

06649258

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington.

Remington[®]


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

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

MODEL 700TM M24

SERIAL NO.
C6649258

ORDER NO.
5716

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

20



5716 C6649258

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649258

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		AL
600	Proof	6 27 9 1		AL
607	Check Headspace	6 27 9 1		AL
610	Dis-assemble Gun	6 27 9 1		AL
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GA
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TH
	Apply Coating (Bolt)			
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		8-5-91	94

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			Aug 5-91	AC
	G) Safety Off Force	4	4	4			Aug 5-91	AC
	H) Trigger Pull Test & Retainability						8-5-91	JL
	I) Firing Pin Indent	.020	.020	.020			Aug 5-91	AC
	J) Assemble Stock						8/6/91	RW
	K) Assemble Swivel Studs						8-7-91	JL
	L) Attach Front and Rear Sight Assemblies						8/6/91	RW
	M) Iron Sight Alignment						8/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/91	RW
	O) Attach Scope to Rifle						8/6/91	RW
	P) Detach & Attach Scope 20 Times						8/6/91	RW
640	Gallery Target & Test						8-6-91	AC
	A) Time						"	AC
	B) Malfunctions						"	AC
	C) Pierced Primers						"	AC
	D) Optical Clarity of Scope						"	AC
645	Inspect for Live Ammo						8-6-91	AC
655	Final Inspection							
	A) Headspace						8-7-91	JL
	B) Trigger Pull	2.49	2.48	2.48	2.49	2.59	8-7-91	JL
	C) Function						8-7-91	JL
660	Pack						8-18-91	AC

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6646258
6 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.152977
1 TO	2	.333257
1 TO	3	.0939415
1 TO	4	.118512
1 TO	5	.114634

*2 < ----POA

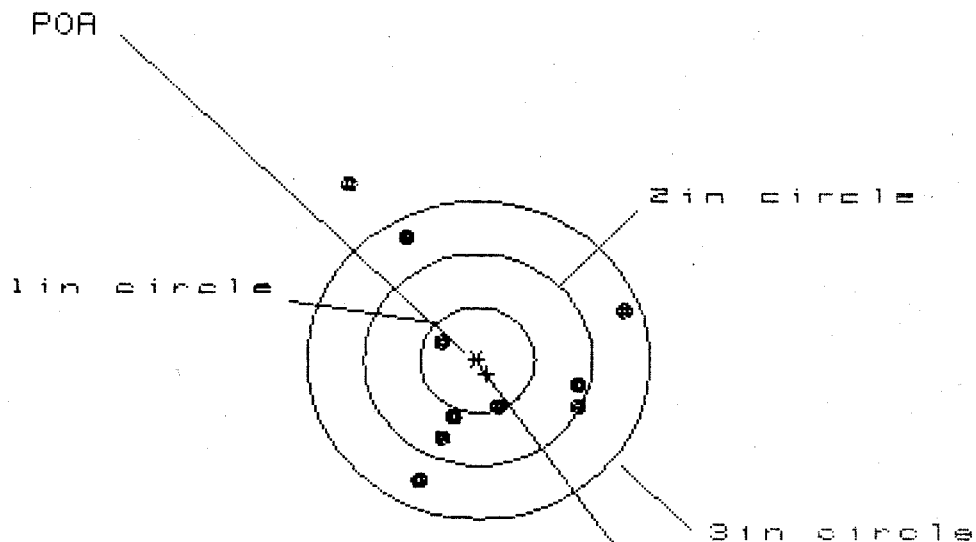
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.021
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0748
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .077692
THE BRK FOR THIS RIFLE IS: .9092

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649258

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS- 2.378

VS- 2.787

GS- 2.904

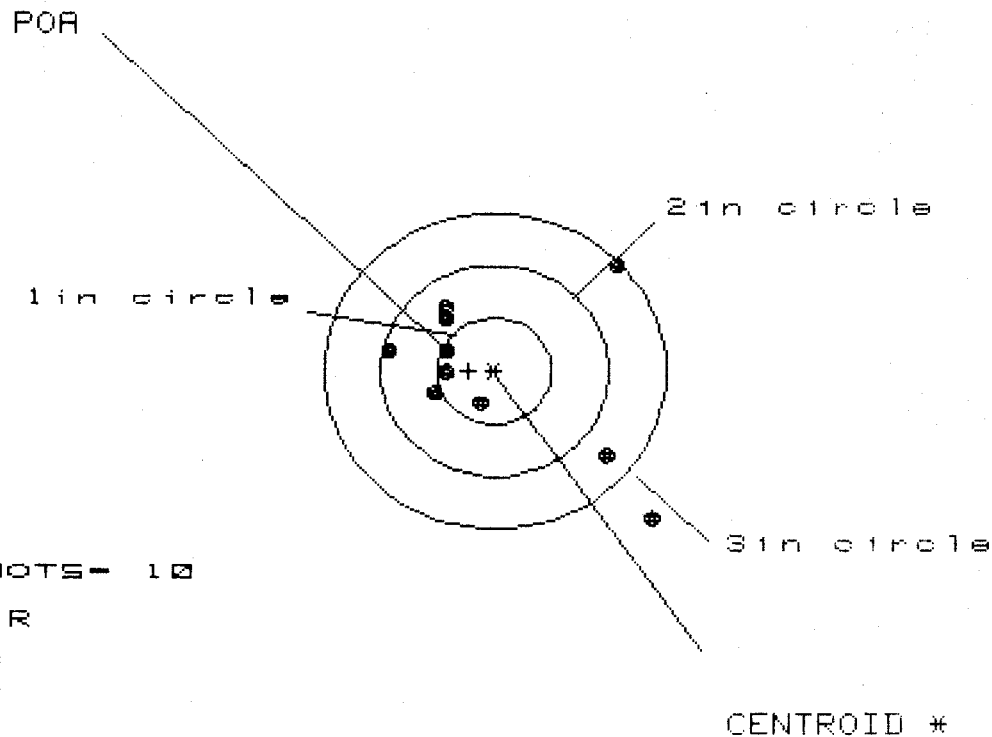
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.263	1.139	.861
MINIMUM X	:	-1.115	-.708	-.565
MAXIMUM Y	:	1.672	1.322	1.402
MINIMUM Y	:	-1.115	-.929	-.849
CENTROID X	:	-.079	.045	-.098
CENTROID Y	:	.131	-.055	-.135
FOR TO CENTROID in.	:	.153	.071	.166
MIN RADIUS	:	.396	.247	.227
MEAN RADIUS	:	.983	.820	.728
MAX RADIUS	:	2.010	1.499	1.512
HORIZONTAL SPREAD	:	2.378	1.847	1.426
VERTICAL SPREAD	:	2.787	2.251	2.251
EXTREME SPREAD	:	2.904	2.356	2.253
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649258

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.294

VS= 2.401

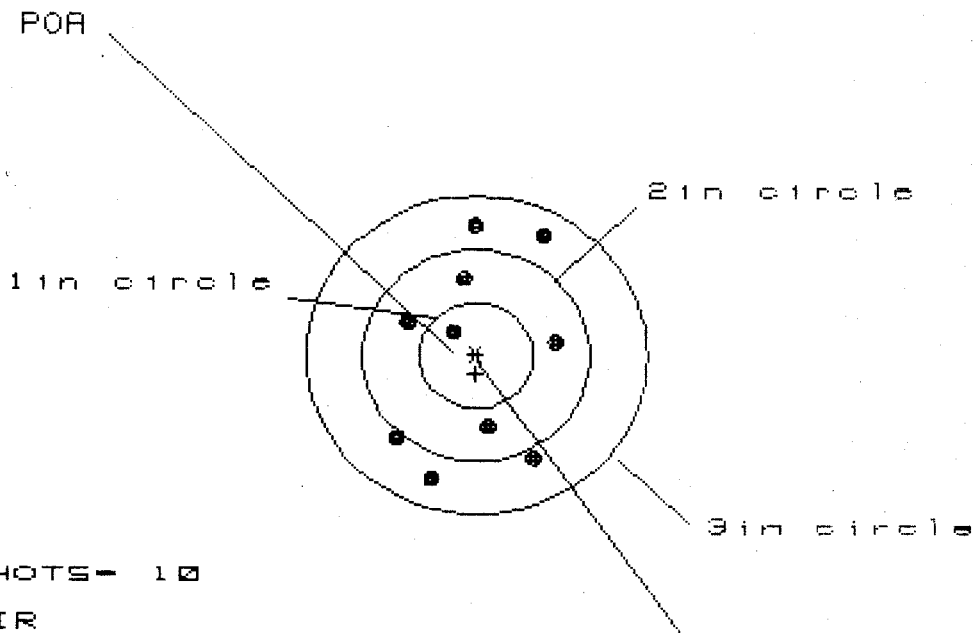
GS= 2.797

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.386	1.197	1.253
MINIMUM X	:	-.908	-.754	-.604
MAXIMUM Y	:	1.044	.893	.575
MINIMUM Y	:	-1.357	-.942	-.831
CENTROID X	:	.227	.073	-.077
CENTROID Y	:	-.001	.150	.039
POR TO CENTROID in.	:	.227	.167	.086
MIN RADIUS	:	.342	.295	.170
MEAN RADIUS	:	.894	.707	.549
MAX RADIUS	:	1.940	1.493	1.503
HORIZONTAL SPREAD	:	2.294	1.951	1.857
VERTICAL SPREAD	:	2.401	1.835	1.406
EXTREME SPREAD	:	2.797	2.125	2.125
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6649258

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS= 1.432

VS= 2.365

GS= 2.467

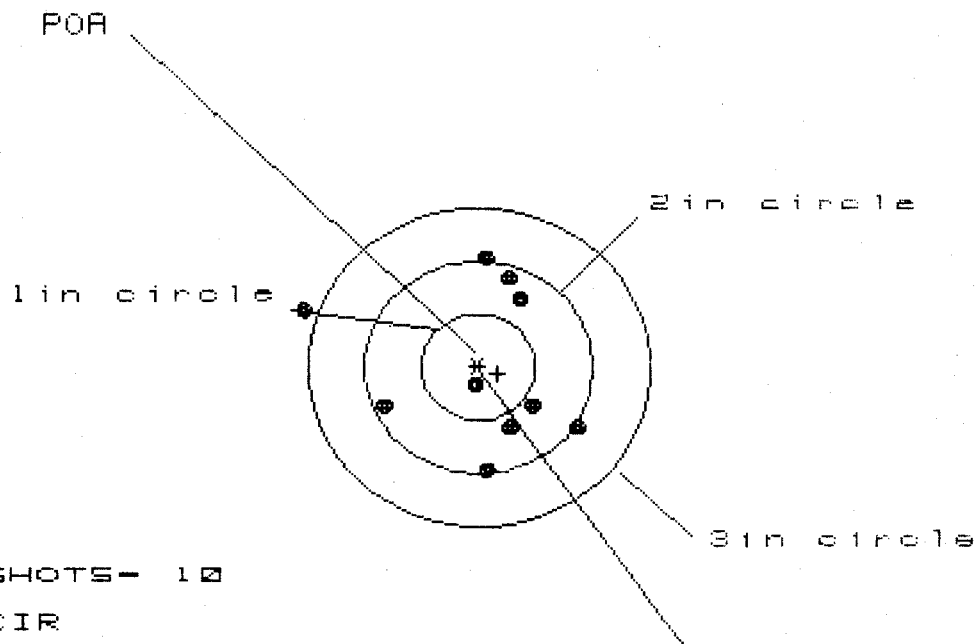
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.739	.803	.765
MINIMUM X	:	-.693	-.629	-.667
MAXIMUM Y	:	1.200	1.324	1.194
MINIMUM Y	:	-1.165	-1.041	-1.022
CENTROID X	:	.006	-.059	-.021
CENTROID Y	:	.171	.047	.177
POA TO CENTROID in.	:	.171	.075	.179
MIN RADIUS	:	.324	.398	.302
MEAN RADIUS	:	.901	.858	.814
MAX RADIUS	:	1.255	1.328	1.195
HORIZONTAL SPREAD	:	1.432	1.432	1.432
VERTICAL SPREAD	:	2.365	2.365	2.216
EXTREME SPREAD	:	2.467	2.399	2.259
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	10	10	10

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649258

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 1

2in - 7

3in = 9

HS- 2.371

VS= 2.005

GS= 2.633

CENTROID *

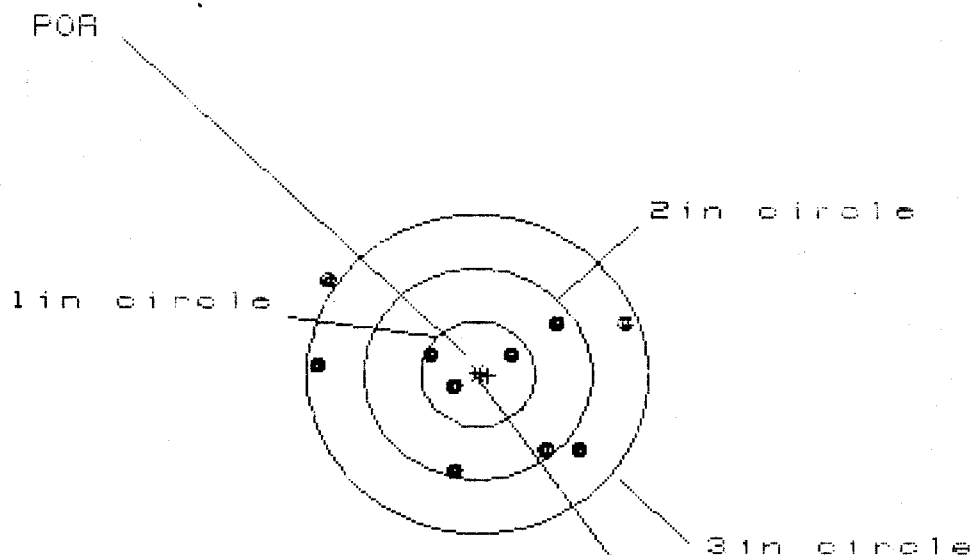
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.876	.710	.344
MINIMUM X	:	-1.495	-.950	-.861
MAXIMUM Y	:	1.030	1.092	1.027
MINIMUM Y	:	-.975	-.913	-.979
CENTROID X	:	-.169	-.003	-.092
CENTROID Y	:	.060	-.002	.063
POA TO CENTROID in.	:	.179	.004	.112
MIN RADIUS	:	.183	.258	.226
MEAN RADIUS	:	.844	.737	.720
MAX RADIUS	:	1.595	1.095	1.027
HORIZONTAL SPREAD	:	2.371	1.660	1.205
VERTICAL SPREAD	:	2.005	2.005	2.005
EXTREME SPREAD	:	2.633	2.005	2.005
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649258

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 6

3 in - 9

HS - 2.673

VS - 1.823

GS - 2.711

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.104	.988
MINIMUM X	:	-1.425	-1.569	-1.761
MAXIMUM Y	:	.891	.624	.653
MINIMUM Y	:	-.932	-.833	-.804
CENTROID X	:	-.090	.054	.250
CENTROID Y	:	.013	-.086	-.115
FOR TO CENTROID in.	:	.091	.102	.275
FOR RADIUS	:	.261	.336	.357
MEAN RADIUS	:	.924	.844	.746
MAX RADIUS	:	1.573	1.586	1.190
HORIZONTAL SPREAD	:	2.673	2.673	1.669
VERTICAL SPREAD	:	1.823	1.457	1.457
EXTREME SPREAD	:	2.711	2.699	2.083
SHOTS IN ONE INCH CIRCLE	=		3	
SHOTS IN TWO INCH CIRCLE	=		6	
SHOTS IN THREE INCH CIRCLE	=		9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649258

DATE 8-5-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.34	2.51	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.35	2.48	2.48	
PULL #3	2.40	2.45	2.44	2.48	
PULL #4	2.39	2.19	2.50	2.49	
PULL #5	2.56	2.50	2.56	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.54		
PULL #2	3.39	3.53		
PULL #3	3.46	3.55		
PULL #4	3.44	3.54		
PULL #5	3.49	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.45		4.49
PULL #2	4.53	4.44		4.47
PULL #3	4.43	4.43		4.43
PULL #4	4.51	4.45		4.52
PULL #5	4.53	4.49		4.48
TOTAL				
AVG.				