

06636250

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

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

SERIAL NO.
C6636250

ORDER NO.
5716

20

UPC
0 47700 25716 7

5716 C6636250

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636250

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	DS.
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL 1	7 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-1-91	JH

BARBER - M24 0032215		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	8	8	8			8-1-91	JP
	G) Safety Off Force	5	5	5			8-1-91	JP
	H) Trigger Pull Test & Retainability						8-1-91	JP
	I) Firing Pin Indent	.022	.022	.022			8-1-91	JP
	J) Assemble Stock						8/2/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/2/91	RW
	M) Iron Sight Alignment						8/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/2/91	RW
	O) Attach Scope to Rifle						8/2/91	RW
	P) Detach & Attach Scope 20 Times						8/2/91	RW
640	Gallery Target & Test						8-2-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-2-91	AF
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.30	2.20	2.14	2.35	2.20	8-6-91	JP
	C) Function						8-6-91	AC
660	Pack						9-19-91	AF

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

SERIAL NO. C-6636250DATE 8-1-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.38	2.40	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.35	2.44	2.20	
PULL #3	2.39	2.39	2.35	2.19	
PULL #4	2.39	2.35	2.30	2.35	
PULL #5	2.38	2.35	2.38	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.53		
PULL #2	3.26	3.59		
PULL #3	3.42	3.56		
PULL #4	3.47	3.47		
PULL #5	3.51	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.30		4.33
PULL #2	4.56	4.29		4.54
PULL #3	4.67	4.27		4.29
PULL #4	4.51	4.38		4.59
PULL #5	4.64	4.33		4.65
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636250
2 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.259201
1 TO	2	.315964
1 TO	3	.616663
1 TO	4	.656544
1 TO	5	.124016

4.5 ←---POA

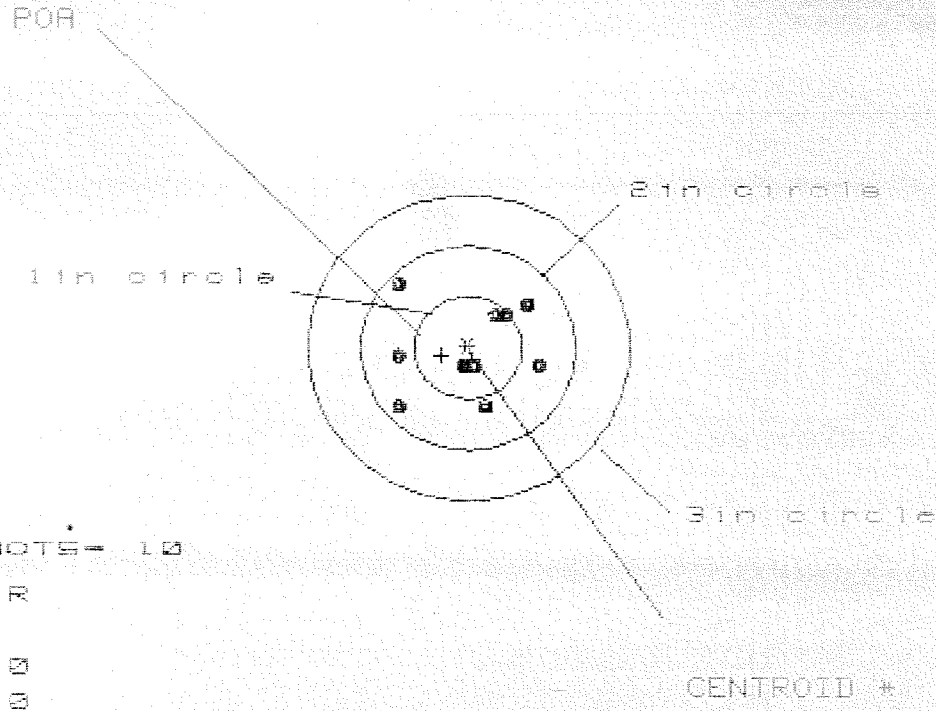
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1101014

THE AMR FOR THIS RIFLE IS: .9586

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636250

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 10

3in = 10

HS = 1.323

VS = 1.269

GS = 1.556

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.648	.577	.491
MINIMUM X	-.675	-.746	-.882
MAXIMUM Y	.651	.543	.475
MINIMUM Y	-.618	-.546	-.554
CENTROID X	.249	.320	.406
CENTROID Y	.072	.000	.068
POA TO CENTROID in.	.259	.320	.411
MIN RADIUS	.182	.180	.193
MEAN RADIUS	.568	.511	.453
MAX RADIUS	.916	.874	.835
HORIZONTAL SPREAD	1.323	1.323	1.323
VERTICAL SPREAD	1.269	1.089	1.029
EXTREME SPREAD	1.556	1.556	1.325
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C853B250

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.193

VS= 3.074

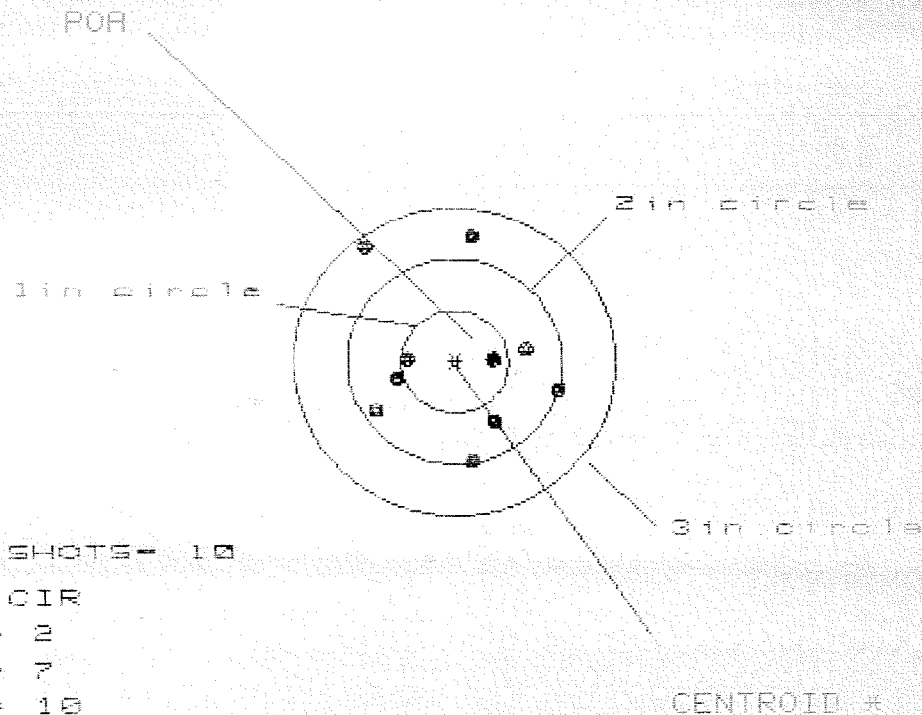
GS= 3.221

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.245	1.202	.954
MINIMUM X	:	-1.948	-1.991	-.967
MAXIMUM Y	:	.975	.742	.712
MINIMUM Y	:	-2.099	-.598	-.628
CENTROID X	:	.097	.140	.388
CENTROID Y	:	-.205	.028	.058
POA TO CENTROID in.	:	.227	.142	.393
MIN RADIUS	:	.155	.167	.244
MEAN RADIUS	:	1.042	.889	.739
MAX RADIUS	:	2.134	2.005	1.144
HORIZONTAL SPREAD	:	3.193	3.193	1.921
VERTICAL SPREAD	:	3.074	1.340	1.340
EXTREME SPREAD	:	3.221	3.203	2.007
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B250

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.758

VS= 2.193

GS= 2.273

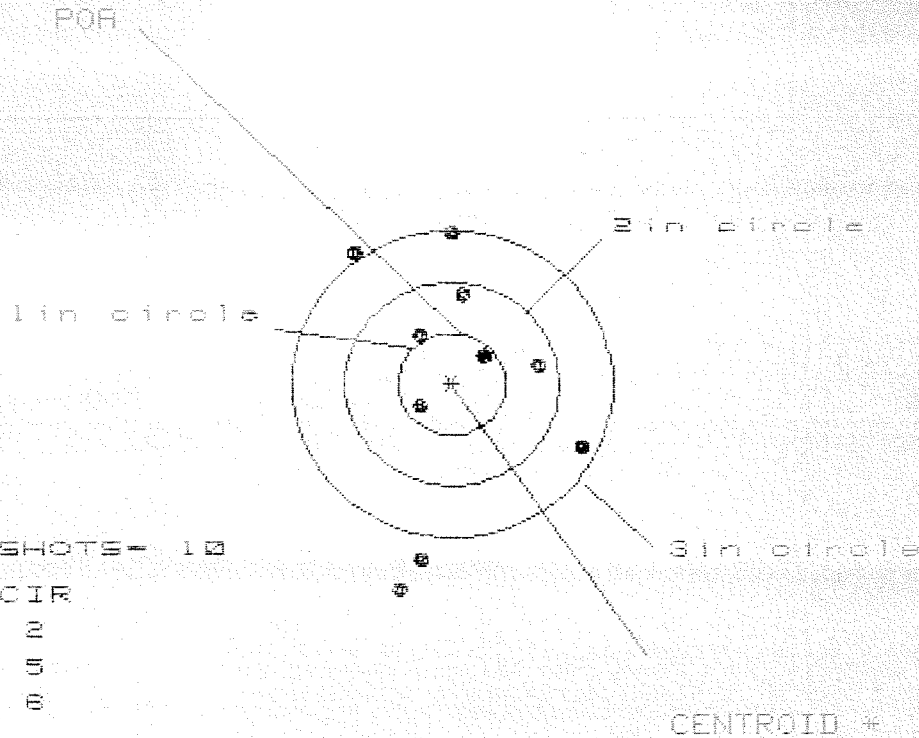
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.954
MINIMUM X	-.804
MAXIMUM Y	1.248
MINIMUM Y	-.946
CENTROID X	-.359
CENTROID Y	-.031
POA TO CENTROID in.	.360
MIN RADIUS	.363
MEAN RADIUS	.822
MAX RADIUS	1.367
HORIZONTAL SPREAD	1.758
VERTICAL SPREAD	2.193
EXTREME SPREAD	2.273
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

2 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3B250

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.068

VS= 3.540

GS= 3.571

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.195	1.141	1.093
MINIMUM X	-1.873	-1.927	-1.975
MAXIMUM Y	1.531	1.308	1.070
MINIMUM Y	-2.009	-1.902	-1.061
CENTROID X	-1.302	-1.248	-1.200
CENTROID Y	-1.285	-1.062	.176
POA TO CENTROID in.	.415	.256	.266
MIN RADIUS	.347	.201	.271
MEAN RADIUS	1.126	.973	.824
MAX RADIUS	2.067	1.941	1.523
HORIZONTAL SPREAD	2.068	2.068	2.068
VERTICAL SPREAD	3.540	3.210	2.131
EXTREME SPREAD	3.571	3.226	2.798
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636250

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 0

3in = 9

HS = 2.230

VS = 1.862

GS = 2.905

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.454
MINIMUM X	-0.776
MAXIMUM Y	0.795
MINIMUM Y	-1.067
CENTROID X	0.251
CENTROID Y	-0.052
POB TO CENTROID in.	0.256
MIN RADIUS	0.189
MEAN RADIUS	0.735
MAX RADIUS	1.803
HORIZONTAL SPREAD	2.230
VERTICAL SPREAD	1.862
EXTREME SPREAD	2.905
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	0
NUMBER IN THREE INCH CIRCLE	9