

06649280

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

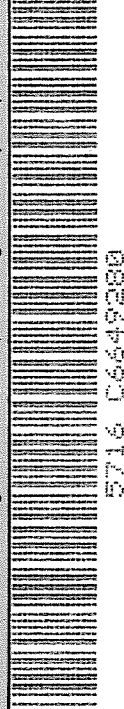
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO.
C6649280

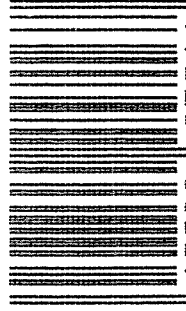
ORDER NO.
5716

20



5716 C6649280

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649280

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		dw
600	Proof	6 27 9 1		dw
607	Check Headspace	6 27 9 1		dw
610	Dis-assemble Gun	6 27 9 1		dw
612	Magnaflux Barrel Action	JUL 2 1991		KR
	Magnaflux Bolt	JUL 2 1991		KR
615	Rollmark Caliber	JUL 2 1991		LS
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	TS
	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		7-29-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7/29/91	QU
	G) Safety Off Force	4	4	4			7/29/91	QU
	H) Trigger Pull Test & Retainability						7-29-91	QU
	I) Firing Pin Indent	.0205	.0205	.0205			7-29-91	QU
	J) Assemble Stock						7/30/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/30/91	RW
	M) Iron Sight Alignment						7/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	RW
	O) Attach Scope to Rifle						7/30/91	RW
	P) Detach & Attach Scope 20 Times						7/30/91	RW
640	Gallery Target & Test						7-30-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						7-30-91	AF
655	Final Inspection							
	A) Headspace						8-5-91	AF
	B) Trigger Pull	2.36	2.42	2.42	2.44	2.43	8-5-91	QU
	C) Function						8-5-91	AF
660	Pack						9-1-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649280DATE 7-29-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.17	2.46	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.57	2.44	2.42	
PULL #3	2.25	2.46	2.40	2.42	
PULL #4	2.18	2.44	2.52	2.44	
PULL #5	2.34	2.56	2.48	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.39		
PULL #2	3.32	3.37		
PULL #3	3.34	3.43		
PULL #4	3.40	3.41		
PULL #5	3.33	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.35		4.61
PULL #2	4.60	4.36		4.42
PULL #3	4.46	4.48		4.40
PULL #4	4.63	4.63		4.46
PULL #5	4.60	4.36		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649280
30 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.244761
1 TO	2	.129248
1 TO	3	.232002
1 TO	4	.248268
1 TO	5	.0753923

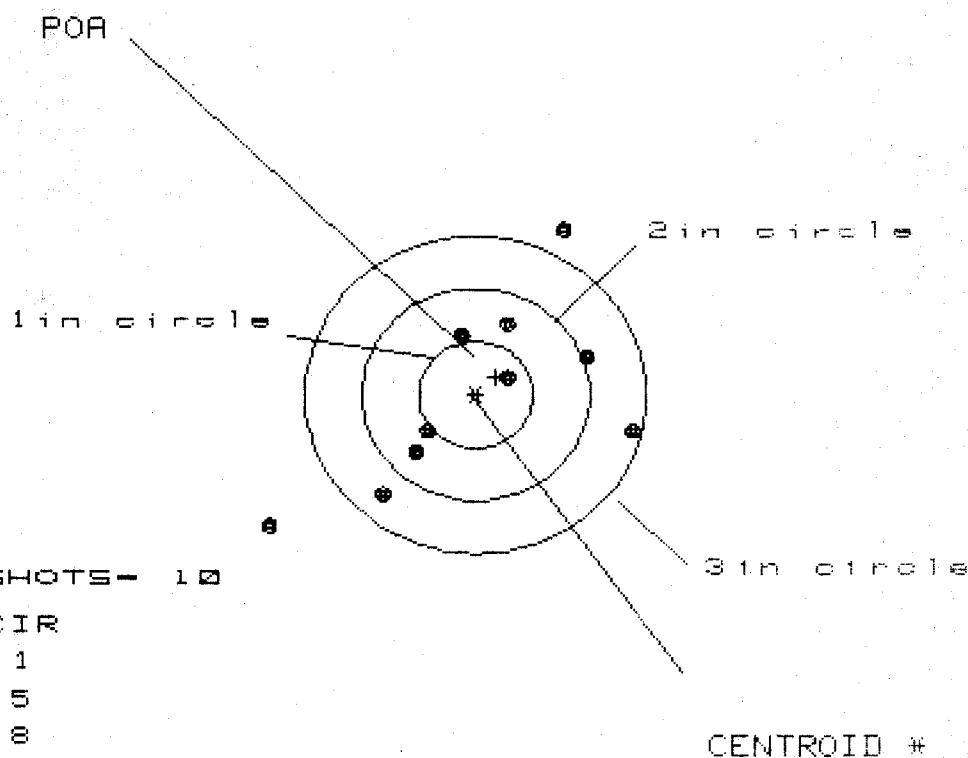
& <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.086
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0822
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118966
THE AMR FOR THIS RIFLE IS: .8868

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066492B0

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.265

VS= 2.857

GS= 3.846

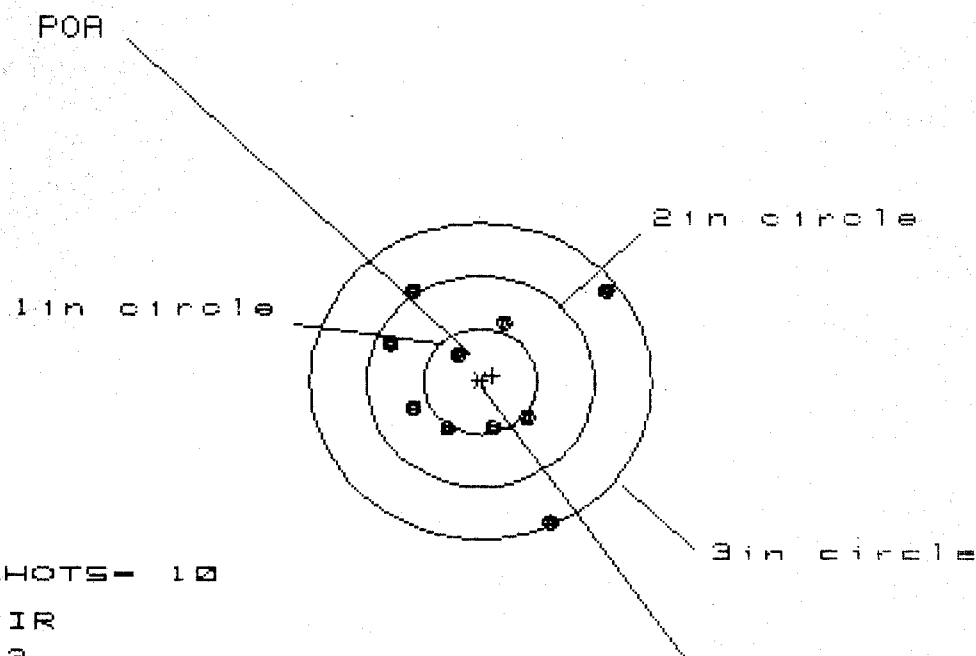
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.218	1.284
MINIMUM X	:	-1.843	-1.003	-.937
MAXIMUM Y	:	1.590	1.449	.746
MINIMUM Y	:	-1.267	-1.045	-.864
CENTROID X	:	-.178	.026	-.040
CENTROID Y	:	-.163	-.022	-.203
POA TO CENTROID in.	:	.242	.034	.207
MIN RADIUS	:	.349	.101	.279
MEAN RADIUS	:	1.070	.902	.838
MAX RADIUS	:	2.236	1.542	1.323
HORIZONTAL SPREAD	:	3.265	2.221	2.221
VERTICAL SPREAD	:	2.857	2.494	1.610
EXTREME SPREAD	:	3.846	2.926	2.286
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

30 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.848

VS= 2.192

GS= 2.457

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	1.134	.646
MINIMUM X	:	-.779	-.714	-.573
MAXIMUM Y	:	.870	.724	.796
MINIMUM Y	:	-1.322	-.616	-.526
CENTROID X	:	-.107	-.172	-.313
CENTROID Y	:	-.060	.086	-.004
POA TO CENTROID in.	:	.123	.192	.313
MIN RADIUS	:	.339	.197	.190
MEAN RADIUS	:	.781	.697	.590
MAX RADIUS	:	1.442	1.345	.874
HORIZONTAL SPREAD	:	1.848	1.848	1.219
VERTICAL SPREAD	:	2.192	1.340	1.322
EXTREME SPREAD	:	2.457	1.982	1.575
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

30 Jul 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.081

VS= 2.042

GS= 2.188

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 =

10

1.070

-1.011

.987

-1.055

.007

-.028

.029

.419

.757

1.502

2.081

2.042

2.188

9

.665

-.892

.870

-.770

-.112

.089

.143

.286

.644

1.119

1.557

1.640

2.016

8

.553

-.502

.786

-.854

.000

.173

.173

.228

.564

.866

1.055

1.640

1.647

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B0

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.750

VS= 1.736

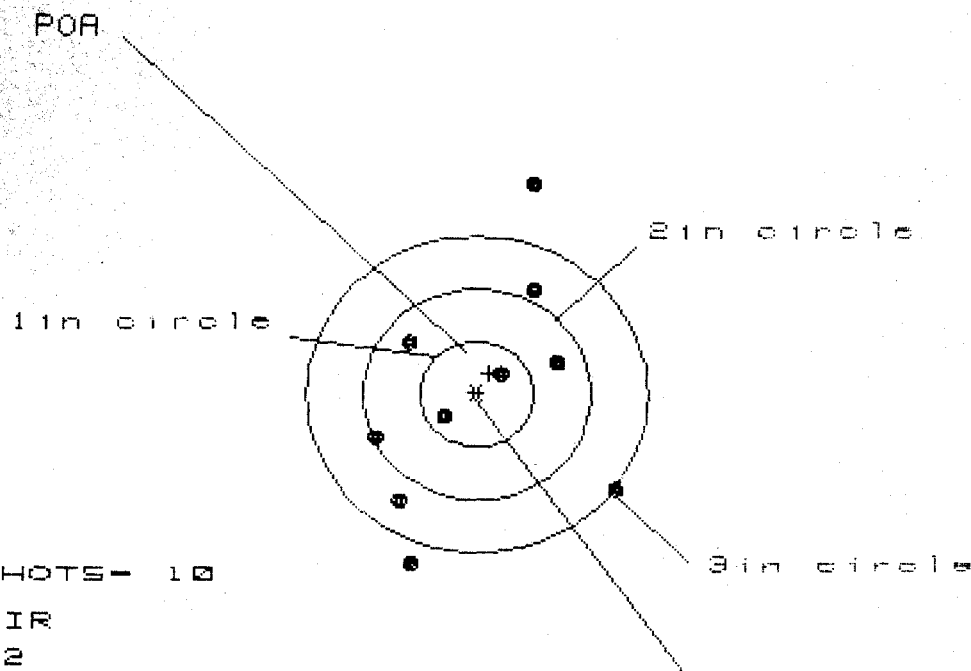
GS= 2.464

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.808	.703	.587
MINIMUM X	:	-.942	-.933	-.548
MAXIMUM Y	:	1.117	1.024	.617
MINIMUM Y	:	-.619	-.495	-.367
CENTROID X	:	-.044	.061	.177
CENTROID Y	:	.041	-.084	-.212
POA TO CENTROID in.	:	.060	.103	.276
MIN RADIUS	:	.159	.162	.035
MEAN RADIUS	:	.737	.630	.503
MAX RADIUS	:	1.461	1.385	.812
HORIZONTAL SPREAD	:	1.750	1.636	1.135
VERTICAL SPREAD	:	1.736	1.519	.984
EXTREME SPREAD	:	2.464	2.232	1.381
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Jul 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.107

VS= 3.530

GS= 3.691

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.186	1.240	1.173
MINIMUM X	-.921	-.867	-.934
MAXIMUM Y	1.975	1.264	1.097
MINIMUM Y	-1.555	-1.335	-.903
CENTROID X	-.108	-.162	-.095
CENTROID Y	-.196	-.416	-.249
POA TO CENTROID in.	.224	.446	.266
MIN RADIUS	.289	.252	.322
MEAN RADIUS	1.089	.979	.903
MAX RADIUS	2.035	1.438	1.472
HORIZONTAL SPREAD	2.107	2.107	2.107
VERTICAL SPREAD	3.530	2.599	2.000
EXTREME SPREAD	3.691	2.826	2.363
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		