

C6649283

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

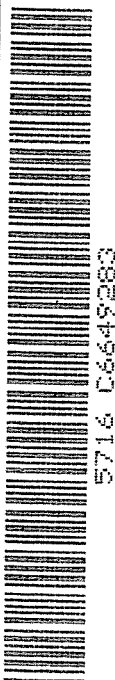
MODEL 700TM M24

SERIAL NO.
 C6649283

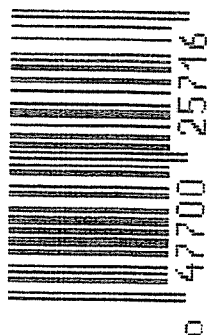
ORDER NO.
5716

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

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06649283

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

op. #	BARBER - M24 0067303		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		4	4	4			8-6-91	D/H
	G) Safety Off Force		2	2	2			8-6-91	D/H
	H) Trigger Pull Test & Retainability							8-5-91	D/H
	I) Firing Pin Indent		.020	.020	.021			8-6-91	D/H
	J) Assemble Stock							8/7/91	RW
	K) Assemble Swivel Studs							8-8-91	D/H
	L) Attach Front and Rear Sight Assemblies							8/2/91	RW
	M) Iron Sight Alignment							8/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container							8/2/91	RW
	O) Attach Scope to Rifle							8/2/91	RW
	P) Detach & Attach Scope 20 Times							8/2/91	RW
640	Gallery Target & Test							8-7-91	AF
	A) Time							"	AF
	B) Malfunctions							"	AF
	C) Pierced Primers							"	AF
	D) Optical Clarity of Scope							"	AF
645	Inspect for Live Ammo							8-7-91	AF
655	Final Inspection								
	A) Headspace							8-8-91	D/H
	B) Trigger Pull		263	250	268	270	252	8-8-91	9/1
	C) Function							8-8-91	D/H
660	Pack							9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 66649283
DATE 8-5-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.31	2.28	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.61	2.68	2.50	
PULL #3	2.57	2.81	2.59	2.68	
PULL #4	2.61	2.81	2.58	2.70	
PULL #5	2.61	2.62	2.70	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.25		
PULL #2	3.45	3.42		
PULL #3	3.48	3.04		
PULL #4	3.36	3.47		
PULL #5	3.28	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.29		4.08
PULL #2	4.26	4.39		3.98
PULL #3	4.27	4.17		4.13
PULL #4	4.29	4.41		4.14
PULL #5	4.29	4.22		4.02
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649283
7 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.0595399
1 TO 2	.0565685
1 TO 3	.0717008
1 TO 4	.125734
1 TO 5	.172977

* <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1138
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1138
THE ANR FOR THIS RIFLE IS: .9854

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B3

CENTERFIRE PATTERNS # 1

POB

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.531

VS = 1.916

GS = 2.598

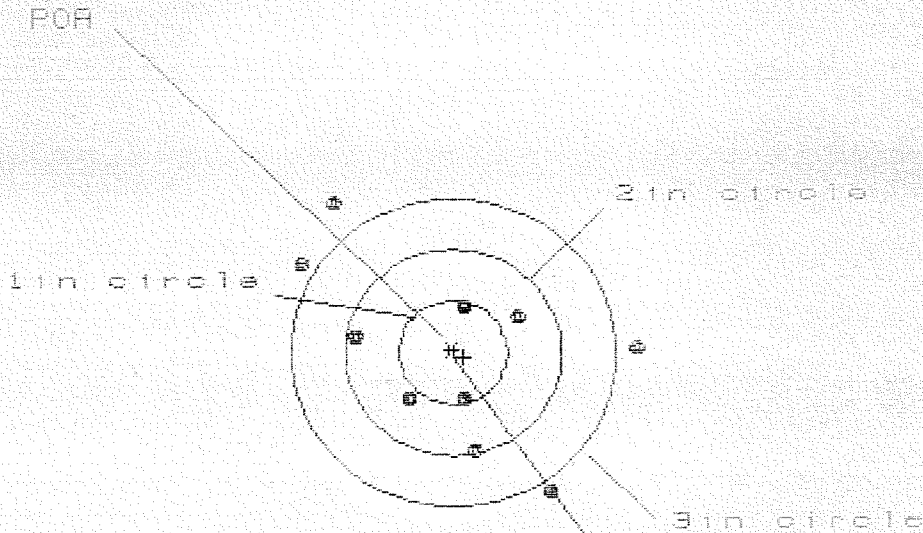
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.049	.891
MINIMUM X	-1.390	-1.263	-.858
MAXIMUM Y	1.077	.983	.940
MINIMUM Y	-.839	-.649	-.692
CENTROID X	-.059	-.186	-.028
CENTROID Y	.008	.102	.145
POB TO CENTROID in.	.060	.212	.148
MIN RADIUS	.085	.135	.057
MEAN RADIUS	.845	.778	.686
MAX RADIUS	1.417	1.310	1.104
HORIZONTAL SPREAD	2.531	2.312	1.759
VERTICAL SPREAD	1.916	1.632	1.632
EXTREME SPREAD	2.598	2.500	2.155
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649283

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 6

CENTROID #

HS= 3.119

VS= 2.763

GS= 3.399

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.692	1.574	.997
MINIMUM X	-1.427	-1.345	-1.349
MAXIMUM Y	1.405	1.019	1.041
MINIMUM Y	-1.358	-1.202	-1.180
CENTROID X	-.099	.019	-.177
CENTROID Y	.048	-.103	-.130
POR TO CENTROID in.	.110	.110	.220
MIN RADIUS	.437	.341	.367
MEAN RADIUS	1.083	.987	.899
MAX RADIUS	1.761	1.851	1.704
HORIZONTAL SPREAD	3.119	3.119	2.346
VERTICAL SPREAD	2.763	2.221	2.221
EXTREME SPREAD	3.399	3.231	3.231
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

7 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C86492B3

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 9

HS = 1.587

VS = 2.565

GS = 2.600

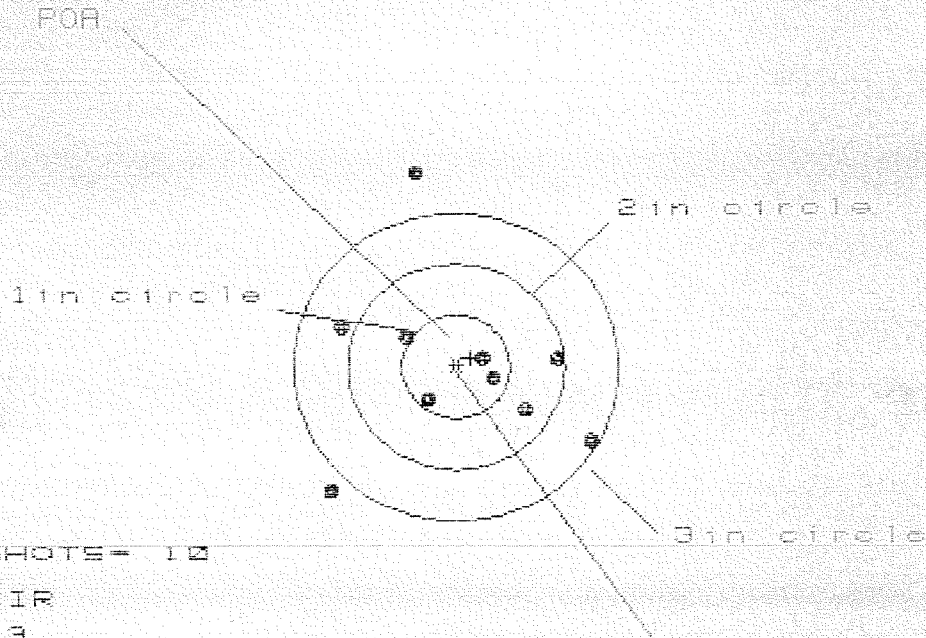
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.923	.944
MINIMUM X	-.630	-.664	-.643
MAXIMUM Y	1.558	1.252	.735
MINIMUM Y	-1.007	-.834	-.678
CENTROID X	-.049	-.014	-.035
CENTROID Y	.079	-.094	-.250
POA TO CENTROID in.	.093	.095	.253
MIN RADIUS	.555	.547	.436
MEAN RADIUS	.898	.804	.729
MAX RADIUS	1.589	1.263	.965
HORIZONTAL SPREAD	1.587	1.587	1.587
VERTICAL SPREAD	2.565	2.006	1.413
EXTREME SPREAD	2.600	2.140	1.693
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86492B3

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 2.455

VS = 3.094

GS = 3.196

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.259
MINIMUM X	-1.196
MAXIMUM Y	1.863
MINIMUM Y	-1.231
CENTROID X	-.139
CENTROID Y	-.089
POR TO CENTROID in.	.165
MIN RADIUS	.228
MEAN RADIUS	.952
MAX RADIUS	1.905
HORIZONTAL SPREAD	2.455
VERTICAL SPREAD	3.094
EXTREME SPREAD	3.196
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8



IN CIR

☐ ☐ ☐ ☐ ☐

217-11

Questions **A**nswers

11-2410

$$\sqrt{e} = 0.599$$

GE-0-407

LEUTROID *

PATTERN #

5

SHOTS (BEST OF)

12

9

20

MAXIMUM	X	1.107	1.349	.954
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MINIMUM	X		-1.313	-1.200	-1.048
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MAXIMUM	Y	:	1.752	.732	.588
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MINIMUM	Y	:	-1.347	-1.152	-1.241
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CENTROID X : -.223 -.336 -.488

CENTROID Y : - .647 - .242 - .698

POA TO CENTROID in.:	.228	.414	.498
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MIN. RADIUS	IN.	MM.	IN.	MM.
0.005	0.005	0.127	0.005	0.127
0.010	0.010	0.254	0.010	0.254
0.020	0.020	0.508	0.020	0.508
0.050	0.050	1.270	0.050	1.270
0.100	0.100	2.540	0.100	2.540
0.200	0.200	5.080	0.200	5.080
0.500	0.500	12.700	0.500	12.700
1.000	1.000	25.400	1.000	25.400
2.000	2.000	50.800	2.000	50.800
5.000	5.000	127.000	5.000	127.000
10.000	10.000	254.000	10.000	254.000
20.000	20.000	508.000	20.000	508.000
50.000	50.000	1270.000	50.000	1270.000
100.000	100.000	2540.000	100.000	2540.000
200.000	200.000	5080.000	200.000	5080.000
500.000	500.000	12700.000	500.000	12700.000
1000.000	1000.000	25400.000	1000.000	25400.000
2000.000	2000.000	50800.000	2000.000	50800.000
5000.000	5000.000	127000.000	5000.000	127000.000
10000.000	10000.000	254000.000	10000.000	254000.000
20000.000	20000.000	508000.000	20000.000	508000.000
50000.000	50000.000	1270000.000	50000.000	1270000.000
100000.000	100000.000	2540000.000	100000.000	2540000.000
200000.000	200000.000	5080000.000	200000.000	5080000.000
500000.000	500000.000	12700000.000	500000.000	12700000.000
1000000.000	1000000.000	25400000.000	1000000.000	25400000.000
2000000.000	2000000.000	50800000.000	2000000.000	50800000.000
5000000.000	5000000.000	127000000.000	5000000.000	127000000.000
10000000.000	10000000.000	254000000.000	10000000.000	254000000.000
20000000.000	20000000.000	508000000.000	20000000.000	508000000.000
50000000.000	50000000.000	1270000000.000	50000000.000	1270000000.000
100000000.000	100000000.000	2540000000.000	100000000.000	2540000000.000
200000000.000	200000000.000	5080000000.000	200000000.000	5080000000.000
500000000.000	500000000.000	12700000000.000	500000000.000	12700000000.000
1000000000.000	1000000000.000	25400000000.000	1000000000.000	25400000000.000
2000000000.000	2000000000.000	50800000000.000	2000000000.000	50800000000.000
5000000000.000	5000000000.000	127000000000.000	5000000000.000	127000000000.000
10000000000.000	10000000000.000	254000000000.000	10000000000.000	254000000000.000
20000000000.000	20000000000.000	508000000000.000	20000000000.000	508000000000.000
50000000000.000	50000000000.000	1270000000000.000	50000000000.000	1270000000000.000
100000000000.000	100000000000.000	2540000000000.000	100000000000.000	2540000000000.000
200000000000.000	200000000000.000	5080000000000.000	200000000000.000	5080000000000.000
500000000000.000	500000000000.000	12700000000000.000	500000000000.000	12700000000000.000
1000000000000.000	1000000000000.000	25400000000000.000	1000000000000.000	25400000000000.000
2000000000000.000	2000000000000.000	50800000000000.000	2000000000000.000	50800000000000.000
5000000000000.000	50000			

MEAN RADIUS	1.149	1.044	.935
MEAN RADIUS	1.149	1.044	.935

MAX. RADIUS	:	2.024	1.677	1.281
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HORIZONTAL SPREAD : 2.419 2.419 2.812

VERTICAL	SPREAD	3.099	1.884	1.829
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EXTREME	SPREAD	3.437	3.859	2.248
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NUMBER IN ONE INCH CIRCLE = 0

NUMBER IN TWO INCH CIRCLE = 6

NUMBER IN THREE INCH CIRCLE = 8