

C6648936

MODEL 700™ M24

Model S&S™

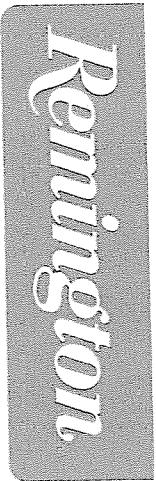
Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

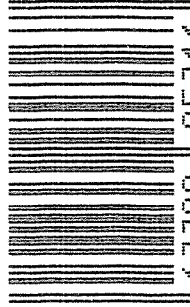


Remington® REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ H24		SERIAL NO. C6648936	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			



5716 C6648936

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648936

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		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	AS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JS

op. #	BARBER - M24 0033523 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-15-91	RL
	G) Safety Off Force	3	3	3			8-15-91	RL
	H) Trigger Pull Test & Retainability						8-15-91	RL
	I) Firing Pin Indent	.0215	.0225	.0215			8-15-91	RL
	J) Assemble Stock						8-15-91	RL
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8-15-91	RL
	M) Iron Sight Alignment						8-15-91	RL
	N) Detach Front & Rear Sights & place in numbered container						8-15-91	RL
	O) Attach Scope to Rifle						8-15-91	RL
	P) Detach & Attach Scope 20 Times						8-15-91	RL
640	Gallery Target & Test						8-15-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-15-91	AF
655	Final Inspection A) Headspace						8-17-91	DH
	B) Trigger Pull	2.22	2.31	2.40	2.46	2.48	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						8-17-91	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648936
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.0777946
1 TO 2	.13618
1 TO 3	.0206155
1 TO 4	.166643
1 TO 5	.346528

5* <----POA

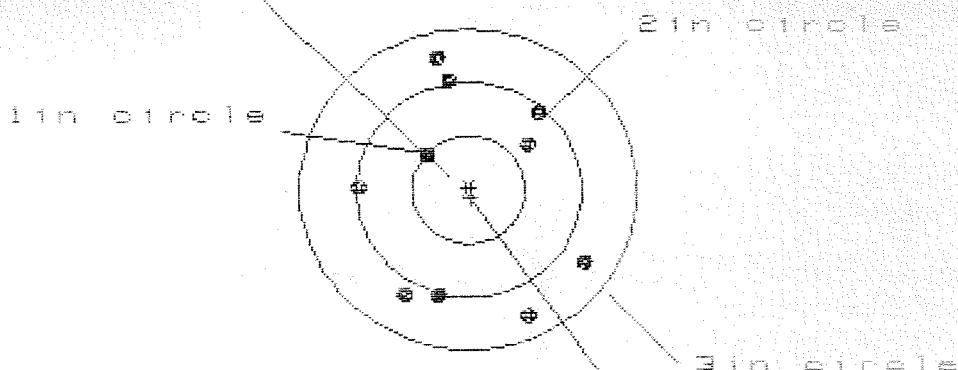
AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.095
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0346
AVERAGE POI RADIUS FOR THIS RIFLE IS: .101105
OF THIS RIFLE IS: .9446

001

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CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.988

VS= 2.419

GS= 2.556

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

1IN RADIUS

2IN RADIUS

3IN RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.007

1.068

1.043

-.981

-.920

-.945

1.240

1.109

1.032

-1.179

-1.127

-.988

-.024

-.085

-.060

.074

.205

.066

.078

.222

.089

.497

.370

.475

1.005

.948

.934

1.384

1.313

1.216

1.988

1.988

1.988

2.419

2.236

2.020

2.556

2.266

2.086

1

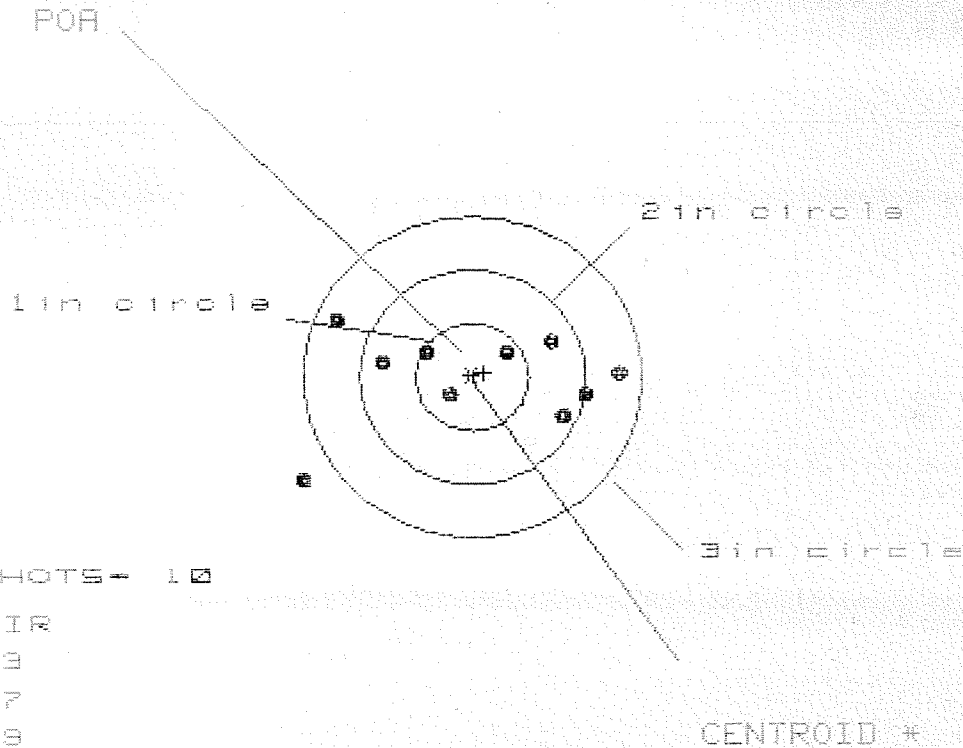
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10

31 Aug 1981

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.800

VS= 1.563

GS= 2.982

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.285	1.116	.945
MINIMUM X	-1.523	-1.366	-1.180
MAXIMUM Y	.584	.475	.258
MINIMUM Y	-.979	-.489	-.429
CENTROID X	-.100	.069	.240
CENTROID Y	-.039	.070	.010
POA TO CENTROID in.	.108	.098	.240
MIN RADIUS	.190	.173	.205
MEAN RADIUS	.896	.770	.669
MAX RADIUS	1.810	1.446	1.185
HORIZONTAL SPREAD	2.808	2.482	2.125
VERTICAL SPREAD	1.563	.964	.687
EXTREME SPREAD	2.982	2.544	2.129
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.257

VS = 2.390

GS = 3.058

CENTROID #

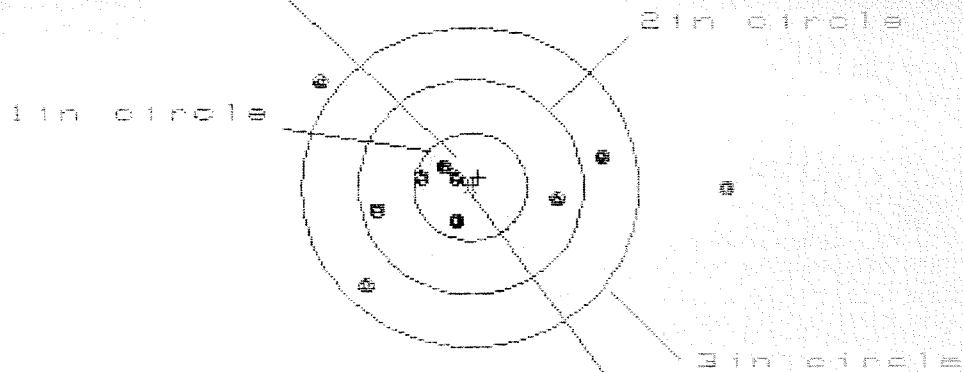
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.175	1.070	.695
MINIMUM X	-1.082	-1.187	-1.053
MAXIMUM Y	1.499	.827	.759
MINIMUM Y	-.891	-.724	-.792
CENTROID X	-.019	.086	-.048
CENTROID Y	.054	-.113	-.045
POA TO CENTROID in.	.057	.142	.066
MIN RADIUS	.425	.509	.442
MEAN RADIUS	.928	.808	.762
MAX RADIUS	1.769	1.446	1.298
HORIZONTAL SPREAD	2.257	2.257	1.748
VERTICAL SPREAD	2.390	1.551	1.551
EXTREME SPREAD	3.058	2.640	1.979
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B336

CENTERFIRE PATTERNS # 4

POR



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 3.672

VS= 1.942

GS= 3.811

CENTROID *

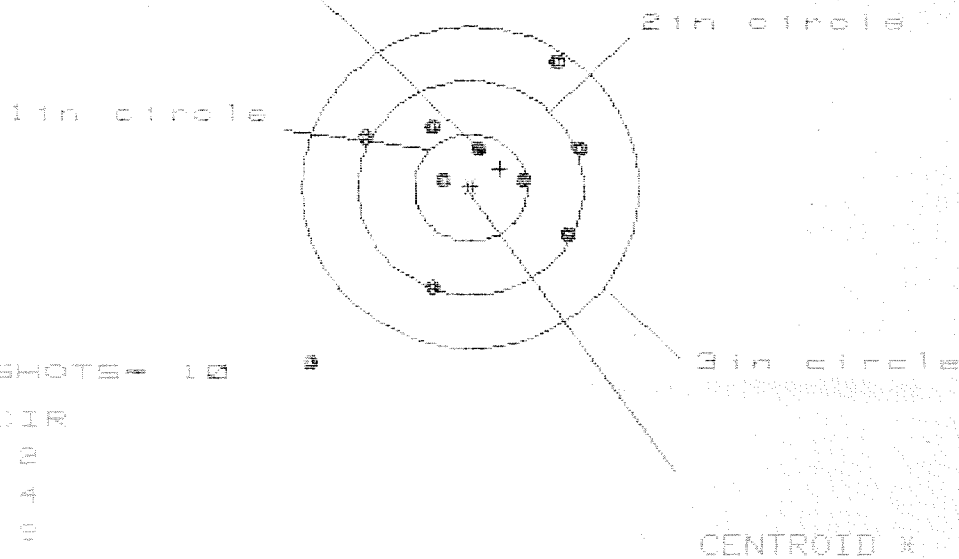
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.289	1.418	1.277
MINIMUM X	-1.393	-1.128	-.854
MAXIMUM Y	1.010	1.009	.392
MINIMUM Y	-.931	-.933	-.806
CENTROID X	-.067	-.321	-.180
CENTROID Y	-.087	-.086	-.213
POR TO CENTROID in.	.110	.332	.279
MIN RADIUS	.135	.137	.154
MEAN RADIUS	.945	.740	.653
MAX RADIUS	2.290	1.514	1.336
HORIZONTAL SPREAD	3.672	2.546	2.131
VERTICAL SPREAD	1.942	1.942	1.198
EXTREME SPREAD	3.811	2.652	2.445
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

23 NOV 1991

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1 IN = 2

2 IN = 4

3 IN = 4

H8= 2.406

V8= 2.774

E8= 3.572

PATTERN #

5

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

ADJ TO CENTROID in.

H8 ADJUST

V8 ADJUST

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE

NUMBER IN TWO

NUMBER IN THREE

:

:

:

:

:

:

:

:

:

:

:

:

:

:

:

:

10

-1.935

1.125

-1.649

-.265

-.175

.318

.203

.949

2.210

2.406

2.774

3.572

=

=

=

9

-1.772

.942

-1.156

-.182

.008

.102

.214

.767

1.252

1.891

2.098

2.367

=

=

=

8

-1.849

.549

-1.039

-.179

-.109

.210

.287

.726

1.114

1.588

2.065

=

=

=

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648976DATE 8-15-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.20	2.30	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.48	2.28	2.31	
PULL #3	2.32	2.20	2.28	2.40	
PULL #4	2.20	2.26	2.35	2.46	
PULL #5	2.28	2.32	2.36	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.28		
PULL #2	3.48	3.33		
PULL #3	3.50	3.26		
PULL #4	3.30	3.27		
PULL #5	3.42	3.20		
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	4.21		4.26
PULL #2	4.27	4.20		4.32
PULL #3	4.33	4.23		4.24
PULL #4	4.26	4.23		4.20
PULL #5	4.34	4.31		4.29
TOTAL				
AVG.				