

C6636093

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

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

SERIAL NO.
C6636093

ORDER NO.
5716

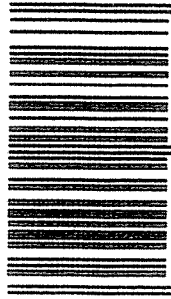
20

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



5716 C6636093

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636093

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	"
615	Rollmark Caliber	APR	9 1991	GL
617	Drill and Tap Sight Holes	APR	19 1991	EB
618	Polish Barrel	APR	19 1991	EB
620	Apply Coatings (Barrel Action)		5-10-91	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	JH

op. #	BARBER M24 0037616	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5-16-91	JK
	G) Safety Off Force	3	3	3			5-16-91	JK
	H) Trigger Pull Test & Retainability						5-16-91	JK
	I) Firing Pin Indent	.0215	.021	.021			5-16-91	JK
	J) Assemble Stock						5/16/91	RW
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/16/91	RW
	M) Iron Sight Alignment						5/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/16/91	RW
	O) Attach Scope to Rifle						5/16/91	RW
	P) Detach & Attach Scope 20 Times						5/16/91	RW
640	Gallery Target & Test						5-20-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-20-91	AF
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.33	2.35	2.38	2.38	2.38	5/21/91	JK
	C) Function						5-21-91	DH
660	Pack						6-17-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636093DATE 5-16-91TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.34	2.32	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.16	2.32	2.30	2.35	
PULL #3	2.35	2.36	2.39	2.38	
PULL #4	2.17	2.28	2.27	2.38	
PULL #5	2.32	2.38	2.26	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.42		
PULL #2	3.23	3.47		
PULL #3	3.35	3.38		
PULL #4	3.45	3.21		
PULL #5	3.43	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.33		4.39
PULL #2	4.32	4.28		4.38
PULL #3	4.28	4.34		4.38
PULL #4	4.23	4.25		4.24
PULL #5	4.26	4.30		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636093
20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0845991
1 TO	2	.173234
1 TO	3	.0594643
1 TO	4	.00860233
1 TO	5	.475429

$\frac{2}{5}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .02
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115603

THE AMR FOR THIS RIFLE IS: 1.019

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636093

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HE = 3.914

VS = 4.801

GS = 4.993

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.811	1.864	1.944
MINIMUM X	-2.103	-1.902	-1.822
MAXIMUM Y	2.206	.713	.419
MINIMUM Y	-2.595	-2.350	-.780
CENTROID X	.071	-.130	-.210
CENTROID Y	.046	-.199	.095
POA TO CENTROID in.	.085	.238	.231
MIN RADIUS	.437	.499	.204
MEAN RADIUS	1.478	1.313	1.123
MAX RADIUS	2.854	2.436	1.984
HORIZONTAL SPREAD	3.914	3.766	3.766
VERTICAL SPREAD	4.801	3.863	1.199
EXTREME SPREAD	4.993	3.789	3.773
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636093

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.421

VS = 2.773

GS = 2.997

PATTERN #

2

SHOTS (BEST OF)

10 9 8

MAXIMUM X

-1.236 -1.109 -.945

MINIMUM X

-1.185 -1.312 -1.009

MAXIMUM Y

1.175 .997 .935

MINIMUM Y

-1.598 -.769 -.644

CENTROID X

.182 .309 .473

CENTROID Y

-.087 .091 -.034

POA TO CENTROID in.

.202 .322 .474

MIN RADIUS

.344 .300 .099

MEAN RADIUS

.973 .830 .663

MAX RADIUS

1.966 1.648 1.143

HORIZONTAL SPREAD

2.421 2.421 1.954

VERTICAL SPREAD

2.773 1.766 1.579

EXTREME SPREAD

2.997 2.997 2.199

NUMBER IN ONE INCH CIRCLE = 2

NUMBER IN TWO INCH CIRCLE = 5

NUMBER IN THREE INCH CIRCLE = 8

20 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8636093

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.726

VS = 1.802

CS = 2.047

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.774	.752	.783
MINIMUM X	-.952	-.974	-.880
MAXIMUM Y	.655	.528	.489
MINIMUM Y	-1.147	-.666	-.600
CENTROID X	.015	.037	-.057
CENTROID Y	.066	.193	.127
POA TO CENTROID in.	.068	.197	.139
MIN RADIUS	.453	.467	.398
MEAN RADIUS	.757	.703	.669
MAX RADIUS	1.164	.980	.897
HORIZONTAL SPREAD	1.726	1.726	1.663
VERTICAL SPREAD	1.802	1.194	1.089
EXTREME SPREAD	2.047	1.777	1.680
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636093

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 2.638

VS = 3.128

GS = 3.156

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.902	.685
MINIMUM X	-1.739	-1.736	-.803
MAXIMUM Y	1.088	.861	.703
MINIMUM Y	-2.040	-1.266	-1.115
CENTROID X	.064	.061	.278
CENTROID Y	.051	.278	.436
POA TO CENTROID in.	.082	.284	.517
MIN RADIUS	.751	.590	.424
MEAN RADIUS	1.164	1.015	.786
MAX RADIUS	2.040	2.148	1.374
HORIZONTAL SPREAD	2.638	2.638	1.488
VERTICAL SPREAD	3.128	2.127	1.818
EXTREME SPREAD	3.156	3.058	2.837
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536093

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 9

HS = 1.509

VS = 2.589

GS = 2.590

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.955	.920	.868
MINIMUM X	-.654	-.689	-.741
MAXIMUM Y	1.484	.542	.425
MINIMUM Y	-1.105	-.941	-.523
CENTROID X	.128	.163	.215
CENTROID Y	-.426	-.590	-.473
POA TO CENTROID in.	.444	.613	.520
MIN RADIUS	.316	.256	.288
MEAN RADIUS	.722	.612	.561
MAX RADIUS	1.517	1.028	1.013
HORIZONTAL SPREAD	1.609	1.609	1.609
VERTICAL SPREAD	2.589	1.483	.948
EXTREME SPREAD	2.590	1.868	1.868
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		