

C6611718

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

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

MODEL 700™ M24

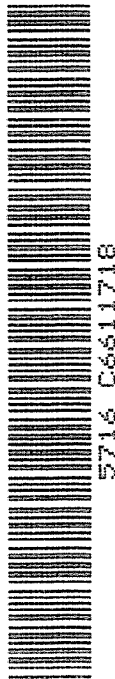
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

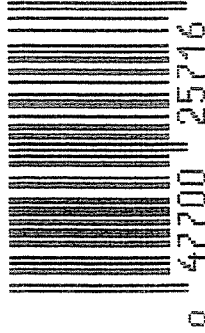
SERIAL NO.
 C6611718

ORDER NO.
 5716

46



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611718

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	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		5/2/91	JH

op. #	BARBER AM24 0034743	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			5-2-91	DH
	G) Safety Off Force	3	3	3			5-2-91	DH
	H) Trigger Pull Test & Retainability						5/2/91	JU
	I) Firing Pin Indent	.022	.022	.023			5-2-91	DH
	J) Assemble Stock						5/3/91	RW
	K) Assemble Swivel Studs						5-10-91	A
	L) Attach Front and Rear Sight Assemblies						5/3/91	RW
	M) Iron Sight Alignment						5/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/3/91	RW
	O) Attach Scope to Rifle						5/3/91	RW
	P) Detach & Attach Scope 20 Times						5/3/91	RW
640	Gallery Target & Test						5/3/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/3/91	KT
655	Final Inspection							
	A) Headspace						5-10-91	A
	B) Trigger Pull	2.23	2.25	2.23	2.32	2.29	5/9/91	JU
	C) Function						5-10-91	A
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611718

DATE 5/2/91

TESTER JCI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.42	2.40	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.36	2.41	2.25	
PULL #3	2.33	2.37	2.48	2.23	
PULL #4	2.39	2.38	2.36	2.32	
PULL #5	2.38	2.43	2.41	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.44		
PULL #2	3.46	3.35		
PULL #3	3.48	3.42		
PULL #4	3.25	3.46		
PULL #5	3.31	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.47		4.48
PULL #2	4.47	4.45		4.43
PULL #3	4.40	4.47		4.43
PULL #4	4.48	4.44		4.44
PULL #5	4.45	4.48		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611718
3 May 1991

CENTROIDAL DISTANCES

0 TO	1	.297405
1 TO	2	.521714
1 TO	3	.431051
1 TO	4	.349292
1 TO	5	.320975

91 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0976
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134126
THE AMR FOR THIS RIFLE IS: .9582

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11718

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.445

VS= 2.637

GS= 3.194

CENTROID *

PATTERN

SHOTS (BEST OF)

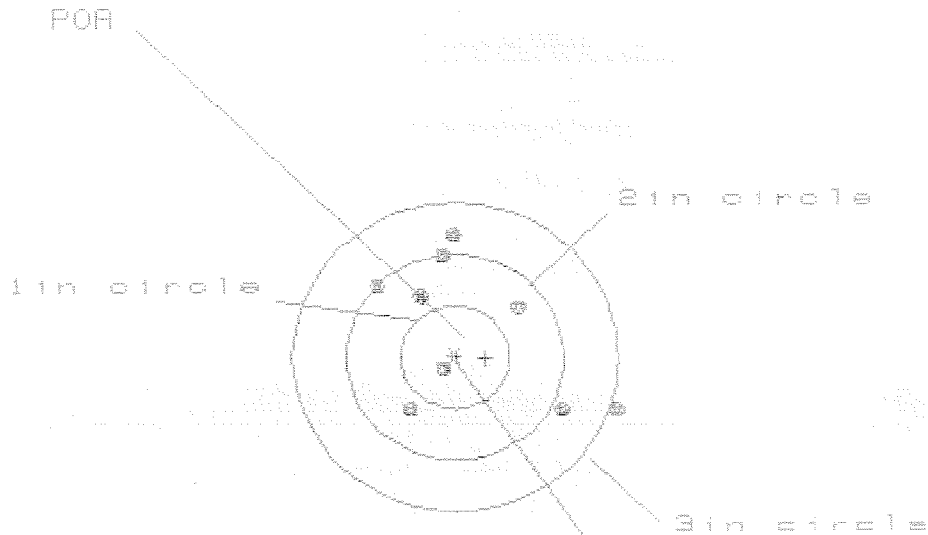
	10	9	6
MAXIMUM X	1.012	.853	.739
MINIMUM X	-1.433	-1.322	-1.215
MAXIMUM Y	1.411	1.095	.642
MINIMUM Y	-1.226	-1.070	-.933
CENTROID X	.177	.336	.229
CENTROID Y	-.239	-.395	-.532
POA TO CENTROID in.	.297	.519	.580
MIN RADIUS	.222	.445	.501
MEAN RADIUS	.982	.843	.767
MAX RADIUS	2.011	1.388	1.246
HORIZONTAL SPREAD	2.445	2.175	1.954
VERTICAL SPREAD	2.637	2.165	1.575
EXTREME SPREAD	3.194	2.376	1.988
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611718

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.872

VS= 3.541

GS= 3.774

PATTERN #

2

SHOTS (BEST OF)

10

9

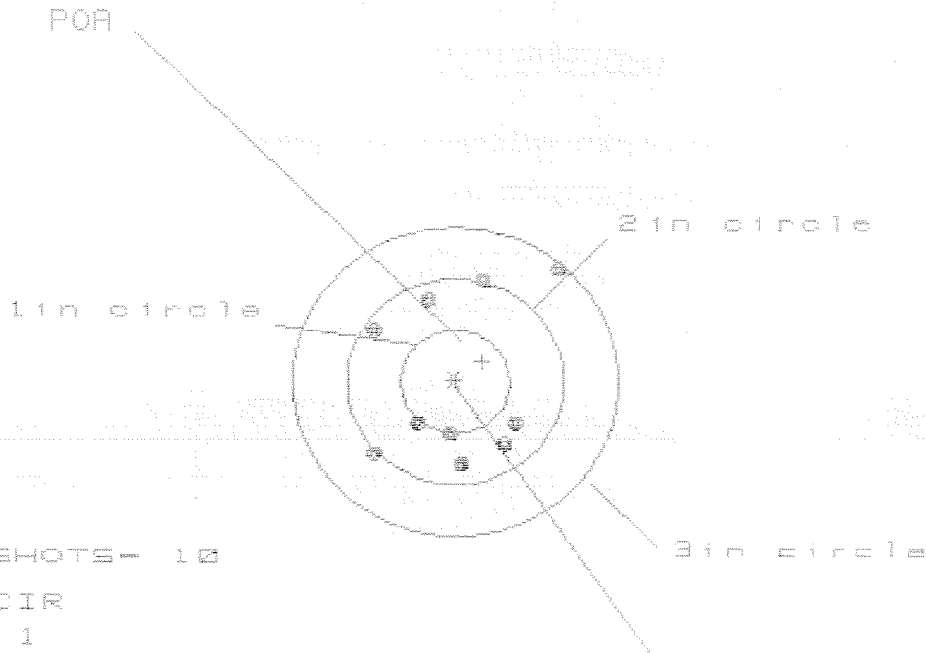
8

MAXIMUM X	1.521	1.371	1.008
MINIMUM X	-1.351	-.824	-.652
MAXIMUM Y	1.178	.916	.814
MINIMUM Y	-2.363	-.812	-.835
CENTROID X	-.282	-.132	-.304
CENTROID Y	.009	.271	.373
POA TO CENTROID in.	.283	.302	.481
MIN RADIUS	.128	.426	.395
MEAN RADIUS	1.079	.868	.737
MAX RADIUS	2.721	1.594	1.308
HORIZONTAL SPREAD	2.872	2.195	1.660
VERTICAL SPREAD	3.541	1.728	1.649
EXTREME SPREAD	3.774	2.516	2.019
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611718

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.683

VS= 1.876

GS= 2.471

CENTROID *

PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.917	.683	.602
MINIMUM X	-.786	-.664	-.745
MAXIMUM Y	1.097	1.080	1.005
MINIMUM Y	-.779	-.657	-.732
CENTROID X	-.252	-.354	-.273
CENTROID Y	-.197	-.319	-.244
POA TO CENTROID (in)	.320	.477	.366
MIN RADIUS	.499	.368	.449
MEAN RADIUS	.847	.749	.741
MAX RADIUS	1.438	1.136	1.041
HORIZONTAL SPREAD	1.683	1.347	1.347
VERTICAL SPREAD	1.876	1.737	1.737
EXTREME SPREAD	2.471	1.959	1.754
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

3 May 1991

FILE:/PATTERNING/CENTERFIRE PATT/C8611718

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.481

VS= 2.023

GS= 3.533

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

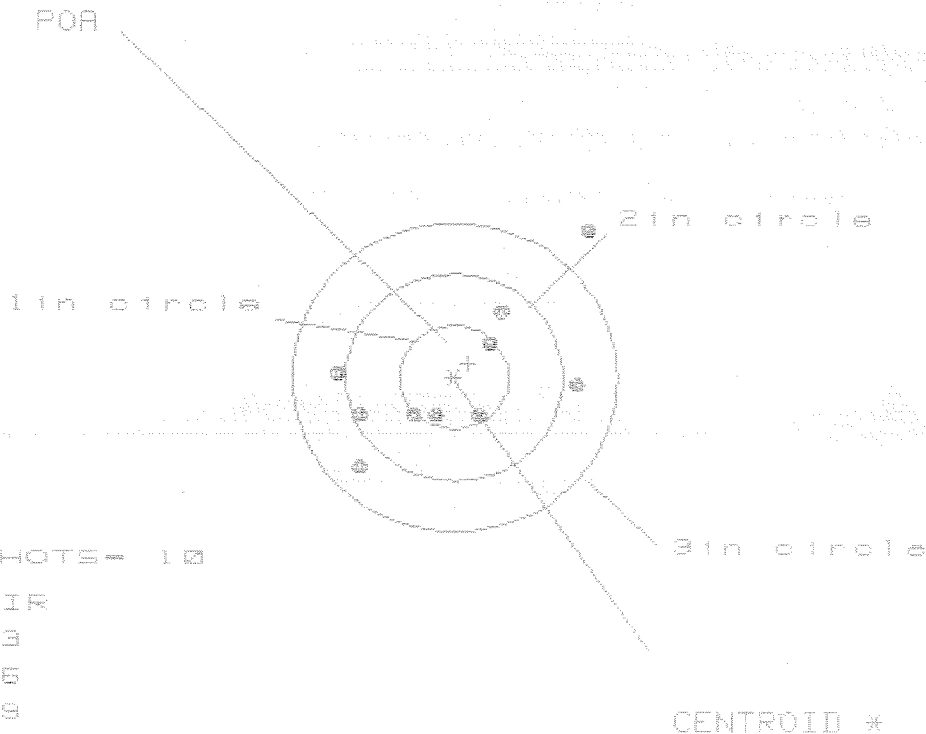
MAXIMUM X	-1.556	1.343	1.020
MINIMUM X	-1.925	-.743	-.576
MAXIMUM Y	.780	.787	.721
MINIMUM Y	-1.243	-1.236	-1.302
CENTROID X	.024	.237	.070
CENTROID Y	.075	.068	.134
POA TO CENTROID in.	.079	.247	.151
MIN RADIUS	.526	.615	.510
MEAN RADIUS	.999	.895	.796
MAX RADIUS	1.926	1.443	1.424
HORIZONTAL SPREAD	3.481	2.086	1.596
VERTICAL SPREAD	2.023	2.023	2.023
EXTREME SPREAD	3.533	2.203	2.172
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11718

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.311

VS= 2.311

GS= 3.100

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.230

1.276

1.189

MINIMUM X

-1.081

-.944

-1.031

MAXIMUM Y

1.414

.801

.709

MINIMUM Y

-.897

-.740

-.323

CENTROID X

-.127

-.264

-.177

CENTROID Y

-.136

-.293

-.201

POA TO CENTROID in.

.186

.395

.267

MIN RADIUS

.414

.233

.344

MEAN RADIUS

.884

.735

.707

MAX RADIUS

1.874

1.277

1.189

HORIZONTAL SPREAD

2.311

2.220

2.220

VERTICAL SPREAD

2.311

1.541

1.032

EXTREME SPREAD

3.100

2.222

2.222

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9