

C6649133

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

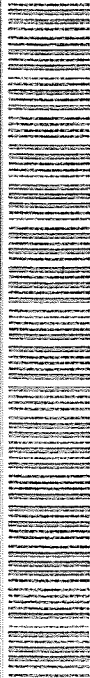
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6649133

ORDER NO. 5716

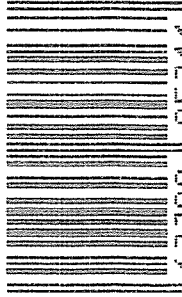
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

20



5716 C6649133

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649133

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		dw
600	Proof	6 27 91		dw
607	Check Headspace	6 27 91		dw
610	Dis-assemble Gun	6 27 91		dw
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	JS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-1-91	JA

op. #	BARBER - M24 0065189		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		7	7	7			8-1-91	JH
	G) Safety Off Force		5	5	5			8-1-91	JH
	H) Trigger Pull Test & Retainability							8-1-91	JH
	I) Firing Pin Indent		10205	1205	1205			8-1-91	JH
	J) Assemble Stock							8/5/91	RW
	K) Assemble Swivel Studs							8-6-91	AC
	L) Attach Front and Rear Sight Assemblies							8/5/91	RW
	M) Iron Sight Alignment							8/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container							8/5/91	RW
	O) Attach Scope to Rifle							8/5/91	RW
	P) Detach & Attach Scope 20 Times							8/5/91	RW
640	Gallery Target & Test							8-5-91	AC
	A) Time							8-5-91	AC
	B) Malfunctions							8-5-91	AC
	C) Pierced Primers							8-5-91	AC
	D) Optical Clarity of Scope							8-5-91	AC
645	Inspect for Live Ammo							8-5-91	AC
655	Final Inspection								
	A) Headspace							8-6-91	AC
	B) Trigger Pull		2.35	2.31	2.34	2.33	2.34	8-5-91	JH
	C) Function							8-6-91	AC
660	Pack							7/7/91	JH

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

SERIAL NO. 06649133DATE 8-1-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.30	2.38	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.33	2.34	2.31	
PULL #3	2.50	2.34	2.34	2.34	
PULL #4	2.55	2.34	2.30	2.33	
PULL #5	2.60	2.31	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.37		
PULL #2	3.27	3.31		
PULL #3	3.46	3.31		
PULL #4	3.57	3.32		
PULL #5	3.48	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.50		4.40
PULL #2	4.42	4.41		4.40
PULL #3	4.42	4.55		4.44
PULL #4	4.42	4.40		4.49
PULL #5	4.39	4.29		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649133
5 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.466135
1 TO	2	.393289
1 TO	3	.453848
1 TO	4	.689456
1 TO	5	.501328

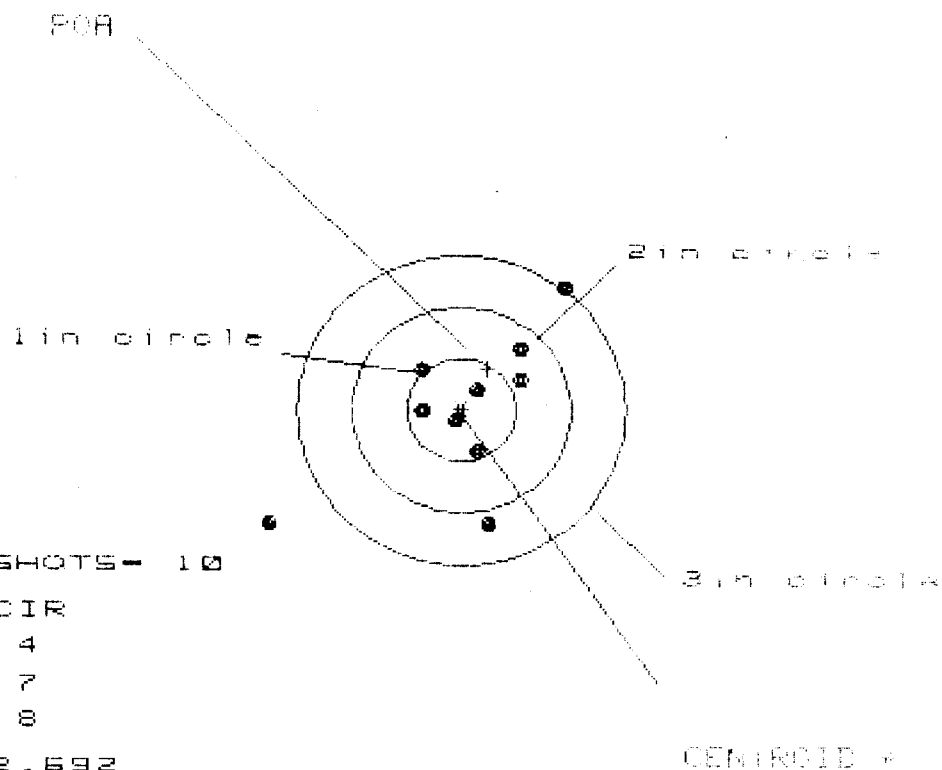
45+ <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.3546
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0000
THE AVERAGE Z-COORDINATE FOR THIS RIFLE IS: 1.0000
THE AVERAGE R FOR THIS RIFLE IS: .9825

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649135

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.692

VS= 2.356

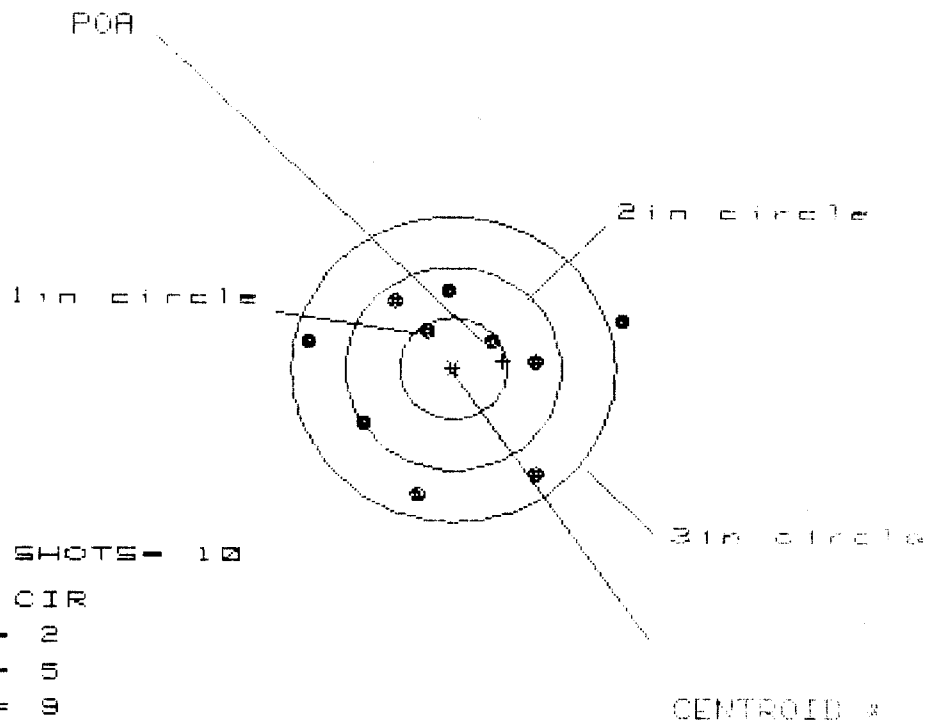
GS= 3.572

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.913	.716	.484
MINIMUM X	-1.778	-.564	-.475
MAXIMUM Y	1.213	1.087	.031
MINIMUM Y	-1.143	-1.269	-1.183
CENTROID X	-.241	-.044	-.133
CENTROID Y	-.399	-.273	-.409
POB TO CENTROID in.	.467	.277	.430
1in RADIUS	.067	.132	.139
2in RADIUS	.786	.630	.533
3in RADIUS	2.110	1.302	1.141
HORIZONTAL SPREAD	2.692	1.280	.939
VERTICAL SPREAD	2.356	2.356	1.764
CIRCLE SPREAD	3.572	2.449	1.781
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.872

VS= 1.967

GS= 2.880

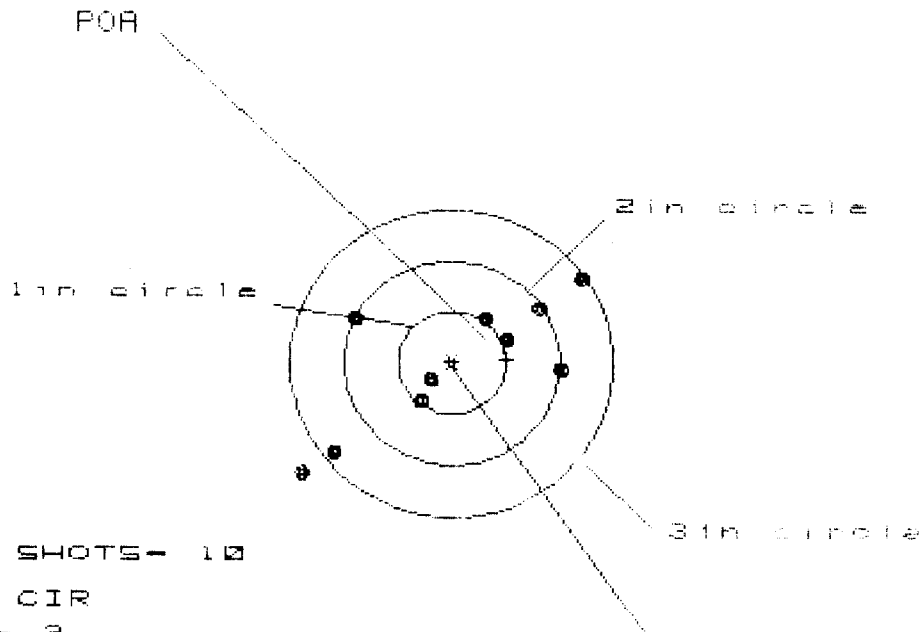
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.518
MINIMUM X	:	-1.354
MAXIMUM Y	:	.774
MINIMUM Y	:	-1.193
CENTROID X	:	-.461
CENTROID Y	:	-.073
POA TO CENTROID in.	:	.467
MIN RADIUS	:	.406
MEAN RADIUS	:	.967
MAX RADIUS	:	1.584
HORIZONTAL SPREAD	:	2.872
VERTICAL SPREAD	:	1.967
EXTREME SPREAD	:	2.880
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	9

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.550

VS= 1.816

GS= 3.131

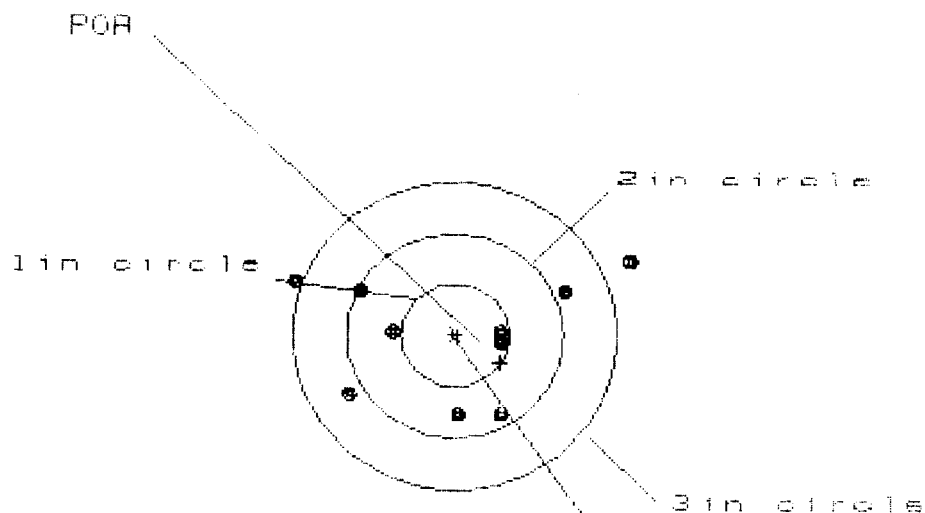
CENTROID *

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.171
MINIMUM X	:	-1.379
MAXIMUM Y	:	.769
MINIMUM Y	:	-1.027
CENTROID X	:	-.508
CENTROID Y	:	-.032
POA TO CENTROID in.	:	.509
MIN RADIUS	:	.261
MEAN RADIUS	:	.945
MAX RADIUS	:	1.719
HORIZONTAL SPREAD	:	2.550
VERTICAL SPREAD	:	1.816
EXTREME SPREAD	:	3.131
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	4
NUMBER IN THREE INCH CIRCLE =	:	9

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.055

VS= 1.510

GS= 3.060

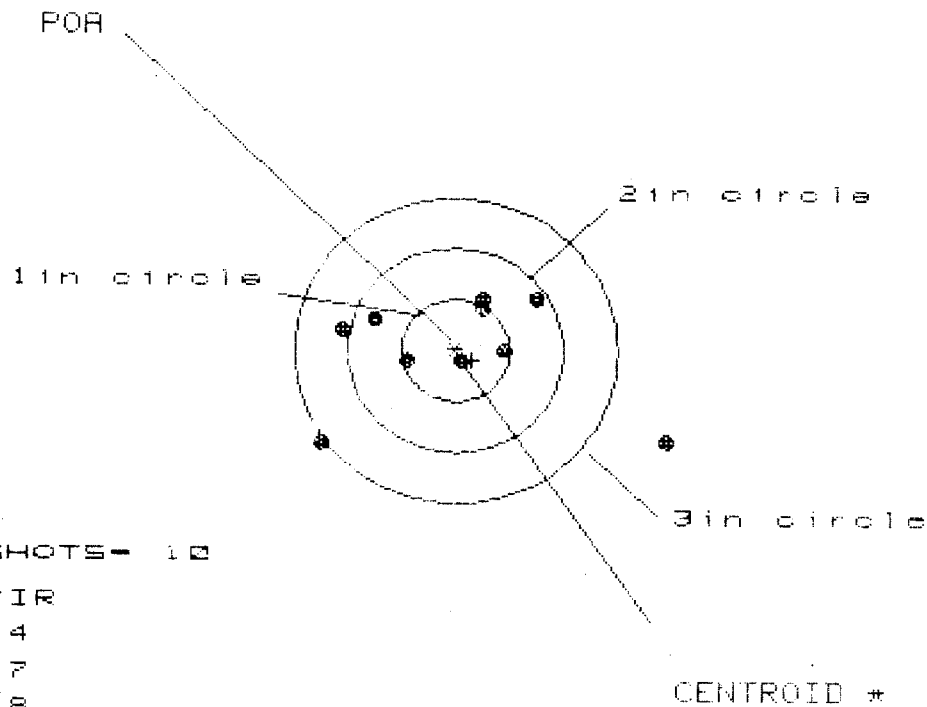
CENTROID #

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.595	1.214	1.054
MINIMUM X	-1.460	-1.283	-1.939
MAXIMUM Y	.725	.628	.638
MINIMUM Y	-.785	-.705	-.626
CENTROID X	-.423	-.600	-.440
CENTROID Y	.266	.186	.107
POA TO CENTROID IN.	.500	.628	.453
MIN RADIUS	.382	.448	.427
MEAN RADIUS	.962	.868	.772
MAX RADIUS	1.752	1.428	1.219
HORIZONTAL SPREAD	3.055	2.497	1.992
VERTICAL SPREAD	1.510	1.333	1.264
EXTREME SPREAD	3.060	2.499	2.052
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.196

VS= 1.441

GS= 3.197

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.987	.996	.861
MINIMUM X	:	-1.289	-1.077	-1.021
MAXIMUM Y	:	.519	.424	.296
MINIMUM Y	:	-.902	-1.017	-.337
CENTROID X	:	-.150	-.362	-.227
CENTROID Y	:	.094	.189	.317
POR TO CENTROID in.	:	.177	.408	.390
MIN RADIUS	:	.057	.276	.293
MEAN RADIUS	:	.854	.713	.591
MAX RADIUS	:	2.092	1.482	1.022
HORIZONTAL SPREAD	:	3.196	2.073	1.832
VERTICAL SPREAD	:	1.441	1.441	.533
EXTREME SPREAD	:	3.197	2.525	1.912
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	