

C6611741

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*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

SERIAL NO. C6611741

ORDER NO. 5716

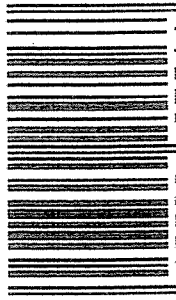
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

46



5716 C6611741

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611741

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	U
615	Rollmark Caliber		APR 2 1991	GS
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/11/91	JK
	G) Safety Off Force	3	3	3			4/11/91	JK
	H) Trigger Pull Test & Retainability						4/11/91	JK
	I) Firing Pin Indent	.022	.022	.022			4/11/91	JK
	J) Assemble Stock						4/11/91	KS
	K) Assemble Swivel Studs						4-22-91	A
	L) Attach Front and Rear Sight Assemblies						4/11/91	KS
	M) Iron Sight Alignment						4/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/11/91	KS
	O) Attach Scope to Rifle						4/11/91	KS
	P) Detach & Attach Scope 20 Times						4/11/91	KS
640	Gallery Target & Test						4-12-91	DH
	A) Time						4-12-91	DH
	B) Malfunctions						4-12-91	DH
	C) Pierced Primers						4-12-91	DH
	D) Optical Clarity of Scope						4-12-91	DH
645	Inspect for Live Ammo						4-12-91	DH
655	Final Inspection						4-22-91	A
	A) Headspace						4/16/91	JK
	B) Trigger Pull	2.49	2.54	2.50	2.32	2.41	4-22-91	AC
660	C) Function						4-22-91	AC
	Pack						6-18-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 26611741

DATE 4/11/91

TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.16	2.22	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.19	2.20	2.54	
PULL #3	2.19	2.22	2.27	2.50	
PULL #4	2.19	2.21	2.20	2.32	
PULL #5	2.22	2.18	2.22	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.34		
PULL #2	3.43	3.41		
PULL #3	3.50	3.24		
PULL #4	3.41	3.25		
PULL #5	3.40	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.37		4.40
PULL #2	4.37	4.31		4.32
PULL #3	4.19	4.22		4.32
PULL #4	4.33	4.40		4.27
PULL #5	4.30	4.40		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611741
12 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.175328
1 TO	2	.477272
1 TO	3	.264025
1 TO	4	.077801
1 TO	5	.174542

$\bar{x}_2$ ----- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0902
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .158721
THE AMR FOR THIS RIFLE IS: .916

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C861174J

CENTERFIRE PATTERNS

1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.945

VS= 2.519

GS= 2.578

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.105

1.094

1.094

MINIMUM X

-.840

-.717

-.717

MAXIMUM Y

1.305

1.402

.663

MINIMUM Y

-1.214

-1.117

-.942

CENTROID X

.076

-.047

-.047

CENTROID Y

-.158

-.255

-.430

POR TO CENTROID in.

.175

.259

.433

MIN RADIUS

.327

.306

.459

MEAN RADIUS

.898

.820

.760

MAX RADIUS

1.409

1.402

1.134

HORIZONTAL SPREAD

1.945

1.811

1.811

VERTICAL SPREAD

2.519

2.519

1.605

EXTREME SPREAD

2.578

2.535

1.845

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11741

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.306

VS= 2.108

GS= 2.561

CENTROID #

PATTERN #

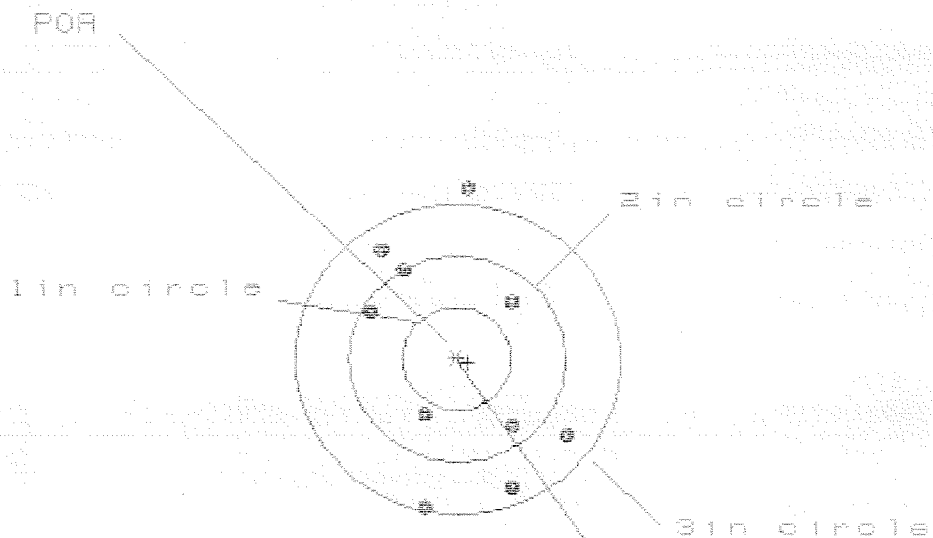
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.115	1.021	1.007
MINIMUM X	-1.191	-1.285	-1.157
MAXIMUM Y	1.029	1.064	1.166
MINIMUM Y	-1.079	-0.965	-0.863
CENTROID X	.546	.640	.512
CENTROID Y	-.241	-.355	-.457
POA TO CENTROID IN.	.597	.732	.686
MIN RADIUS	.471	.484	.327
MEAN RADIUS	1.004	.962	.895
MAX RADIUS	1.329	1.305	1.190
HORIZONTAL SPREAD	2.306	2.306	2.164
VERTICAL SPREAD	2.108	2.029	2.029
EXTREME SPREAD	2.561	2.433	2.221
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611741

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 1.751

VS = 3.117

GS = 3.141

CENTROID *

PATTERN #		3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.986	.993	.953
MINIMUM X	:	-.765	-.758	-.798
MAXIMUM Y	:	1.670	1.212	1.054
MINIMUM Y	:	-1.447	-1.261	-1.224
CENTROID X	:	-.102	-.109	-.069
CENTROID Y	:	.037	-.149	.009
POR TO CENTROID IN	:	.109	.184	.069
MIN RADIUS	:	.523	.412	.565
MEAN RADIUS	:	1.105	1.023	.986
MAX RADIUS	:	1.671	1.412	1.322
HORIZONTAL SPREAD	:	1.751	1.751	1.751
VERTICAL SPREAD	:	3.117	2.473	2.278
EXTREME SPREAD	:	3.141	2.605	2.605
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611741

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.182

VS= 2.101

GS= 2.827

CENTROID # 4

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.708

.577

.377

MINIMUM X

-1.474

-1.605

-.690

MAXIMUM Y

.916

.784

.888

MINIMUM Y

-1.185

-.789

-.765

CENTROID X

.014

.145

.345

CENTROID Y

-.205

-.073

-.097

POA TO CENTROID IN.

.205

.162

.359

MIN RADIUS

.231

.370

.272

MEAN RADIUS

.864

.745

.576

MAX RADIUS

1.674

1.616

.968

HORIZONTAL SPREAD

2.182

2.182

1.067

VERTICAL SPREAD

2.101

1.573

1.573

EXTREME SPREAD

2.827

2.261

1.738

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811741

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.602

VS= 2.113

GS= 2.793

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.363

.656

.520

MINIMUM X

-1.239

-1.088

-.791

MAXIMUM Y

1.064

.546

.567

MINIMUM Y

-1.049

-.931

-.910

CENTROID X

-.083

-.234

-.098

CENTROID Y

-.086

-.204

-.225

POA TO CENTROID in.

.119

.311

.246

MIN RADIUS

.116

.091

.158

MEAN RADIUS

.709

.596

.516

MAX RADIUS

1.729

1.101

.919

HORIZONTAL SPREAD

2.602

1.744

1.221

VERTICAL SPREAD

2.113

1.477

1.477

EXTREME SPREAD

2.793

1.785

1.613

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9