

C6636189

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.

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

MODEL 700TM M24

SERIAL NO.
C6636189

ORDER NO.
5716

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

20



5716 C6636189



Stock
Repaired

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636189

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	FS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	JS

op. #	BARBER M24 0038715	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	6			5/29/91	SH
	G) Safety Off Force	3	3	3			5/29/91	SH
	H) Trigger Pull Test & Retainability						5/29/91	SH
	I) Firing Pin Indent	.021	.022	.022			5/29/91	SH
	J) Assemble Stock						5/29/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	KS
	M) Iron Sight Alignment						5/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	KS
	O) Attach Scope to Rifle						5/29/91	KS
	P) Detach & Attach Scope 20 Times						5/29/91	KS
640	Gallery Target & Test						6-4-91	AC
	A) Time						6-4-91	AC
	B) Malfunctions						6-4-91	AC
	C) Pierced Primers						6-4-91	AC
	D) Optical Clarity of Scope						6-4-91	AC
645	Inspect for Live Ammo						6-9-91	AC
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.29	2.27	2.21	2.28	2.27	6-8-91	SH
	C) Function						6-8-91	DH
660	Pack						6-20-91	NE

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

SERIAL NO. C-6636189DATE 5/29/91TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.44	2.50	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.22	2.49	2.27	
PULL #3	2.45	2.29	2.47	2.21	
PULL #4	2.39	2.48	2.47	2.28	
PULL #5	2.46	2.47	2.46	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.20		
PULL #2	3.64	3.60		
PULL #3	3.62	3.64		
PULL #4	3.67	3.18		
PULL #5	3.54	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.24		4.17
PULL #2	4.38	4.33		4.38
PULL #3	4.15	4.29		4.41
PULL #4	4.31	4.23		4.29
PULL #5	4.24	4.24		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636189
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.136033
1 TO	2	.452356
1 TO	3	.457542
1 TO	4	.398058
1 TO	5	.206155

371 <----POR

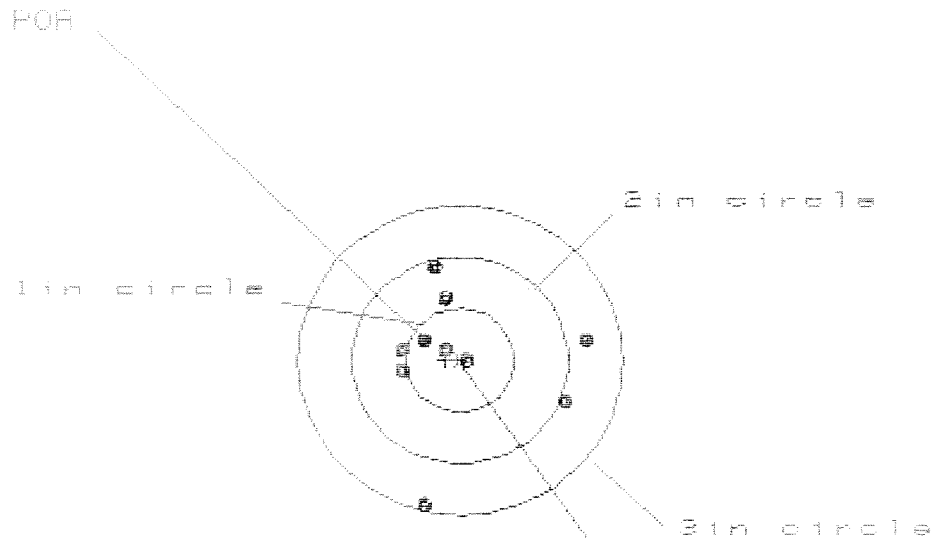
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0408
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148899
THE AMR FOR THIS RIFLE IS: .7992

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636189

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.773

VS= 2.290

GS= 2.290

CENTROID #

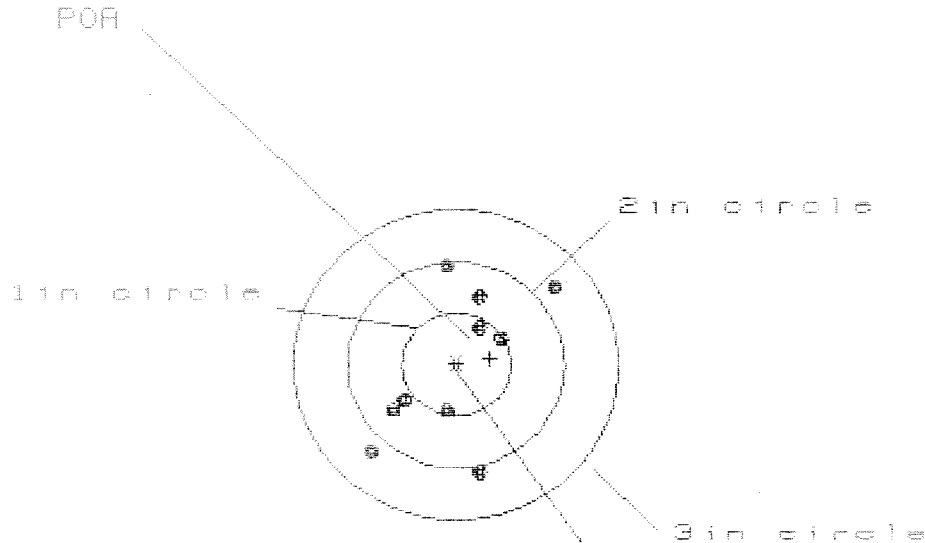
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	1.164	1.107
MINIMUM X	-.577	-.609	-.463
MAXIMUM Y	.867	.709	.714
MINIMUM Y	-1.423	-.599	-.594
CENTROID X	.136	.168	.022
CENTROID Y	-.003	.155	.150
POB TO CENTROID in.	.136	.228	.152
MIN RADIUS	.049	.164	.092
MEAN RADIUS	.690	.604	.485
MAX RADIUS	1.452	1.165	1.256
HORIZONTAL SPREAD	1.773	1.773	1.570
VERTICAL SPREAD	2.290	1.308	1.308
EXTREME SPREAD	2.290	1.815	1.815
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638189

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.681

VS= 1.984

GS= 2.328

CENTROID #

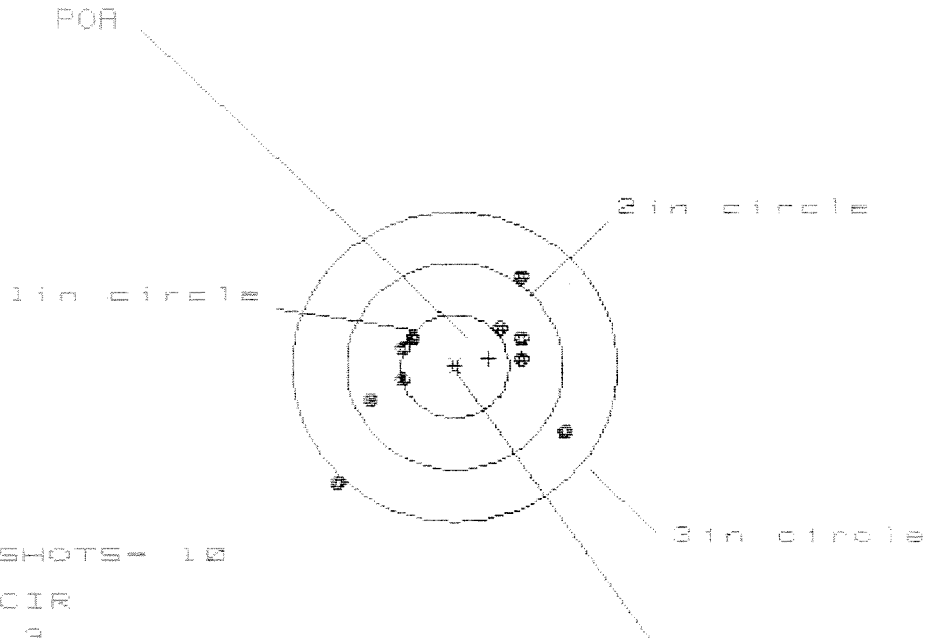
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.933	.517	.436
MINIMUM X	-.748	-.644	-.519
MAXIMUM Y	.970	1.059	.969
MINIMUM Y	-1.014	-.925	-1.015
CENTROID X	-.313	-.417	-.336
CENTROID Y	-.058	-.147	-.057
POA TO CENTROID in.	.319	.442	.341
MIN RADIUS	.373	.322	.383
MEAN RADIUS	.755	.692	.652
MAX RADIUS	1.229	1.061	1.037
HORIZONTAL SPREAD	1.681	1.161	.955
VERTICAL SPREAD	1.984	1.984	1.984
EXTREME SPREAD	2.326	1.998	1.998
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06696189

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.150

VS= 1.946

GS= 2.602

CENTROID #

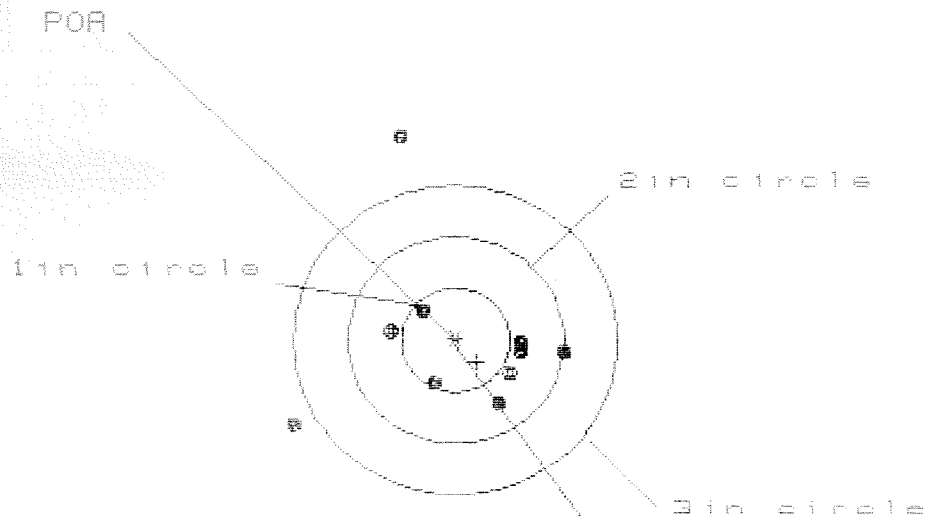
PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.905	.603
MINIMUM X	-1.120	-.925	-.812
MAXIMUM Y	.859	.738	.646
MINIMUM Y	-1.087	-.737	-.502
CENTROID X	-.316	-.191	-.304
CENTROID Y	-.074	.047	.139
POA TO CENTROID in.	.324	.197	.335
MIN RADIUS	.445	.398	.376
MEAN RADIUS	.792	.685	.609
MAX RADIUS	1.561	1.167	.954
HORIZONTAL SPREAD	2.150	1.830	1.415
VERTICAL SPREAD	1.946	1.475	1.148
EXTREME SPREAD	2.602	1.859	1.817
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 3.506

VS = 2.762

GS = 2.951

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	.953	.759
MINIMUM X	-1.502	-1.553	-.850
MAXIMUM Y	1.962	.476	.403
MINIMUM Y	-.800	-.582	-.430
CENTROID X	-.199	-.148	.046
CENTROID Y	.212	-.006	.067
POA TO CENTROID in.	.291	.148	.082
MIN RADIUS	.415	.276	.272
MEAN RADIUS	.865	.699	.536
MAX RADIUS	2.015	1.659	.871
HORIZONTAL SPREAD	2.506	2.506	1.609
VERTICAL SPREAD	2.762	1.058	.833
EXTREME SPREAD	2.951	2.606	1.614
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

4 Jun 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 1.675

VS = 3.518

GS = 3.533

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.539
MINIMUM X	-1.136
MAXIMUM Y	1.523
MINIMUM Y	-1.995
CENTROID X	-.024
CENTROID Y	.127
POA TO CENTROID in.	.129
MIN RADIUS	.113
MEAN RADIUS	.894
MAX RADIUS	2.005
HORIZONTAL SPREAD	1.675
VERTICAL SPREAD	3.518
EXTREME SPREAD	3.533
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8