

06649131

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ M24

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

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

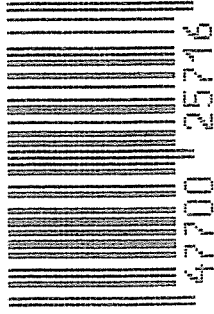
SERIAL NO.
C6649131

ORDER NO.
5716

DUPONT
REG. U.S. PAT. & T.M. OFF

20

UPC



0 4700 25716 7



5716 C6649131

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649131

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	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 20 1991	WB
620	Apply Coatings (Barrel Action)		8-2-91	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		8-9-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 $\frac{1}{2}$	6			8-10-91	DH
	G) Safety Off Force	3	2 $\frac{3}{4}$	3			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-9-91	SH
	I) Firing Pin Indent	.021	.020	.021			8-10-91	DH
	J) Assemble Stock						8/14/91	KL
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/14/91	KL
	M) Iron Sight Alignment						8/14/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	KL
	O) Attach Scope to Rifle						8/14/91	KL
	P) Detach & Attach Scope 20 Times						8/14/91	KL
640	Gallery Target & Test						8/15/91	KT
	A) Time						..	KT
	B) Malfunctions						..	KT
	C) Pierced Primers						..	KT
	D) Optical Clarity of Scope						..	KT
645	Inspect for Live Ammo						8/15/91	KT
655	Final Inspection							
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.36	2.27	2.32	2.36	2.36	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-19-91	VF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649131
20 AUG 1991

CENTROIDAL DISTANCES

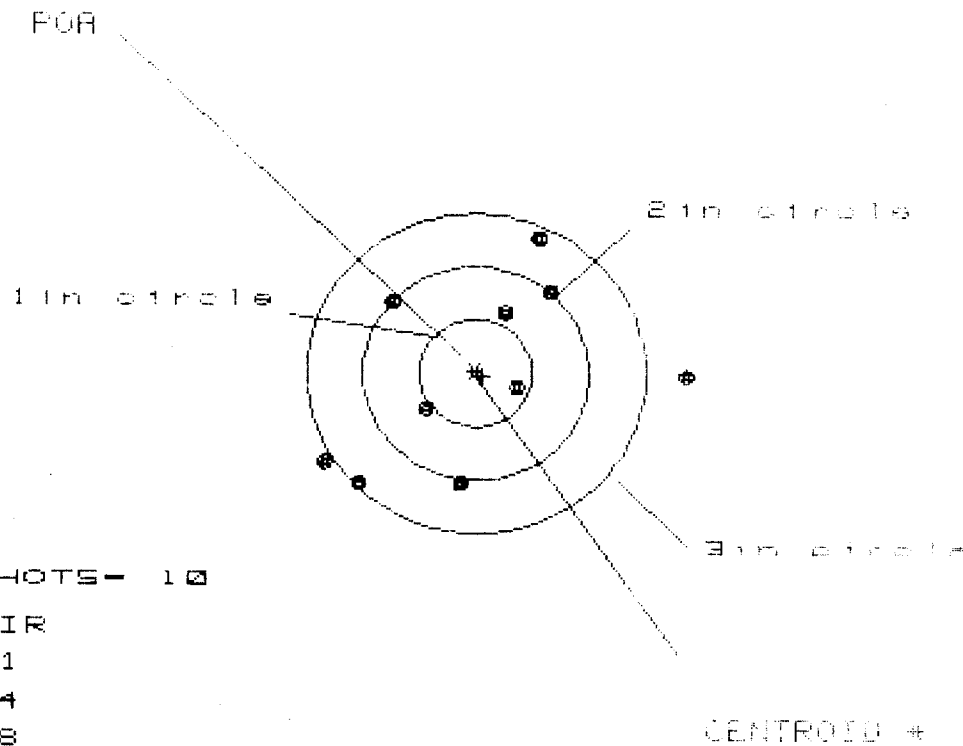
0 TO	1	.0666408
1 TO	2	.331958
1 TO	3	.200871
1 TO	4	.0161245
1 TO	5	.293138

2 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0343
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120800
THE AMP FOR THIS RIFLE IS: 1.033

FILE: PATTERNING/CENTERFIRE_PATT/06649131

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.109

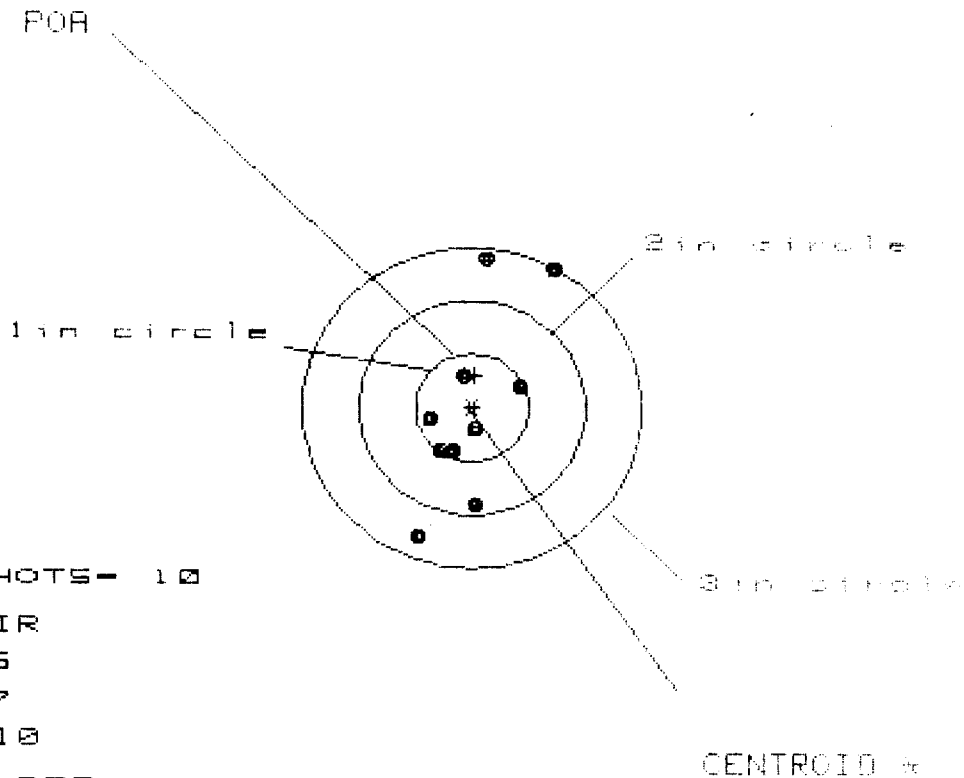
VS = 2.376

GS = 3.190

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.818	.908	.771
MINIMUM X	-1.291	-1.089	-.935
MAXIMUM Y	1.318	1.310	1.211
MINIMUM Y	-1.058	-1.066	-1.165
CENTROID X	-.060	-.262	-.125
CENTROID Y	.029	.037	.136
POA TO CENTROID in.	.066	.264	.185
MIN RADIUS	.355	.386	.460
MEAN RADIUS	1.082	.993	.934
MAX RADIUS	1.819	1.501	1.438
HORIZONTAL SPREAD	3.109	1.997	1.696
VERTICAL SPREAD	2.376	2.376	2.376
EXTREME SPREAD	3.190	2.821	2.821
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

FILE:/PATTERNING/CENTERFIRE_PATT/06649131

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.200

VS= 2.513

GS= 2.692

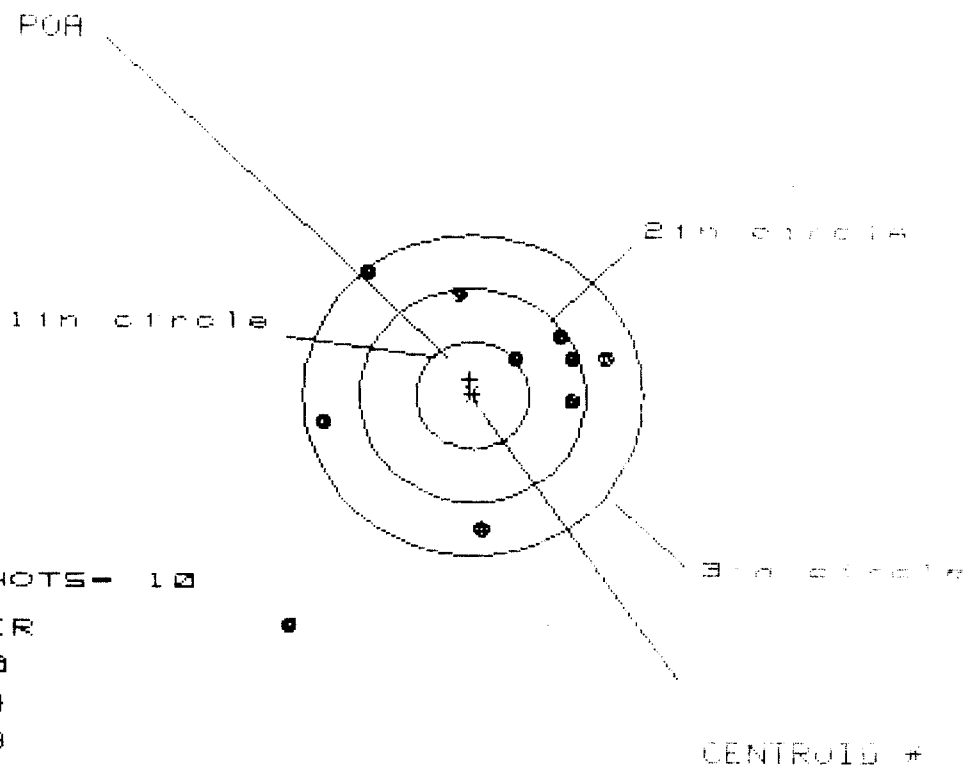
PATTERN #	:	2	3	4
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.751	.490	.520
MINIMUM X	:	-.449	-.365	-.335
MAXIMUM Y	:	1.354	1.493	.631
MINIMUM Y	:	-1.159	-1.020	-.833
CENTROID X	:	-.024	-.108	-.138
CENTROID Y	:	-.301	-.440	-.627
POA TO CENTROID in.	:	.302	.453	.642
MIN RADIUS	:	.177	.083	.110
MEAN RADIUS	:	.726	.605	.469
MAX RADIUS	:	1.460	1.513	.898
HORIZONTAL SPREAD	:	1.200	.855	.855
VERTICAL SPREAD	:	2.513	2.513	1.464
EXTREME SPREAD	:	2.692	2.586	1.632
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

08649131

FILE: PATTERNING/CENTERFIRE_PATT/08649131

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.806

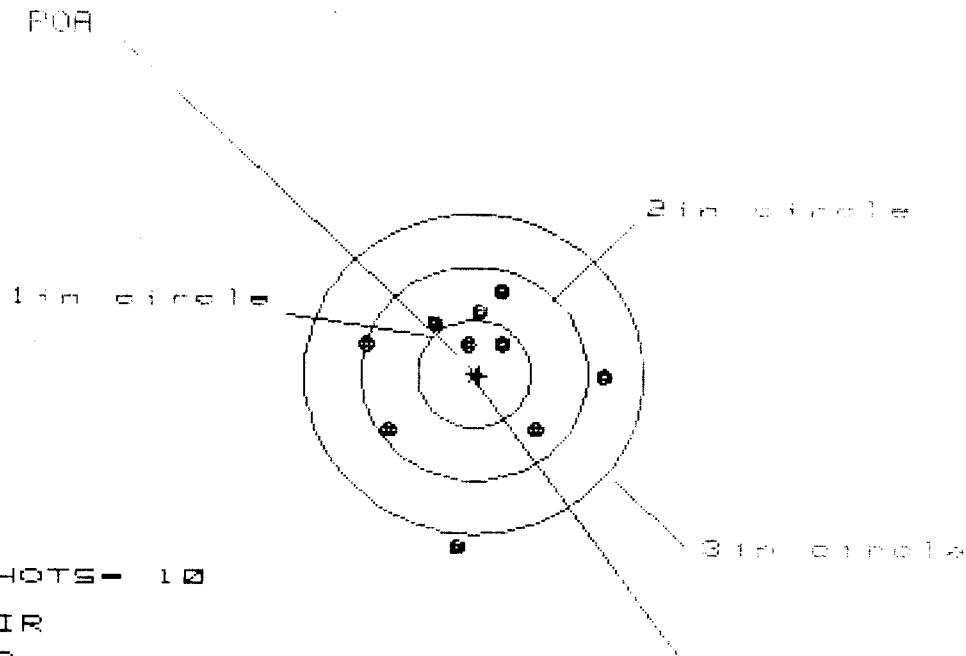
VS= 3.332

GS= 3.746

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	.955	.921
MINIMUM X	:	-1.666	-1.486	-1.620
MAXIMUM Y	:	1.163	.922	.871
MINIMUM Y	:	-2.169	-1.524	-1.409
CENTROID X	:	.025	.210	.344
CENTROID Y	:	-.153	.088	-.027
POA TO CENTROID in.	:	.155	.228	.345
MIN RADIUS	:	.513	.212	.255
MEAN RADIUS	:	1.221	.950	.866
MAX RADIUS	:	2.735	1.552	1.654
HORIZONTAL SPREAD	:	2.806	2.441	2.441
VERTICAL SPREAD	:	3.332	2.446	2.280
EXTREME SPREAD	:	3.746	2.624	2.495
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

FILE: PATTERNING/CENTERFIRE_PATT/06049101

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in = 9

HS- 2.125

VS= 2.411

GS= 2.438

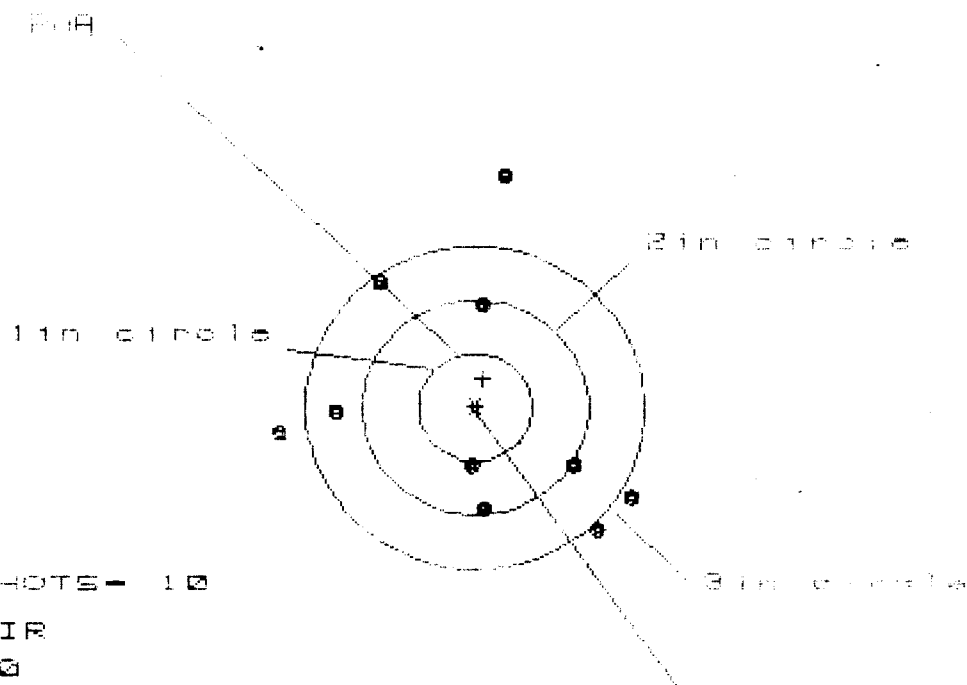
CENTROID

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.173	1.157	.628
MINIMUM X	:	-.952	-.968	-.824
MAXIMUM Y	:	.806	.628	.602
MINIMUM Y	:	-1.605	-.711	-.737
CENTROID X	:	-.046	-.030	-.174
CENTROID Y	:	.021	.199	.225
POA TO CENTROID in.	:	.050	.201	.285
MIN RADIUS	:	.311	.142	.135
MEAN RADIUS	:	.809	.665	.592
MAX RADIUS	:	1.611	1.176	.962
HORIZONTAL SPREAD	:	2.125	2.125	1.452
VERTICAL SPREAD	:	2.411	1.339	1.339
EXTREME SPREAD	:	2.438	2.150	1.666
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

FILE:/PATTERNING/CENTERFIRE PATT/06849101

INTERFERING PATTERNS

#



OF SHOTS - 10

IN CIR

1171 - 2

210 - 21

$$515 = 5$$

145- 2,096

2000 3.2000

US= 3.385

CENTRO ID #

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PATTERN #          :          5
RADIS (BEST OF)   :          10          9          8
MAXIMUM X         :          1.375          1.400          1.188
MINIMUM X         :          -1.722          -1.696          -1.413
MAXIMUM Y         :          2.717          2.325          1.383
MINIMUM Y         :          -1.142          -1.906          -1.908
CENTROID X       :          1.000          1.001          1.119
CENTROID Y       :          -1.264          -1.500          -1.498
DIST TO CENTROID in. :          1.272          1.509          1.512
IDM RADIUS       :          1.575          1.340          1.390
IDM RADIUS       :          1.328          1.194          1.110
OUT RADIUS       :          2.133          1.696          1.712
VAL ANGLE SPREAD :          3.096          3.096          2.601
VAL ANGLE SPREAD :          3.200          2.291          2.291
VAL ANGLE SPREAD :          3.385          3.152          2.958
VAL ANGLE SPREAD IN-H CIRCLE =          0
VAL ANGLE SPREAD IN-H CIRCLE =          2
VAL ANGLE SPREAD IN-H CIRCLE =          6

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SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 66649131

DATE 8-9-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.35	2.40	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.29	2.38	2.27	
PULL #3	2.20	2.28	2.44	2.32	
PULL #4	2.33	2.28	2.20	2.36	
PULL #5	2.33	2.35	2.28	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.44		
PULL #2	3.53	3.36		
PULL #3	3.49	3.51		
PULL #4	3.48	3.44		
PULL #5	3.52	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.55		4.45
PULL #2	4.49	4.44		4.44
PULL #3	4.28	4.50		4.51
PULL #4	4.35	4.46		4.43
PULL #5	4.35	4.44		4.45
TOTAL				
AVG.				