

C6611450

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.

MODEL 700™ M24

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

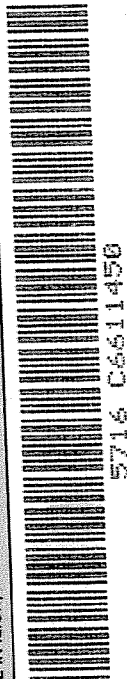
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SERIAL NO.
 C6611450

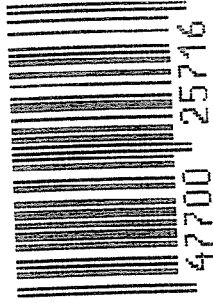
ORDER NO.
5716

46

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



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611450

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		3/27/91	KR
615	Rollmark Caliber		3/27/91	GL
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/18/91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JK

op. #	BARBER M24 0077066	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-22-91	DH
	G) Safety Off Force	2	2	2 1/4			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	98
	I) Firing Pin Indent	1.022	1.021	1.022			4-22-91	DH
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/24/91	KS
	O) Attach Scope to Rifle						4/24/91	KS
	P) Detach & Attach Scope 20 Times						4/24/91	KS
640	Gallery Target & Test						4-25-91	DH
	A) Time						4-25-91	DH
	B) Malfunctions						4-25-91	DH
	C) Pierced Primers						4-25-91	DH
	D) Optical Clarity of Scope						4-25-91	DH
645	Inspect for Live Ammo						4-25-91	DH
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.28	2.27	2.42	2.44	2.45	4/26/91	98
	C) Function						5-1-91	DH
660	Pack						6-17-91	NF

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

SERIAL NO. C6611450

DATE: 4/19/91

TESTER: J. J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.36	2.28	MIN. SETTING,
PULL #2	2.33	2.27	2.28	2.27	NO AVG. OF 5
PULL #3	2.42	2.42	2.30	2.42	READINGS (ACCEPT-
PULL #4	2.51	2.42	2.45	2.44	ABLE LESS THAN 2#
PULL #5	2.55	2.40	2.45	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.53	3.39		
PULL #2	3.32	3.48		
PULL #3	3.44	3.12		
PULL #4	3.34	3.52		
PULL #5	3.48	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.52		4.59
PULL #2	4.51	4.40		4.59
PULL #3	4.17	4.24		4.26
PULL #4	4.17	4.33		4.59
PULL #5	4.63	4.58		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611450
25 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.366958
1 TO 2	.371576
1 TO 3	.541554
1 TO 4	.302152
1 TO 5	.3539

109
#

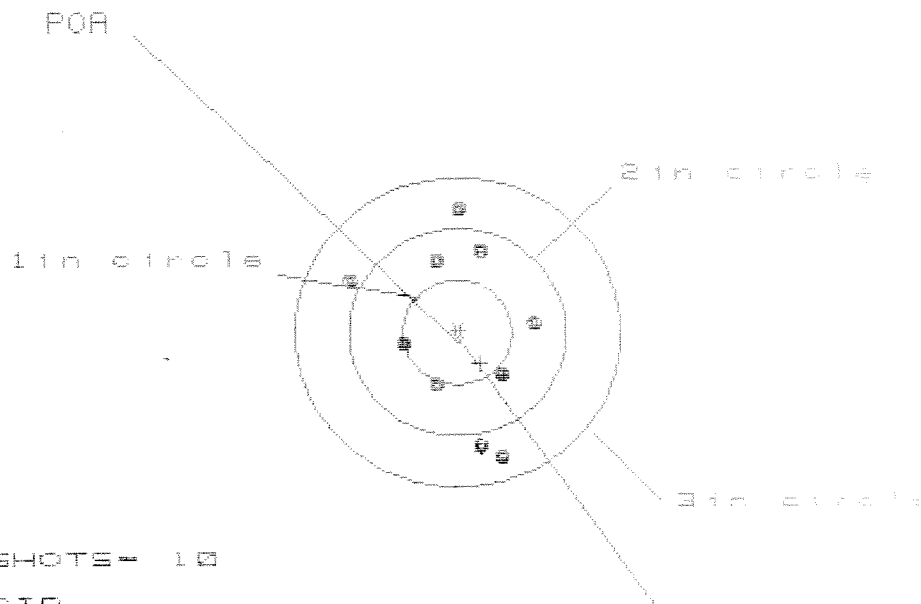
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .036
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1678
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .171618
THE AMR FOR THIS RIFLE IS: .9462

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611150

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 1.737

VS= 2.472

GS= 2.506

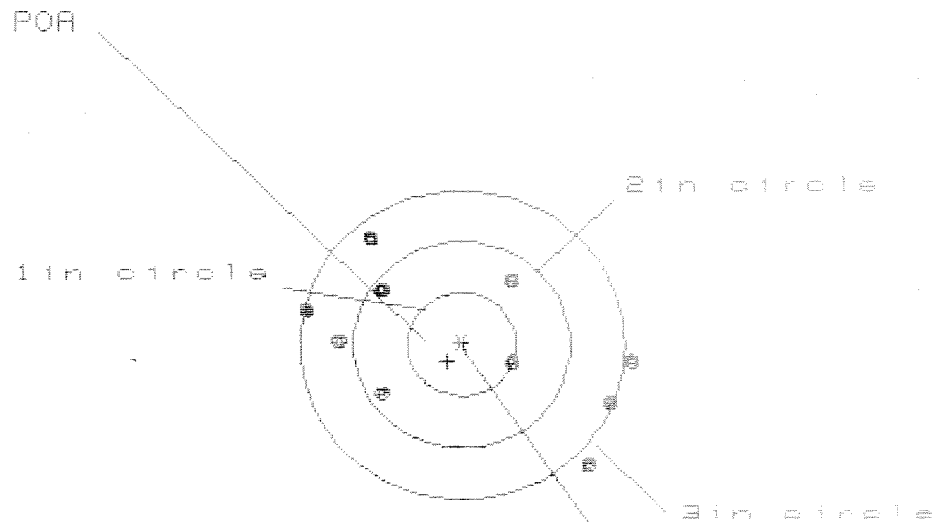
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.704	.745	.746
MINIMUM X	-1.033	-.992	-.991
MAXIMUM Y	1.224	1.086	.797
MINIMUM Y	-1.248	-1.226	-1.091
CENTROID X	-.207	-.248	-.249
CENTROID Y	.303	.441	.306
POA TO CENTROID in.	.366	.506	.394
MIN RADIUS	.518	.526	.477
MEAN RADIUS	.866	.810	.766
MAX RADIUS	1.303	1.245	1.123
HORIZONTAL SPREAD	1.737	1.737	1.737
VERTICAL SPREAD	2.472	2.312	1.868
EXTREME SPREAD	2.506	2.322	2.019
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611450

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 0

HS = 2.971

VS = 2.151

GS = 3.012

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.570	1.695	1.658
MINIMUM X	-1.401	-1.276	-1.064
MAXIMUM Y	1.024	.899	.863
MINIMUM Y	-1.127	-.650	-.686
CENTROID X	.138	.013	-.199
CENTROID Y	.165	.290	.326
POA TO CENTROID in.	.215	.290	.382
MIN RADIUS	.453	.617	.534
MEAN RADIUS	1.149	1.081	.965
MAX RADIUS	1.589	1.719	1.794
HORIZONTAL SPREAD	2.971	2.971	2.722
VERTICAL SPREAD	2.151	1.549	1.549
EXTREME SPREAD	3.012	3.012	2.853
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	0		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11450

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.715

VS = 2.055

GS = 3.108

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.572	1.472	1.351
MINIMUM X	-1.143	-0.968	-0.568
MAXIMUM Y	1.105	1.044	1.155
MINIMUM Y	-0.950	-1.011	-0.900
CENTROID X	.333	.158	.279
CENTROID Y	.262	.323	.212
POR TO CENTROID in.	.423	.360	.350
MIN RADIUS	.287	.206	.218
MEAN RADIUS	.974	.867	.807
MAX RADIUS	1.668	1.514	1.373
HORIZONTAL SPREAD	2.715	2.440	1.919
VERTICAL SPREAD	2.055	2.055	2.055
EXTREME SPREAD	3.108	2.741	2.258
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11450

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 2.036

VS= 1.602

GS= 2.294

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.749
MINIMUM X	-1.287
MAXIMUM Y	.931
MINIMUM Y	-.671
CENTROID X	-.171
CENTROID Y	.003
POA TO CENTROID in.	.171
MIN RADIUS	.228
MEAN RADIUS	.717
MAX RADIUS	1.352
HORIZONTAL SPREAD	2.036
VERTICAL SPREAD	1.602
EXTREME SPREAD	2.294
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	9
NUMBER IN THREE INCH CIRCLE	10

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611450

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 1.872

VS = 2.866

GS = 3.287

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.026	.932	1.016
MINIMUM X	-.846	-.738	-.654
MAXIMUM Y	1.365	1.198	.715
MINIMUM Y	-1.502	-1.323	-1.174
CENTROID X	.087	.181	.097
CENTROID Y	.106	.273	.124
POB TO CENTROID in.	.137	.328	.157
MIN RADIUS	.313	.136	.294
MEAN RADIUS	1.025	.906	.868
MAX RADIUS	1.723	1.384	1.235
HORIZONTAL SPREAD	1.872	1.670	1.670
VERTICAL SPREAD	2.866	2.521	1.889
EXTREME SPREAD	3.287	2.740	2.302
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	