

C6649159

MODEL 700™ M24

Model S&S™

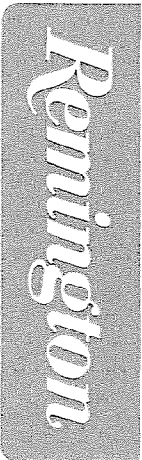
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

DUPONT

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

MODEL 700TM M24

SERIAL NO.
C6649159

ORDER NO.
5716

20

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

UPC
0 47700 25716 7

5716 C6649159

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649159

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KS
600	Proof		6/27/91	KS
607	Check Headspace		6/27/91	KS
610	Dis-assemble Gun		6/27/91	KS
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	EB
618	Polish Barrel	JUL 2	8 1991	CB
620	Apply Coatings (Barrel Action)		8/7/91	HA
	Apply Coating (Bolt)			HA
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KL
	C) Inspect Ejector Hole for Chamfer		8/22/91	KL
	D) Oil Firing Pin Ass'y		8/22/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/25/91	KL

op. #	UP. NAME BARBER M24 0065483	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ³ / ₄	5	5			8-23-91	DH
	G) Safety Off Force	2	2 ¹ / ₄	2			8-23-91	DH
	H) Trigger Pull Test & Retainability						8/23/91	QZ
	I) Firing Pin Indent	.020	.020	.020			8-23-91	DH
	J) Assemble Stock						8/28/91	TK
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	TK
	M) Iron Sight Alignment						8/28/91	TK
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	TK
	O) Attach Scope to Rifle						8/28/91	TK
	P) Detach & Attach Scope 20 Times						8/28/91	TK
640	Gallery Target & Test						8-28-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-28-91	NF
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	2.59	2.59	2.50	2.49	2.54	8/29/91	QZ
	C) Function						8-31-91	DH
660	Pack						9-18-91	NF

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

SERIAL NO. C6649159DATE 8/23/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.31	2.40	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.30	2.38	2.59	
PULL #3	2.64	2.30	2.35	2.50	
PULL #4	2.42	2.30	2.44	2.49	
PULL #5	2.45	2.34	2.30	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.47		
PULL #2	3.58	3.50		
PULL #3	3.57	3.20		
PULL #4	3.55	3.52		
PULL #5	3.59	3.56		
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	4.33		4.24
PULL #2	4.44	4.29		4.31
PULL #3	4.44	4.15		4.16
PULL #4	4.38	4.35		4.42
PULL #5	4.15	4.26		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6649159

29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.120905
1 TO	2	.20662
1 TO	3	.117107
1 TO	4	.273885
1 TO	5	.225



<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0154
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0158152
THE AMR FOR THIS RIFLE IS: 1.005

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06549159

CENTERFIRE PATTERNS # 1

POA

1 in. circle

2 in. circle

3 in. circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in - 4

2 in - 7

3 in - 8

HS - 3.915

VS - 1.684

GS - 3.954

PATTERN #

:

10

9

8

SHOTS (BEST OF)

:

1.957

1.735

.863

MAXIMUM X

:

-1.958

-1.013

-.795

MINIMUM X

:

.826

.597

.643

MAXIMUM Y

:

-.858

-.767

-.721

MINIMUM Y

:

.043

.261

.043

CENTROID X

:

.113

.022

-.024

CENTROID Y

:

.121

.262

.049

POA TO CENTROID in.

:

.269

.442

.275

MIN RADIUS

:

.875

.777

.585

MEAN RADIUS

:

2.125

1.777

1.125

MAX RADIUS

:

3.915

2.752

1.658

HORIZONTAL SPREAD

:

1.684

1.364

1.364

VERTICAL SPREAD

:

3.954

2.762

1.882

EXTREME SPREAD

:

4

7

8

NUMBER IN ONE

INCH CIRCLE

=

4

NUMBER IN TWO

INCH CIRCLE

=

7

NUMBER IN THREE

INCH CIRCLE

=

8

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FILE: PATTERNING/CENTERFIRE_PATT/C3649159

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 3.014

VS= 2.716

GS= 3.148

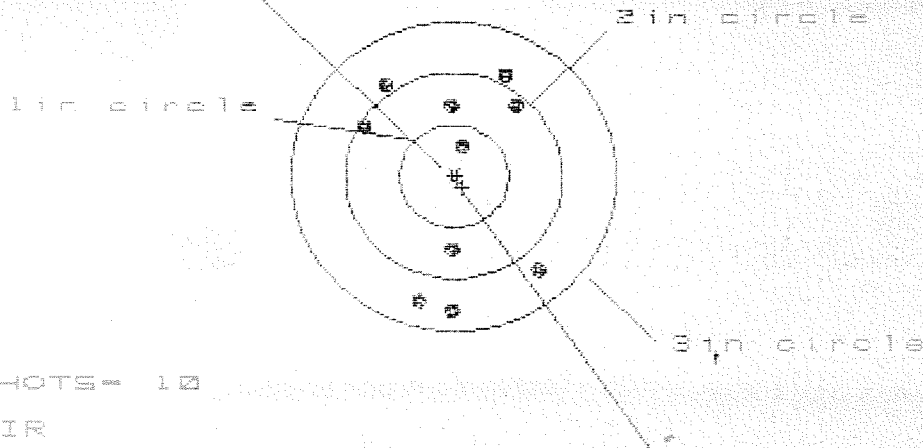
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	.966	1.001
MINIMUM X	:	-1.843	-1.540	-1.505
MAXIMUM Y	:	1.248	1.211	1.023
MINIMUM Y	:	-1.468	-1.505	-1.093
CENTROID X	:	.137	.342	.307
CENTROID Y	:	-.071	-.033	.155
POA TO CENTROID in.	:	.154	.344	.344
MIN RADIUS	:	.550	.358	.314
MEAN RADIUS	:	1.196	1.080	.989
MAX RADIUS	:	1.874	1.610	1.642
HORIZONTAL SPREAD	:	3.014	2.506	2.506
VERTICAL SPREAD	:	2.716	2.716	2.116
EXTREME SPREAD	:	3.148	2.780	2.699
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649159

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.653

VS= 2.370

GS= 2.408

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.797	.754
MINIMUM X	-.858	-.856	-.899
MAXIMUM Y	1.013	.862	.696
MINIMUM Y	-1.357	-1.330	-1.195
CENTROID X	-.074	-.076	-.033
CENTROID Y	.108	.259	.425
POA TO CENTROID in.	.131	.270	.426
MIN RADIUS	.343	.201	.045
MEAN RADIUS	.969	.891	.776
MAX RADIUS	1.357	1.373	1.413
HORIZONTAL SPREAD	1.653	1.653	1.653
VERTICAL SPREAD	2.370	2.192	1.891
EXTREME SPREAD	2.408	2.330	2.315
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 1.641

VS= 2.598

GS= 2.599

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.885

.776

.668

MINIMUM X

-.836

-.865

-.889

MAXIMUM Y

.680

.466

.487

MINIMUM Y

-1.918

-1.478

-1.502

CENTROID X

-.846

-.817

.091

CENTROID Y

-.146

.060

.127

POA TO CENTROID in.

.153

.070

.157

MIN RADIUS

.474

.261

.185

MEAN RADIUS

.816

.638

.572

MAX RADIUS

1.936

.988

.836

HORIZONTAL SPREAD

1.641

1.641

1.477

VERTICAL SPREAD

2.598

.944

.909

EXTREME SPREAD

2.599

1.641

1.532

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

9

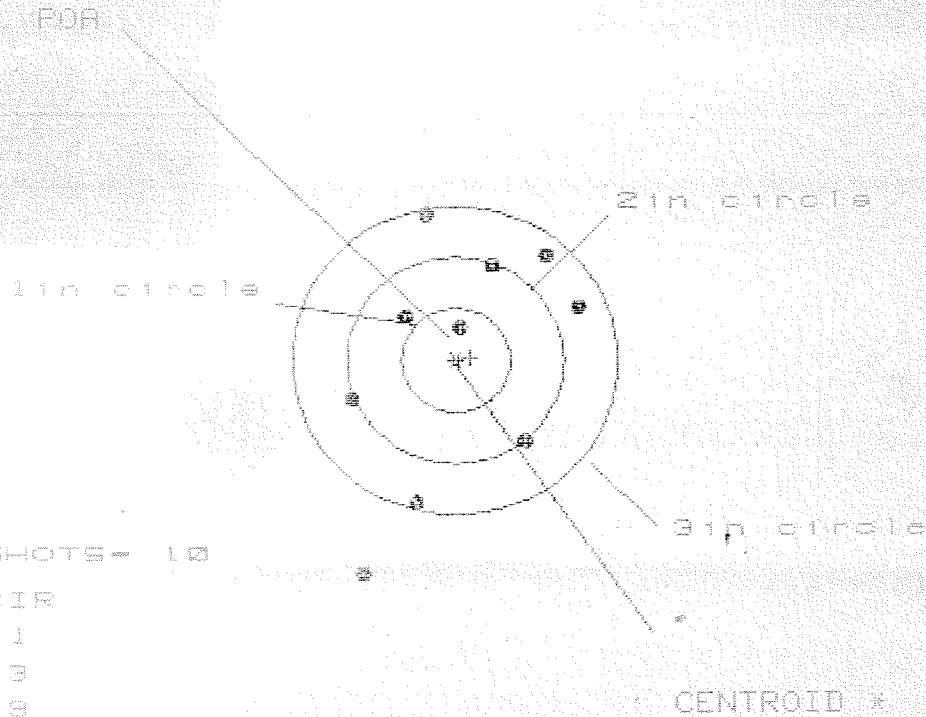
NUMBER IN THREE INCH CIRCLE =

9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649159

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.070

VS= 3.543

GS= 3.591

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	1.140	1.043	.993
MINIMUM X	-.930	-1.027	-1.077
MAXIMUM Y	1.442	1.209	.898
MINIMUM Y	-2.101	-1.602	-1.451
CENTROID X	-.137	-.040	.009
CENTROID Y	-.022	.211	.060
POA TO CENTROID in.	.139	.215	.061
MIN RADIUS	.361	.132	.291
MEAN RADIUS	1.170	.988	.973
MAX RADIUS	2.278	1.675	1.548
HORIZONTAL SPREAD	2.070	2.070	2.070
VERTICAL SPREAD	3.543	2.811	2.349
EXTREME SPREAD	3.591	2.813	2.635
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	9	9	9