

06649271

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remond

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

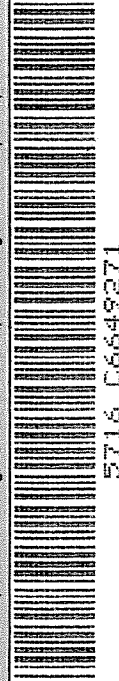
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

MODEL 700™ M24

SERIAL NO.
 C6649271

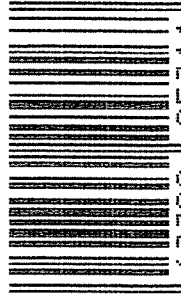
ORDER NO.
 5716

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



5716 C6649271

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649271

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GS.
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	RW
	C) Inspect Ejector Hole for Chamfer		8/5/91	RW
	D) Oil Firing Pin Ass'y		8/5/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-7-91	GF

BARBER - M24 0067170

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-7-91	DH
	G) Safety Off Force	3½	3¼	3			8-7-91	DH
	H) Trigger Pull Test & Retainability						8-7-91	SH
	I) Firing Pin Indent	.020	.021	.022			8-7-91	DH
	J) Assemble Stock						8/15/91	RW
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/15/91	RW
	M) Iron Sight Alignment						8/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/15/91	RW
	O) Attach Scope to Rifle						8/15/91	RW
	P) Detach & Attach Scope 20 Times						8/15/91	RW
640	Gallery Target & Test						8-15-91	DH
	A) Time						8-15-91	DH
	B) Malfunctions						8-15-91	DH
	C) Pierced Primers						8-15-91	DH
	D) Optical Clarity of Scope						8-15-91	DH
645	Inspect for Live Ammo						8-15-91	DH
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	229	226	230	230	232	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-16-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06649271

DATE 8-7-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.49	2.52	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.37	2.39	2.24	
PULL #3	2.29	2.42	2.50	2.30	
PULL #4	2.39	2.39	2.51	2.30	
PULL #5	2.55	2.50	2.38	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.28		
PULL #2	3.30	3.21		
PULL #3	3.18	3.19		
PULL #4	3.28	3.21		
PULL #5	3.25	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.44		4.27
PULL #2	4.40	4.45		4.15
PULL #3	4.36	4.50		4.41
PULL #4	4.41	4.48		4.33
PULL #5	4.32	4.32		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C5649271
 23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.323883
1 TO	2	.118619
1 TO	3	.157487
1 TO	4	.292015
1 TO	5	.510589

12
 1 X-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .11754
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .083
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194047
 THE AMR FOR THIS RIFLE IS: .921

23 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8645271

CENTERFIRE PATTERNS

1

POA

2 in circle

1 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.987

VS = 2.886

CS = 3.853

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.348

1.157

1.234

MINIMUM X

-1.647

-1.074

-.929

MAXIMUM Y

.963

1.018

1.109

MINIMUM Y

-1.123

-1.068

-.977

CENTROID X

.232

.415

.276

CENTROID Y

.236

.171

.088

POA TO CENTROID in.

.324

.449

.281

MIN RADIUS

.278

.284

.135

MEAN RADIUS

1.086

.930

.848

MAX RADIUS

1.718

1.371

1.261

HORIZONTAL SPREAD

2.987

2.231

2.163

VERTICAL SPREAD

2.886

2.886

2.886

EXTREME SPREAD

3.853

2.369

2.179

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8E49271

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.725

VS = 1.978

GS = 2.725

CENTROID #

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 =

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649271

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.000

VS = 2.003

GS = 3.332

CENTROID +

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.068	.747	.635
MINIMUM X	-1.012	-.893	-.425
MAXIMUM Y	1.322	1.180	.886
MINIMUM Y	-1.280	-1.295	-1.147
CENTROID X	-.060	-.179	-.060
CENTROID Y	.229	.372	.224
POA TO CENTROID in.	.237	.413	.234
MIN RADIUS	.076	.261	.077
MEAN RADIUS	.877	.783	.691
MAX RADIUS	1.668	1.480	1.153
HORIZONTAL SPREAD	2.080	1.640	1.061
VERTICAL SPREAD	2.603	2.475	2.093
EXTREME SPREAD	3.332	2.715	2.037
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

30 Aug 1997

FILE:/PATTERNING/CENTERFIRE_PATT/08645271

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.732

VS = 2.857

GS = 2.797

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	: 1.363	1.350	.677
MINIMUM X	: -1.369	-1.382	-1.213
MAXIMUM Y	: .909	.714	.611
MINIMUM Y	: -1.748	-.825	-.484
CENTROID X	: .192	.205	.036
CENTROID Y	: -1.283	-1.088	-1.015
POA TO CENTROID in.	: .341	.223	.033
MIN RADIUS	: .187	.238	.164
MEAN RADIUS	: .872	.738	.621
MAX RADIUS	: 1.752	1.582	1.256
HORIZONTAL SPREAD	: 2.732	2.732	1.890
VERTICAL SPREAD	: 2.657	1.539	1.895
EXTREME SPREAD	: 2.797	2.797	2.057
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	