

C6611465

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Smead®

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

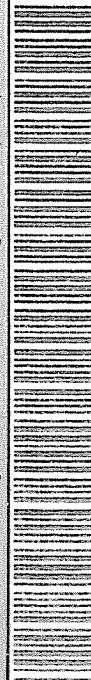
VERY IMPORTANT!
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

MODEL 700TM M24

SERIAL NO.
 C6611465

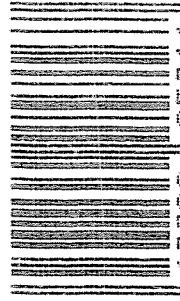
ORDER NO.
 5716

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



5716 C6611465

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611465**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	APR 3 1991		GL
618	Polish Barrel	APR 3 1991		GL
620	Apply Coatings (Barrel Action)		4-19-91	GL
	Apply Coating (Bolt)			GL
625	Final Assembly A) Clean inside of Bolt Assembly		4/26/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/26/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/26/91	K.S.
	D) Oil Firing Pin Ass'y		4/26/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	GL

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/30/91	PH
	G) Safety Off Force	4	3	3			4/30/91	PH
	H) Trigger Pull Test & Retainability						4/29/91	PH
	I) Firing Pin Indent	.0225	.0225	.0225			4/30/91	PH
	J) Assemble Stock						4/30/91	KS
	K) Assemble Swivel Studs						5-1-91	PH
	L) Attach Front and Rear Sight Assemblies						4/30/91	KS
	M) Iron Sight Alignment						4/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	KS
	O) Attach Scope to Rifle						4/30/91	KS
	P) Detach & Attach Scope 20 Times						4/30/91	KS
640	Gallery Target & Test						5-1-91	AC
	A) Time						5-1-91	AC
	B) Malfunctions						5-1-91	AC
	C) Pierced Primers						5-1-91	AC
	D) Optical Clarity of Scope						5-1-91	AC
645	Inspect for Live Ammo						5-1-91	AC
655	Final Inspection							
	A) Headspace						5-1-91	PH
	B) Trigger Pull	2.22	2.25	2.24	2.23	2.32	5/10/91	PH
	C) Function						5/13/91	PH
660	Pack						6-20-91	PH

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

SERIAL NO. C-6611485

DATE 4/29/91

TESTER J. J. (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.44	2.41	2.22	MIN? SETTING,
PULL #2	2.38	2.48	2.44	2.25	NO AVG. OF 5
PULL #3	2.43	2.39	2.38	2.24	READINGS ACCEPT-
PULL #4	2.45	2.35	2.26	2.23	ABLE LESS THAN 2#
PULL #5	2.39	2.29	2.25	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.29	3.47			
PULL #2	3.34	3.34			
PULL #3	3.43	3.46			
PULL #4	3.56	3.45			
PULL #5	3.38	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	4.21	4.17		4.23
PULL #2	4.42	4.14		4.23
PULL #3	4.40	4.22		4.17
PULL #4	4.40	4.11		4.25
PULL #5	4.27	4.17		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611465
1 May 1991

CENTROIDAL DISTANCES

0 TO 1	.163884
1 TO 2	.206155
1 TO 3	.470469
1 TO 4	.172012
1 TO 5	.291153

~~4~~ 3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .049
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25829

THE AMR FOR THIS RIFLE IS: .9392

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 8

HS = 2.186

VS = 3.345

GS = 3.495

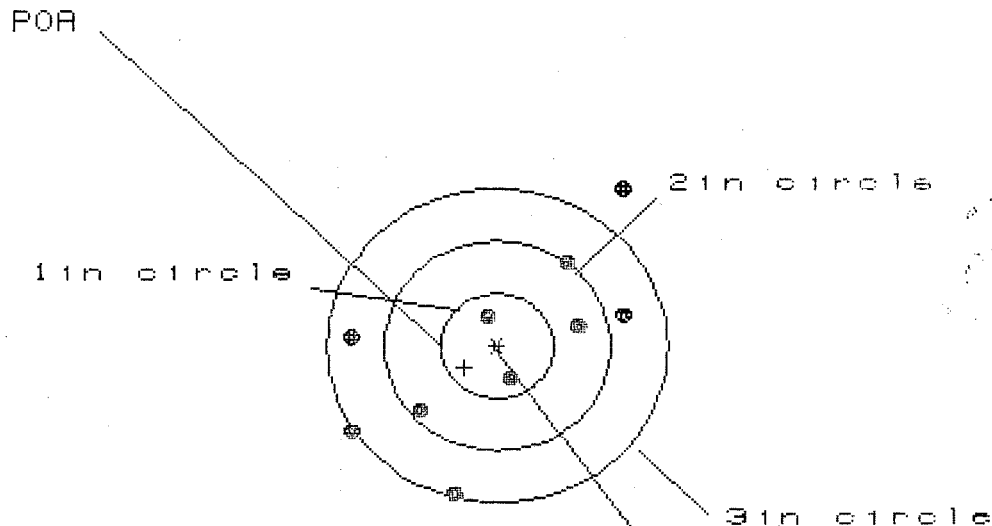
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	1.003	1.001
MINIMUM X	:	-1.182	-1.183	-1.058
MAXIMUM Y	:	1.499	1.293	.976
MINIMUM Y	:	-1.846	-1.384	-1.222
CENTROID X	:	.157	.158	.033
CENTROID Y	:	.047	.253	.091
POA TO CENTROID in.	:	.164	.298	.097
MIN RADIUS	:	.125	.205	.007
MEAN RADIUS	:	1.119	1.029	.912
MAX RADIUS	:	1.846	1.637	1.397
HORIZONTAL SPREAD	:	2.186	2.186	2.059
VERTICAL SPREAD	:	3.345	2.677	2.198
EXTREME SPREAD	:	3.495	3.000	2.535
NUMBER IN ONE INCH CIRCLE	=	2	3	8
NUMBER IN TWO INCH CIRCLE	=			
NUMBER IN THREE INCH CIRCLE	=			

1 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.453

VS= 2.866

GS= 3.275

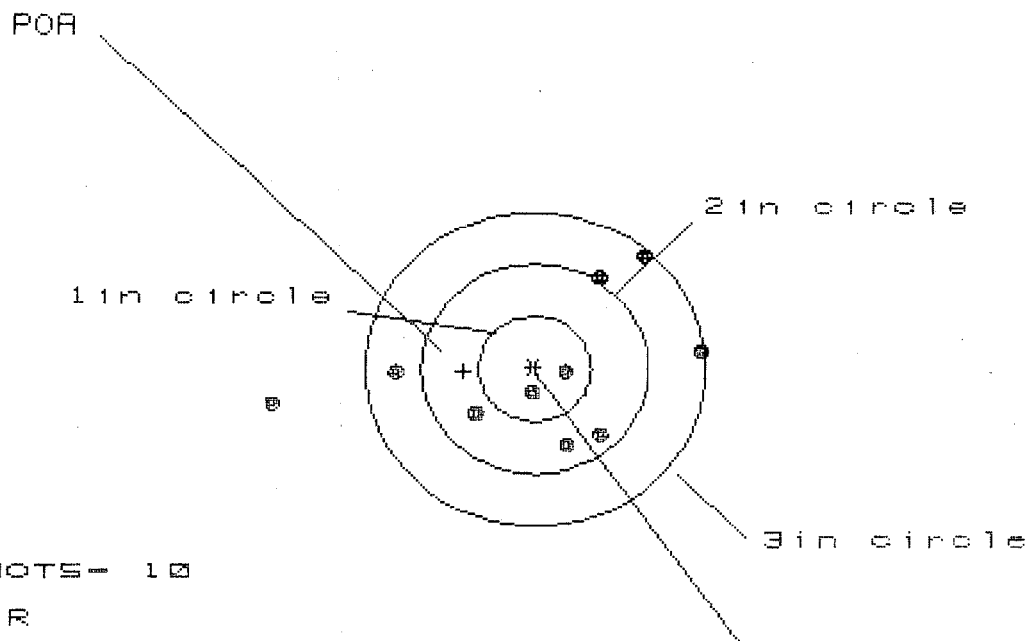
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	1.272	1.133
MINIMUM X	:	-1.305	-1.181	-1.320
MAXIMUM Y	:	1.456	.958	.877
MINIMUM Y	:	-1.410	-1.248	-1.329
CENTROID X	:	.287	.163	.302
CENTROID Y	:	.207	.045	.126
POA TO CENTROID in.	:	.354	.169	.327
MIN RADIUS	:	.304	.272	.225
MEAN RADIUS	:	1.048	.957	.893
MAX RADIUS	:	1.838	1.351	1.387
HORIZONTAL SPREAD	:	2.453	2.453	2.453
VERTICAL SPREAD	:	2.866	2.206	2.206
EXTREME SPREAD	:	3.275	2.631	2.465
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.820

VS= 1.791

GS= 3.852

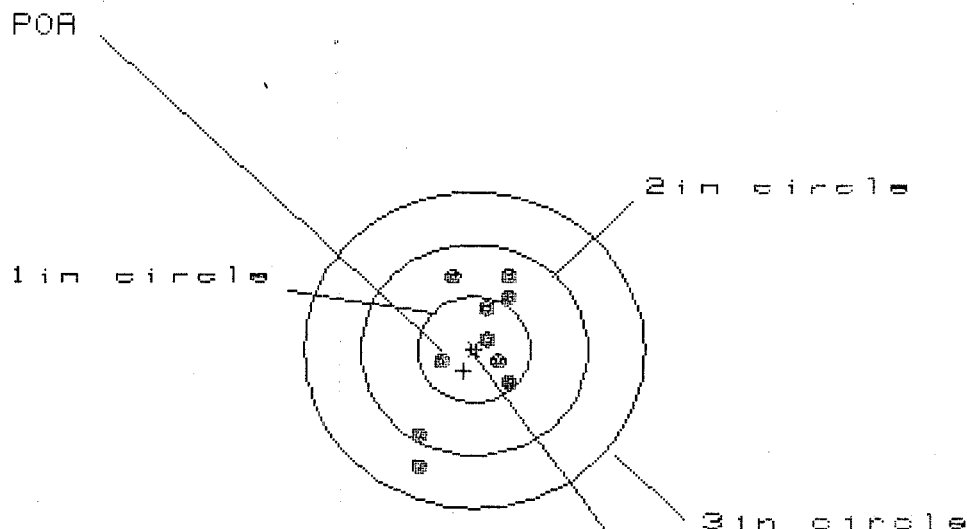
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.493	1.234	.888
MINIMUM X	-2.327	-1.531	-1.377
MAXIMUM Y	1.102	1.071	1.093
MINIMUM Y	-.689	-.720	-.698
CENTROID X	.627	.886	.731
CENTROID Y	.026	.057	.035
POA TO CENTROID in.	.628	.888	.732
MIN RADIUS	.193	.067	.207
MEAN RADIUS	1.040	.864	.811
MAX RADIUS	2.344	1.531	1.408
HORIZONTAL SPREAD	3.820	2.765	2.264
VERTICAL SPREAD	1.791	1.791	1.791
EXTREME SPREAD	3.852	2.774	2.523
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = .816

VS = 1.874

GS = 2.005

CENTROID #

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.351	.302	.238
MINIMUM X	-.465	-.514	-.404
MAXIMUM Y	.736	.610	.497
MINIMUM Y	-1.138	-.900	-.567
CENTROID X	.089	.138	.202
CENTROID Y	.205	.331	.444
POA TO CENTROID in.	.223	.359	.488
MIN RADIUS	.125	.061	.111
MEAN RADIUS	.582	.483	.401
MAX RADIUS	1.220	1.037	.615
HORIZONTAL SPREAD	.816	.816	.642
VERTICAL SPREAD	1.874	1.510	1.064
EXTREME SPREAD	2.005	1.680	1.187
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1991

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS - 2.502

VS - 2.279

GS - 2.832

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.117

.963

.697

MINIMUM X

-1.385

-1.254

-1.133

MAXIMUM Y

1.238

.945

1.026

MINIMUM Y

-1.041

-.904

-.823

CENTROID X

.108

.262

.141

CENTROID Y

-.240

-.377

-.458

POA TO CENTROID in.

.263

.459

.480

MIN RADIUS

.309

.259

.327

MEAN RADIUS

.907

.761

.701

MAX RADIUS

1.857

1.260

1.152

HORIZONTAL SPREAD

2.502

2.217

1.830

VERTICAL SPREAD

2.279

1.849

1.849

EXTREME SPREAD

2.832

2.279

1.875

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9