

C6636124

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Remington		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6636124	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		46	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636124

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	2 28 91		RW
610	Dis-assemble Gun	3 28 91		RW
612	Magnaflux Barrel Action	APR	2 1991	BR
	Magnaflux Bolt	APR	2 1991	KR
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	UB
620	Apply Coatings (Barrel Action)		4-10-91	JS
	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		4/15/91	JS

BARBER - M24 0037984								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5		5		5	4/15/91	RL
	G) Safety Off Force	3		3		3	4/15/91	RL
	H) Trigger Pull Test & Retainability						4/15/91	RL
	I) Firing Pin Indent	.022		.0225		.0225	4/15/91	RL
	J) Assemble Stock						4/16/91	RL
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/16/91	RL
	M) Iron Sight Alignment						4/16/91	RL
	N) Detach Front & Rear Sights & place in numbered container						4/16/91	RL
	O) Attach Scope to Rifle						4/16/91	RL
	P) Detach & Attach Scope 20 Times						4/16/91	RL
640	Gallery Target & Test						4-16-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-16-91	AF
655	Final Inspection							
	A) Headspace						4-17-91	A
	B) Trigger Pull	2.34	2.31	2.35	2.42	2.44	4/17/91	RL
	C) Function						4-17-91	AC
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636124

DATE 4/15/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.43	2.48	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.41	2.43	2.31	
PULL #3	2.18	2.42	2.46	2.35	
PULL #4	2.47	2.44	2.49	2.42	
PULL #5	2.50	2.44	2.45	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.47		
PULL #2	3.58	3.44		
PULL #3	3.55	3.31		
PULL #4	3.32	3.46		
PULL #5	3.53	3.49		
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	4.31		4.45
PULL #2	4.11	4.33		4.17
PULL #3	4.42	4.34		4.41
PULL #4	4.29	4.33		4.43
PULL #5	4.36	4.44		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636124
16 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.137306
1 TO	2	.288134
1 TO	3	.122381
1 TO	4	.0863539
1 TO	5	.22358

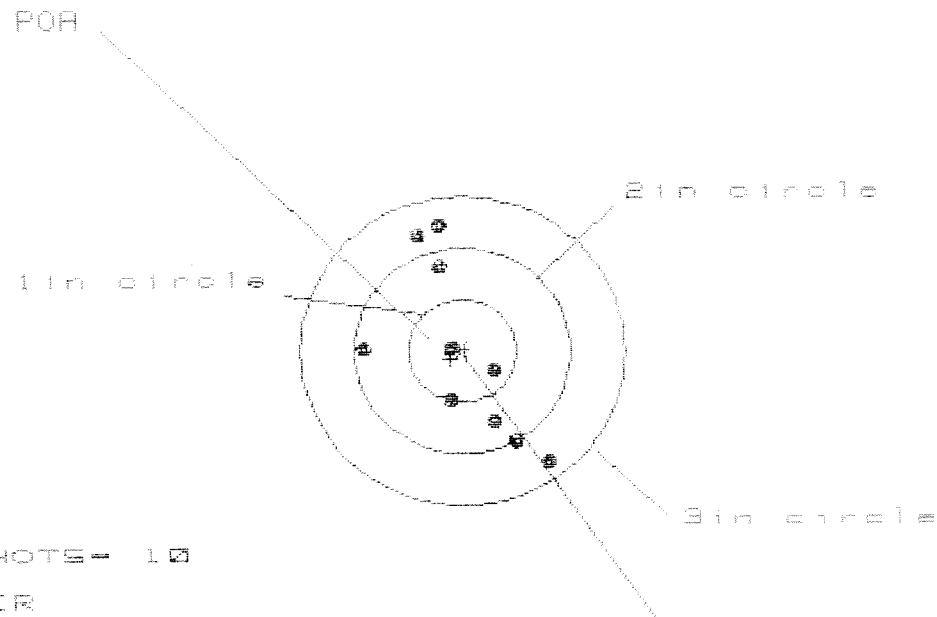
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0934
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1528
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .17582
THE AMR FOR THIS RIFLE IS: .778

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636124

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.688

VS= 2.275

GS= 2.469

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.773

.601

.589

-.915

-.830

-.842

1.226

1.109

1.105

-1.049

-.946

-.807

.113

.028

.040

.078

.195

.056

.138

.197

.069

.107

.071

.072

.806

.752

.685

1.303

1.121

1.145

1.688

1.431

1.431

2.275

2.055

1.912

2.469

2.172

2.108

3

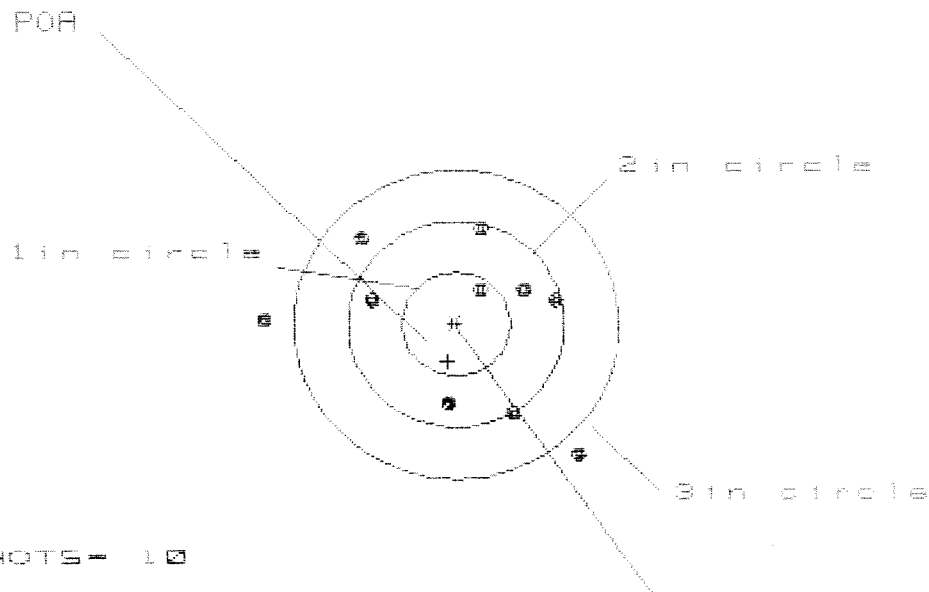
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10

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FILE:/PATTERNING/CENTERFIRE_PATT/C8636124

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.955

VS = 2.136

GS = 3.216

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.143	.942	.805
MINIMUM X	-1.812	-1.118	-1.000
MAXIMUM Y	.919	.925	.774
MINIMUM Y	-1.216	-1.211	-1.031
CENTROID X	.078	.279	.161
CENTROID Y	.364	.358	.509
POA TO CENTROID in.	.372	.454	.534
MIN RADIUS	.369	.315	.201
MEAN RADIUS	1.025	.907	.810
MAX RADIUS	1.813	1.534	1.213
HORIZONTAL SPREAD	2.955	2.060	1.806
VERTICAL SPREAD	2.136	2.136	1.805
EXTREME SPREAD	3.216	2.905	2.232
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 3

3in = 6

CENTROID #

HS = 2.190

VS = 2.232

GS = 2.595

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.351	.978	1.000
MINIMUM X	-.839	-.688	-.666
MAXIMUM Y	.905	.758	.378
MINIMUM Y	-1.327	-.639	-.544
CENTROID X	.029	-.122	-.144
CENTROID Y	-.011	.136	.041
POA TO CENTROID in.	.031	.182	.150
MIN RADIUS	.281	.218	.268
MEAN RADIUS	.757	.582	.561
MAX RADIUS	1.894	1.012	1.013
HORIZONTAL SPREAD	2.190	1.666	1.666
VERTICAL SPREAD	2.232	1.397	.922
EXTREME SPREAD	2.595	1.671	1.671
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.986

VS = 1.788

GS = 2.155

CENTROID #

PATTERN #

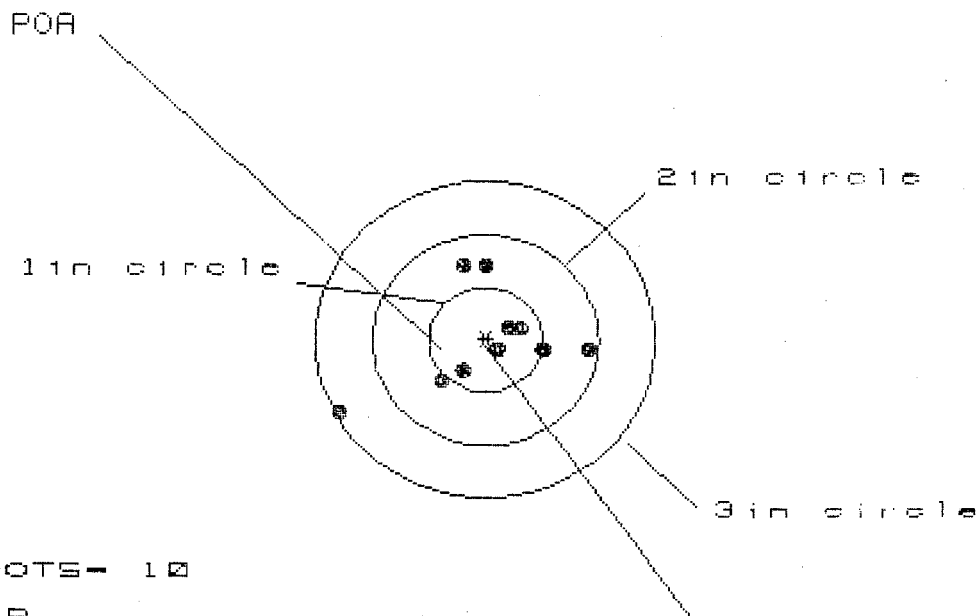
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	.909	.742	.621
MINIMUM X	-1.077	-.976	-.589
MAXIMUM Y	.884	.729	.747
MINIMUM Y	-.904	-.806	-.788
CENTROID X	.037	-.064	.057
CENTROID Y	.037	-.061	-.079
POA TO CENTROID in.	.052	.089	.098
MIN RADIUS	.139	.196	.107
MEAN RADIUS	.712	.639	.586
MAX RADIUS	1.268	.986	.859
HORIZONTAL SPREAD	1.986	1.718	1.209
VERTICAL SPREAD	1.788	1.535	1.535
EXTREME SPREAD	2.155	1.743	1.503
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 4

2in - 9

3in = 10

HS= 2.240

VS= 1.387

GS= 2.319

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.902	.753	.496
MINIMUM X	:	-1.338	-.525	-.430
MAXIMUM Y	:	.711	.636	.617
MINIMUM Y	:	-.676	-.459	-.478
CENTROID X	:	.195	.344	.249
CENTROID Y	:	.286	.361	.380
POA TO CENTROID in.	:	.346	.499	.455
MIN RADIUS	:	.099	.104	.106
MEAN RADIUS	:	.590	.457	.429
MAX RADIUS	:	1.499	.769	.651
HORIZONTAL SPREAD	:	2.240	1.278	.926
VERTICAL SPREAD	:	1.387	1.095	1.095
EXTREME SPREAD	:	2.319	1.318	1.117
NUMBER IN ONE INCH CIRCLE =		4		
NUMBER IN TWO INCH CIRCLE =		9		
NUMBER IN THREE INCH CIRCLE =		10		