

C6649114

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

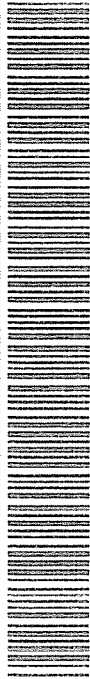
MODEL 700™ M24

SERIAL NO.
C6649114

ORDER NO.
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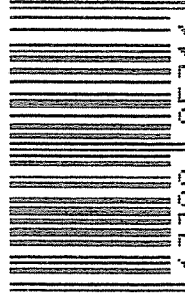
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649114

UPC



0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # 9114

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
KT	8/12/91	Shave Brass	KS
	2nd		
	8/13/91	Polish face of Bolt 100 Rd Test Needed	KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>shot OK</i> <i>Test</i> <i>8-13-91</i>	<i>D/H</i>
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

GUN SERIAL #

C 6649114

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 6 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-10-91	DH
	G) Safety Off Force	2 1/2	2 1/4	2 1/4			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	DH
	I) Firing Pin Indent	.020	.021	.020			8-10-91	DH
	J) Assemble Stock						8-10-91	KA
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8-10-91	KA
	M) Iron Sight Alignment						8-10-91	KA
	N) Detach Front & Rear Sights & place in numbered container						8-10-91	KA
	O) Attach Scope to Rifle						8-10-91	KA
	P) Detach & Attach Scope 20 Times						8-10-91	KA
640	Gallery Target & Test						8-12-91	LT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8-12-91	KT
655	Final Inspection							
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.39	2.45	2.40	2.35	2.48	8-13-91	KA
	C) Function						8-13-91	DH
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CC649114

DATE 8-10-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.50	2.32	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.45	2.48	2.45	
PULL #3	2.63	2.50	2.85	2.40	
PULL #4	2.53	2.48	2.74	2.35	
PULL #5	2.63	2.54	2.95	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.24		
PULL #2	3.16	3.20		
PULL #3	3.17	3.23		
PULL #4	3.07	3.26		
PULL #5	3.21	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	4.49		4.27
PULL #2	4.20	4.53		4.23
PULL #3	4.06	4.57		4.28
PULL #4	4.34	4.57		4.38
PULL #5	4.34	4.30		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649114
 12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.261138
1 TO	2	.644426
1 TO	3	.228965
1 TO	4	.432612
1 TO	5	.701565

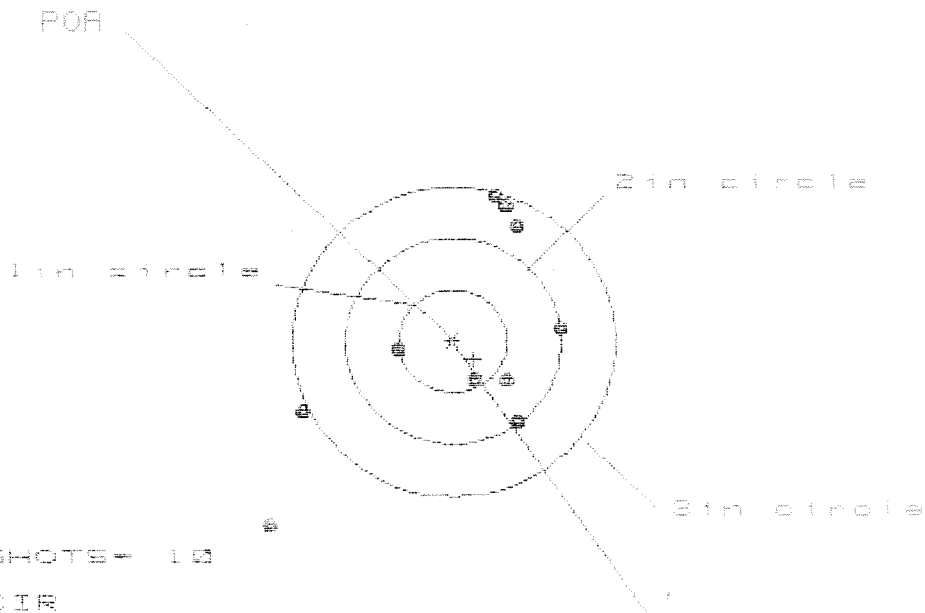
$\frac{1}{5} \sum x_i^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .123
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .05
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132774
 THE AMR FOR THIS RIFLE IS: 1.021

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649114

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.758

VS = 3.214

GS = 3.837

PATTERN #

51

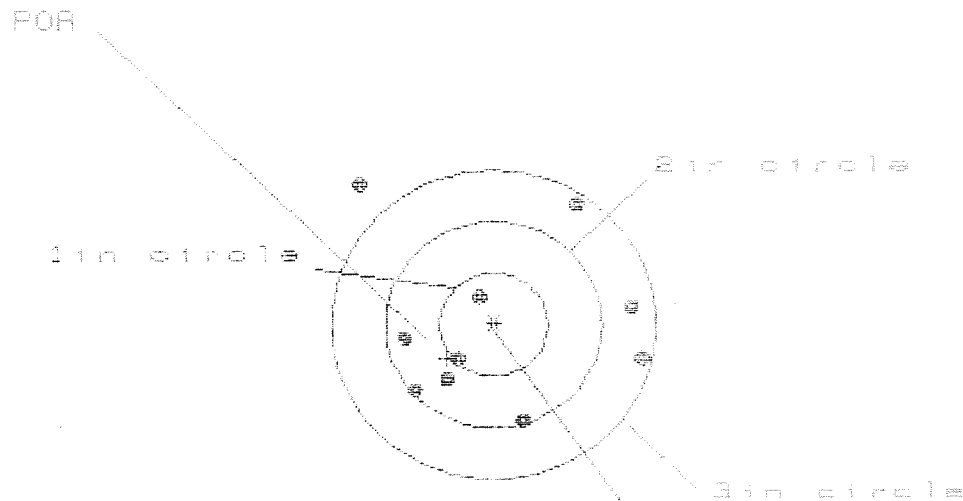
	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.818	.825	.628
MINIMUM X	-1.748	-1.638	-.911
MAXIMUM Y	1.453	1.257	1.147
MINIMUM Y	-1.761	-.959	-1.068
CENTROID X	-.192	.001	.386
CENTROID Y	.177	.373	.482
POA TO CENTROID in.	.261	.373	.525
MIN RADIUS	.437	.601	.645
MEAN RADIUS	1.184	1.023	.901
MAX RADIUS	2.476	1.858	1.148
HORIZONTAL SPREAD	2.758	2.463	1.531
VERTICAL SPREAD	3.214	2.216	2.216
EXTREME SPREAD	3.837	2.796	2.238
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

12 Aug 1991

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CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.597

VS = 2.337

CS = 3.140

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.358	1.228	1.329
MINIMUM X	-1.239	-.923	-.770
MAXIMUM Y	1.396	1.334	1.387
MINIMUM Y	-.941	-.786	-.813
CENTROID X	.434	.572	.419
CENTROID Y	.330	.175	.282
POA TO CENTROID in.	.545	.598	.465
MIN RADIUS	.312	.487	.356
MEAN RADIUS	1.020	.926	.844
MAX RADIUS	1.866	1.470	1.517
HORIZONTAL SPREAD	2.597	2.143	2.095
VERTICAL SPREAD	2.337	2.120	2.120
EXTREME SPREAD	3.140	2.342	2.342
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/0884B114

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.596

VS= 2.130

ES= 2.666

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.818	.621	.622
MINIMUM X	-1.778	-1.498	-1.497
MAXIMUM Y	1.374	1.329	.744
MINIMUM Y	-.756	-.801	-.635
CENTROID X	-.108	.089	.088
CENTROID Y	-.036	.009	-.157
POA TO CENTROID in.	.114	.090	.180
MIN RADIUS	.106	.291	.337
MEAN RADIUS	.750	.647	.550
MAX RADIUS	1.822	1.329	.819
HORIZONTAL SPREAD	2.596	1.119	1.119
VERTICAL SPREAD	2.130	2.130	1.379
EXTREME SPREAD	2.666	2.145	1.409
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08649114

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.131

VS = 2.090

CS = 2.145

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.292	.922	.997
MINIMUM X	-.839	-.696	-.621
MAXIMUM Y	1.082	1.086	1.216
MINIMUM Y	-1.008	-1.004	-.874
CENTROID X	.240	.097	.022
CENTROID Y	.154	.150	.020
POA TO CENTROID in.	.285	.179	.030
MIN RADIUS	.402	.356	.350
MEAN RADIUS	.876	.808	.734
MAX RADIUS	1.292	1.201	1.216
HORIZONTAL SPREAD	2.131	1.618	1.613
VERTICAL SPREAD	2.090	2.090	2.090
EXTREME SPREAD	2.145	2.137	2.090
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 7

HS = 2.946

VS = 3.353

GS = 3.839

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.452
MINIMUM X	-1.494
MAXIMUM Y	1.966
MINIMUM Y	-1.387
CENTROID X	.241
CENTROID Y	-.375
POA TO CENTROID in.	.446
MIN RADIUS	.480
MEAN RADIUS	1.273
MAX RADIUS	2.052
HORIZONTAL SPREAD	2.946
VERTICAL SPREAD	3.353
EXTREME SPREAD	3.839
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	7