

C6649228

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ M24

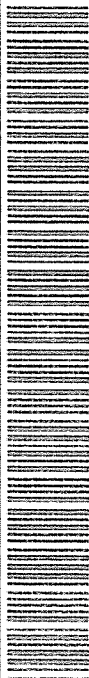
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

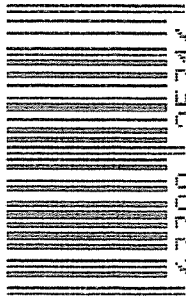
SERIAL NO.
C6649228

ORDER NO.
5716



5716 C6649228

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649228

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GS.
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	15
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	AL

op. #	BARBER M24 0066699	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/4/91	WJ
	G) Safety Off Force	4	4	4			9/4/91	WJ
	H) Trigger Pull Test & Retainability						9/4/91	WJ
	I) Firing Pin Indent	.020	.021	.021			9/4/91	WJ
	J) Assemble Stock						9/4/91	RW
	K) Assemble Swivel Studs						9-10-91	AC
	L) Attach Front and Rear Sight Assemblies						9/4/91	RW
	M) Iron Sight Alignment						9/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	RW
	O) Attach Scope to Rifle						9/4/91	RW
	P) Detach & Attach Scope 20 Times						9/4/91	RW
640	Gallery Target & Test						9-5-91	DH
	A) Time						9-5-91	DH
	B) Malfunctions						9-5-91	DH
	C) Pierced Primers						9-5-91	DH
	D) Optical Clarity of Scope						9-5-91	DH
645	Inspect for Live Ammo						9-5-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	2.71	2.63	2.57	2.47	2.47	9-6-91	WJ
	C) Function						9-10-91	AC
660	Pack						9-7-91	DH

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

SERIAL NO 26649228DATE 9-4-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.52	2.48	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.47	2.44	2.63	
PULL #3	2.35	2.42	2.50	2.52	
PULL #4	2.37	2.48	2.43	2.47	
PULL #5	2.34	2.43	2.44	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.40		
PULL #2	3.50	3.42		
PULL #3	3.53	3.44		
PULL #4	3.50	3.60		
PULL #5	3.56	3.53		
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	4.25		4.53
PULL #2	4.32	4.30		4.43
PULL #3	4.28	4.21		4.35
PULL #4	4.44	4.26		4.37
PULL #5	4.44	4.51		4.40
TOTAL				
AVG.				

M24 0066701
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649228
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.175824
1 TO	2	.210535
1 TO	3	.593001
1 TO	4	.26466
1 TO	5	.467372

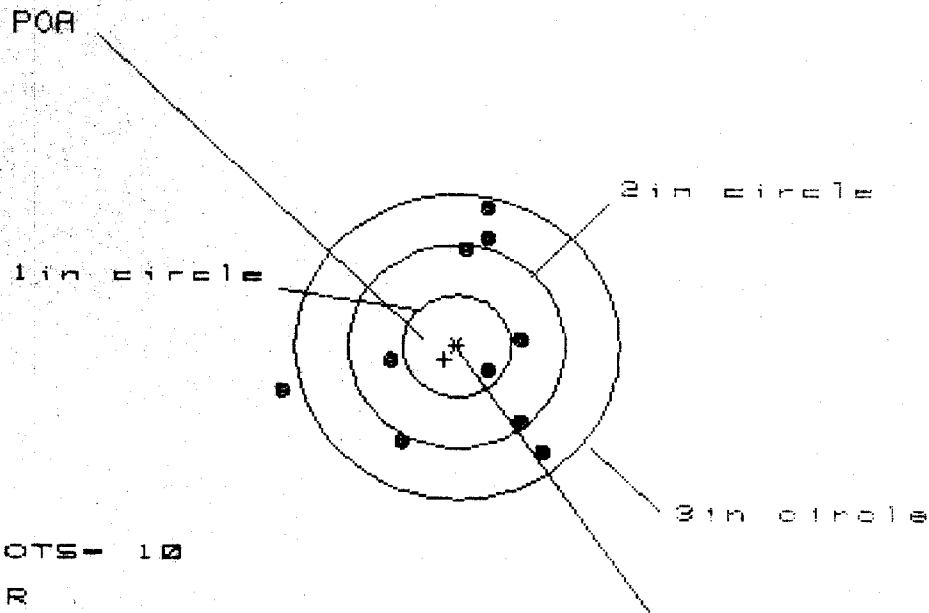
37 <----POB

COORDINATE FOR THIS RIFLE IS: -.1592
COORDINATE FOR THIS RIFLE IS: .0142
AVERAGE POI RADIUS FOR THIS RIFLE IS: .159332
THIS RIFLE IS: .9458

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

CENTROID *

HS = 2.402

VS = 2.343

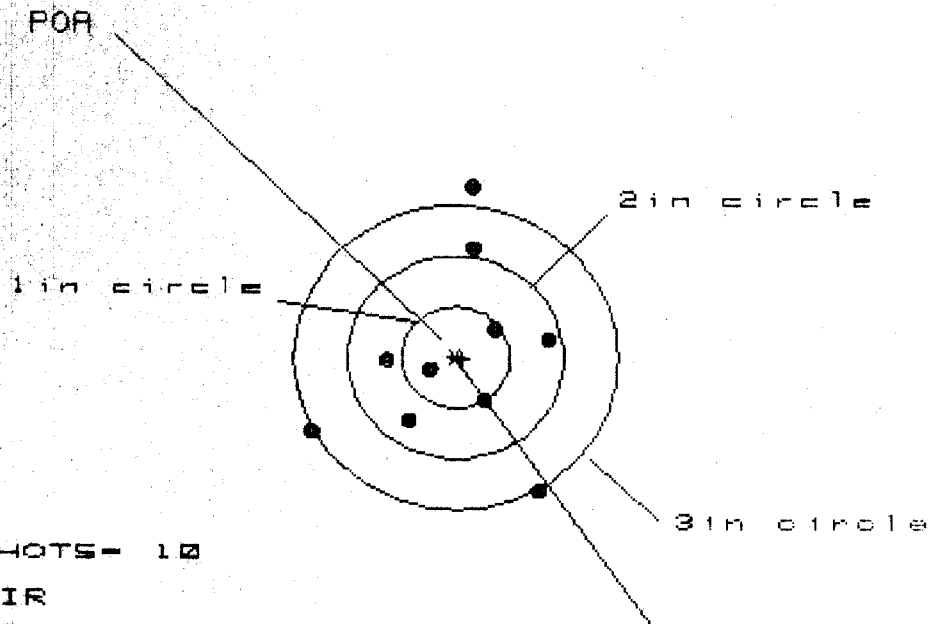
GS = 2.598

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.755	.573	.586
MINIMUM X	:	-1.647	-.830	-.817
MAXIMUM Y	:	1.334	1.289	1.168
MINIMUM Y	:	-1.009	-1.054	-.893
CENTROID X	:	.115	.297	.284
CENTROID Y	:	.133	.178	.017
POA TO CENTROID in.	:	.176	.347	.285
MIN RADIUS	:	.368	.279	.162
MEAN RADIUS	:	1.002	.896	.823
MAX RADIUS	:	1.695	1.293	1.179
HORIZONTAL SPREAD	:	2.402	1.403	1.403
VERTICAL SPREAD	:	2.343	2.343	2.061
EXTREME SPREAD	:	2.598	2.444	2.199
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.148

VS = 3.061

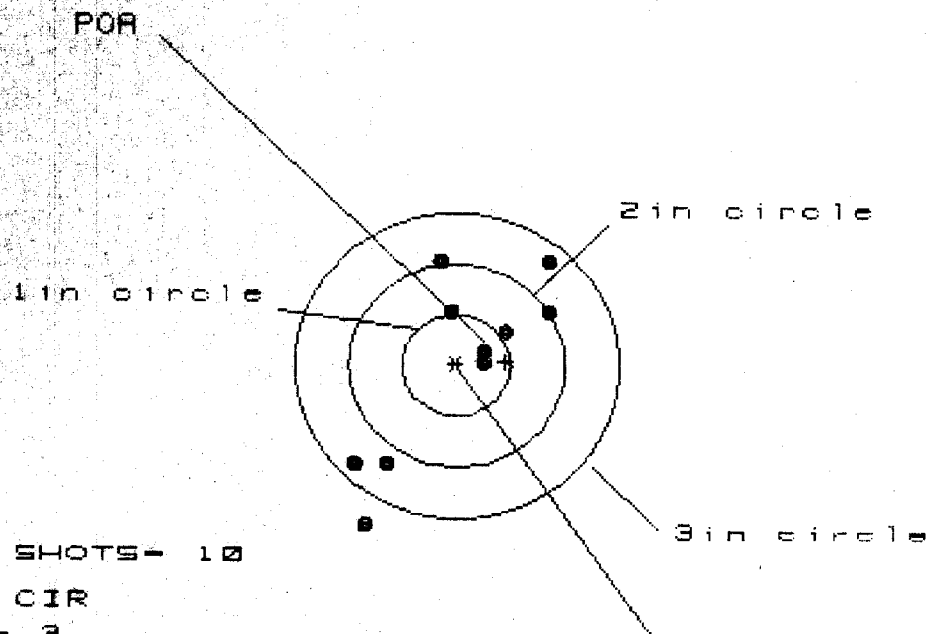
GS = 3.130

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.856	.870	.971
MINIMUM X	-1.292	-1.278	-1.178
MAXIMUM Y	1.728	1.270	1.127
MINIMUM Y	-1.333	-1.141	-.689
CENTROID X	-.062	-.076	-.176
CENTROID Y	.019	-.173	-.030
POA TO CENTROID in.	.065	.189	.179
MIN RADIUS	.241	.230	.116
MEAN RADIUS	.926	.819	.732
MAX RADIUS	1.733	1.394	1.364
HORIZONTAL SPREAD	2.148	2.148	2.148
VERTICAL SPREAD	3.061	2.411	1.816
EXTREME SPREAD	3.130	2.488	2.334
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

5 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.757

VS= 2.564

GS= 3.084

CENTROID #

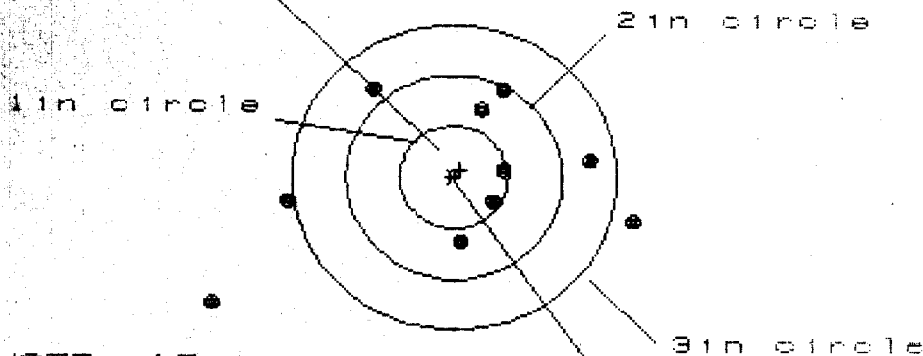
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.846	.749	.623
MINIMUM X	:	-.911	-1.008	-.898
MAXIMUM Y	:	.995	.821	.674
MINIMUM Y	:	-1.569	-1.169	-1.252
CENTROID X	:	-.454	-.357	-.231
CENTROID Y	:	-.034	.140	.286
POA TO CENTROID in.	:	.455	.384	.368
MIN RADIUS	:	.277	.127	.157
MEAN RADIUS	:	.916	.746	.600
MAX RADIUS	:	1.793	1.544	1.540
HORIZONTAL SPREAD	:	1.757	1.757	1.521
VERTICAL SPREAD	:	2.564	1.990	1.926
EXTREME SPREAD	:	3.084	2.655	2.454
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 4

POA



* OF SHOTS - 10

* IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.901

VS = 2.052

GS = 3.977

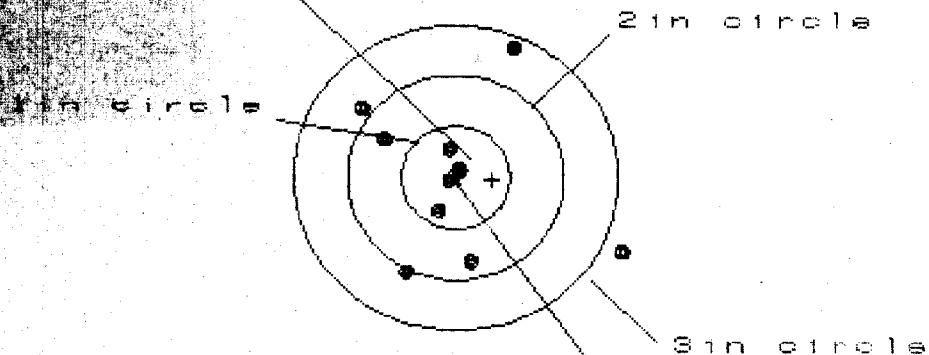
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.669	1.421	1.188
MINIMUM X	:	-2.232	-1.754	-1.576
MAXIMUM Y	:	.867	.735	.667
MINIMUM Y	:	-1.185	-1.786	-1.854
CENTROID X	:	-.056	.192	.014
CENTROID Y	:	-.069	.063	.131
POA TO CENTROID in.	:	.089	.202	.131
MIN RADIUS	:	.431	.214	.404
MEAN RADIUS	:	1.141	.915	.862
MAX RADIUS	:	2.527	1.784	1.625
HORIZONTAL SPREAD	:	3.901	3.175	2.764
VERTICAL SPREAD	:	2.052	1.521	1.521
EXTREME SPREAD	:	3.977	3.182	2.792
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

FILE: PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 2.330

VS = 2.162

GS = 2.685

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	.658	.382
MINIMUM X	:	-.831	-.665	-.582
MAXIMUM Y	:	1.285	1.209	.723
MINIMUM Y	:	-.877	-.953	-.802
CENTROID X	:	-.339	-.505	-.588
CENTROID Y	:	.022	.098	-.053
POA TO CENTROID in.	:	.340	.515	.590
MIN RADIUS	:	.085	.181	.195
MEAN RADIUS	:	.744	.640	.546
MAX RADIUS	:	1.648	1.376	.928
HORIZONTAL SPREAD	:	2.330	1.323	.964
VERTICAL SPREAD	:	2.162	2.162	1.525
EXTREME SPREAD	:	2.685	2.373	1.717
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		