

C6611800

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

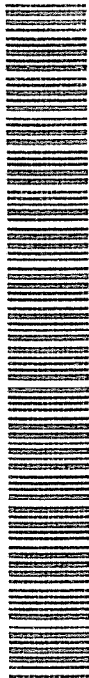
Remington  REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

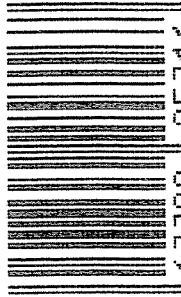
SERIAL NO. C6611800	ORDER NO. 5716
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VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.



5716 C6611800

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611800

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	LS
617	Drill and Tap Sight Holes	2 2	91	FB
618	Polish Barrel <i>ROBB</i>	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/5/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/5/91	KL
	C) Inspect Ejector Hole for Chamfer		3/5/91	KL
	D) Oil Firing Pin Ass'y		3/5/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		3/7/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			3/7/91	WB
	G) Safety Off Force	2	2	2			3/7/91	WB
	H) Trigger Pull Test & Retainability						3/7/91	WB
	I) Firing Pin Indent	.022	.023	.0225			3/7/91	WB
	J) Assemble Stock						3/7/91	KH
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/7/91	KH
	M) Iron Sight Alignment						3/7/91	KH
	N) Detach Front & Rear Sights & place in numbered container						3/7/91	KH
	O) Attach Scope to Rifle						3/7/91	KH
	P) Detach & Attach Scope 20 Times						3/7/91	KH
640	Gallery Target & Test						3/8/91	KH
	A) Time							KH
	B) Malfunctions							KH
	C) Pierced Primers							KH
	D) Optical Clarity of Scope							KH
645	Inspect for Live Ammo						3/8/91	KH
655	Final Inspection							
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.46	2.36	2.42	2.43	2.44	3/8/91	KH
	C) Function						3-11-91	D/H
660	Pack						3-20-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611800

DATE 3/7/91

TESTER WAB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.42	2.35	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.47	2.34	2.36	
PULL #3	2.52	2.43	2.30	2.42	
PULL #4	2.43	2.53	2.34	2.43	
PULL #5	2.53	2.55	2.32	2.44	
TOTAL	12.52	12.40	11.65		
AVG.	2.50	2.48	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.08		
PULL #2	3.12	3.09		
PULL #3	3.12	3.02		
PULL #4	3.07	3.12		
PULL #5	3.13	3.14		
TOTAL	15.62	15.45		
AVG.	3.12	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.05		4.06
PULL #2	4.11	4.01		4.08
PULL #3	4.13	4.03		4.09
PULL #4	4.06	4.03		4.08
PULL #5	4.12	4.06		4.15
TOTAL	20.48	20.18		20.46
AVG.	4.10	4.03		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611800
8 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0340588
1 TO	2	.120071
1 TO	3	.178877
1 TO	4	.136015
1 TO	5	.165702

56 (----POA

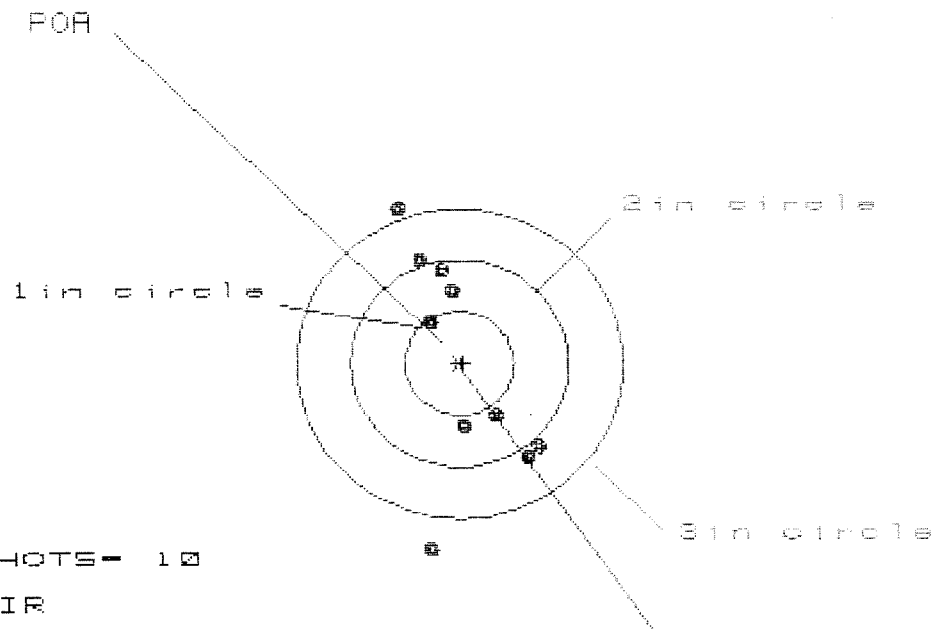
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0328737

THE AMR FOR THIS RIFLE IS: 1.002

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11800

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 1.255

VS= 3.345

CS= 3.352

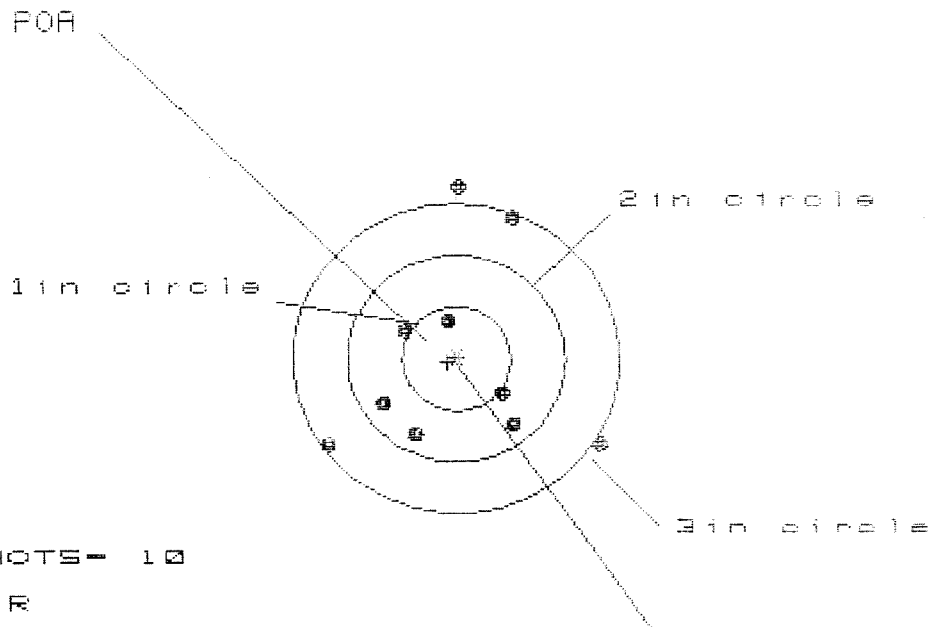
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.725	.690	.619
MINIMUM X	-.530	-.565	-.455
MAXIMUM Y	1.538	1.338	.936
MINIMUM Y	-1.807	-1.048	-.881
CENTROID X	-.034	.001	.072
CENTROID Y	-.002	.198	.031
POA TO CENTROID in.	.034	.198	.078
MIN RADIUS	.534	.410	.559
MEAN RADIUS	.987	.870	.798
MAX RADIUS	1.834	1.452	1.040
HORIZONTAL SPREAD	1.255	1.255	1.074
VERTICAL SPREAD	3.345	2.386	1.817
EXTREME SPREAD	3.352	2.639	2.056
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

8 Mar 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.426

VS= 2.516

GS= 2.811

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.277	.691
MINIMUM X	:	-1.151	-1.149	-.989
MAXIMUM Y	:	1.712	1.583	1.506
MINIMUM Y	:	-.804	-.613	-.687
CENTROID X	:	.082	.080	-.080
CENTROID Y	:	.029	-.162	-.085
POA TO CENTROID in.	:	.087	.180	.117
MIN RADIUS	:	.417	.474	.499
MEAN RADIUS	:	1.015	.917	.841
MAX RADIUS	:	1.712	1.669	1.657
HORIZONTAL SPREAD	:	2.426	2.426	1.680
VERTICAL SPREAD	:	2.516	2.196	2.193
EXTREME SPREAD	:	2.811	2.763	2.763
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.585

VS = 1.290

GS = 3.585

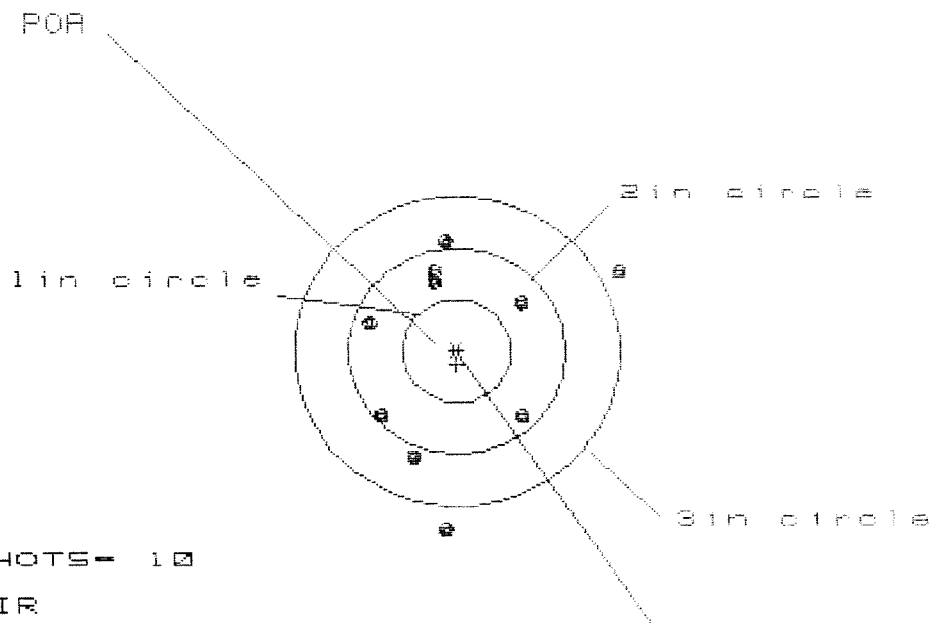
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.841
MINIMUM X	-1.744
MAXIMUM Y	.591
MINIMUM Y	-.699
CENTROID X	.120
CENTROID Y	-.093
POA TO CENTROID in.	.152
MIN RADIUS	.431
MEAN RADIUS	1.006
MAX RADIUS	1.869
HORIZONTAL SPREAD	3.585
VERTICAL SPREAD	1.290
EXTREME SPREAD	3.585
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811800

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 6

3 in - 8

HS- 2.314

VS- 2.776

GS- 2.906

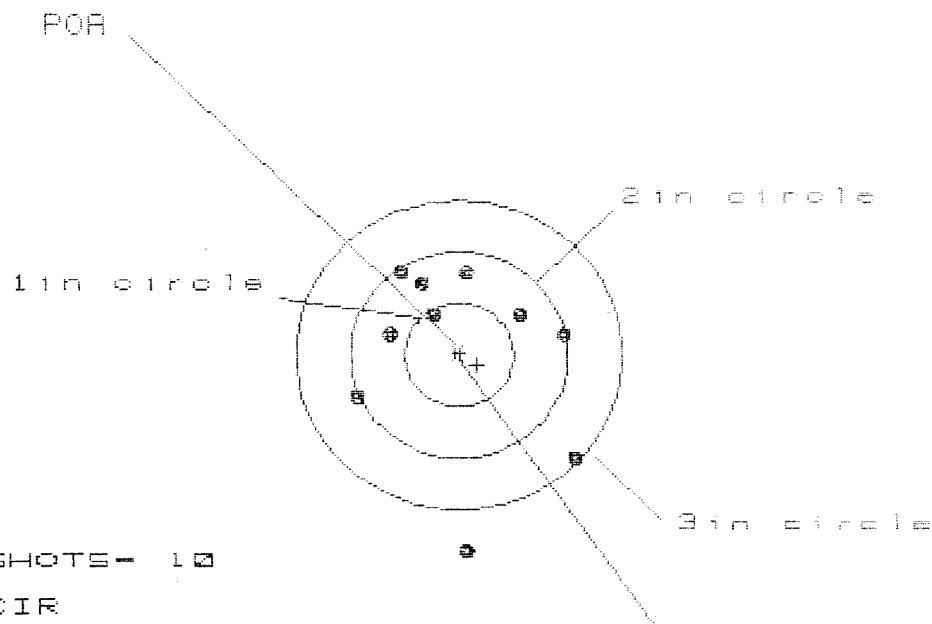
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.495	1.480	.756
MINIMUM X	:	-.819	-.834	-.649
MAXIMUM Y	:	1.094	.907	.974
MINIMUM Y	:	-1.682	-1.251	-1.184
CENTROID X	:	.006	.021	-.164
CENTROID Y	:	.128	.315	.248
POA TO CENTROID in.	:	.128	.316	.297
MIN RADIUS	:	.704	.534	.555
MEAN RADIUS	:	1.052	.949	.860
MAX RADIUS	:	1.688	1.574	1.212
HORIZONTAL SPREAD	:	2.314	2.314	1.405
VERTICAL SPREAD	:	2.776	2.158	2.158
EXTREME SPREAD	:	2.906	2.626	2.176
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.908

VS= 2.681

GS= 2.747

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	1.023	1.082
MINIMUM X	:	-0.891	-0.885	-0.758
MAXIMUM Y	:	.774	.563	.413
MINIMUM Y	:	-1.907	-1.199	-0.764
CENTROID X	:	-0.163	-0.169	-0.296
CENTROID Y	:	.102	.313	.463
POA TO CENTROID in.	:	.192	.356	.550
MIN RADIUS	:	.476	.326	.152
MEAN RADIUS	:	.951	.781	.617
MAX RADIUS	:	1.907	1.576	1.092
HORIZONTAL SPREAD	:	1.908	1.908	1.839
VERTICAL SPREAD	:	2.681	1.762	1.177
EXTREME SPREAD	:	2.747	2.357	1.938
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	