

C6611682

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 700TM H24

46

SERIAL NO.
C6611682

ORDER NO.
5716

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

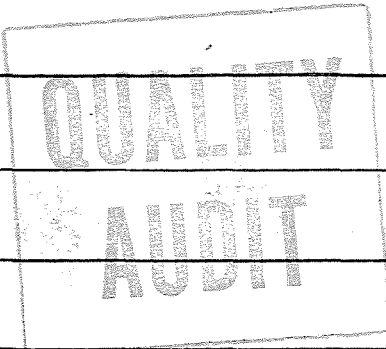


5716 C6611682



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611682

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/25/91	RW
600	Proof		3/25/91	RW
607	Check Headspace		3/25/91	RW
610	Dis-assemble Gun		3/25/91	RW
612	Magnaflux Barrel Action	3 28 91	91	KR
	Magnaflux Bolt	3 28 91		11
615	Rollmark Caliber	3 28 91		28
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/4/91	JS

op. #	BARBER - M24 0034265 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/4/91	SM
	G) Safety Off Force	4	4	4			5/4/91	SM
	H) Trigger Pull Test & Retainability						5/4/91	SM
	I) Firing Pin Indent	.0235	.023	.023			5/4/91	SM
	J) Assemble Stock						5/6/91	RW
	K) Assemble Swivel Studs						5-9-91	AC
	L) Attach Front and Rear Sight Assemblies						5/6/91	RW
	M) Iron Sight Alignment						5/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	RW
	O) Attach Scope to Rifle						5/6/91	RW
	P) Detach & Attach Scope 20 Times						5/6/91	RW
640	Gallery Target & Test						5-6-91	AC
	A) Time						5-6-91	AC
	B) Malfunctions						5-6-91	AC
	C) Pierced Primers						5-6-91	AC
	D) Optical Clarity of Scope						5-6-91	AC
645	Inspect for Live Ammo						5-6-91	AC
655	Final Inspection							
	A) Headspace						5-9-91	AC
	B) Trigger Pull	2.35	2.33	2.23	2.31	2.32	5/9/91	SM
	C) Function						5-9-91	AC
660	Pack						6-18-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611682

DATE 5/4/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.41	2.45	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.42	2.41	2.33	
PULL #3	2.56	2.39	2.43	2.23	
PULL #4	2.51	2.45	2.46	2.31	
PULL #5	2.40	2.43	2.46	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.40		
PULL #2	3.51	3.49		
PULL #3	3.26	3.42		
PULL #4	3.56	3.53		
PULL #5	3.55	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.38		4.42
PULL #2	4.37	4.40		4.46
PULL #3	4.29	4.44		4.34
PULL #4	4.39	4.41		4.41
PULL #5	4.36	4.42		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611682
6 May 1991

CENTROIDAL DISTANCES

0 TO	1	.121433
1 TO	2	.764438
1 TO	3	.283981
1 TO	4	.432261
1 TO	5	.689162

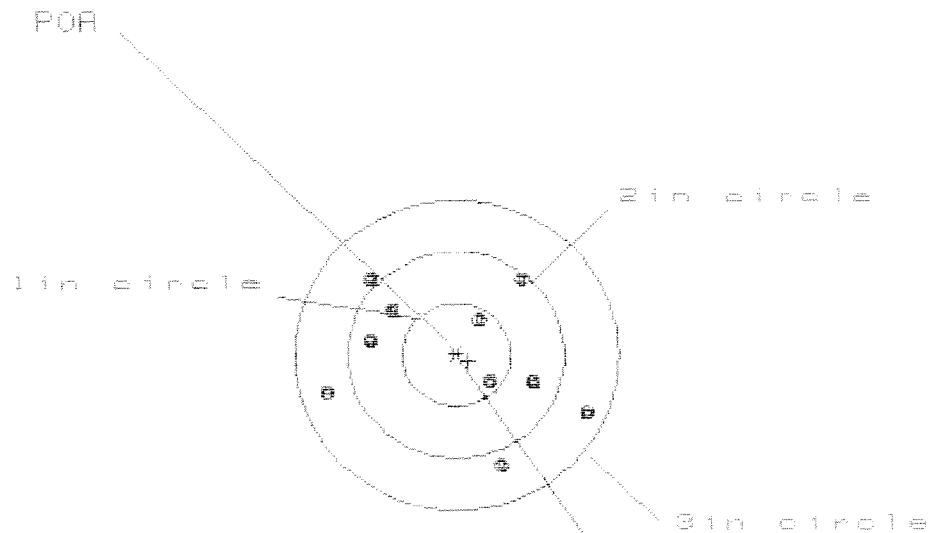
4 2
4 5 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .283
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2006
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .265392
THE AMR FOR THIS RIFLE IS: .9728

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611662

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.350

VS= 1.853

GS= 2.453

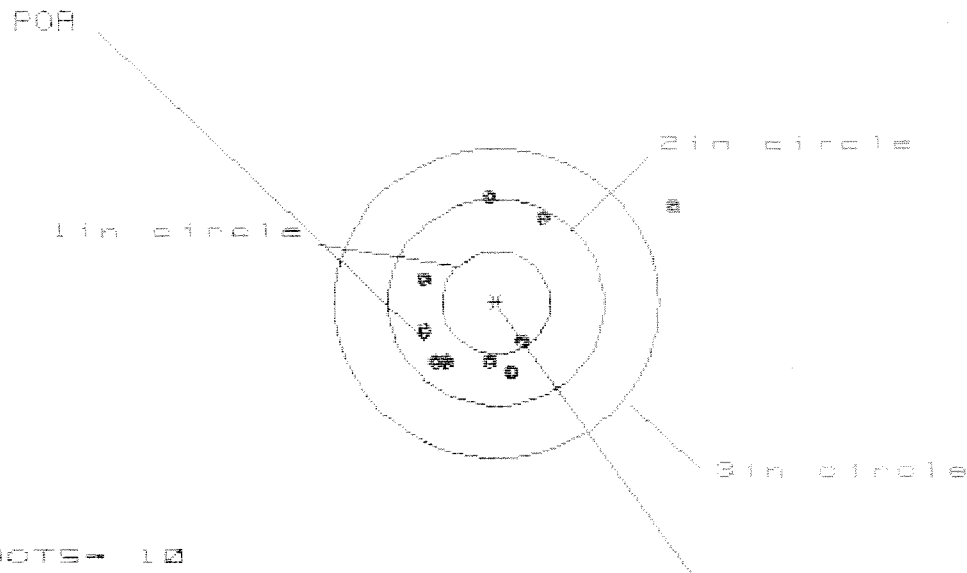
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.204	.865	.738
MINIMUM X	-1.146	-1.012	-.815
MAXIMUM Y	.787	.720	.670
MINIMUM Y	-1.066	-1.133	-1.183
CENTROID X	-.105	-.239	-.112
CENTROID Y	.061	.128	.178
POA TO CENTROID in.	.121	.271	.210
MIN RADIUS	.384	.433	.307
MEAN RADIUS	.898	.842	.794
MAX RADIUS	1.348	1.249	1.248
HORIZONTAL SPREAD	2.350	1.877	1.553
VERTICAL SPREAD	1.853	1.853	1.853
EXTREME SPREAD	2.453	2.210	2.210
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611882

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.349

VS= 1.781

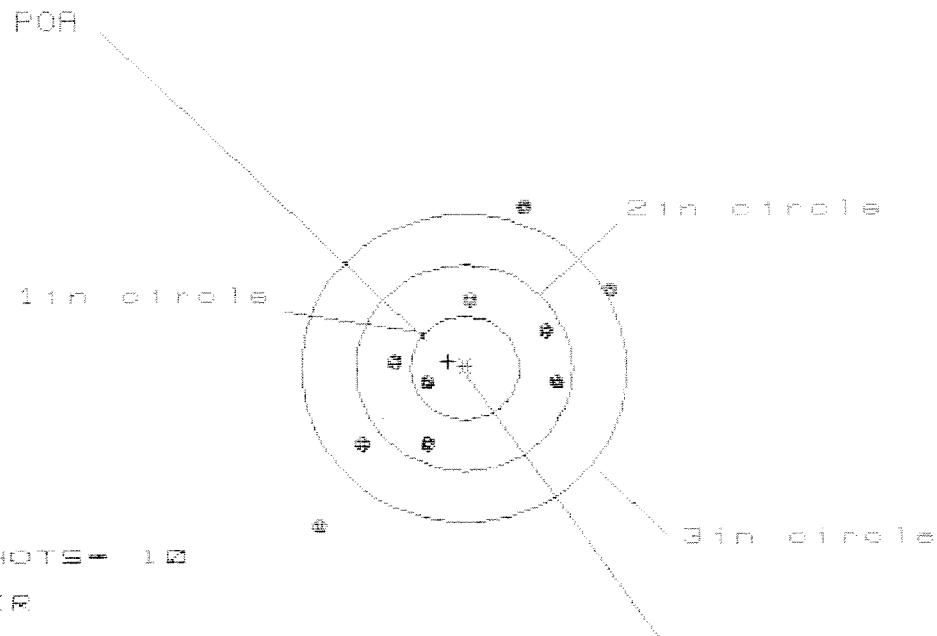
GS= 2.658

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.670	.572	.588
MINIMUM X	-.679	-.493	-.477
MAXIMUM Y	1.042	1.140	1.123
MINIMUM Y	-.660	-.561	-.418
CENTROID X	.468	.282	.266
CENTROID Y	.567	.468	.325
POA TO CENTROID in.	.735	.546	.420
MIN RADIUS	.434	.475	.382
MEAN RADIUS	.854	.684	.581
MAX RADIUS	1.892	1.148	1.268
HORIZONTAL SPREAD	2.349	1.065	1.065
VERTICAL SPREAD	1.781	1.781	1.541
EXTREME SPREAD	2.658	1.739	1.739
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611682

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 2.653

VS = 3.023

QS = 3.574

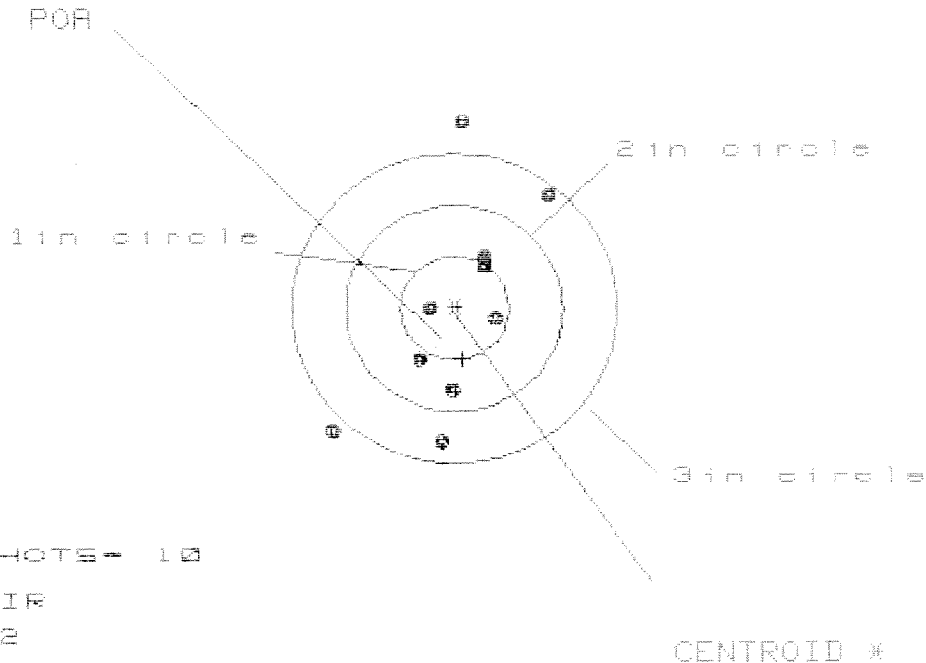
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.341	1.195	1.252
MINIMUM X	-1.312	-1.063	-1.066
MAXIMUM Y	1.518	1.350	.735
MINIMUM Y	-1.506	-.949	-.780
CENTROID X	.149	.295	.238
CENTROID Y	-.066	.101	-.068
POA TO CENTROID in.	.163	.311	.248
MIN RADIUS	.404	.488	.489
MEAN RADIUS	1.058	.945	.874
MAX RADIUS	1.997	1.423	1.451
HORIZONTAL SPREAD	2.653	2.258	2.258
VERTICAL SPREAD	3.023	2.299	1.515
EXTREME SPREAD	3.574	2.736	2.709
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

6 May 1991

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CENTERFIRE PATTERNS # 4



PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.853	.862	.719
MINIMUM X	-1.154	-1.145	-.483
MAXIMUM Y	1.814	1.342	1.217
MINIMUM Y	-1.292	-1.690	-1.215
CENTROID X	-.072	-.081	.062
CENTROID Y	.492	.290	.415
POA TO CENTROID in.	.497	.301	.420
MIN RADIUS	.262	.338	.287
MEAN RADIUS	.931	.822	.721
MAX RADIUS	1.816	1.595	1.413
HORIZONTAL SPREAD	2.007	2.007	1.282
VERTICAL SPREAD	3.106	2.432	2.432
EXTREME SPREAD	3.256	3.082	2.612
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611682

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.271

VS= 3.165

GS= 3.213

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.425	1.370	1.520
MINIMUM X	-0.846	-0.901	-0.751
MAXIMUM Y	1.272	1.069	1.151
MINIMUM Y	-1.833	-1.178	-1.097
CENTROID X	.575	.630	.486
CENTROID Y	-.051	.152	.071
POA TO CENTROID in.	.577	.648	.486
MIN RADIUS	.361	.207	.247
MEAN RADIUS	1.123	.991	.957
MAX RADIUS	1.900	1.532	1.635
HORIZONTAL SPREAD	2.271	2.271	2.271
VERTICAL SPREAD	3.165	2.247	2.247
EXTREME SPREAD	3.213	2.781	2.781
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	