

C6636180

MODEL 700™ M24

Model **S&S**™

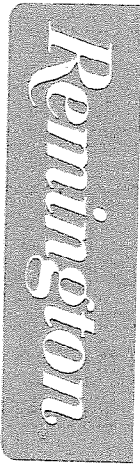
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6636180	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636180

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCD
	Magnaflux Bolt	5 8 9 1		KCD
615	Rollmark Caliber	5 2 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/29/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/1/91	WB

op. #	BARBER M24 0038619	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6/1/91	WB
	G) Safety Off Force	3	3	3			6/1/91	WB
	H) Trigger Pull Test & Retainability						6/1/91	WB
	I) Firing Pin Indent	.0235	.023	.023			6/1/91	WB
	J) Assemble Stock						6/3/91	Rev
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/3/91	Rev
	M) Iron Sight Alignment						6/3/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	Rev
	O) Attach Scope to Rifle						6/3/91	Rev
	P) Detach & Attach Scope 20 Times						6/3/91	Rev
640	Gallery Target & Test						6-3-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-3-91	NF
655	Final Inspection						6-8-91	D/H
	A) Headspace						6-8-91	SEP.
	B) Trigger Pull	2.58	2.52	2.65	2.48	2.40	6-8-91	D/H
	C) Function						6-8-91	D/H
660	Pack						6-20-91	NF

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

SERIAL NO. C 6636180
DATE 6/1/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.26	2.19	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.28	2.72	2.52	
PULL #3	2.43	2.33	2.73	2.65	
PULL #4	2.31	2.37	2.33	2.18	
PULL #5	2.30	2.29	2.12	2.60	
TOTAL	11.83	11.53	11.09		
AVG.	2.37	2.31	2.22		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	2.95		
PULL #2	3.05	3.00		
PULL #3	3.10	2.85		
PULL #4	3.24	3.11		
PULL #5	3.15	3.01		
TOTAL	15.61	14.92		
AVG.	3.12	2.98		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	3.85		4.22
PULL #2	4.17	3.95		4.26
PULL #3	4.16	4.00		4.37
PULL #4	4.14	4.05		4.23
PULL #5	4.18	4.00		4.33
TOTAL	20.74	19.85		21.41
AVG.	4.15	3.97		4.28

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636180
3 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.118811
1 TO	2	.324373
1 TO	3	.190709
1 TO	4	.133507
1 TO	5	.117398

24 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0221775
THE AMR FOR THIS RIFLE IS: 1.313

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB38180

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 = 7

HS = 2.200

VS = 4.382

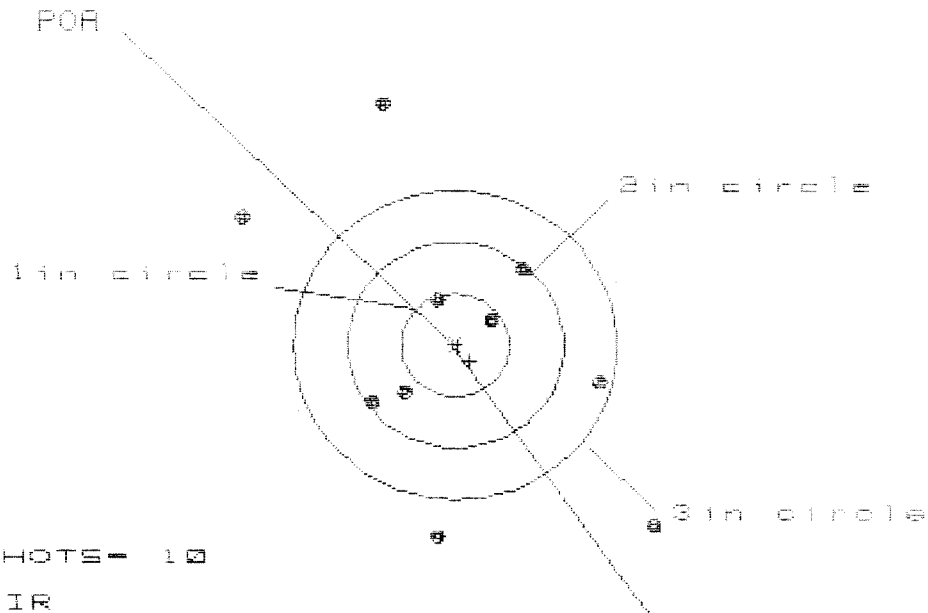
GS = 4.436

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.892	.879	.777
MINIMUM X	:	-1.308	-1.321	-1.423
MAXIMUM Y	:	2.387	1.215	.999
MINIMUM Y	:	-1.995	-1.730	-1.853
CENTROID X	:	.070	.083	.185
CENTROID Y	:	-.096	-.361	-.145
POA TO CENTROID in.	:	.119	.371	.235
MIN RADIUS	:	.461	.303	.493
MEAN RADIUS	:	1.290	1.172	1.036
MAX RADIUS	:	2.390	1.914	2.009
HORIZONTAL SPREAD	:	2.200	2.200	2.200
VERTICAL SPREAD	:	4.382	2.945	2.852
EXTREME SPREAD	:	4.436	3.294	3.294
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636180

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS = 3.856

VS = 4.183

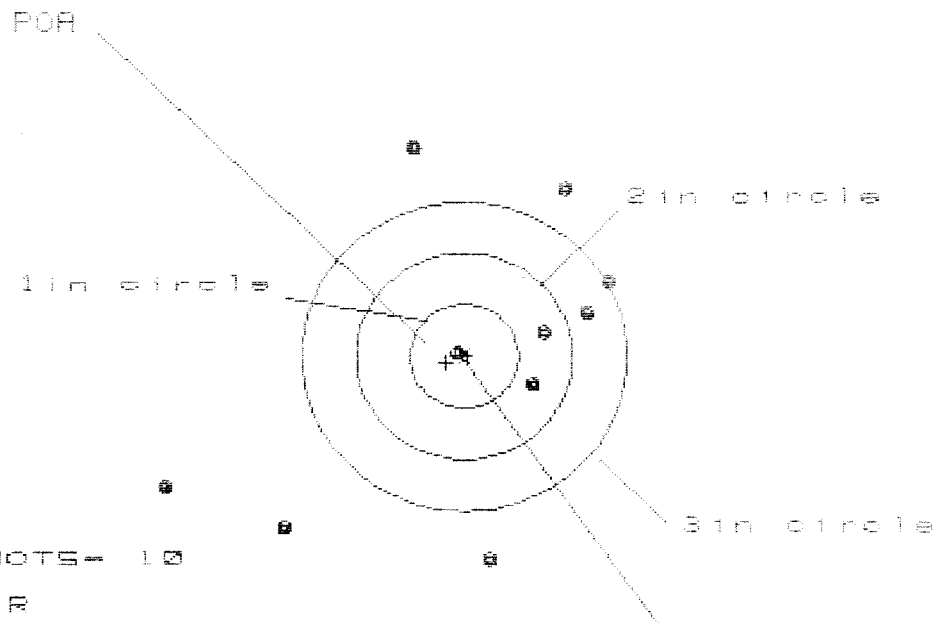
GS = 4.926

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.852
MINIMUM X	-2.004
MAXIMUM Y	2.311
MINIMUM Y	-1.873
CENTROID X	-.133
CENTROID Y	.157
POA TO CENTROID in.	.205
MIN RADIUS	.413
MEAN RADIUS	1.420
MAX RADIUS	2.586
HORIZONTAL SPREAD	3.856
VERTICAL SPREAD	4.183
EXTREME SPREAD	4.926
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	6

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636180

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 4.062

VS= 3.949

GS= 4.729

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.009	.768
MINIMUM X	:	-2.748	-1.924	-1.989
MAXIMUM Y	:	2.030	1.886	1.655
MINIMUM Y	:	-1.919	-2.063	-2.294
CENTROID X	:	.169	.474	.715
CENTROID Y	:	.067	.211	.442
POA TO CENTROID in.	:	.182	.519	.840
MIN RADIUS	:	.087	.340	.179
MEAN RADIUS	:	1.545	1.294	1.057
MAX RADIUS	:	3.035	2.668	2.322
HORIZONTAL SPREAD	:	4.062	2.933	1.757
VERTICAL SPREAD	:	3.949	3.949	3.949
EXTREME SPREAD	:	4.729	4.236	3.999
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C88886180

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS = 2.785

VS = 3.263

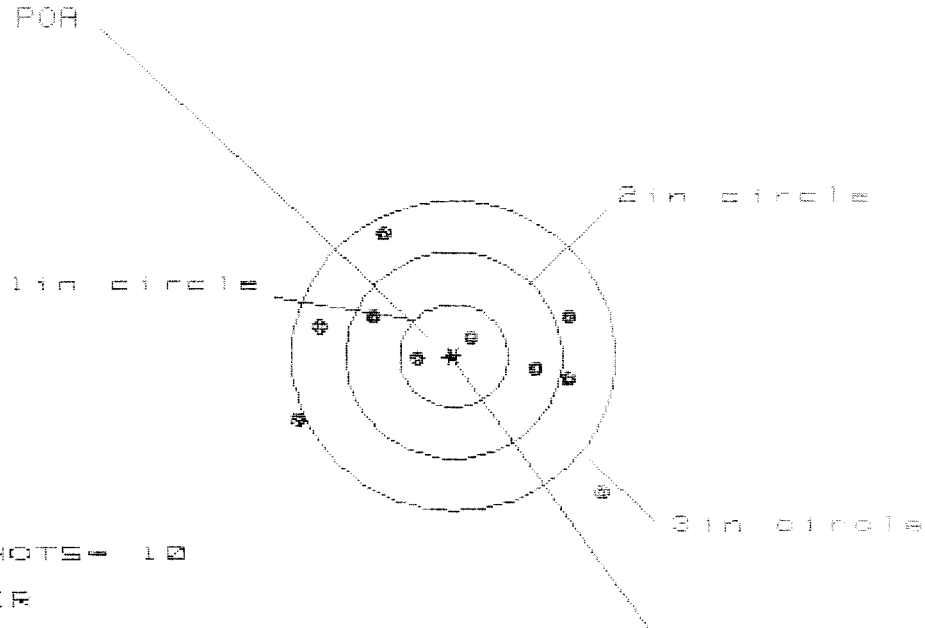
GS = 3.344

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.555	1.418	1.326
MINIMUM X	-1.230	-1.036	-1.128
MAXIMUM Y	1.672	1.808	1.626
MINIMUM Y	-1.591	-1.455	-1.445
CENTROID X	-.062	.075	.167
CENTROID Y	-.076	-.212	-.030
POA TO CENTROID in.	.098	.225	.170
MIN RADIUS	.695	.715	.655
MEAN RADIUS	1.276	1.211	1.152
MAX RADIUS	1.735	1.808	1.630
HORIZONTAL SPREAD	2.785	2.454	2.454
VERTICAL SPREAD	3.263	3.263	3.071
EXTREME SPREAD	3.344	3.344	3.090
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		6	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08696150

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.784

VS = 2.443

GS = 3.187

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	1.212	1.054
MINIMUM X	-1.412	-1.259	-1.216
MAXIMUM Y	1.134	.989	.891
MINIMUM Y	-1.309	-.782	-.455
CENTROID X	.042	-.111	.047
CENTROID Y	.018	.163	.261
POA TO CENTROID in.	.045	.197	.265
MIN RADIUS	.230	.285	.189
MEAN RADIUS	1.032	.918	.839
MAX RADIUS	1.896	1.482	1.218
HORIZONTAL SPREAD	2.784	2.471	2.270
VERTICAL SPREAD	2.443	1.771	1.346
EXTREME SPREAD	3.187	2.638	2.332
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636180
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0531507
1 TO	2	.297599
1 TO	3	.257049
1 TO	4	.461191
1 TO	5	.163686

3
2
1 <----FOR

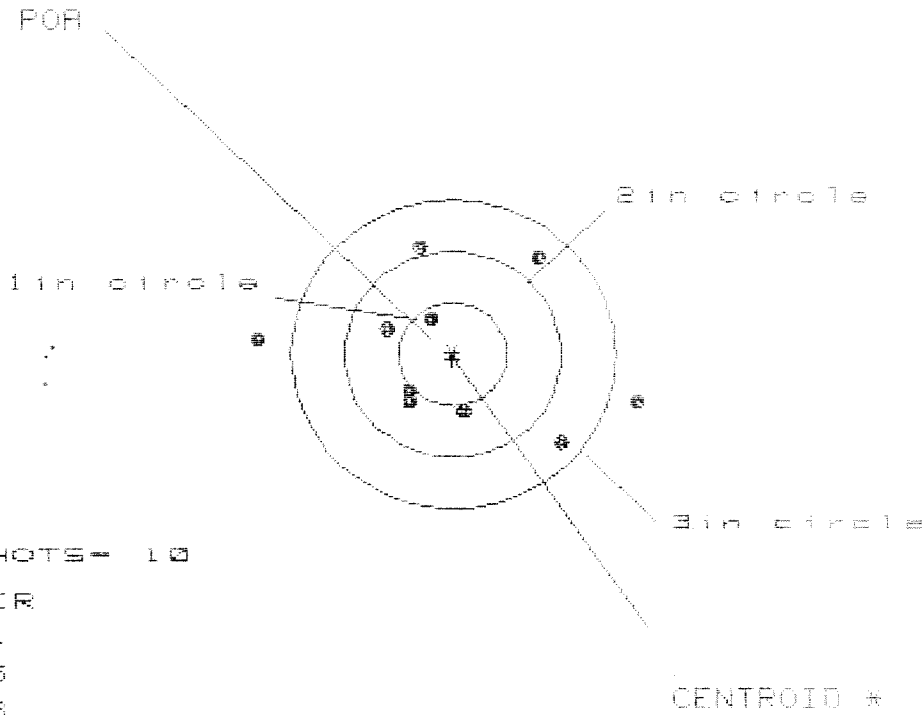
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0204
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1708
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .172014

THE AMR FOR THIS RIFLE IS: .9834

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6636100.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.467

VS= 1.913

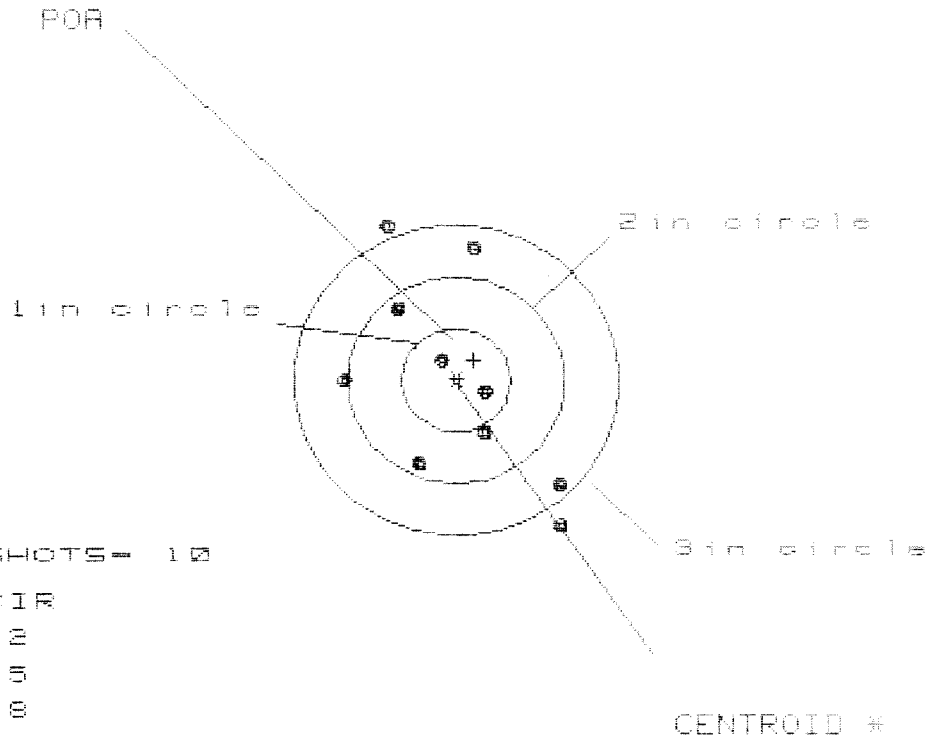
GS= 3.505

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.687	1.489	1.025
MINIMUM X	-1.780	-1.793	-1.606
MAXIMUM Y	1.062	1.074	1.024
MINIMUM Y	-1.851	-1.839	-1.889
CENTROID X	.004	.202	.015
CENTROID Y	.053	.041	.091
POA TO CENTROID in.	.053	.206	.093
MIN RADIUS	.370	.502	.343
MEAN RADIUS	.984	.921	.793
MAX RADIUS	1.783	1.542	1.357
HORIZONTAL SPREAD	3.467	2.282	1.632
VERTICAL SPREAD	1.913	1.913	1.913
EXTREME SPREAD	3.505	2.500	2.352
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6536180.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.071

VS = 2.890

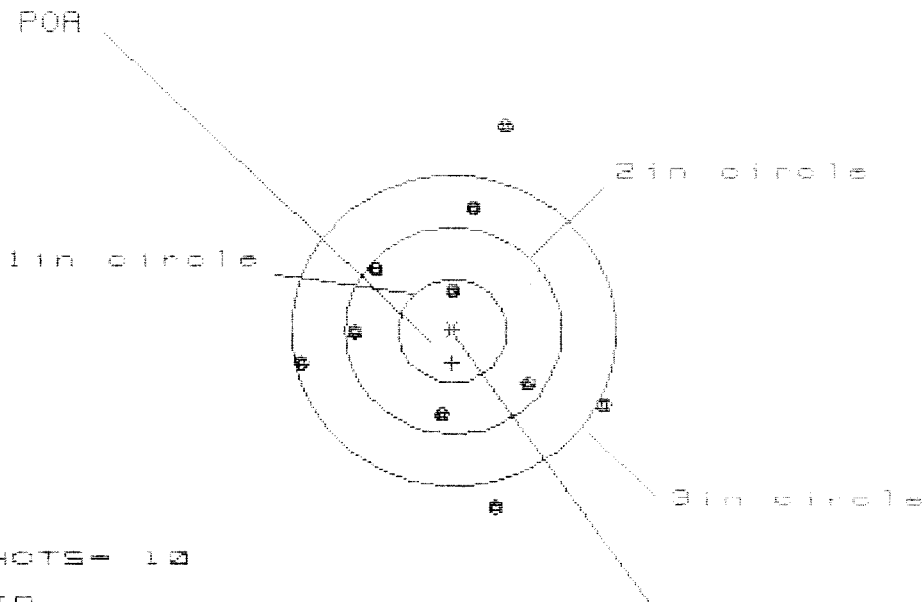
GS = 3.325

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	1.117	1.051
MINIMUM X	-1.061	-0.949	-1.014
MAXIMUM Y	1.504	1.350	1.388
MINIMUM Y	-1.386	-1.125	-0.956
CENTROID X	-0.162	-0.274	-0.209
CENTROID Y	-0.194	-0.040	-0.209
POA TO CENTROID in.	.253	.277	.295
MIN RADIUS	.267	.078	.259
MEAN RADIUS	1.002	.907	.834
MAX RADIUS	1.715	1.585	1.421
HORIZONTAL SPREAD	2.071	2.066	2.066
VERTICAL SPREAD	2.890	2.475	2.294
EXTREME SPREAD	3.325	2.969	2.434
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6636100.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.820

VS = 3.733

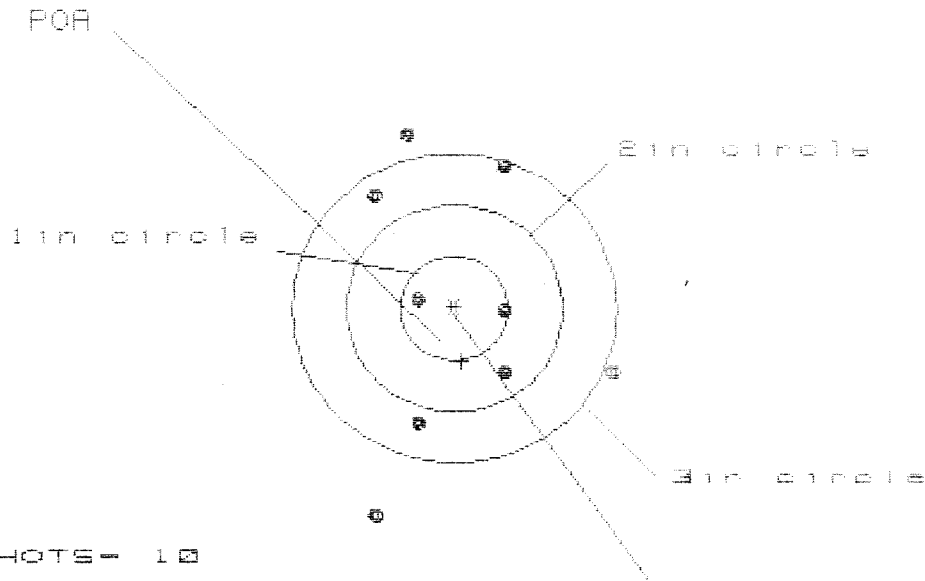
GS = 3.734

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.368	1.421	1.475
MINIMUM X	-1.452	-1.399	-1.345
MAXIMUM Y	1.986	1.409	1.218
MINIMUM Y	-1.747	-1.526	-1.772
CENTROID X	.009	-.044	-.098
CENTROID Y	.310	.089	.280
POA TO CENTROID in.	.310	.100	.297
MIN RADIUS	.358	.580	.398
MEAN RADIUS	1.187	1.085	.998
MAX RADIUS	2.041	1.587	1.642
HORIZONTAL SPREAD	2.820	2.820	2.820
VERTICAL SPREAD	3.733	2.935	1.990
EXTREME SPREAD	3.734	2.939	2.849
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB636180.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS= 2.217

VS= 3.668

GS= 3.678

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.444	1.361	1.291
MINIMUM X	:	-1.773	-1.856	-1.926
MAXIMUM Y	:	1.705	1.487	1.337
MINIMUM Y	:	-1.963	-1.328	-1.143
CENTROID X	:	-.065	.018	.000
CENTROID Y	:	.509	.727	.542
POA TO CENTROID in.	:	.513	.728	.549
MIN RADIUS	:	.332	.409	.349
MEAN RADIUS	:	1.130	1.025	.932
MAX RADIUS	:	2.101	1.589	1.434
HORIZONTAL SPREAD	:	2.217	2.217	2.217
VERTICAL SPREAD	:	3.668	2.815	2.480
EXTREME SPREAD	:	3.678	2.995	2.754
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ CB836180.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.269

VS= 1.325

GS= 1.835

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.722
MINIMUM X	-.547
MAXIMUM Y	.775
MINIMUM Y	-.550
CENTROID X	.112
CENTROID Y	.176
POA TO CENTROID in.	.209
MIN RADIUS	.310
MEAN RADIUS	.614
MAX RADIUS	1.046
HORIZONTAL SPREAD	1.269
VERTICAL SPREAD	1.325
EXTREME SPREAD	1.835
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10