

C6636153

MODEL 700™ M24

Model S&S™

Action

Barrel Length

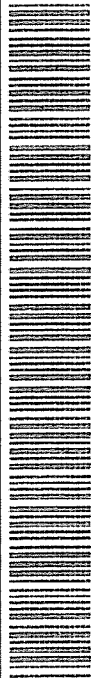
Capacity

Order No. 5715

*Includes 1 in chamber.

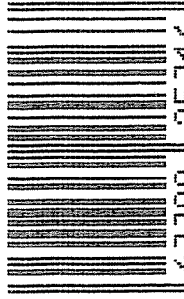
Remington

Remington  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TH H24		SERIAL NO. C6636153
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6636153

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636153

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	KB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	DA
	Apply Coating (Bolt)		8-6-91	DA
625	Final Assembly A) Clean inside of Bolt Assembly		8/19/91	JK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	JK
	C) Inspect Ejector Hole for Chamfer		8/19/91	JK
	D) Oil Firing Pin Ass'y		8/19/91	JK
	E) Adjust Trigger Pull to Min Setting and Stake		8-21-91	PH

op. #	BARBER - M24 0038316	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 $\frac{3}{4}$	5 $\frac{3}{4}$			8-21-91	DH
	G) Safety Off Force	2	2	2			8-21-91	DH
	H) Trigger Pull Test & Retainability						8-21-91	DH
	I) Firing Pin Indent	.022	.020	.020			8-21-91	DH
	J) Assemble Stock						8/21/91	KS
	K) Assemble Swivel Studs						8/21/91	DH
	L) Attach Front and Rear Sight Assemblies						8/21/91	KS
	M) Iron Sight Alignment						8/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	KS
	O) Attach Scope to Rifle						8/21/91	KS
	P) Detach & Attach Scope 20 Times						8/21/91	KS
640	Gallery Target & Test						8/22/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/22/91	KT
655	Final Inspection							
	A) Headspace						8-23-91	DH
	B) Trigger Pull	2.51	2.41	2.55	2.58	2.33	8/23/91	DH
	C) Function						8-23-91	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. CCG36153DATE 8-21-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.52	2.44	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.38	2.57	2.41	
PULL #3	2.53	2.41	2.43	2.55	
PULL #4	2.52	2.12	2.48	2.58	
PULL #5	2.50	2.38	2.40	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.36		
PULL #2	3.15	3.37		
PULL #3	3.31	3.26		
PULL #4	3.45	3.40		
PULL #5	3.36	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.16		4.42
PULL #2	4.18	4.16		4.23
PULL #3	4.02	4.04		4.40
PULL #4	4.13	4.24		4.41
PULL #5	4.13	4.11		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636153
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.202002
1 TO	2	.147472
1 TO	3	.333624
1 TO	4	.416909
1 TO	5	.671107

$\bar{P}_{45}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2468
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .04
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25002
THE AMR FOR THIS RIFLE IS: .896

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636153

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS= 1.966

VS= 2.372

GS= 2.713

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.933	.965	.848
MINIMUM X	-1.033	-1.001	-.820
MAXIMUM Y	1.607	.826	.752
MINIMUM Y	-.765	-.586	-.342
CENTROID X	-.001	-.033	.092
CENTROID Y	.202	.023	.097
POA TO CENTROID in.	.202	.040	.134
MIN RADIUS	.187	.011	.145
MEAN RADIUS	.693	.545	.489
MAX RADIUS	1.632	1.160	1.113
HORIZONTAL SPREAD	1.966	1.966	1.660
VERTICAL SPREAD	2.372	1.412	1.094
EXTREME SPREAD	2.713	1.992	1.988
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06690153

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.752

VS= 1.449

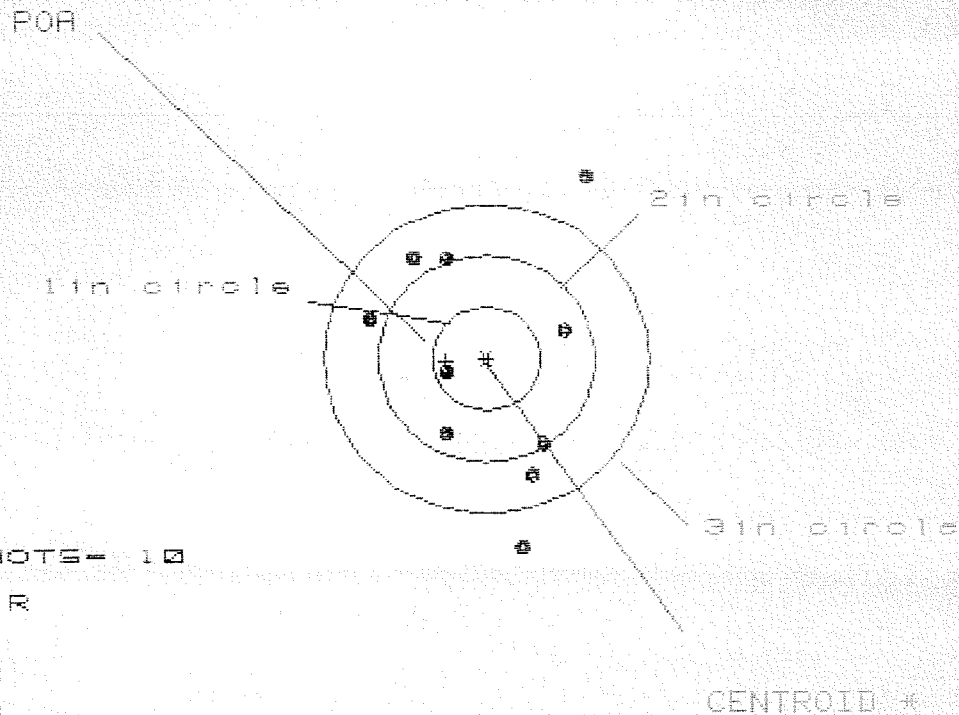
GS= 2.861

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.688
MINIMUM X	-1.064
MAXIMUM Y	.707
MINIMUM Y	-.742
CENTROID X	.616
CENTROID Y	-.062
POA TO CENTROID in.	.619
MIN RADIUS	.123
MEAN RADIUS	.722
MAX RADIUS	1.987
HORIZONTAL SPREAD	2.752
VERTICAL SPREAD	1.449
EXTREME SPREAD	2.861
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

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FILE:/PATTERNING/CENTERFIRE_PATT/06636153

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 1.873

VS = 3.582

GS = 3.639

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.925
MINIMUM X	-1.048
MAXIMUM Y	1.806
MINIMUM Y	-1.775
CENTROID X	.376
CENTROID Y	.024
POA TO CENTROID in.	.377
MIN RADIUS	.349
MEAN RADIUS	1.143
MAX RADIUS	2.029
HORIZONTAL SPREAD	1.973
VERTICAL SPREAD	3.582
EXTREME SPREAD	3.639
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

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FILE:/PATTERNING/CENTERFIRE_PATT/06636153

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.846

VS= 3.357

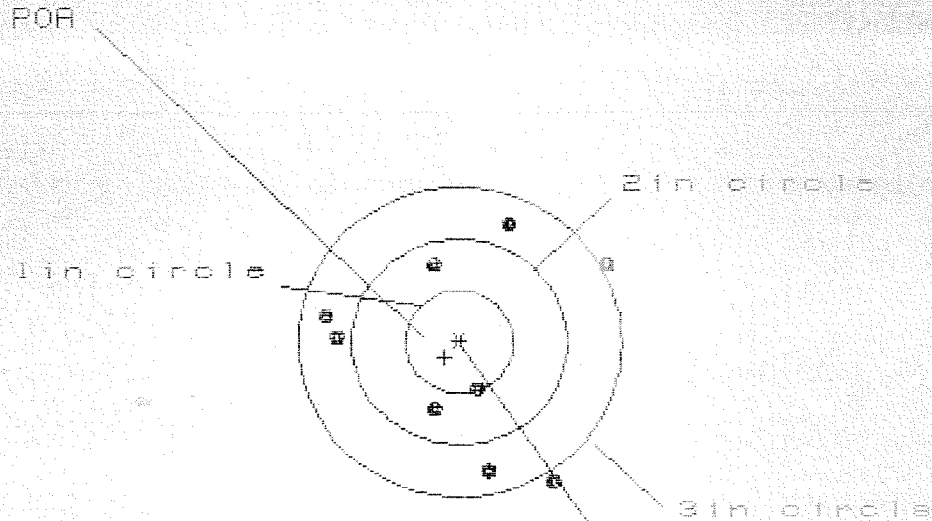
GS= 3.542

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.899
MINIMUM X	-.947
MAXIMUM Y	1.059
MINIMUM Y	-2.298
CENTROID X	.106
CENTROID Y	-.114
POA TO CENTROID in.	.156
MIN RADIUS	.275
MEAN RADIUS	.857
MAX RADIUS	2.485
HORIZONTAL SPREAD	1.846
VERTICAL SPREAD	3.357
EXTREME SPREAD	3.542
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636153

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.595

VS = 2.483

GS = 2.646

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.449	.731
MINIMUM X	-1.242	-1.146	-.965
MAXIMUM Y	1.143	.994	1.068
MINIMUM Y	-1.340	-1.370	-1.296
CENTROID X	.137	.041	-.140
CENTROID Y	.150	.299	.225
POA TO CENTROID in.	.203	.302	.265
MIN RADIUS	.448	.584	.633
MEAN RADIUS	1.065	.989	.898
MAX RADIUS	1.595	1.564	1.398
HORIZONTAL SPREAD	2.595	2.595	1.696
VERTICAL SPREAD	2.483	2.364	2.364
EXTREME SPREAD	2.646	2.639	2.373
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		