

C6649277

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®
REG. U.S. PAT. & TM. OFF.

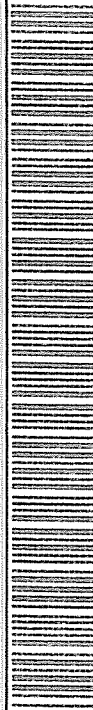
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
06649277

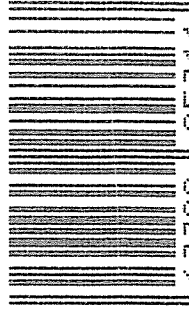
ORDER NO.
5716

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



5716 06649277

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649277

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		GS
	Magnaflux Bolt	JUL 2 2 1991		GS
615	Rollmark Caliber	JUL 2 2 1991		GS
617	Drill and Tap Sight Holes	JUL 2 2 1991		LB
618	Polish Barrel	7/22/91		WB
620	Apply Coatings (Barrel Action)		8-2-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-16-91	DH

op. #	BARBER - M24 0067236 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-16-91	DH
	G) Safety Off Force	2 1/2	2	2			8-16-91	DH
	H) Trigger Pull Test & Retainability						8-16-91	DH
	I) Firing Pin Indent	0.21	0.22	0.21			8-16-91	D/H
	J) Assemble Stock						8-16-91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-16-91	RW
	M) Iron Sight Alignment						8-16-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-16-91	RW
	O) Attach Scope to Rifle						8-16-91	RW
	P) Detach & Attach Scope 20 Times						8-16-91	RW
640	Gallery Target & Test						8-16-91	AC
	A) Time						8-16-91	AC
	B) Malfunctions						8-16-91	AC
	C) Pierced Primers						8-16-91	AC
	D) Optical Clarity of Scope						8-16-91	AC
645	Inspect for Live Ammo						8-16-91	AC
655	Final Inspection						8-17-91	D/H
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	2.60	2.56	2.37	2.45	2.55	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						8-17-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C66 49277DATE 8-16-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.51	2.60	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.49	2.59	2.56	
PULL #3	2.36	2.60	2.48	2.37	
PULL #4	2.39	2.62	2.50	2.45	
PULL #5	2.56	2.41	2.52	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	2.92		
PULL #2	3.24	3.16		
PULL #3	3.30	3.06		
PULL #4	3.15	2.99		
PULL #5	3.11	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.19		4.12
PULL #2	4.23	4.14		4.23
PULL #3	4.26	4.09		4.24
PULL #4	4.28	4.14		4.21
PULL #5	4.28	4.12		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649277
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.170176
1 TO	2	.398062
1 TO	3	.243977
1 TO	4	.435412
1 TO	5	.384387

$\frac{3+1}{2+4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0596
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.083
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102162
THE AMP FOR THIS RIFLE IS: .9948

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649277

CENTERFIRE PATTERNS

1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 10

HE= 2.471

VS= 2.428

GS= 2.841

PATTERN



SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.399

1.140

1.058

MINIMUM X

-1.072

-.917

-.999

MAXIMUM Y

1.174

1.233

1.084

MINIMUM Y

-1.254

-1.195

-1.093

CENTROID X

.156

.001

.083

CENTROID Y

.068

.009

.158

POR TO CENTROID in.

.170

.009

.178

MIN RADIUS

.134

.289

.155

MEAN RADIUS

.960

.966

.614

MAX RADIUS

1.497

1.363

1.132

HORIZONTAL SPREAD

2.471

2.057

2.057

VERTICAL SPREAD

2.428

2.428

2.177

EXTREME SPREAD

2.841

2.478

2.177

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

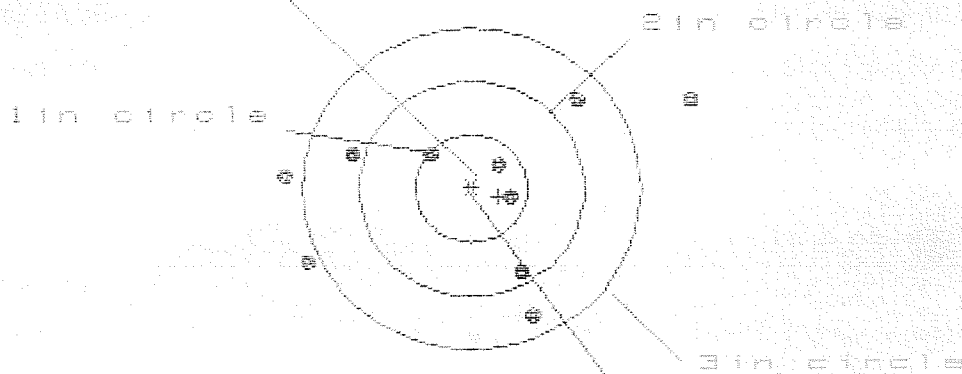
10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649277

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.648

VS = 1.966

GS = 3.705

CENTROID *

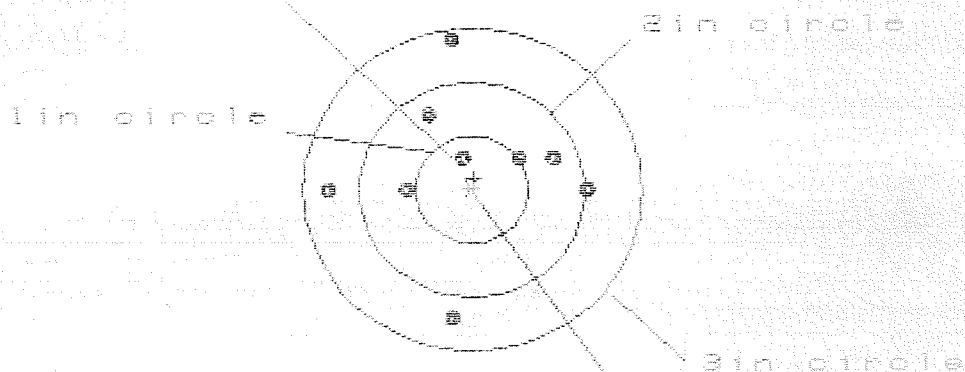
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.982	1.194	1.013
MINIMUM X	-1.666	-1.446	-1.383
MAXIMUM Y	.837	.925	.955
MINIMUM Y	-1.129	-1.041	-1.011
CENTROID X	-.242	-.462	-.281
CENTROID Y	.075	-.013	-.043
FOR TO CENTROID in.	.253	.462	.284
MIN RADIUS	.352	.476	.381
MEAN RADIUS	1.111	1.005	.921
MAX RADIUS	2.135	1.510	1.487
HORIZONTAL SPREAD	3.648	2.640	2.396
VERTICAL SPREAD	1.966	1.966	1.966
EXTREME SPREAD	3.705	2.828	2.828
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

22 Aug 1991

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CENTERFIRE PATTERNS # 3

POB



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HSE = 0.000

VS = 3.154

GS = 3.217

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.025	1.079	1.068
MINIMUM X	-1.273	-1.219	-1.230
MAXIMUM Y	1.390	1.194	.636
MINIMUM Y	-1.764	-1.410	-1.260
CENTROID X	-.019	-.073	-.062
CENTROID Y	-.102	.094	-.056
POB TO CENTROID in.	.104	.119	.083
MIN RADIUS	.278	.080	.229
MEAN RADIUS	.967	.824	.796
MAX RADIUS	1.831	1.414	1.266
HORIZONTAL SPREAD	2.298	2.298	2.298
VERTICAL SPREAD	3.154	2.604	1.896
EXTREME SPREAD	3.217	2.604	2.298
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.282

VS= 3.184

GS= 3.391

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.366	1.429	1.366
MINIMUM X	-0.916	-0.853	-0.916
MAXIMUM Y	1.409	1.244	1.740
MINIMUM Y	-1.755	-1.164	-1.000
CENTROID X	-0.016	-0.079	-0.016
CENTROID Y	-0.332	-0.137	-0.299
POA TO CENTROID in.	0.333	0.159	0.293
MIN RADIUS	0.227	0.348	0.252
MEAN RADIUS	1.037	0.926	0.872
MAX RADIUS	1.845	1.453	1.370
HORIZONTAL SPREAD	2.282	2.282	2.282
VERTICAL SPREAD	3.194	2.488	1.740
EXTREME SPREAD	3.391	2.490	2.355
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

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CENTERFIRE PATTERNS

5

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 2.341

VS = 2.483

GS = 2.982

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.024	.877	.882
MINIMUM X	-1.817	-1.656	-1.651
MAXIMUM Y	.953	.969	.790
MINIMUM Y	-1.538	-1.424	-1.892
CENTROID X	-.177	-.030	-.035
CENTROID Y	-.124	-.230	-.051
POB TO CENTROID in.	.216	.232	.082
MIN RADIUS	.363	.216	.394
MEAN RADIUS	.899	.807	.727
MAX RADIUS	1.626	1.425	.919
HORIZONTAL SPREAD	2.341	1.533	1.533
VERTICAL SPREAD	2.483	2.393	1.683
EXTREME SPREAD	2.982	2.393	1.698
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	