

C6636309

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

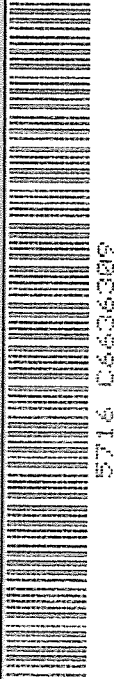
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

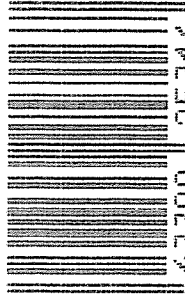
SERIAL NO. C6636309

ORDER NO. 5716

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



UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636309

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KE
600	Proof		6/24/91	KE
607	Check Headspace		6/24/91	KE
610	Dis-assemble Gun		6/24/91	KE
612	Magnaflux Barrel Action		1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS.
617	Drill and Tap Sight Holes	JUL	1 1991	EB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	KE
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	KE
	C) Inspect Ejector Hole for Chamfer		8/5/91	KE
	D) Oil Firing Pin Ass'y		8/5/91	KE
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5 1/2			8-6-91	DH
	G) Safety Off Force	3	3 1/2	3 1/2			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	DH
	I) Firing Pin Indent	.020	.020	.020			8-6-91	DH
	J) Assemble Stock						8/7/91	✓
	K) Assemble Swivel Studs						8-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/7/91	✓
	M) Iron Sight Alignment						8/7/91	✓
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	✓
	O) Attach Scope to Rifle						8/7/91	✓
	P) Detach & Attach Scope 20 Times						8/7/91	✓
640	Gallery Target & Test						8-7-91	✓
	A) Time						"	✓
	B) Malfunctions						"	✓
	C) Pierced Primers						"	✓
	D) Optical Clarity of Scope						"	✓
645	Inspect for Live Ammo						8-7-91	✓
655	Final Inspection						8-8-91	D/H
	A) Headspace						8-8-91	✓
	B) Trigger Pull	2.52	2.58	2.71	2.54	2.61	8-8-91	✓
	C) Function						8-8-91	D/H
660	Pack						9-18-91	✓

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

SERIAL NO. C6636309DATE 8-6-91TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.39	2.50	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.47	2.74	2.58	
PULL #3	2.64	2.44	2.62	2.71	
PULL #4	2.64	2.49	2.38	2.54	
PULL #5	2.70	2.48	2.64	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.24		
PULL #2	3.45	3.37		
PULL #3	3.47	3.36		
PULL #4	3.45	3.25		
PULL #5	3.26	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.28		4.37
PULL #2	4.24	4.35		4.19
PULL #3	4.45	4.40		4.19
PULL #4	4.16	4.43		4.13
PULL #5	4.15	4.23		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636309
7 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.129035
1 TO 2	.0519711
1 TO 3	.267748
1 TO 4	.097
1 TO 5	.0581378

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0498
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0528
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0725802
THE AMR FOR THIS RIFLE IS: .924

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636309

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.728

VS = 2.205

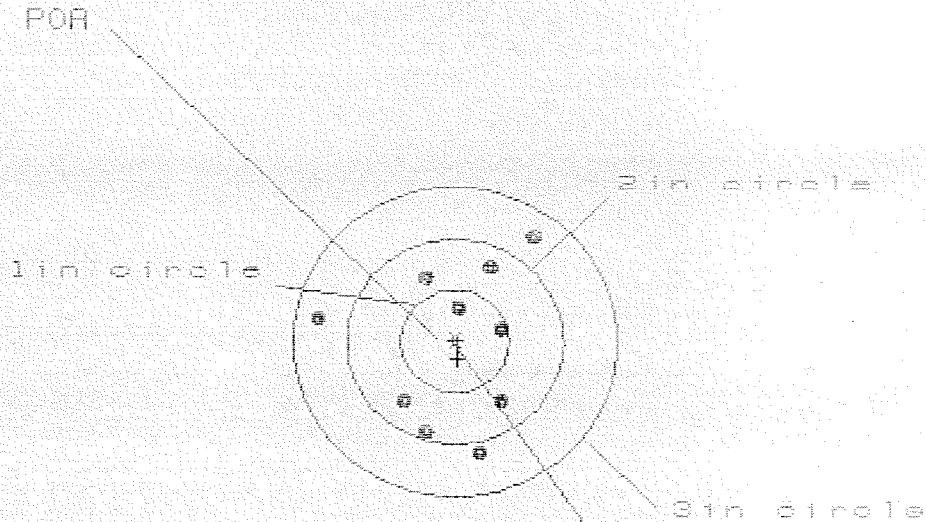
GS = 2.578

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.563	.545	.609
MINIMUM X	-1.065	-.834	-.770
MAXIMUM Y	1.127	1.036	1.101
MINIMUM Y	-1.078	-1.169	-1.039
CENTROID X	-.039	.079	.016
CENTROID Y	.123	.214	.084
FOR TO CENTROID in.	.129	.228	.086
MIN RADIUS	.100	.249	.141
MEAN RADIUS	.863	.801	.748
MAX RADIUS	1.341	1.290	1.204
HORIZONTAL SPREAD	1.728	1.379	1.379
VERTICAL SPREAD	2.205	2.205	2.140
EXTREME SPREAD	2.578	2.286	2.286
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86363B9

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.072

VS = 2.150

GS = 2.224

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.752	.606	.401
MINIMUM X	-1.320	-.608	-.532
MAXIMUM Y	1.072	1.102	.899
MINIMUM Y	-1.073	-1.048	-.910
CENTROID X	-.029	.118	.042
CENTROID Y	.174	.144	.006
POA TO CENTROID in.	.176	.186	.043
MIN RADIUS	.360	.337	.473
MEAN RADIUS	.844	.776	.716
MAX RADIUS	1.346	1.257	.937
HORIZONTAL SPREAD	2.072	1.214	.933
VERTICAL SPREAD	2.150	2.150	1.909
EXTREME SPREAD	2.224	2.212	1.812
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/08636303

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 3.077

VS = 1.648

GS = 3.224

CENTROID *

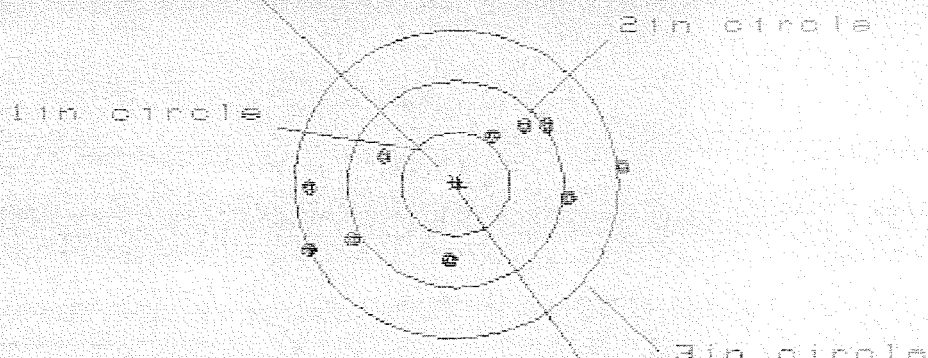
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.571	1.681	1.515
MINIMUM X	:	-1.506	-1.331	-1.581
MAXIMUM Y	:	.731	.608	.590
MINIMUM Y	:	-.917	-.836	-.854
CENTROID X	:	-.059	-.234	-.068
CENTROID Y	:	-.144	-.225	-.207
POA TO CENTROID in.	:	.156	.325	.217
MIN RADIUS	:	.064	.201	.072
MEAN RADIUS	:	.833	.718	.631
MAX RADIUS	:	1.733	1.702	1.535
HORIZONTAL SPREAD	:	3.077	3.012	2.096
VERTICAL SPREAD	:	1.648	1.444	1.444
EXTREME SPREAD	:	3.224	3.041	2.280
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C863B3B9

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 2.895

VS = 1.281

GS = 3.000

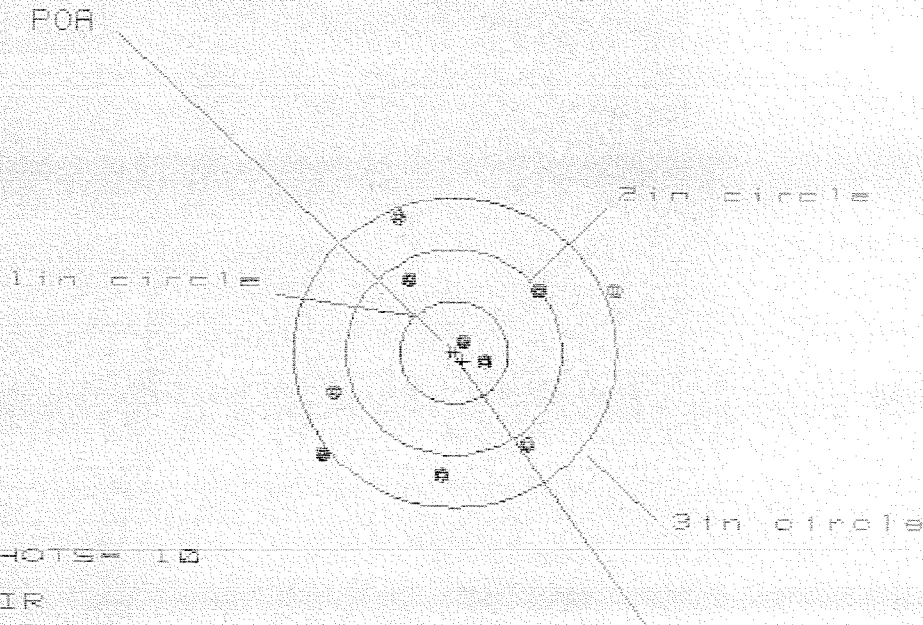
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.490	1.334	1.052
MINIMUM X	:	-1.405	-1.544	-1.377
MAXIMUM Y	:	.558	.487	.497
MINIMUM Y	:	-.723	-.794	-.784
CENTROID X	:	-.039	.117	-.050
CENTROID Y	:	.026	.097	.087
POA TO CENTROID in.	:	.047	.152	.100
MIN RADIUS	:	.646	.503	.605
MEAN RADIUS	:	1.044	.963	.921
MAX RADIUS	:	1.542	1.549	1.382
HORIZONTAL SPREAD	:	2.895	2.878	2.429
VERTICAL SPREAD	:	1.281	1.281	1.281
EXTREME SPREAD	:	3.000	2.885	2.431
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.784

VS= 2.481

GS= 3.220

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.528
MINIMUM X	-1.256
MAXIMUM Y	1.314
MINIMUM Y	-1.167
CENTROID X	-0.083
CENTROID Y	.085
POA TO CENTROID in.	.119
MIN RADIUS	.200
MEAN RADIUS	1.036
MAX RADIUS	1.648
HORIZONTAL SPREAD	2.784
VERTICAL SPREAD	2.481
EXTREME SPREAD	3.220
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8