

C6649180

MODEL 700™ M24

Model **S&S**™

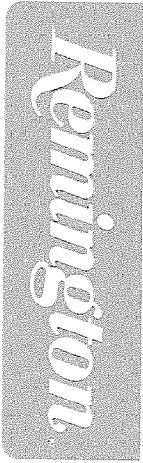
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

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

MODEL 700™ M24

SERIAL NO. C6649180

ORDER NO. 5716

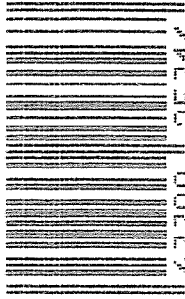
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649180

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649180

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		RW
600	Proof	6 27 91		RW
607	Check Headspace	6 27 91		RW
610	Dis-assemble Gun	6 27 91		RW
612	Magnaflux Barrel Action		1 JUL 2 1991	KR
	Magnaflux Bolt		1 JUL 2 1991	KR
615	Rollmark Caliber		1 JUL 2 1991	GS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	UB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			P
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		7-26-91	SW

op. #	BARBER - M24 0065802 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5½	5½			7-26-91	NH
	G) Safety Off Force	3¼	3¾	3¾			7-26-91	NH
	H) Trigger Pull Test & Retainability						7-26-91	JH
	I) Firing Pin Indent	.020	.020	.020			7-26-91	NH
	J) Assemble Stock						8/1/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/1/91	RW
	M) Iron Sight Alignment						8/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	RW
	O) Attach Scope to Rifle						8/1/91	RW
	P) Detach & Attach Scope 20 Times						8/1/91	RW
640	Gallery Target & Test						8/1/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/1/91	KT
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.30	2.25	2.40	2.35	2.39	8-5-91	JH
	C) Function						8-6-91	AC
660	Pack						9-19-91	NF

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

SERIAL NO. C-6649180DATE 7-26-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.20	2.20	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.44	2.28	2.25	
PULL #3	2.32	2.41	2.44	2.40	
PULL #4	2.48	2.31	2.38	2.35	
PULL #5	2.64	2.16	2.38	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.65		
PULL #2	3.27	3.60		
PULL #3	3.17	3.61		
PULL #4	3.41	3.61		
PULL #5	3.50	3.57		
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	4.50		4.51
PULL #2	4.32	4.33		4.54
PULL #3	4.29	4.40		4.52
PULL #4	4.35	4.44		4.58
PULL #5	4.42	4.48		4.59
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6649180
1 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.117388
1 TO	2	.0760592
1 TO	3	.193569
1 TO	4	.243319
1 TO	5	.123491

---FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00420475
THE AMR FOR THIS RIFLE IS: 1.034

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB49180

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.547

VS= 1.413

GS= 3.648

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.897	1.330	1.137
MINIMUM X	-1.750	-1.539	-1.266
MAXIMUM Y	.891	.844	.773
MINIMUM Y	-.522	-.569	-.516
CENTROID X	-.144	-.355	-.163
CENTROID Y	.044	.091	.162
POA TO CENTROID in.	.151	.366	.230
MIN RADIUS	.280	.231	.388
MEAN RADIUS	1.847	.928	.847
MAX RADIUS	1.945	1.641	1.375
HORIZONTAL SPREAD	3.647	2.869	2.404
VERTICAL SPREAD	1.413	1.413	1.286
EXTREME SPREAD	3.648	3.198	2.508
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08848180

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS = 12

IN CIR

1in = 3

2in = 5

3in = 6

HS = 2.558

VS = 4.328

GS = 4.585

CENTROID *

PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.199	1.185	1.081
MINIMUM X	-1.457	-1.471	-1.986
MAXIMUM Y	2.774	1.238	1.092
MINIMUM Y	-1.554	-1.246	-1.392
CENTROID X	.096	.110	.294
CENTROID Y	.679	-.229	-.083
POR TO CENTROID in.	.124	.254	.306
MIN RADIUS	.111	.420	.341
MEAN RADIUS	1.220	1.092	.974
MAX RADIUS	2.777	1.878	1.673
HORIZONTAL SPREAD	2.656	2.656	1.987
VERTICAL SPREAD	4.328	2.484	2.484
EXTREME SPREAD	4.585	3.088	3.088
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86491B0

CENTERFIRE PATTERNS

4

FOR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.409

VS= 1.862

CS= 2.508

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.367
MINIMUM X	-1.042
MAXIMUM Y	1.092
MINIMUM Y	-0.770
CENTROID X	.010
CENTROID Y	-.041
FOR TO CENTROID in.	.043
MIN RADIUS	.715
MEAN RADIUS	1.003
MAX RADIUS	1.367
HORIZONTAL SPREAD	2.409
VERTICAL SPREAD	1.862
EXTREME SPREAD	2.508
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849180

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 2.851

VGS= 4.568

GS= 4.591

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.336	1.337	1.396
MINIMUM X	-1.515	-1.514	-1.455
MAXIMUM Y	2.185	1.920	.814
MINIMUM Y	-2.383	-1.387	-1.147
CENTROID X	.046	.045	-.014
CENTROID Y	-.108	.157	-.083
POA TO CENTROID in.	.118	.163	.085
MIN RADIUS	.286	.352	.223
MEAN RADIUS	1.181	1.812	1.892
MAX RADIUS	2.383	1.978	1.807
HORIZONTAL SPREAD	2.851	2.851	2.851
VERTICAL SPREAD	4.568	3.307	1.961
EXTREME SPREAD	4.591	3.418	3.086
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		