

C6511420

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

MODEL 700™ M24

SERIAL NO.
C6611420

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

20

ORDER NO.
5716



5716 C6611420

UPC



0 47700 25716 7

MOD.		GA. CAL.	GUN #
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Safe file stock	RW
	2nd	File stock by Safety Arm. Bench Check OK	RW
	3rd		
	4th		

2/19/91

FUNCTION

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CEM

GUN SERIAL # C6611420

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25 9		RW
600	Proof	1 25 9		RW
607	Check Headspace	1 25 81		RW
610	Dis-assemble Gun	1 25 91		RW
612	Magnaflux Barrel Action	1 25 91		KR
	Magnaflux Bolt	1 25 91		KR
615	Rollmark Caliber	1 25 91		LG
617	Drill and Tap Sight Holes	1 30 91		LB
618	Polish Barrel RBB	1 30 91		WB
620	Apply Coatings (Barrel Action)		2-10-91	DT
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	DL

Op. #	BARBER M24 0076532	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/15/91	WB
	G) Safety Off Force	2	2	2			2/15/91	WB
	H) Trigger Pull Test & Retainability						2/15/91	SL
	I) Firing Pin Indent	.020	.0205	.020			2/15/91	WB
	J) Assemble Stock						2/15/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/15/91	RW
	M) Iron Sight Alignment						2/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	RW
	O) Attach Scope to Rifle						2/15/91	RW
	P) Detach & Attach Scope 20 Times						2/15/91	RW
640	Gallery Target & Test						2-15-91	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						2-15-91	A
655	Final Inspection							
	A) Headspace						2-25-91	A
	B) Trigger Pull	2.15	2.12	2.13	2.15	2.15	2/21/91	SL
	C) Function						2-25-91	A
660	Pack						3/19/91	V

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6611420DATE 2/15/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.34	2.27	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.24	2.24	2.12	
PULL #3	2.26	2.26	2.35	2.13	
PULL #4	2.21	2.24	2.26	2.15	
PULL #5	2.26	2.27	2.35	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.20		
PULL #2	3.29	3.22		
PULL #3	3.23	3.20		
PULL #4	3.14	3.16		
PULL #5	3.20	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.37		4.29
PULL #2	4.50	4.42		4.27
PULL #3	4.51	4.39		4.19
PULL #4	4.37	4.27		4.27
PULL #5	4.55	4.19		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611420
15 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.243354
1 TO 2	.0601664
1 TO 3	.410943
1 TO 4	.309416
1 TO 5	.384796

5a <----POA

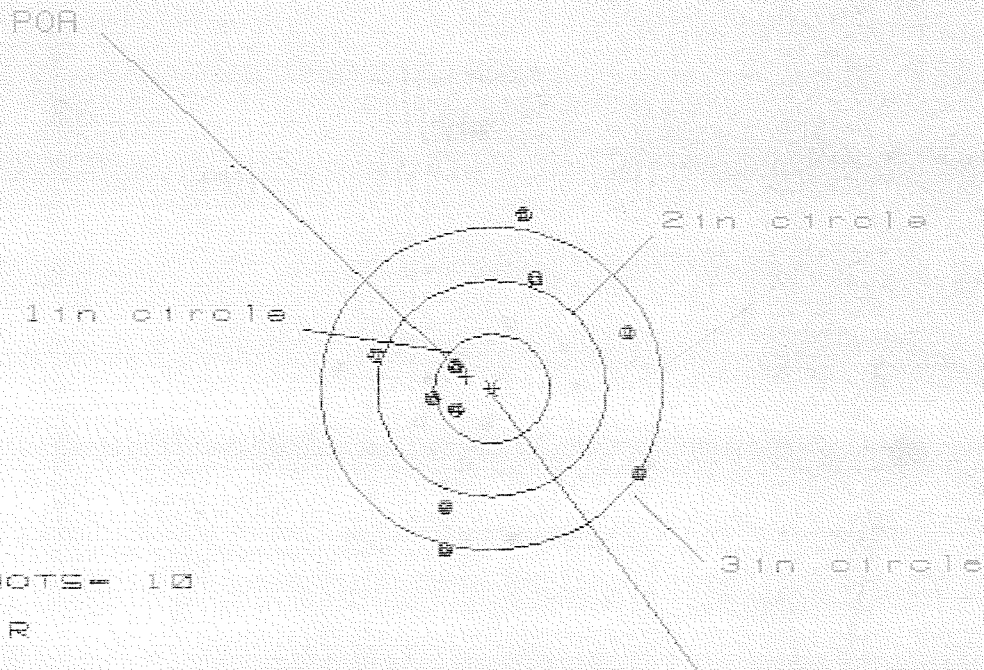
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0576
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0577529
THE ABR FOR THIS RIFLE IS: .9238

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611420

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS = 2.287

VS = 3.082

GS = 3.154

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.273	1.381	1.253
MINIMUM X	-.994	-.966	-1.014
MAXIMUM Y	1.626	1.157	.997
MINIMUM Y	-1.456	-1.275	-1.112
CENTROID X	.215	.187	.235
CENTROID Y	-.114	-.295	-.135
POA TO CENTROID in.	.244	.349	.271
MIN RADIUS	.396	.311	.411
MEAN RADIUS	1.061	.984	.936
MAX RADIUS	1.646	1.433	1.466
HORIZONTAL SPREAD	2.267	2.267	2.267
VERTICAL SPREAD	3.082	2.432	2.109
EXTREME SPREAD	3.154	2.548	2.536
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =			8

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611420

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.756

VS= 1.989

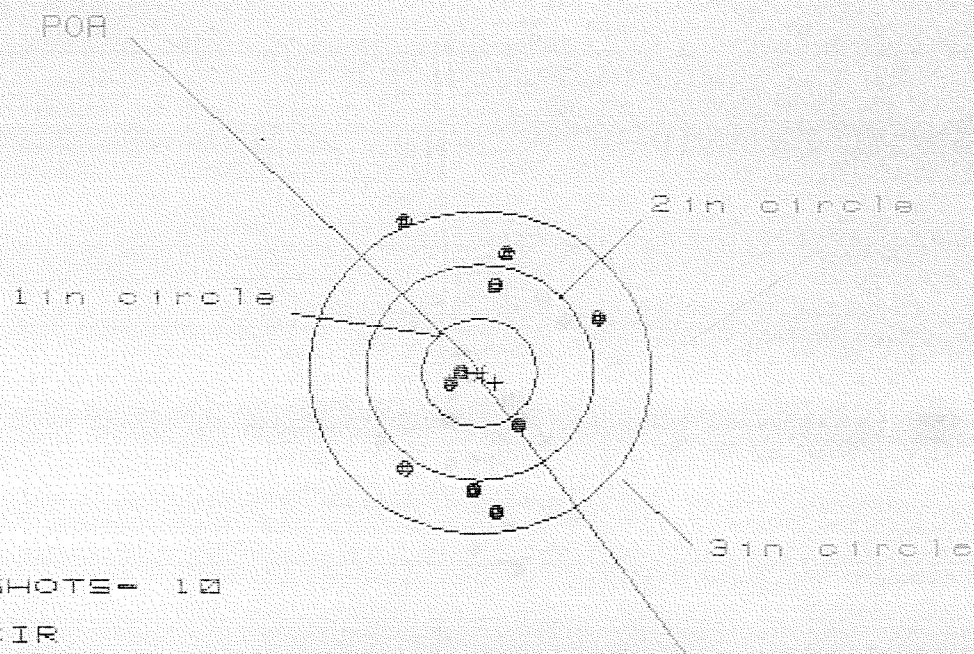
GS= 2.989

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	.965	.824
MINIMUM X	:	-1.293	-1.131	-.551
MAXIMUM Y	:	.955	.909	.968
MINIMUM Y	:	-1.034	-1.080	-1.021
CENTROID X	:	.157	-.005	.136
CENTROID Y	:	-.130	-.084	-.143
POA TO CENTROID in.	:	.204	.084	.197
MIN RADIUS	:	.080	.219	.105
MEAN RADIUS	:	.820	.730	.660
MAX RADIUS	:	1.520	1.225	1.063
HORIZONTAL SPREAD	:	2.756	2.096	1.375
VERTICAL SPREAD	:	1.989	1.989	1.989
EXTREME SPREAD	:	2.989	2.205	1.989
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611420

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 1.729

VS = 2.648

GS = 2.753

CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.036	.963	.965
MINIMUM X	-.693	-.766	-.764
MAXIMUM Y	1.374	1.266	1.126
MINIMUM Y	-1.274	-1.121	-1.059
CENTROID X	-.140	-.067	-.069
CENTROID Y	.093	-.060	.080
POA TO CENTROID in.	.168	.090	.106
MIN RADIUS	.192	.292	.261
MEAN RADIUS	.915	.841	.802
MAX RADIUS	1.524	1.273	1.135
HORIZONTAL SPREAD	1.729	1.729	1.729
VERTICAL SPREAD	2.648	2.387	2.185
EXTREME SPREAD	2.753	2.390	2.218
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

15-Feb-1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11420

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.608

VS= 2.308

GS= 2.341

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.705

.773

.809

MINIMUM X

-.903

-.835

-.799

MAXIMUM Y

1.297

.870

.761

MINIMUM Y

-1.011

-.867

-.859

CENTROID X

-.048

-.116

-.152

CENTROID Y

.049

-.095

.014

POA TO CENTROID in.

.069

.150

.153

MIN RADIUS

.326

.251

.216

MEAN RADIUS

.797

.712

.672

MAX RADIUS

1.435

.915

.940

HORIZONTAL SPREAD

1.608

1.608

1.608

VERTICAL SPREAD

2.308

1.737

1.620

EXTREME SPREAD

2.341

1.778

1.751

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

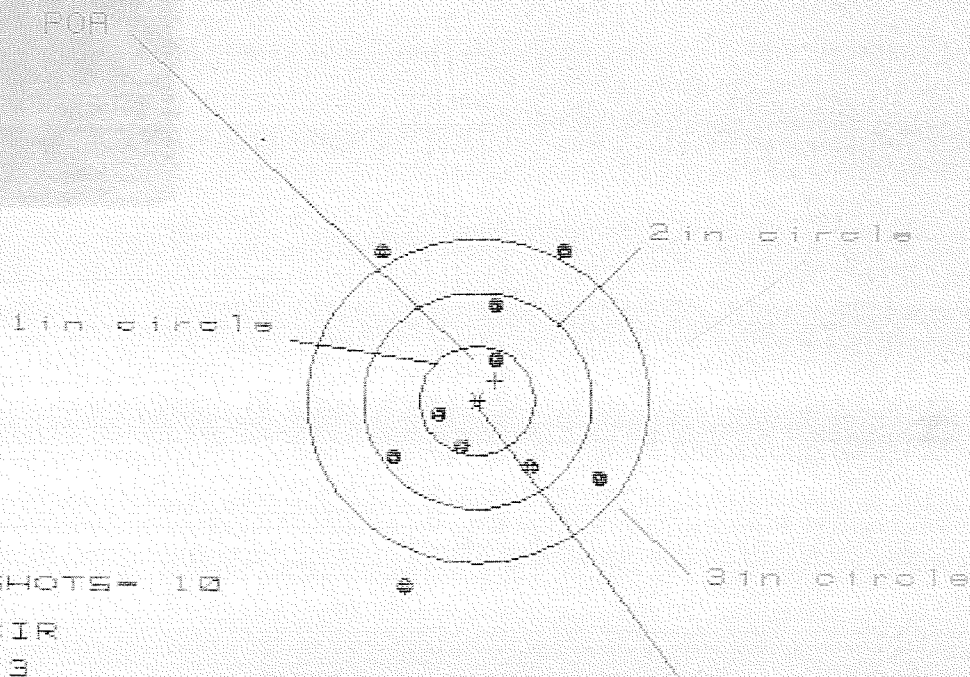
10

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11420

CENTERFIRE PATTERNS

5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 1.841

VS = 3.170

GS = 3.465

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	.949	1.041
MINIMUM X	-.827	-.892	-.800
MAXIMUM Y	1.427	1.233	1.373
MINIMUM Y	-1.743	-.912	-.758
CENTROID X	-.163	-.097	-.189
CENTROID Y	-.186	.008	-.146
POA TO CENTROID in.	.247	.097	.239
MIN RADIUS	.389	.239	.379
MEAN RADIUS	1.026	.935	.849
MAX RADIUS	1.841	1.511	1.589
HORIZONTAL SPREAD	1.841	1.841	1.841
VERTICAL SPREAD	3.170	2.145	2.131
EXTREME SPREAD	3.465	2.816	2.816
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		