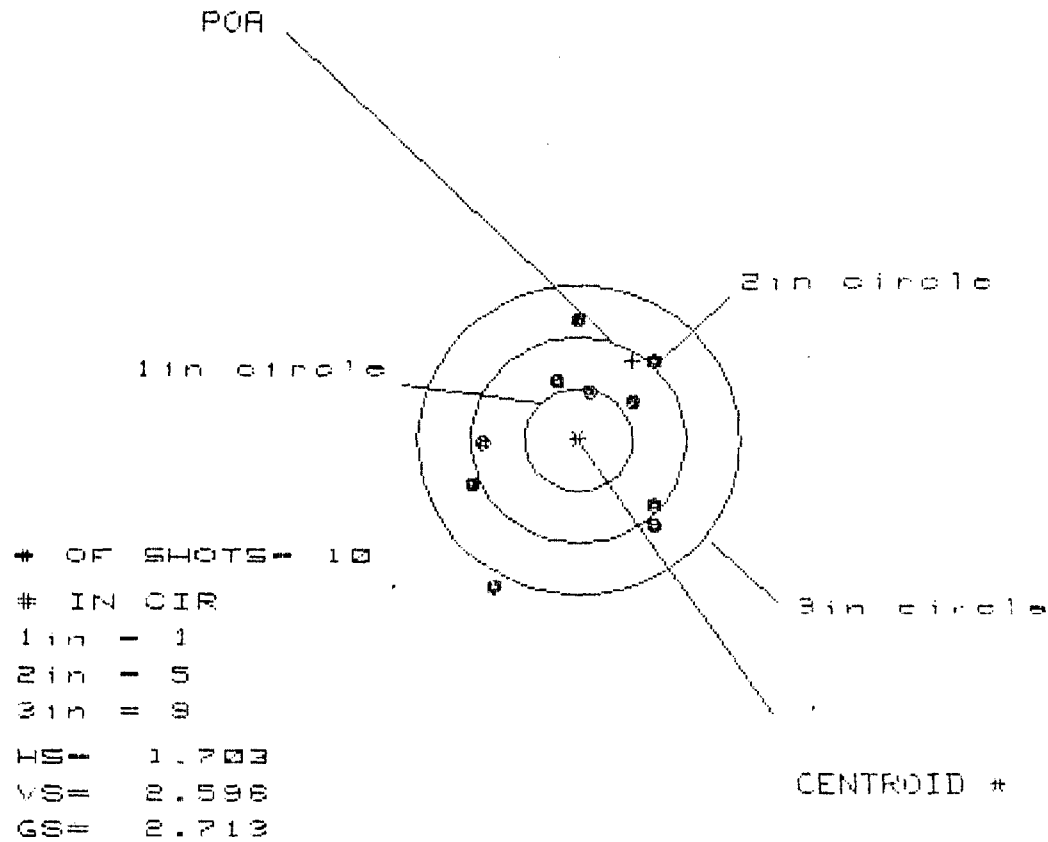
OF SHOTS- 10
 # IN CIR
 1in = 2
 2in = 7
 3in = 9
 HS= 2.009
 VS= 2.619
 GS= 2.852

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.946
MINIMUM X	-1.063
MAXIMUM Y	1.601
MINIMUM Y	-1.018
CENTROID X	-.031
CENTROID Y	-.009
POR TO CENTROID in.	.032
MIN RADIUS	.373
MEAN RADIUS	.860
MAX. RADIUS	1.603
HORIZONTAL SPREAD	2.009
VERTICAL SPREAD	2.619
EXTREME SPREAD	2.852
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	9

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CENTERFIRE PATTERNS # 4

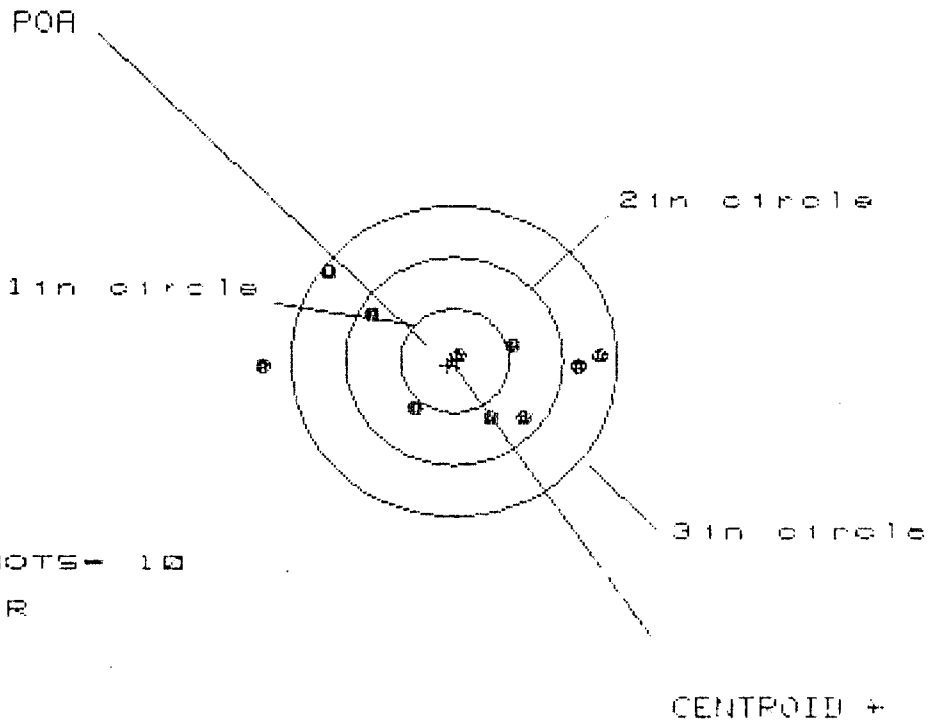


PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.748	.663	.655
MINIMUM X	-.955	-1.040	-1.048
MAXIMUM Y	1.176	1.019	.774
MINIMUM Y	-1.420	-1.029	-.902
CENTROID X	-.503	-.418	-.410
CENTROID Y	-.769	-.611	-.738
POA TO CENTROID in.	.918	.740	.844
MIN RADIUS	.476	.302	.427
MEAN RADIUS	.958	.842	.836
MAX RADIUS	1.613	1.191	1.142
HORIZONTAL SPREAD	1.703	1.703	1.703
VERTICAL SPREAD	2.596	2.047	1.676
EXTREME SPREAD	2.713	2.143	2.076
NUMBER IN ONE INCH CIRCLE =		1	
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 = 6

3in = 9

IM = 3.130

VM = 1.402

OM = 3.130

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.321
MINIMUM X	-1.869
MAXIMUM Y	.845
MINIMUM Y	-.557
CENTROID X	.062
CENTROID Y	.047
POA TO CENTROID IN.	.078
1IN RADIUS	.098
2IN RADIUS	.199
3IN RADIUS	.299
HORIZONTAL SPREAD	3.130
VERTICAL SPREAD	1.402
DIAG SPREAD	3.133
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9