

C6649249

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.

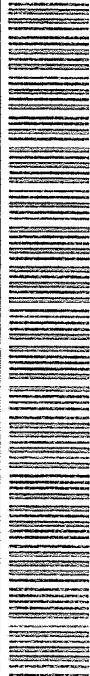
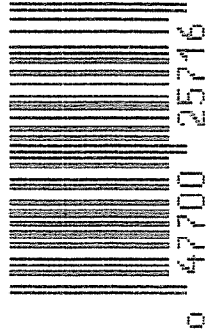
SERIAL NO.
 06649249

ORDER NO.
 5716

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

20

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649249

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action	JUL 2 2 1991	9 1	Y8
	Magnaflux Bolt	JUL 2 2 1991	9 1	Y8
615	Rollmark Caliber	JUL 2 2 1991	9 1	Y8
617	Drill and Tap Sight Holes	JUL 2 2 1991	9 1	FB
618	Polish Barrel	7/28/91	9 1	WB
620	Apply Coatings (Barrel Action)	8/2/91	9 1	Y8
	Apply Coating (Bolt)	8/2/91	9 1	Y8
625	Final Assembly A) Clean inside of Bolt Assembly	8/9/91	9 1	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head	8/9/91	9 1	RW
	C) Inspect Ejector Hole for Chamfer	8/9/91	9 1	RW
	D) Oil Firing Pin Ass'y	8/9/91	9 1	RW
	E) Adjust Trigger Pull to Min Setting and Stake	8/20/91	9 1	Y8

op. #	NAME BARBER - M24 0066929	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/20/91	RU
	G) Safety Off Force	3	3	3			8/20/91	RU
	H) Trigger Pull Test & Retainability						8/20/91	RU
	I) Firing Pin Indent	.021	.0215	.0215			8/20/91	RU
	J) Assemble Stock						8/20/91	RU
	K) Assemble Swivel Studs						8-21-91	AC
	L) Attach Front and Rear Sight Assemblies						8/20/91	RU
	M) Iron Sight Alignment						8/20/91	RU
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	RU
	O) Attach Scope to Rifle						8/20/91	RU
	P) Detach & Attach Scope 20 Times						8/20/91	RU
640	Gallery Target & Test						8-20-91	AC
	A) Time						8-20-91	AC
	B) Malfunctions						8-20-91	AC
	C) Pierced Primers						8-20-91	AC
	D) Optical Clarity of Scope						8-20-91	AC
645	Inspect for Live Ammo						8-20-91	AC
655	Final Inspection							
	A) Headspace						8-21-91	AC
	B) Trigger Pull	248	240	247	247	255	8-20-91	DH
	C) Function						8-21-91	AC
660	Pack						9-8-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6649279DATE 8/20/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.47	2.48	2.48	MIN. SETTING
PULL #2	2.23	2.42	2.50	2.40	NO AVG. OF 5
PULL #3	2.38	2.38	2.56	2.47	READINGS ACCEPT-
PULL #4	2.44	2.42	2.40	2.47	ABLE LESS THAN 2#
PULL #5	2.50	2.49	2.44	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.58		
PULL #2	3.60	3.55		
PULL #3	3.55	3.60		
PULL #4	3.53	3.61		
PULL #5	3.50	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.27		4.26
PULL #2	4.23	4.27		4.37
PULL #3	4.42	4.34		4.44
PULL #4	4.31	4.28		4.40
PULL #5	4.29	4.21		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649249
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.274876
1 TO	2	.413001
1 TO	3	.101514
1 TO	4	.233174
1 TO	5	.170602

2 <----POA

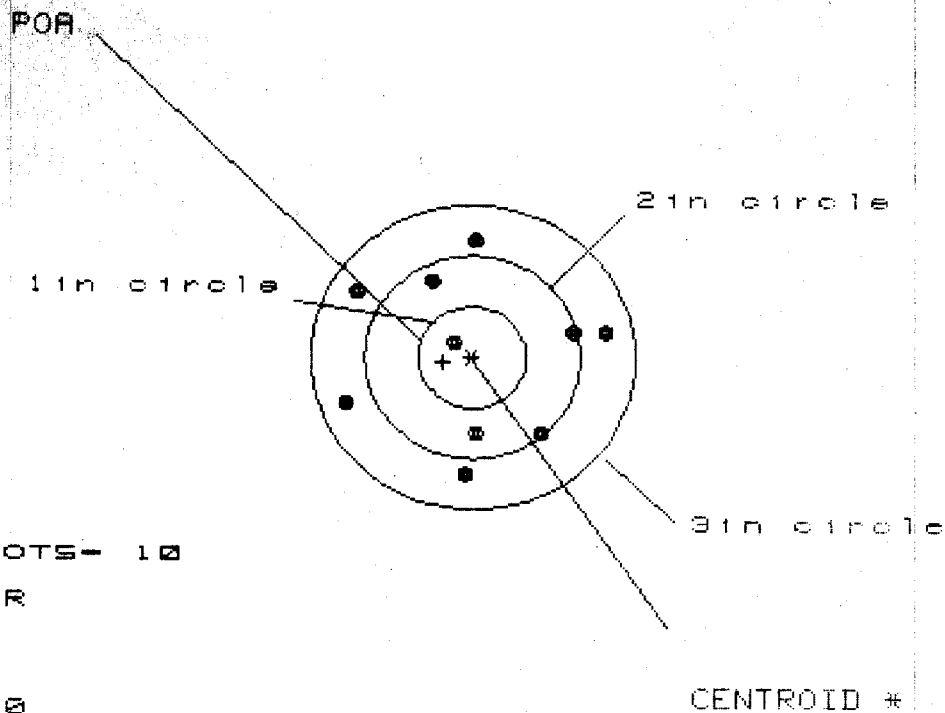
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .207
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0824
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .222798

THE ARE FOR THIS RIFLE IS: .9496

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649249

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.394

VS= 2.229

GS= 2.497

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.216	1.093	.931
MINIMUM X	-1.179	-1.301	-.682
MAXIMUM Y	1.110	1.181	1.132
MINIMUM Y	-1.119	-1.048	-1.097
CENTROID X	.271	.394	.556
CENTROID Y	.046	-.025	.024
POA TO CENTROID in.	.275	.395	.557
MIN RADIUS	.215	.349	.453
MEAN RADIUS	.972	.935	.872
MAX RADIUS	1.274	1.359	1.152
HORIZONTAL SPREAD	2.394	2.394	1.613
VERTICAL SPREAD	2.229	2.229	2.229
EXTREME SPREAD	2.497	2.497	2.232
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 2.442

VS = 3.464

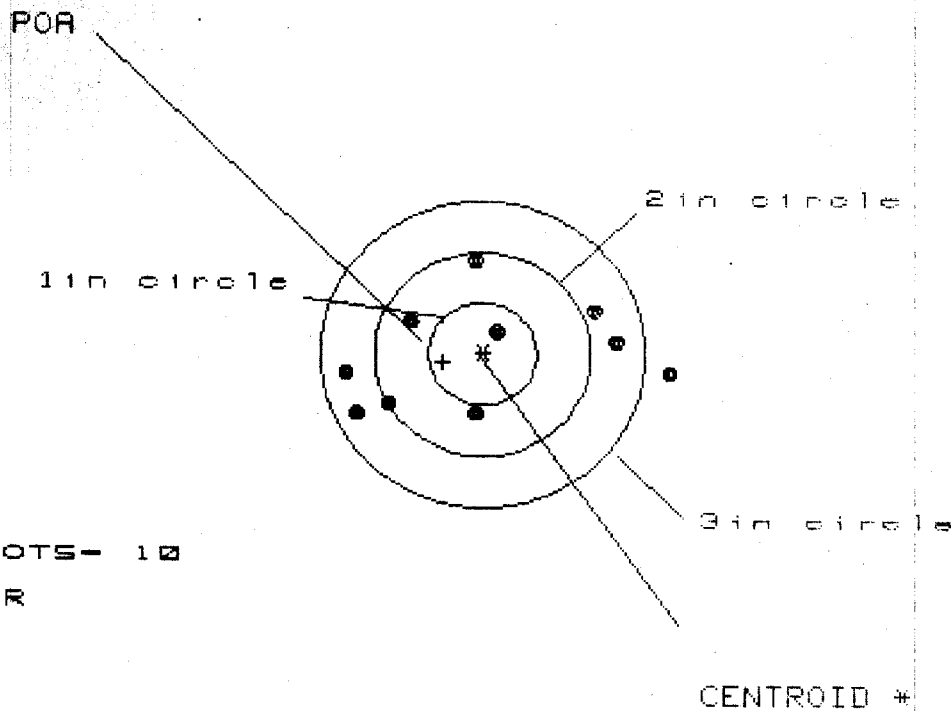
GS = 3.488

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.285	1.141
MINIMUM X	-1.082	-1.157	-1.024
MAXIMUM Y	1.559	1.348	.954
MINIMUM Y	-1.905	-1.277	-1.109
CENTROID X	.138	.213	.357
CENTROID Y	-.345	-.134	-.302
POA TO CENTROID in.	.372	.251	.468
MIN RADIUS	.128	.101	.142
MEAN RADIUS	1.060	.936	.799
MAX RADIUS	2.020	1.776	1.509
HORIZONTAL SPREAD	2.442	2.442	2.165
VERTICAL SPREAD	3.464	2.625	2.063
EXTREME SPREAD	3.488	2.941	2.941
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649249

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 3.001

VS= 1.501

GS= 3.001

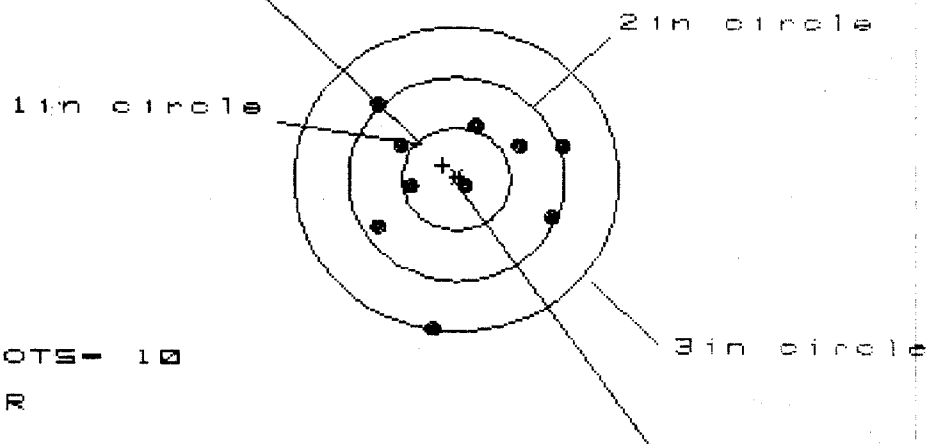
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.756	1.420	1.294
MINIMUM X	-1.245	-1.050	-1.176
MAXIMUM Y	.892	.876	.806
MINIMUM Y	-.609	-.625	-.695
CENTROID X	.367	.172	.298
CENTROID Y	.079	.095	.165
POA TO CENTROID in.	.376	.197	.340
MIN RADIUS	.270	.409	.265
MEAN RADIUS	1.020	.921	.882
MAX RADIUS	1.761	1.423	1.294
HORIZONTAL SPREAD	3.001	2.470	2.470
VERTICAL SPREAD	1.501	1.501	1.501
EXTREME SPREAD	3.001	2.510	2.485
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

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CENTERFIRE PATTERNS # 4

POR



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in = 10

HS= 1.736

VS= 2.121

GS= 2.176

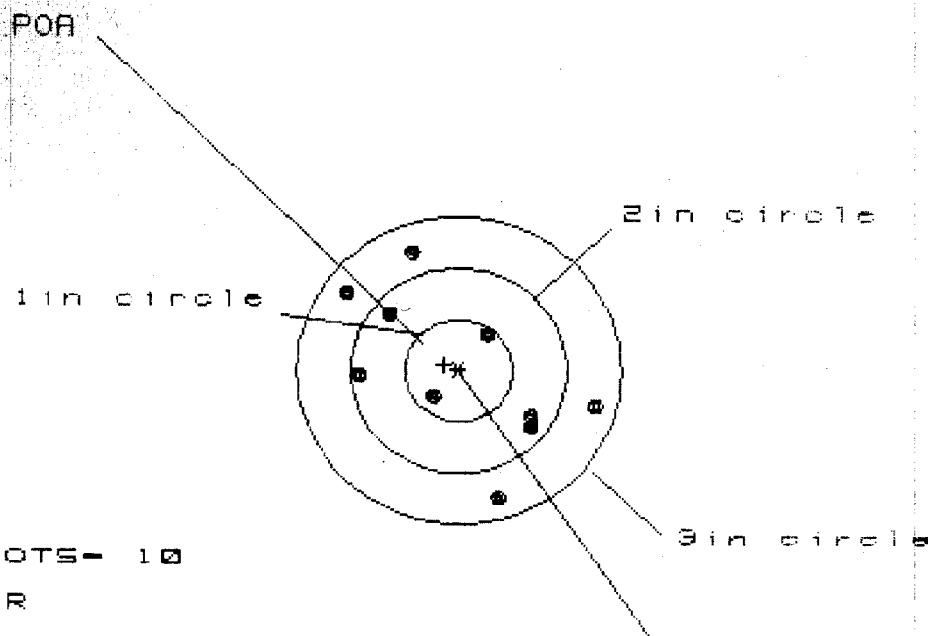
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.006	.975	.925
MINIMUM X	-.730	-.761	-.639
MAXIMUM Y	.704	.547	.570
MINIMUM Y	-1.417	-.597	-.574
CENTROID X	.124	.155	.033
CENTROID Y	-.135	.022	-.001
POR TO CENTROID in.	.184	.156	.033
MIN RADIUS	.136	.233	.287
MEAN RADIUS	.767	.678	.630
MAX RADIUS	1.443	.993	1.043
HORIZONTAL SPREAD	1.736	1.736	1.564
VERTICAL SPREAD	2.121	1.144	1.144
EXTREME SPREAD	2.176	1.905	1.885
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

Aug 1983

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in - 10

HS- 2.356

VS- 2.358

GS- 2.610

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.276	1.156	.734
MINIMUM X	:	-1.080	-1.019	-.874
MAXIMUM Y	:	1.159	1.246	1.214
MINIMUM Y	:	-1.199	-1.112	-1.145
CENTROID X	:	.135	.255	.110
CENTROID Y	:	-.057	-.144	-.111
POA TO CENTROID in.	:	.147	.293	.157
1IN RADIUS	:	.358	.404	.303
MEAN RADIUS	:	.929	.876	.828
MAX RADIUS	:	1.331	1.354	1.273
HORIZONTAL SPREAD	:	2.356	2.175	1.608
VERTICAL SPREAD	:	2.358	2.358	2.358
EXTREME SPREAD	:	2.610	2.489	2.489
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		