

C6649084

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

S&S
Smith

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

SERIAL NO.
C6649084

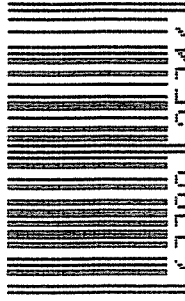
ORDER NO.
5716

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



5716 C6649084

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649084

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	YS
	Magnaflux Bolt		JUL 22 1991	YS
615	Rollmark Caliber		JUL 22 1991	YS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		7/28/91	LB
	Apply Coating (Bolt)		7/28/91	LB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	9/1

op. #	BARBER - M24 0031467	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	54	8-29-91	DH		
	G) Safety Off Force	22	22	22	8-29-91	DH		
	H) Trigger Pull Test & Retainability				8/29/91	JH		
	I) Firing Pin Indent	.020	.021	.021	8-29-91	DH		
	J) Assemble Stock				8/30/91	RW		
	K) Assemble Swivel Studs				8-31-91	DH		
	L) Attach Front and Rear Sight Assemblies				8/30/91	RW		
	M) Iron Sight Alignment				8/30/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				8/30/91	RW		
	O) Attach Scope to Rifle				8/30/91	RW		
	P) Detach & Attach Scope 20 Times				8/30/91	RW		
640	Gallery Target & Test				8/30/91	KT		
	A) Time					KT		
	B) Malfunctions					KT		
	C) Pierced Primers					KT		
	D) Optical Clarity of Scope					KT		
645	Inspect for Live Ammo				8/30/91	KT		
655	Final Inspection							
	A) Headspace				8-31-91	DH		
	B) Trigger Pull	260	267	249	258	266	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						8-31-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6649084

DATE 8/29/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.42	2.51	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.49	2.55	2.67	
PULL #3	2.47	2.52	2.49	2.49	
PULL #4	2.40	2.51	2.51	2.58	
PULL #5	2.46	2.50	2.52	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.52		
PULL #2	3.33	3.42		
PULL #3	3.51	3.53		
PULL #4	3.51	3.53		
PULL #5	3.51	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	4.48	4.46		4.51
PULL #2	4.46	4.47		4.59
PULL #3	4.45	4.52		4.53
PULL #4	4.15	4.50		4.43
PULL #5	4.43	4.47		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649084
30 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.366922
1 TO	2	.287388
1 TO	3	.374092
1 TO	4	.560201
1 TO	5	.461741

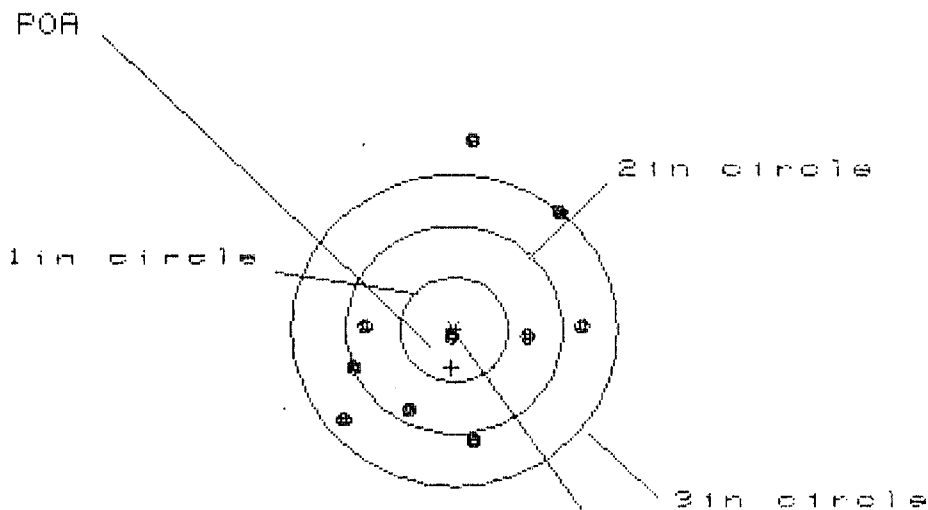
43 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1248
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0892
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152821
THE AMR FOR THIS RIFLE IS: .8648

30 Aug 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.135

VS = 2.879

GS = 2.933

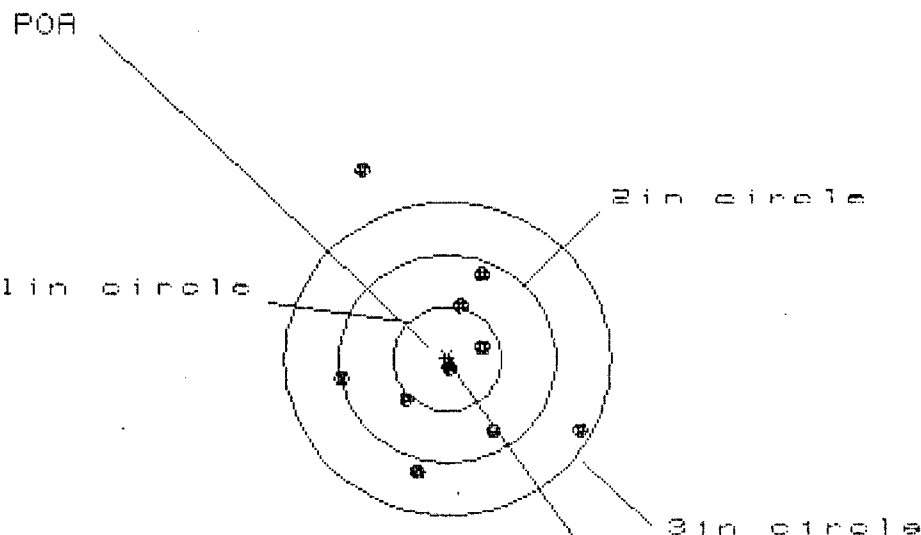
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.154	1.179	1.299
MINIMUM X	-.981	-.956	-.836
MAXIMUM Y	1.844	1.307	.444
MINIMUM Y	-1.035	-.830	-.667
CENTROID X	.026	.001	-.119
CENTROID Y	.366	.161	-.002
POA TO CENTROID in.	.367	.161	.119
MIN RADIUS	.035	.172	.365
MEAN RADIUS	1.021	.907	.796
MAX RADIUS	1.857	1.621	1.373
HORIZONTAL SPREAD	2.135	2.135	2.135
VERTICAL SPREAD	2.879	2.137	1.111
EXTREME SPREAD	2.933	2.721	2.320
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

IS= 2.150

VS= 2.896

GS= 3.200

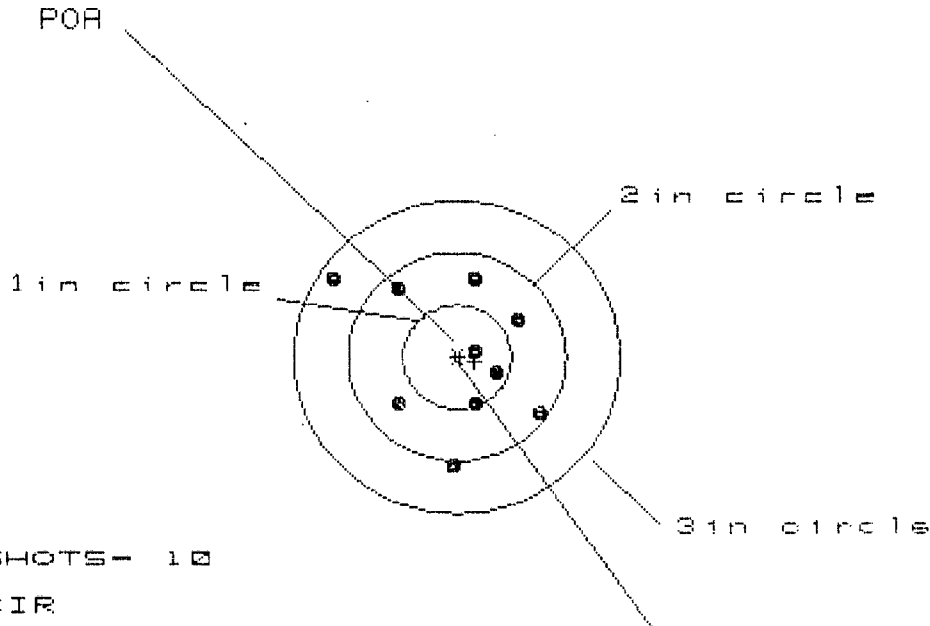
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	1.111	.504
MINIMUM X	-.947	-1.039	-.900
MAXIMUM Y	1.773	.966	.902
MINIMUM Y	-1.123	-.926	-.990
CENTROID X	-.018	.074	-.065
CENTROID Y	.082	-.115	-.051
POA TO CENTROID in.	.084	.136	.083
MIN RADIUS	.077	.144	.085
MEAN RADIUS	.055	.726	.648
MAX RADIUS	1.957	1.223	1.018
HORIZONTAL SPREAD	2.150	2.150	1.404
VERTICAL SPREAD	2.896	1.892	1.892
EXTREME SPREAD	3.200	2.211	1.977
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.931

VS= 1.789

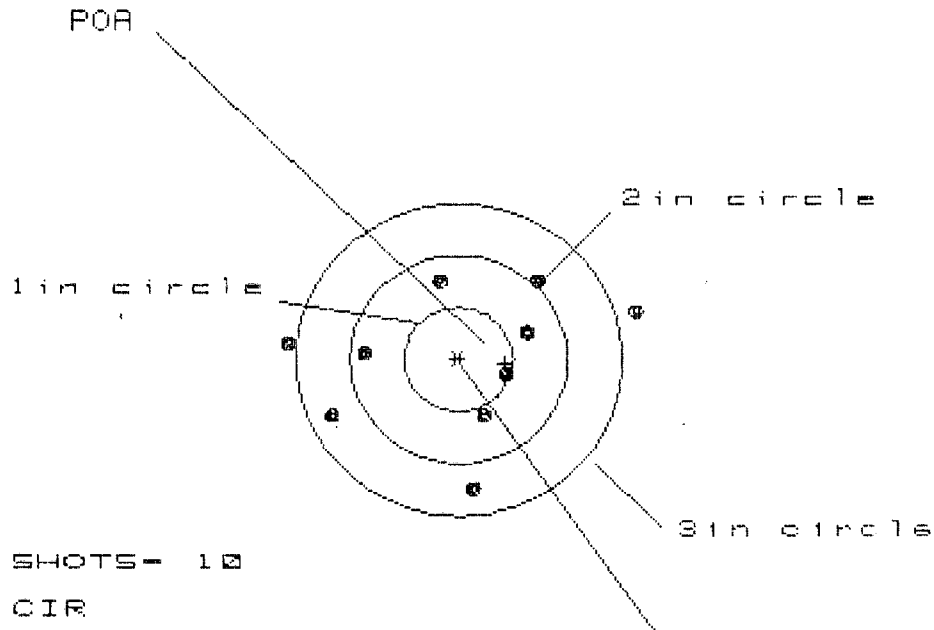
GS= 2.316

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.809	.684	.657
MINIMUM X	:	-1.122	-.707	-.724
MAXIMUM Y	:	.767	.848	.731
MINIMUM Y	:	-1.022	-.936	-.543
CENTROID X	:	-.161	-.036	-.019
CENTROID Y	:	.042	-.044	.073
POA TO CENTROID in.	:	.166	.056	.076
MIN RADIUS	:	.197	.145	.052
MEAN RADIUS	:	.743	.639	.592
MAX RADIUS	:	1.360	1.021	.950
HORIZONTAL SPREAD	:	1.931	1.391	1.391
VERTICAL SPREAD	:	1.789	1.784	1.274
EXTREME SPREAD	:	2.316	1.809	1.809
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.158

VS= 1.952

GS= 3.169

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.592	.949	.775
MINIMUM X	-1.566	-1.389	-1.184
MAXIMUM Y	.711	.763	.796
MINIMUM Y	-1.241	-1.189	-1.156
CENTROID X	-.431	-.608	-.434
CENTROID Y	.042	-.010	-.043
POA TO CENTROID in.	.433	.608	.436
MIN RADIUS	.437	.593	.416
MEAN RADIUS	1.011	.943	.856
MAX RADIUS	1.660	1.413	1.254
HORIZONTAL SPREAD	3.158	2.338	1.959
VERTICAL SPREAD	1.952	1.952	1.952
EXTREME SPREAD	3.169	2.392	2.303
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.434

VS = 1.648

GS = 2.437

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.237	.917	.684
MINIMUM X	-1.197	-1.059	-.642
MAXIMUM Y	1.048	.994	.940
MINIMUM Y	-.600	-.654	-.708
CENTROID X	-.040	-.178	-.045
CENTROID Y	-.091	-.037	.017
POA TO CENTROID in.	.100	.182	.049
MIN RADIUS	.065	.015	.077
MEAN RADIUS	.694	.613	.535
MAX RADIUS	1.332	1.144	.985
HORIZONTAL SPREAD	2.434	1.876	1.326
VERTICAL SPREAD	1.648	1.648	1.648
EXTREME SPREAD	2.437	1.889	1.833
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		