

C6649235

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
 MODEL 700™ M24

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

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

SERIAL NO.
 C6649235

ORDER NO.
 5716

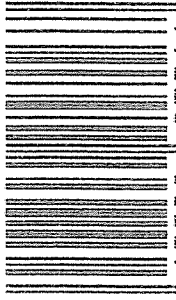
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649235

LJPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649235

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	25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LL
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	JA
	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		9/5/91	JH

op. #	BARBER M24 0066766	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/5/91	GU
	G) Safety Off Force	3	3	3			9/5/91	GU
	H) Trigger Pull Test & Retainability						9/5/91	GU
	I) Firing Pin Indent	.0215	.020	.0205			9/5/91	GU
	J) Assemble Stock						9/6/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/6/91	RW
	M) Iron Sight Alignment						9/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/91	RW
	O) Attach Scope to Rifle						9/6/91	RW
	P) Detach & Attach Scope 20 Times						9/6/91	RW
640	Gallery Target & Test						9-9-91	AC
	A) Time						9-9-91	AC
	B) Malfunctions						9-9-91	AC
	C) Pierced Primers						9-9-91	AC
	D) Optical Clarity of Scope						9-9-91	AC
645	Inspect for Live Ammo						9-9-91	AC
655	Final Inspection A) Headspace						9-10-91	DH
	B) Trigger Pull	264	249	244	267	274	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

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

SERIAL NO. C6649235DATE 9-5-91TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.67	2.55	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.57	2.52	2.49	
PULL #3	2.52	2.62	2.44	2.44	
PULL #4	2.55	2.52	2.50	2.67	
PULL #5	2.57	2.34	2.50	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.29		
PULL #2	3.32	3.39		
PULL #3	3.31	3.34		
PULL #4	3.37	3.40		
PULL #5	3.35	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.37		4.40
PULL #2	4.22	4.36		4.35
PULL #3	4.20	4.35		4.41
PULL #4	4.22	4.41		4.37
PULL #5	4.20	4.31		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649235
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.371953
1 TO	2	.438617
1 TO	3	.648991
1 TO	4	.456232
1 TO	5	.279485

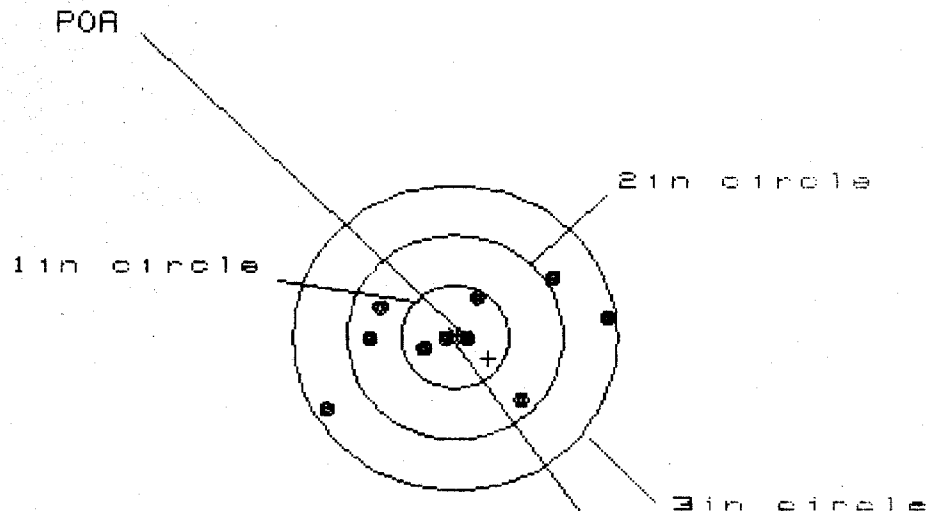
15.3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0516
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .20868
THE AVERAGE Z-COORDINATE FOR THIS RIFLE IS: .9322

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649235

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.685

VS = 1.294

GS = 2.825

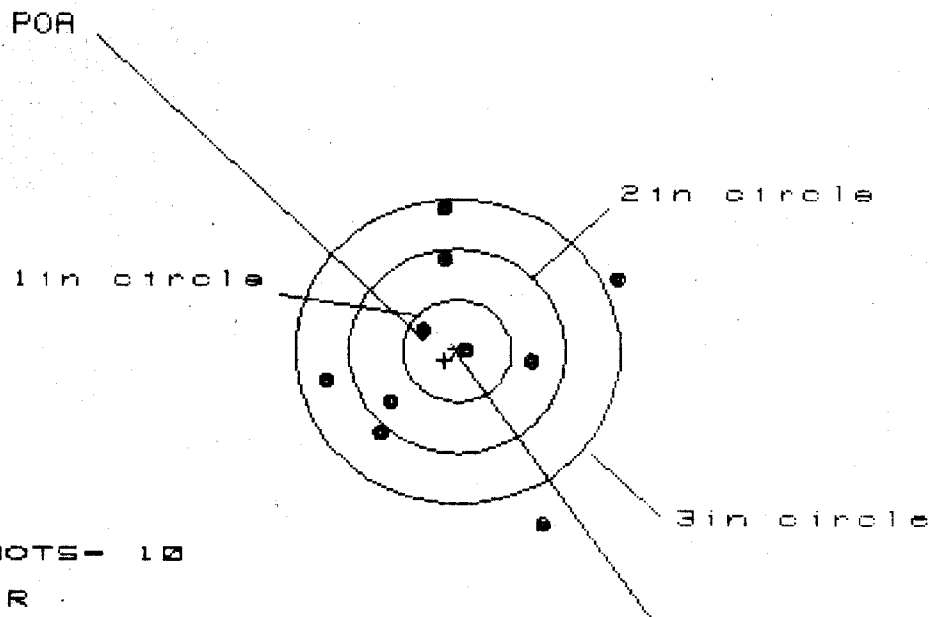
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.050	.916
MINIMUM X	:	-1.233	-1.071	-.809
MAXIMUM Y	:	.615	.637	.555
MINIMUM Y	:	-.679	-.657	-.695
CENTROID X	:	-.307	-.469	-.335
CENTROID Y	:	.210	.188	.270
POA TO CENTROID in.	:	.372	.505	.430
MIN RADIUS	:	.075	.091	.097
MEAN RADIUS	:	.736	.647	.565
MAX RADIUS	:	1.466	1.257	1.071
HORIZONTAL SPREAD	:	2.685	2.121	1.725
VERTICAL SPREAD	:	1.294	1.294	1.250
EXTREME SPREAD	:	2.825	2.485	1.831
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649235

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.727

VS= 3.076

GS= 3.184

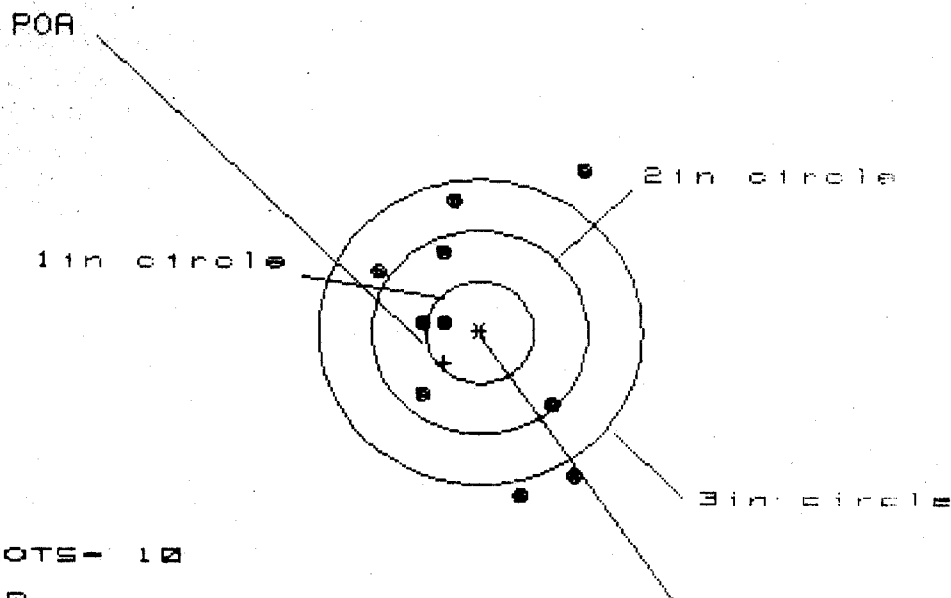
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.515	1.598	.983
MINIMUM X	:	-1.212	-1.129	-.929
MAXIMUM Y	:	1.430	1.248	1.318
MINIMUM Y	:	-1.646	-.951	-.881
CENTROID X	:	.116	.033	-.167
CENTROID Y	:	.094	.276	.206
POA TO CENTROID in.	:	.149	.278	.265
MIN RADIUS	:	.083	.249	.126
MEAN RADIUS	:	1.014	.918	.796
MAX RADIUS	:	1.809	1.696	1.335
HORIZONTAL SPREAD	:	2.727	2.727	1.912
VERTICAL SPREAD	:	3.076	2.199	2.199
EXTREME SPREAD	:	3.184	2.923	2.285
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 1.905

VS = 3.165

GS = 3.236

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.990	1.044
MINIMUM X	:	-.907	-.796	-.742
MAXIMUM Y	:	1.550	1.443	1.263
MINIMUM Y	:	-1.615	-1.443	-1.373
CENTROID X	:	.335	.224	.170
CENTROID Y	:	.305	.133	.313
POA TO CENTROID in.	:	.453	.261	.356
MIN RADIUS	:	.314	.342	.167
MEAN RADIUS	:	1.101	.998	.890
MAX RADIUS	:	1.844	1.550	1.725
HORIZONTAL SPREAD	:	1.905	1.786	1.786
VERTICAL SPREAD	:	3.165	2.886	2.636
EXTREME SPREAD	:	3.236	2.937	2.857
NUMBER IN ONE INCH CIRCLE	=	1	5	7
NUMBER IN TWO INCH CIRCLE	=	5	5	7
NUMBER IN THREE INCH CIRCLE	=	7	5	7

9 Sep 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.332

VS = 1.890

GS = 2.446

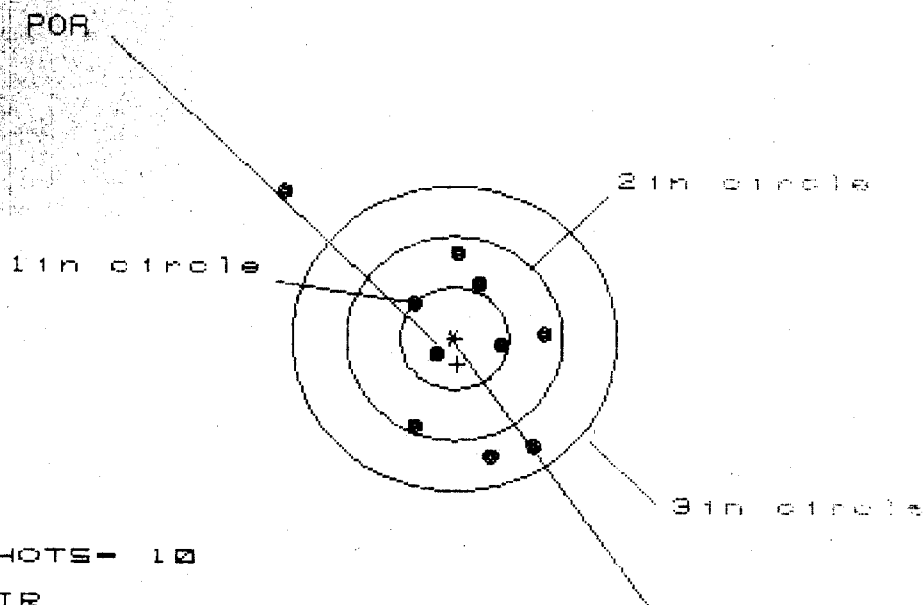
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.787	.615	.558
MINIMUM X	:	-1.545	-1.102	-1.159
MAXIMUM Y	:	1.023	.973	.972
MINIMUM Y	:	-.867	-.917	-.795
CENTROID X	:	.145	.317	.374
CENTROID Y	:	.148	.198	.077
POA TO CENTROID in.	:	.207	.374	.382
MIN RADIUS	:	.336	.311	.187
MEAN RADIUS	:	.924	.818	.757
MAX RADIUS	:	1.610	1.216	1.224
HORIZONTAL SPREAD	:	2.332	1.717	1.717
VERTICAL SPREAD	:	1.890	1.890	1.767
EXTREME SPREAD	:	2.446	2.004	1.967
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

[REDACTED]

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.483

VS= 2.557

GS= 3.391

CENTROID *

PATTERN #		10	9	8
SHOTS - BEST OF		10	9	8
MAXIMUM		.875	.696	.764
MINIMUM		-1.608	-.597	-.529
MAXIMUM		1.427	.966	.856
MINIMUM		-1.130	-.971	-1.081
CENTROID		-.031	.148	.080
CENTROID		.254	.095	.205
POR TO CENTROID		.256	.176	.220
MIN WAD		.238	.251	.287
NEAR RADIUS		.886	.735	.679
MAX RADIUS		2.150	1.033	1.101
HORIZONTAL SPREAD		2.483	1.293	1.293
VERTICAL SPREAD		2.557	1.937	1.937
EXTREME SPREAD		3.391	1.979	1.962
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		