

C6611820

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

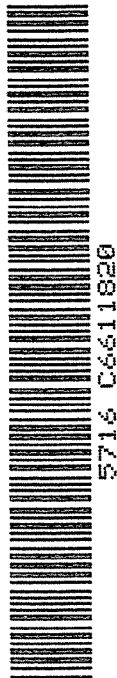
MODEL 700TM M24

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

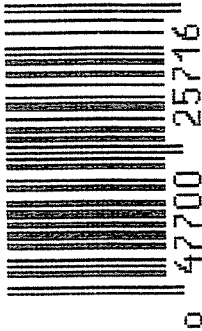
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6611820	ORDER NO. 5716
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LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611820

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	Y
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	LB
620	Apply Coatings (Barrel Action)		4-9-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	TH

op. #	BARBER - M24 0036542 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/18/91	gcl
	G) Safety Off Force	3	3	3			4/18/91	gcl
	H) Trigger Pull Test & Retainability						4/17/91	gcl
	I) Firing Pin Indent	.022	.0225	.0225			4/18/91	gcl
	J) Assemble Stock						4/22/91	Rw
	K) Assemble Swivel Studs						4/23/91	gcl
	L) Attach Front and Rear Sight Assemblies						4/22/91	Rw
	M) Iron Sight Alignment						4/22/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	Rw
	O) Attach Scope to Rifle						4/22/91	Rw
	P) Detach & Attach Scope 20 Times						4/22/91	Rw
640	Gallery Target & Test						4/22/91	K2
	A) Time							K2
	B) Malfunctions							K2
	C) Pierced Primers							K2
	D) Optical Clarity of Scope							K2
645	Inspect for Live Ammo						4/22/91	K2
655	Final Inspection							
	A) Headspace						4/23/91	gcl
	B) Trigger Pull	2.42	2.52	2.48	2.48	2.46	4/23/91	gcl
	C) Function						4/23/91	gcl
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611820

DATE 4/17/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.50	2.48	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.46	2.52	
PULL #3	2.34	2.46	2.44	2.48	
PULL #4	2.50	2.45	2.50	2.48	
PULL #5	2.30	2.58	2.48	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.43		
PULL #2	3.19	3.46		
PULL #3	3.36	3.34		
PULL #4	3.44	3.48		
PULL #5	3.50	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.41		4.39
PULL #2	4.18	4.41		4.46
PULL #3	4.44	4.39		4.40
PULL #4	4.35	4.28		4.44
PULL #5	4.40	4.43		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611820
22 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.076922
1 TO	2	.0996092
1 TO	3	.0788923
1 TO	4	.336214
1 TO	5	.322298

4.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0918
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101457

THE AMR FOR THIS RIFLE IS: .7916

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11820

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 2.192

VS = 1.512

CS = 2.263

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.695	.735
MINIMUM X	-1.348	-.777	-.737
MAXIMUM Y	1.008	.970	.552
MINIMUM Y	-.504	-.542	-.420
CENTROID X	.069	.219	.179
CENTROID Y	.034	.072	-.050
FOR TO CENTROID in.	.077	.231	.186
MIN RADIUS	.352	.337	.228
MEAN RADIUS	.698	.609	.533
MAX RADIUS	1.390	1.023	.921
HORIZONTAL SPREAD	2.193	1.472	1.472
VERTICAL SPREAD	1.512	1.512	.973
EXTREME SPREAD	2.263	1.650	1.552
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611820

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 2.050

VS = 1.769

GS = 2.050

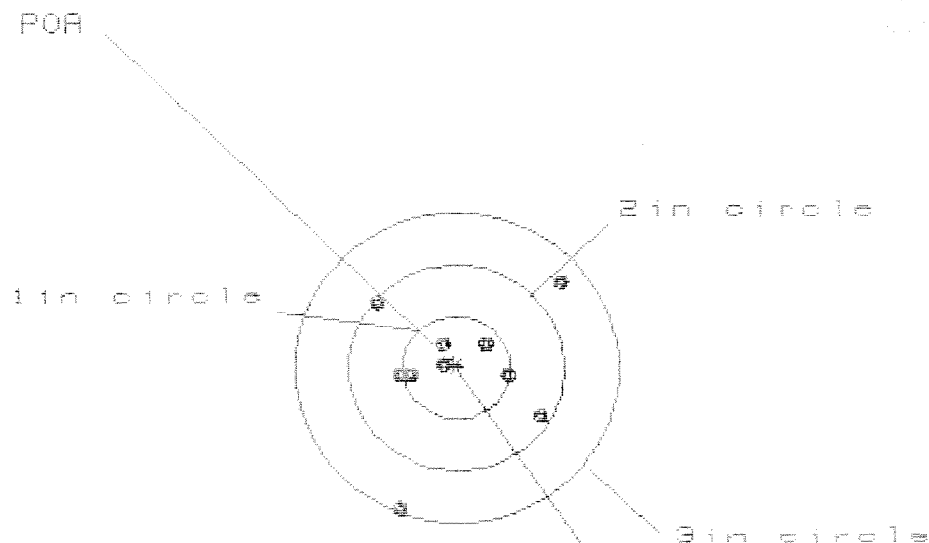
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.791	.651	.534
MINIMUM X	-1.259	-.931	-.785
MAXIMUM Y	.938	.927	.470
MINIMUM Y	-.831	-.842	-.726
CENTROID X	.080	.220	.337
CENTROID Y	-.065	-.054	-.170
POA TO CENTROID in.	.103	.227	.377
MIN RADIUS	.243	.125	.040
MEAN RADIUS	.732	.637	.526
MAX RADIUS	1.263	1.314	.876
HORIZONTAL SPREAD	2.050	1.582	1.319
VERTICAL SPREAD	1.769	1.769	1.196
EXTREME SPREAD	2.050	2.000	1.374
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611820

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.710

VS= 2.232

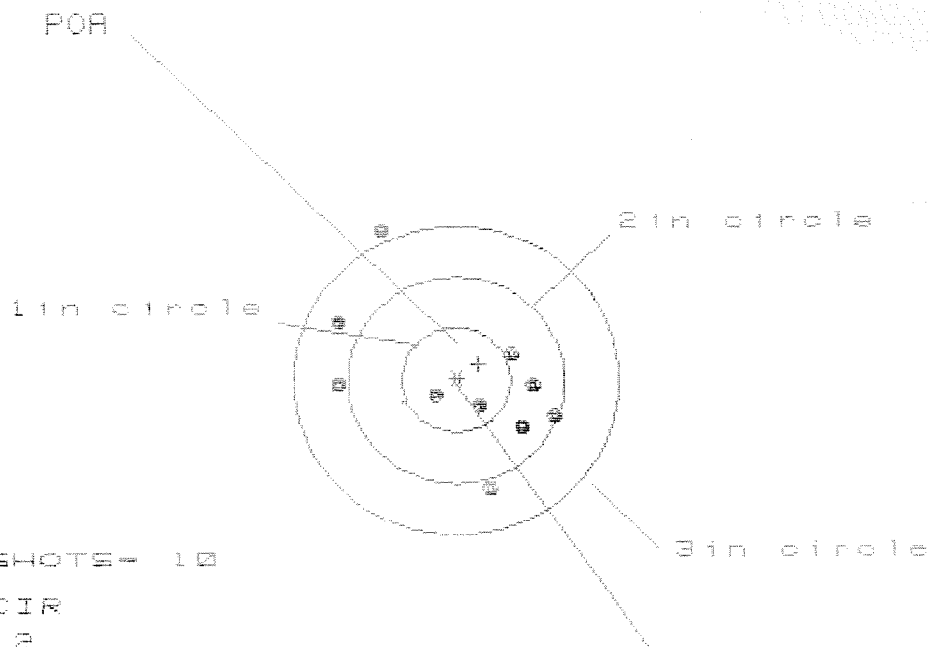
GS= 2.673

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.988	.935	.834
MINIMUM X	-.722	-.773	-.658
MAXIMUM Y	.858	.705	.572
MINIMUM Y	-1.374	-.587	-.498
CENTROID X	.029	.082	-.035
CENTROID Y	-.034	.119	.030
POA TO CENTROID in.	.044	.144	.046
MIN RADIUS	.132	.195	.097
MEAN RADIUS	.687	.592	.497
MAX RADIUS	1.456	1.171	.971
HORIZONTAL SPREAD	1.710	1.710	1.492
VERTICAL SPREAD	2.232	1.292	1.070
EXTREME SPREAD	2.673	1.836	1.836
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611820

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.050

VS= 2.538

GS= 2.734

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.989	.830	.677
MINIMUM X	-1.140	-1.220	-1.330
MAXIMUM Y	1.461	.752	.513
MINIMUM Y	-1.077	-.915	-.821
CENTROID X	-.207	-.127	.026
CENTROID Y	-.158	-.320	-.414
POA TO CENTROID in.	.260	.344	.415
MIN RADIUS	.208	.111	.072
MEAN RADIUS	.856	.727	.682
MAX RADIUS	1.627	1.433	1.346
HORIZONTAL SPREAD	2.050	2.050	2.007
VERTICAL SPREAD	2.538	1.667	1.334
EXTREME SPREAD	2.734	2.241	2.024
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611820

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 1.632

VS= 3.374

GS= 3.667

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.893	.978	.637
MINIMUM X	-.939	-.854	-.731
MAXIMUM Y	2.297	1.411	1.318
MINIMUM Y	-1.077	-.821	-.914
CENTROID X	.245	.160	.030
CENTROID Y	-.236	-.492	-.399
POA TO CENTROID in.	.340	.517	.400
MIN RADIUS	.145	.125	.174
MEAN RADIUS	.985	.802	.749
MAX RADIUS	2.421	1.501	1.463
HORIZONTAL SPREAD	1.832	1.832	1.368
VERTICAL SPREAD	3.374	2.232	2.232
EXTREME SPREAD	3.667	2.490	2.490
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	