

C6649284

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

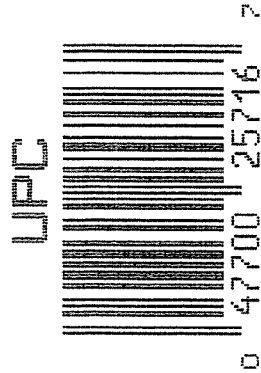
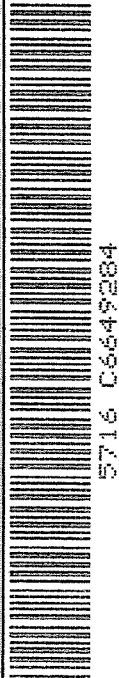
MODEL 700™ M24

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

SERIAL NO.
C6649284

ORDER NO.
5716

20



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649284

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	LS.
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL 1	7 1991	WB
620	Apply Coatings (Barrel Action)		8-22-91	LB
	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		8-13-91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-13-91	XL
	G) Safety Off Force	3	3	3			8-13-91	XL
	H) Trigger Pull Test & Retainability						8-13-91	XL
	I) Firing Pin Indent	.022	.022	.022			8-13-91	XL
	J) Assemble Stock						8/14/91	RW
	K) Assemble Swivel Studs						8-15-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/14/91	RW
	M) Iron Sight Alignment						8/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	RW
	O) Attach Scope to Rifle						8/14/91	RW
	P) Detach & Attach Scope 20 Times						8/14/91	RW
640	Gallery Target & Test						8-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-14-91	NF
655	Final Inspection							
	A) Headspace						8-15-91	D/H
	B) Trigger Pull	2.33	2.25	2.20	2.18	2.20	8-15-91	XL
	C) Function						8-15-91	D/H
660	Pack						8-15-91	NF

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

SERIAL NO C6649284
DATE 8-13-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.64	2.48	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.54	2.55	2.25	
PULL #3	2.43	2.60	2.40	2.20	
PULL #4	2.60	2.46	2.44	2.18	
PULL #5	2.44	2.60	2.54	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.35		
PULL #2	3.37	3.27		
PULL #3	3.38	3.42		
PULL #4	3.44	3.37		
PULL #5	3.39	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.66	4.28		4.43
PULL #2	4.46	4.25		4.33
PULL #3	4.43	4.34		4.36
PULL #4	4.47	4.31		4.45
PULL #5	4.50	4.35		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649284
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.0483735
1 TO 2	.088459
1 TO 3	.141905
1 TO 4	.121672
1 TO 5	.0847231

(----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0292
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0343463
THE AMR FOR THIS RIFLE IS: 1.035

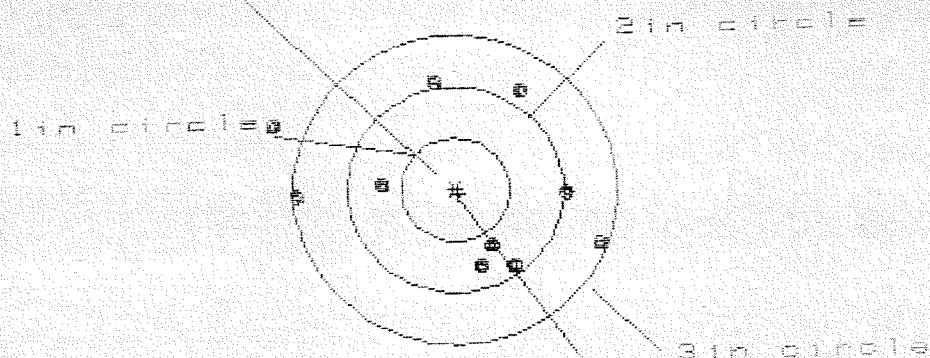
23 Aug 1991

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CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.018

VS= 1.774

GS= 3.231

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.323	1.135	.924
MINIMUM X	-1.695	-1.687	-1.103
MAXIMUM Y	1.032	1.100	1.100
MINIMUM Y	-.742	-.674	-.674
CENTROID X	-.024	.164	.375
CENTROID Y	.042	-.026	-.026
POA TO CENTROID in.	.048	.166	.376
MIN RADIUS	.632	.495	.483
MEAN RADIUS	1.089	.974	.855
MAX RADIUS	1.802	1.687	1.226
HORIZONTAL SPREAD	3.018	2.822	2.027
VERTICAL SPREAD	1.774	1.774	1.774
EXTREME SPREAD	3.231	2.862	2.150
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 8		

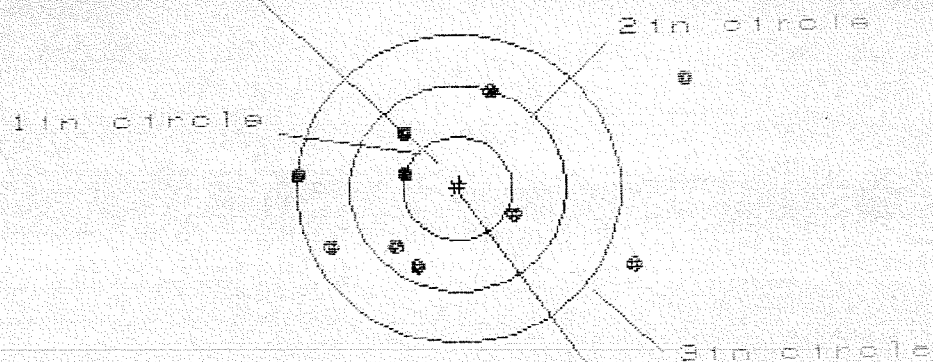
23 Aug 1991

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CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 7

HS = 3.577

VS = 1.785

GS = 3.775

CENTROID #

PATTERN #

2

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.151	1.822	1.015
MINIMUM X	-1.526	-1.287	-1.059
MAXIMUM Y	1.000	1.091	1.007
MINIMUM Y	-.785	-.674	-.719
CENTROID X	-.015	-.254	-.482
CENTROID Y	-.046	-.157	-.073
POA TO CENTROID in.	.049	.239	.488
MIN RADIUS	.502	.354	.176
MEAN RADIUS	1.148	.956	.788
MAX RADIUS	2.372	1.943	1.297
HORIZONTAL SPREAD	3.677	3.109	2.074
VERTICAL SPREAD	1.785	1.765	1.726
EXTREME SPREAD	3.775	3.245	2.152
NUMBER IN ONE INCH CIRCLE =	0	5	7
NUMBER IN TWO INCH CIRCLE =	5	5	7
NUMBER IN THREE INCH CIRCLE =	7	5	7

23 Aug 1991

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 2.727

VS = 2.201

GS = 2.753

CENTROID #

PATTERN #

3

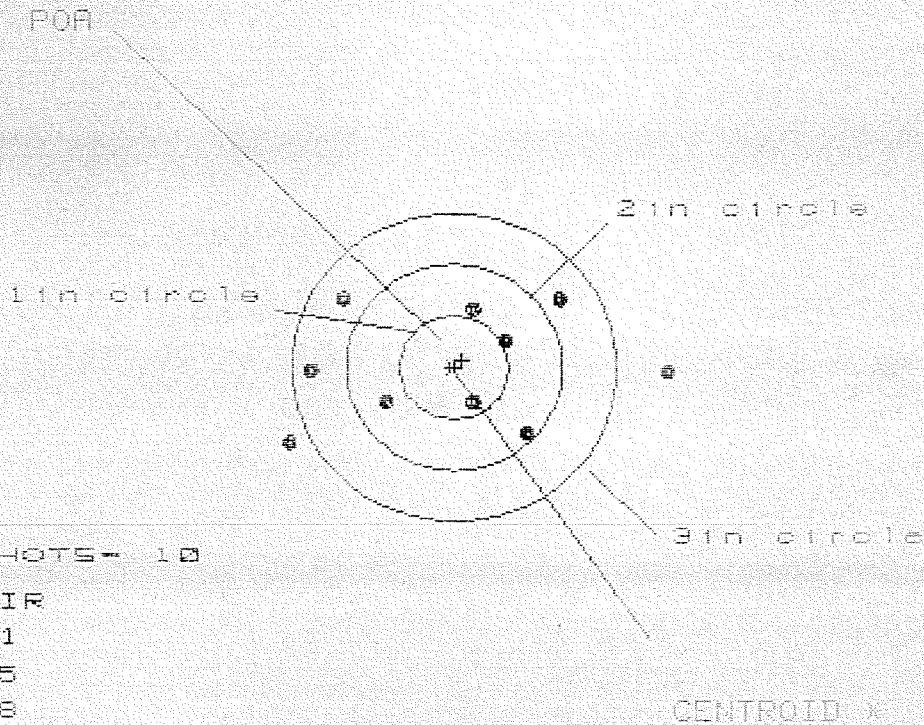
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.451	.872	.765
MINIMUM X	:	-1.276	-1.115	-1.223
MAXIMUM Y	:	1.150	1.115	1.012
MINIMUM Y	:	-1.051	-1.086	-1.189
CENTROID X	:	-.040	-.201	-.093
CENTROID Y	:	-.099	-.064	.039
POA TO CENTROID in.	:	.107	.211	.101
MIN RADIUS	:	.080	.244	.207
MEAN RADIUS	:	.907	.853	.801
MAX RADIUS	:	1.485	1.299	1.225
HORIZONTAL SPREAD	:	2.727	1.987	1.987
VERTICAL SPREAD	:	2.201	2.201	2.201
EXTREME SPREAD	:	2.753	2.490	2.241
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.423

VS= 1.329

GS= 3.492

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.935

1.177

1.018

MINIMUM X

-1.488

-1.273

-1.247

MAXIMUM Y

.633

.632

.545

MINIMUM Y

-.696

-.697

-.681

CENTROID X

-.076

-.291

-.132

CENTROID Y

-.068

-.067

.020

POA TO CENTROID in.

.102

.299

.134

MIN RADIUS

.404

.534

.507

MEAN RADIUS

1.035

.938

.850

MAX RADIUS

1.935

1.451

1.254

HORIZONTAL SPREAD

3.423

2.450

2.265

VERTICAL SPREAD

1.329

1.329

1.226

EXTREME SPREAD

3.492

2.787

2.363

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

28 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 2.282

VS= 3.076

GS= 3.078

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.633	.450	.463
MINIMUM X	-1.649	-.651	-.638
MAXIMUM Y	1.665	1.611	1.703
MINIMUM Y	-1.411	-1.465	-1.264
CENTROID X	.059	.242	.229
CENTROID Y	.025	.079	-.122
POA TO CENTROID in.	.064	.255	.256
MIN RADIUS	.091	.280	.298
MEAN RADIUS	.995	.917	.800
MAX RADIUS	1.721	1.614	1.750
HORIZONTAL SPREAD	2.282	1.101	1.101
VERTICAL SPREAD	3.076	3.076	2.967
EXTREME SPREAD	3.078	3.078	2.992
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	