

C6649224

MODEL 700™ M24

Model S&S™

Action

Barrel Length

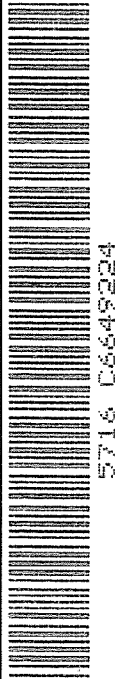
Capacity

Order No. 5716

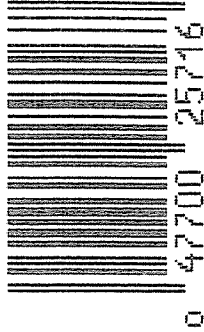
*Includes 1 in chamber.

Remington

Remington® MODEL 700TH H24 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.
DU PONT REGISTRATION OFF		SERIAL NO. C6649224
20		ORDER NO. 5716



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649224

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	Raw
600	Proof	6 25	9 1	Raw
607	Check Headspace	6 25	9 1	Raw
610	Dis-assemble Gun	6 25	9 1	Raw
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	LS.
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	Raw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	Raw
	C) Inspect Ejector Hole for Chamfer		8/27/91	Raw
	D) Oil Firing Pin Ass'y		8/27/91	Raw
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	JS

op. #	BARBER M24 0066647	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-28-91	DH
	G) Safety Off Force	4	4	4			8-28-91	DH
	H) Trigger Pull Test & Retainability						8/28/91	RL
	I) Firing Pin Indent	1022	1021	1022			8-28-91	DH
	J) Assemble Stock						8/29/91	RW
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/29/91	RW
	M) Iron Sight Alignment						8/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/91	RW
	O) Attach Scope to Rifle						8/29/91	RW
	P) Detach & Attach Scope 20 Times						8/29/91	RW
640	Gallery Target & Test						8/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/29/91	KT
655	Final Inspection							
	A) Headspace						8-31-91	DH
	B) Trigger Pull	256	269	275	275	259	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						9-18-91	W

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

SERIAL NO. C-6649224DATE 8/28/91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.52	2.50	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.53	2.55	2.69	
PULL #3	2.53	2.39	2.49	2.75	
PULL #4	2.58	2.62	2.44	2.75	
PULL #5	2.49	2.54	2.52	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.36		
PULL #2	3.32	3.33		
PULL #3	3.41	3.30		
PULL #4	3.34	3.29		
PULL #5	3.25	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.55		4.47
PULL #2	4.46	4.52		4.44
PULL #3	4.40	4.48		4.33
PULL #4	4.41	4.38		4.32
PULL #5	4.49	4.40		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649224
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.320975
1 TO	2	.50946
1 TO	3	.482121
1 TO	4	1.02034
1 TO	5	.712475

$\frac{1}{5}$ <----POA

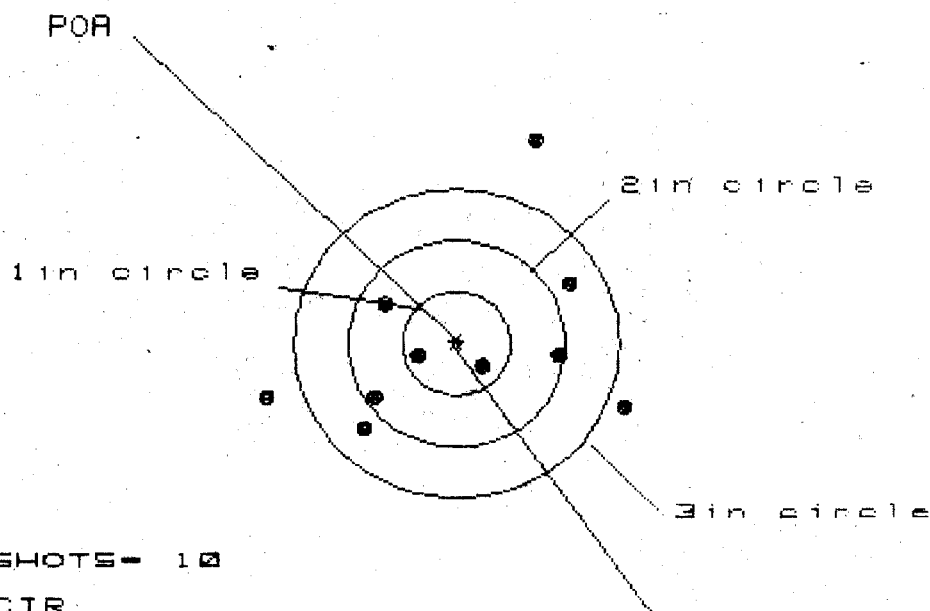
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2254
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .229243

THE AMR FOR THIS RIFLE IS: 1.128

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649224

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.347

VS = 2.785

GS = 3.554

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.539	1.616	1.400
MINIMUM X	-1.808	-1.731	-.973
MAXIMUM Y	1.973	.786	.745
MINIMUM Y	-.812	-.593	-.634
CENTROID X	-.241	-.318	-.102
CENTROID Y	.212	-.007	.034
POA TO CENTROID in.	.321	.318	.107
MIN RADIUS	.352	.312	.143
MEAN RADIUS	1.128	.995	.890
MAX RADIUS	2.093	1.761	1.454
HORIZONTAL SPREAD	3.347	3.347	2.373
VERTICAL SPREAD	2.785	1.379	1.379
EXTREME SPREAD	3.554	3.347	2.385
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS - 10

* IN CIR

1in = 0

2in = 1

3in = 7

HS = 3.898

VS = 3.048

GS = 4.289

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

2.721

1.424

1.507

-1.177

-0.874

-0.791

1.669

1.516

1.472

-1.379

-1.477

-1.287

.415

.112

.029

-.066

.087

-.103

.420

.142

.107

.565

.438

.233

1.407

1.159

1.046

3.050

1.655

1.701

3.898

2.298

2.298

3.048

2.993

2.759

4.289

3.148

2.761

0

1

7

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HE = 2.717

VS = 3.678

GS = 4.250

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.635	1.563	1.756
MINIMUM X	:	-1.082	-.900	-.707
MAXIMUM Y	:	1.535	1.297	1.129
MINIMUM Y	:	-2.143	-1.336	-1.089
CENTROID X	:	.523	.341	.148
CENTROID Y	:	-.454	-.216	-.049
POA TO CENTROID in.	:	.692	.404	.156
MIN RADIUS	:	.487	.422	.369
MEAN RADIUS	:	1.314	1.080	.898
MAX RADIUS	:	2.696	2.041	1.804
HORIZONTAL SPREAD	:	2.717	2.463	2.463
VERTICAL SPREAD	:	3.678	2.633	2.219
EXTREME SPREAD	:	4.250	3.221	2.554
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.745

VS = 1.299

GS = 2.747

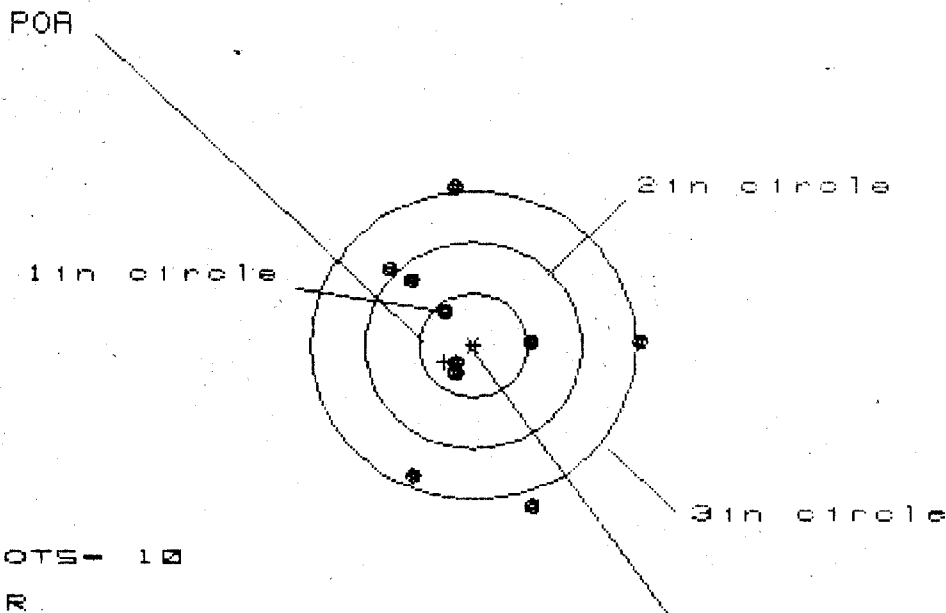
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.587	1.419	.908
MINIMUM X	-1.158	-.981	-.804
MAXIMUM Y	.716	.681	.715
MINIMUM Y	-.583	-.618	-.584
CENTROID X	.155	-.022	-.199
CENTROID Y	-.063	-.028	-.062
POA TO CENTROID in.	.167	.036	.208
MIN RADIUS	.269	.118	.098
MEAN RADIUS	.840	.704	.565
MAX RADIUS	1.618	1.443	.987
HORIZONTAL SPREAD	2.745	2.400	1.712
VERTICAL SPREAD	1.299	1.299	1.299
EXTREME SPREAD	2.747	2.452	1.819
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR.

1in = 3

2in = 5

3in = 7

HS = 2.320

VS = 3.075

GS = 3.151

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.572	1.635	.774
MINIMUM X	:	-.748	-.685	-.481
MAXIMUM Y	:	1.502	1.328	1.315
MINIMUM Y	:	-1.573	-1.455	-1.468
CENTROID X	:	.266	.203	-.001
CENTROID Y	:	.162	.336	.349
POA TO CENTROID in.	:	.311	.393	.350
MIN RADIUS	:	.225	.248	.136
MEAN RADIUS	:	.950	.855	.726
MAX RADIUS	:	1.671	1.638	1.502
HORIZONTAL SPREAD	:	2.320	2.320	1.255
VERTICAL SPREAD	:	3.075	2.783	2.783
EXTREME SPREAD	:	3.151	2.820	2.620
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	