

C6636098

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636098

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	WR
	Magnaflux Bolt	APR	9 1991	✓
615	Rollmark Caliber	APR	9 1991	GL
617	Drill and Tap Sight Holes	APR	19 1991	LB
618	Polish Barrel	APR	19 1991	LB
620	Apply Coatings (Barrel Action)		5-10-91	DA
	Apply Coating (Bolt)		5-10-91	DA
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		5-17-91	D/H

op. #	BARBER M24 0037671	READINGS	DATE	INIT
625 cont.	F) Safety On Force	7 6.5 6.5	5/28/91	Ru
	G) Safety Off Force	3.5 3 3.5	5/28/91	Ru
	H) Trigger Pull Test & Retainability		5-1791	D/H
	I) Firing Pin Indent	.020 .020 .020	5-17-91	A
	J) Assemble Stock		5/28/91	Ru
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies		5/28/91	Ru
	M) Iron Sight Alignment		5/28/91	Ru
	N) Detach Front & Rear Sights & place in numbered container		5/28/91	Ru
	O) Attach Scope to Rifle		5/28/91	Ru
	P) Detach & Attach Scope 20 Times		5/28/91	Ru
640	Gallery Target & Test		5-27-91	AC
	A) Time		5-27-91	AC
	B) Malfunctions		5-27-91	AC
	C) Pierced Primers		5-27-91	AC
	D) Optical Clarity of Scope		5-27-91	AC
645	Inspect for Live Ammo		5-27-91	AC
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636098

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KA
600	Proof		8/2/91	KA
607	Check Headspace		8/2/91	KA
610	Dis-assemble Gun		8/2/91	KA
612	Magnaflux Barrel Action	AUG 7 1991	1991	KR
	Magnaflux Bolt	AUG 7 1991	1991	KR
615	Rollmark Caliber	AUG 7 1991	1991	SB
617	Drill and Tap Sight Holes	AUG 7 1991	1991	KB
618	Polish Barrel	AUG 13 1991	1991	WB
620	Apply Coatings (Barrel Action)		8/2/91	KA
	Apply Coating (Bolt)		8/2/91	KA
625	Final Assembly		8/29/91	KA
	A) Clean inside of Bolt Assembly		8/29/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KA
	C) Inspect Ejector Hole for Chamfer		8/29/91	KA
	D) Oil Firing Pin Ass'y		8/29/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	JH

op. #	BARBER - M24 0037673 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{3}{4}$	5 $\frac{1}{4}$	5 $\frac{1}{2}$			8-31-91	DH
	G) Safety Off Force	2	2	2			8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	DH
	I) Firing Pin Indent	1022	1022	1023			8-31-91	DH
	J) Assemble Stock						9/3/91	KL
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/3/91	KL
	M) Iron Sight Alignment						9/3/91	KL
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	KL
	O) Attach Scope to Rifle						9/3/91	KL
	P) Detach & Attach Scope 20 Times						9/3/91	KL
640	Gallery Target & Test						9/5/91	KL
	A) Time							KL
	B) Malfunctions							KL
	C) Pierced Primers							KL
	D) Optical Clarity of Scope						9/5/91	KL
645	Inspect for Live Ammo							
655	Final Inspection						9-12-91	DH
	A) Headspace							
	B) Trigger Pull	2.15	2.18	2.20	2.16	2.22	9/6/91	DH
	C) Function						9-12-91	DH
660	Pack						9-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636098

DATE 8/31/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.42	2.29	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.50	2.33	2.18	
PULL #3	2.40	2.43	2.45	2.20	
PULL #4	2.41	2.51	2.50	2.16	
PULL #5	2.38	2.32	2.55	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.57		
PULL #2	3.27	3.31		
PULL #3	3.67	3.60		
PULL #4	3.48	3.44		
PULL #5	3.56	3.62		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.45		4.21
PULL #2	4.17	4.29		4.34
PULL #3	4.20	4.25		4.31
PULL #4	4.50	4.24		4.26
PULL #5	4.46	4.32		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636098
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.164247
1 TO	2	.290663
1 TO	3	.0300167
1 TO	4	.214283
1 TO	5	.425699

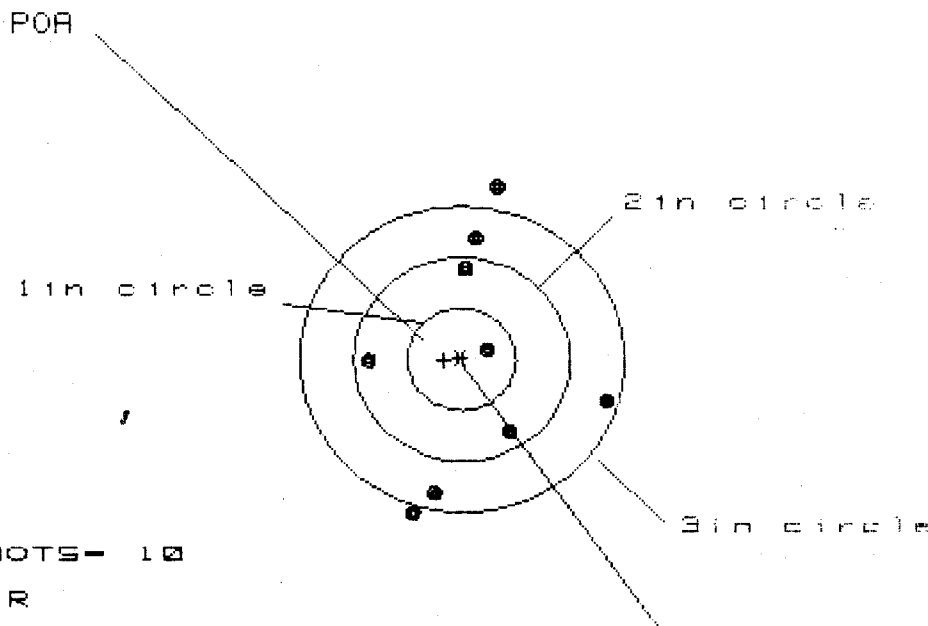
5
14 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0892
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115899
THE AMP FOR THIS RIFLE IS: .8742

SEP 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636098.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.246

VS= 3.168

GS= 3.257

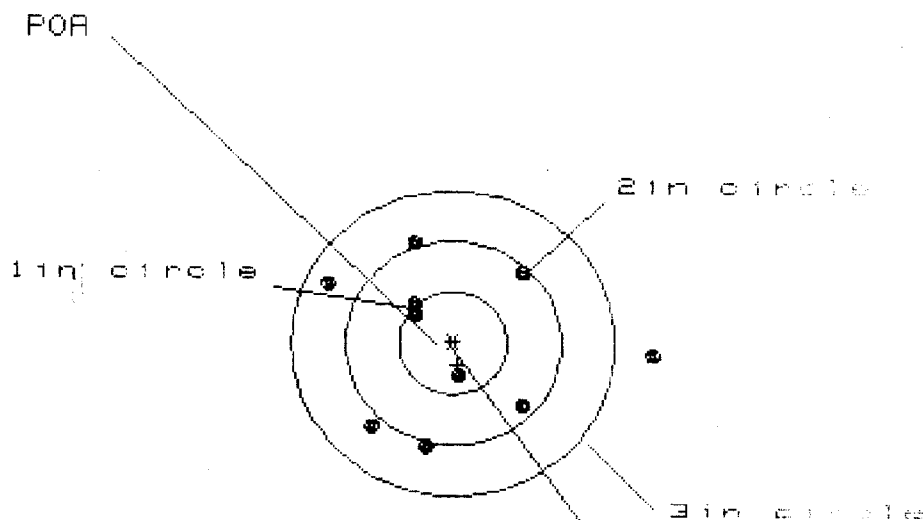
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.347	1.382	1.330
MINIMUM X	:	-.899	-.864	-.916
MAXIMUM Y	:	1.710	1.381	1.223
MINIMUM Y	:	-1.458	-1.269	-1.282
CENTROID X	:	.164	.129	.181
CENTROID Y	:	.009	-.181	-.023
POA TO CENTROID in.	:	.164	.223	.183
MIN RADIUS	:	.271	.415	.272
MEAN RADIUS	:	1.097	1.022	.965
MAX RADIUS	:	1.737	1.401	1.386
HORIZONTAL SPREAD	:	2.246	2.246	2.246
VERTICAL SPREAD	:	3.168	2.650	2.505
EXTREME SPREAD	:	3.257	2.704	2.524
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

5 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.931

VS = 1.969

GS = 3.022

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.796	.881	.764
MINIMUM X	-1.135	-.936	-.707
MAXIMUM Y	.942	.924	.994
MINIMUM Y	-1.027	-1.045	-.975
CENTROID X	-.045	-.244	-.127
CENTROID Y	.211	.229	.159
POA TO CENTROID in.	.215	.334	.203
MIN RADIUS	.305	.295	.277
MEAN RADIUS	.936	.813	.778
MAX RADIUS	1.803	1.090	1.020
HORIZONTAL SPREAD	2.931	1.817	1.471
VERTICAL SPREAD	1.969	1.969	1.969
EXTREME SPREAD	3.022	2.174	2.024
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

5 Sep 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.817

VS= 1.864

GS= 2.348

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.737	.617	.502
MINIMUM X	:	-1.080	-.917	-.771
MAXIMUM Y	:	1.019	1.115	1.021
MINIMUM Y	:	-.845	-.749	-.628
CENTROID X	:	.149	.269	.384
CENTROID Y	:	-.017	-.112	-.018
POA TO CENTROID in.	:	.150	.292	.384
MIN RADIUS	:	.158	.216	.241
MEAN RADIUS	:	.791	.710	.646
MAX RADIUS	:	1.379	1.194	1.068
HORIZONTAL SPREAD	:	1.817	1.534	1.273
VERTICAL SPREAD	:	1.864	1.864	1.649
EXTREME SPREAD	:	2.348	2.299	1.677
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Sep 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.157

VS= 2.705

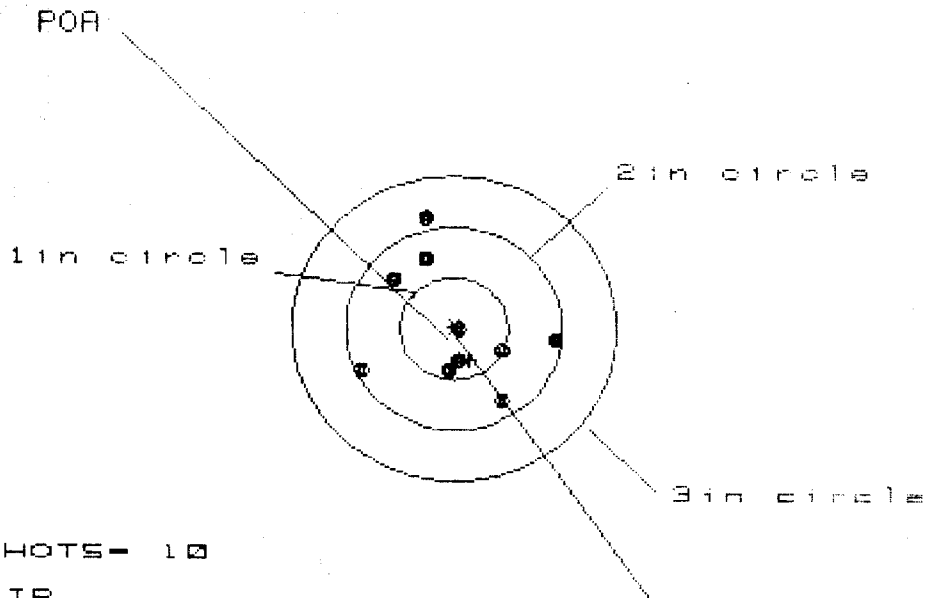
GS= 2.778

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.729	.705
MINIMUM X	:	-1.343	-1.252	-1.161
MAXIMUM Y	:	1.391	1.245	.792
MINIMUM Y	:	-1.314	-1.332	-1.177
CENTROID X	:	.318	.227	.136
CENTROID Y	:	-.140	.006	-.149
POA TO CENTROID in.	:	.347	.227	.202
MIN RADIUS	:	.339	.248	.174
MEAN RADIUS	:	.889	.793	.717
MAX RADIUS	:	1.546	1.442	1.197
HORIZONTAL SPREAD	:	2.157	1.981	1.866
VERTICAL SPREAD	:	2.705	2.577	1.969
EXTREME SPREAD	:	2.778	2.778	2.034
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Sep 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.812

VS= 1.736

GS= 1.846

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.979	.953	.519
MINIMUM X	:	-.833	-.859	-.740
MAXIMUM Y	:	1.043	.798	.799
MINIMUM Y	:	-.693	-.577	-.576
CENTROID X	:	-.140	-.114	-.233
CENTROID Y	:	.307	.191	.190
POA TO CENTROID in.	:	.337	.222	.301
MIN RADIUS	:	.091	.096	.193
MEAN RADIUS	:	.658	.588	.555
MAX RADIUS	:	1.068	.953	.811
HORIZONTAL SPREAD	:	1.812	1.812	1.259
VERTICAL SPREAD	:	1.736	1.375	1.375
EXTREME SPREAD	:	1.846	1.834	1.512
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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

MODEL 700TM H24

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

SERIAL NO.
C6636098

ORDER NO.
5716

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UPC



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