

C6649155

MODEL 790TM M24

Model S&S TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

* Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

DUPONT
REG. U.S. PAT. & TM. OFF.

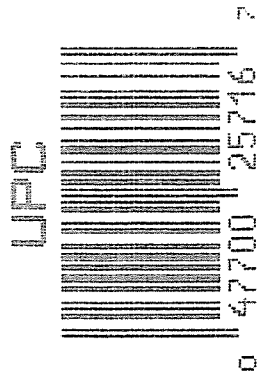
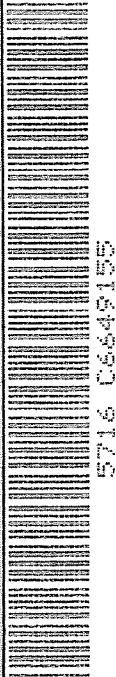
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6649155

ORDER NO.
5716

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649155

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-12-91	RM

op. #	NAME BARBER - M24 0065439	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-12-91	JH
	G) Safety Off Force	3	3	3			8-12-91	JH
	H) Trigger Pull Test & Retainability						8-12-91	JH
	I) Firing Pin Indent	1020	10215	10215			8-12-91	JH
	J) Assemble Stock						8/14/91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/14/91	RW
	M) Iron Sight Alignment						8/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	RW
	O) Attach Scope to Rifle						8/14/91	RW
	P) Detach & Attach Scope 20 Times						8/14/91	RW
640	Gallery Target & Test						8-15-91	AC
	A) Time						8-15-91	AC
	B) Malfunctions						8-15-91	AC
	C) Pierced Primers						8-15-91	AC
	D) Optical Clarity of Scope						8-15-91	AC
645	Inspect for Live Ammo						8-15-91	AC
655	Final Inspection							
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	2.44	2.60	2.56	2.53	2.64	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						9-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649155DATE 8-12-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.32	2.33	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.31	2.44	2.60	
PULL #3	2.35	2.25	2.30	2.56	
PULL #4	2.15	2.23	2.33	2.53	
PULL #5	2.38	2.28	2.20	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.47		
PULL #2	3.20	3.41		
PULL #3	3.31	3.26		
PULL #4	3.42	3.28		
PULL #5	3.37	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.35		4.32
PULL #2	4.32	4.36		4.42
PULL #3	4.32	4.39		4.47
PULL #4	4.35	4.33		4.40
PULL #5	4.38	4.20		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649155
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.214441
1 TO	2	.0765506
1 TO	3	.0864928
1 TO	4	.0863713
1 TO	5	.0300167

4 <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0446
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1552
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .161491
AMP FOR THIS RIFLE IS: .8288

23 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B49155

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.620

VS= 1.700

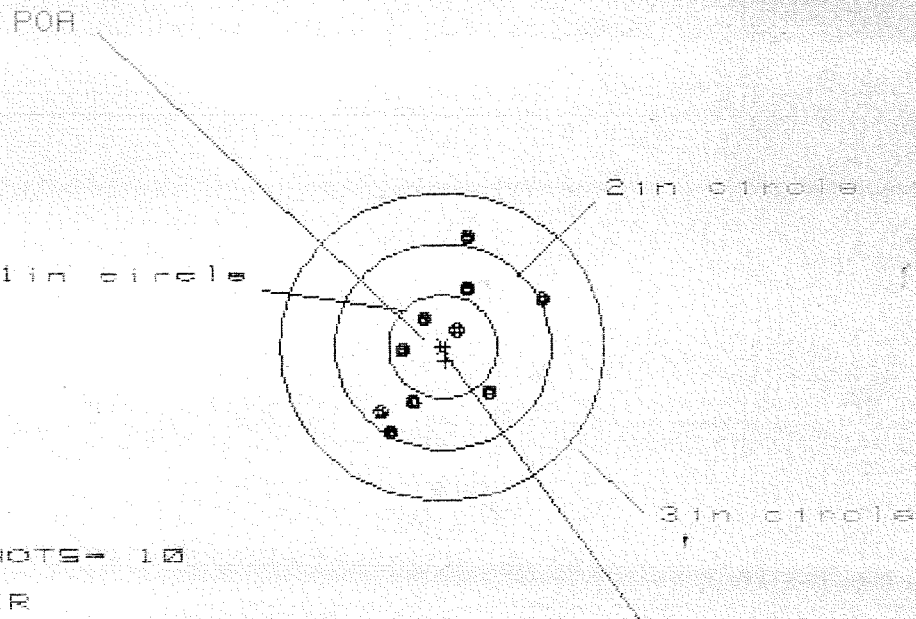
GS= 2.122

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.817	.889	.827
MINIMUM X	-.803	-.712	-.774
MAXIMUM Y	.860	.779	.593
MINIMUM Y	-.848	-.929	-.832
CENTROID X	-.948	-.139	-.077
CENTROID Y	.209	.290	.193
POA TO CENTROID in.	.214	.322	.208
MIN RADIUS	.218	.178	.187
MEAN RADIUS	.693	.627	.597
MAX RADIUS	1.899	.990	.984
HORIZONTAL SPREAD	1.620	1.601	1.601
VERTICAL SPREAD	1.700	1.708	1.365
EXTREME SPREAD	2.122	1.902	1.902
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649155

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.477

VS= 1.851

GS= 1.980

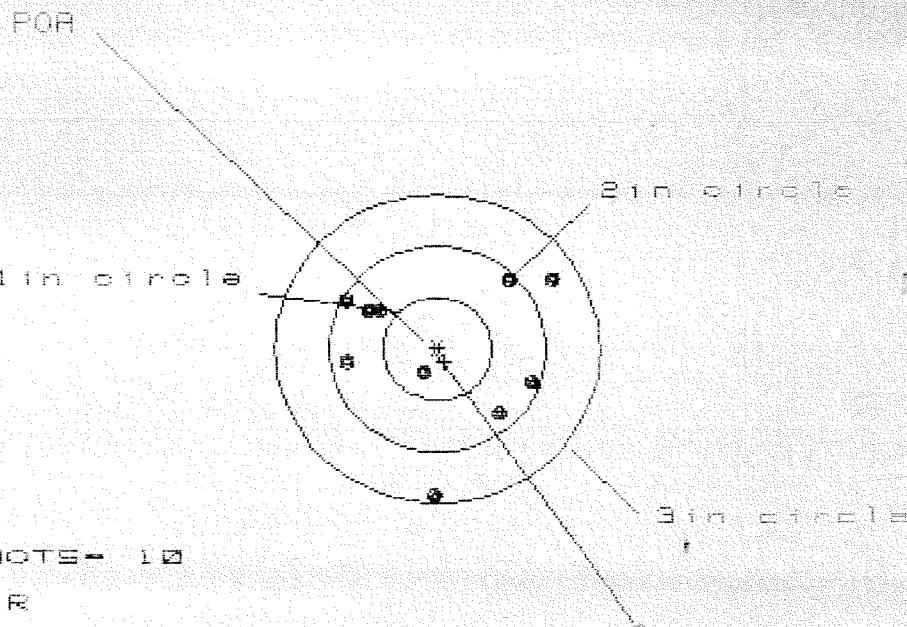
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.875	.905	.589
MINIMUM X	-.602	-.572	-.459
MAXIMUM Y	1.029	.637	.712
MINIMUM Y	-.822	-.708	-.633
CENTROID X	-.022	-.052	-.166
CENTROID Y	.137	.023	-.052
POR TO CENTROID in.	.139	.057	.173
MIN RADIUS	.152	.266	.289
MEAN RADIUS	.645	.601	.531
MAX RADIUS	1.064	1.085	.736
HORIZONTAL SPREAD	1.477	1.477	1.047
VERTICAL SPREAD	1.851	1.345	1.345
EXTREME SPREAD	1.980	1.849	1.482
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.967

VS= 2.136

GS= 2.399

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.091	1.087	.970
MINIMUM X	-.876	-.880	-.745
MAXIMUM Y	.710	.560	.628
MINIMUM Y	-1.418	-.759	-.691
CENTROID X	-.064	-.060	-.195
CENTROID Y	.124	.282	.214
POA TO CENTROID in.	.139	.288	.290
MIN RADIUS	.309	.447	.341
MEAN RADIUS	.981	.840	.761
MAX RADIUS	1.419	1.214	1.051
HORIZONTAL SPREAD	1.967	1.967	1.715
VERTICAL SPREAD	2.136	1.319	1.319
EXTREME SPREAD	2.399	2.119	1.899
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649155

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 1.491

VS= 3.009

GS= 3.049

CENTROID #

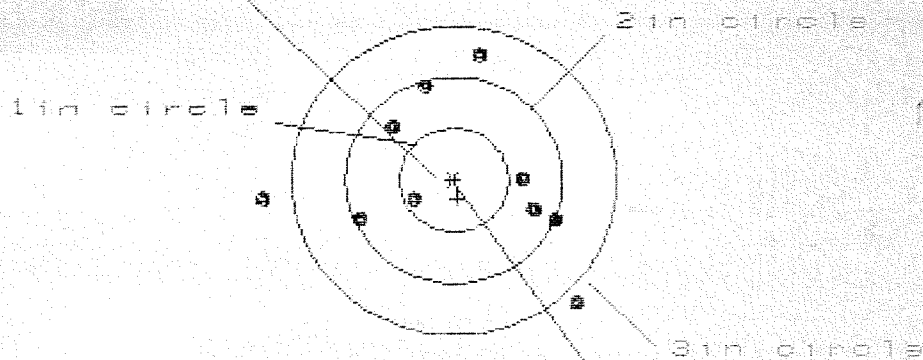
PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.773	.683
MINIMUM X	-.696	-.718	-.508
MAXIMUM Y	1.327	1.140	1.012
MINIMUM Y	-1.683	-1.390	-1.248
CENTROID X	-.056	-.034	.056
CENTROID Y	.123	.309	.167
POR TO CENTROID in.	.135	.311	.176
MIN RADIUS	.267	.177	.284
MEAN RADIUS	.897	.757	.714
MAX RADIUS	1.695	1.422	1.265
HORIZONTAL SPREAD	1.491	1.491	1.241
VERTICAL SPREAD	3.009	2.530	2.260
EXTREME SPREAD	3.049	2.736	2.386
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

28 Aug 1981

FILE: /PATTERNING/CENTERFIRE_PATT/CS64B155

CENTERFIRE PATTERNS # 5

POB



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.932

VS = 2.415

GS = 3.120

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.139
MINIMUM X	-1.793
MAXIMUM Y	1.200
MINIMUM Y	-1.215
CENTROID X	-0.033
CENTROID Y	0.183
POB TO CENTROID in.	0.186
MIN RADIUS	0.372
MEAN RADIUS	1.008
MAX RADIUS	1.799
HORIZONTAL SPREAD	2.932
VERTICAL SPREAD	2.415
EXTREME SPREAD	3.120
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	8