

C6611489

MODEL 700TM M24

Model S&S TM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

S&S

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

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

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

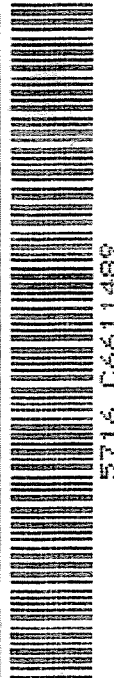
MODEL 700TM M24

SERIAL NO.
C6611489

ORDER NO.
5716

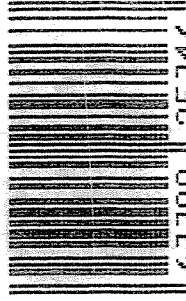
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MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611489

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611489

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	K.R.
	Magnaflux Bolt		11	K.R.
615	Rollmark Caliber		3/27/91	S.S.
617	Drill and Tap Sight Holes	APR	3 1991	K.B.
618	Polish Barrel	APR	3 1991	W.B.
620	Apply Coatings (Barrel Action)		4/12/91	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/18/91	K.S.
	D) Oil Firing Pin Ass'y		4/18/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	J.H.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	6			4-22-91	DH
	G) Safety Off Force	3	3	3			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	JEL
	I) Firing Pin Indent	.020	.021	.021			4-22-91	DH
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-2-91	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						5-2-91	DH
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.60	2.66	2.68	2.61	2.68	4/26/91	JU
	C) Function						5-2-91	DH
660	Pack						6-18-91	VF

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

SERIAL NO. C 6611489

DATE 4/19/91

TESTER JZ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.49	2.44	2.60	MIN. SETTING,
PULL #2	2.53	2.45	2.48	2.60	NO AVG. OF 5
PULL #3	2.20	2.46	2.45	2.61	READINGS ACCEPT-
PULL #4	2.45	2.47	2.44	2.61	ABLE LESS THAN 2#
PULL #5	2.47	2.41	2.41	2.68	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.56	3.28		
PULL #2	3.59	3.23		
PULL #3	3.52	3.34		
PULL #4	3.60	3.22		
PULL #5	3.46	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	4.30	4.28		4.29
PULL #2	4.12	4.28		4.28
PULL #3	4.21	4.30		4.23
PULL #4	4.28	4.32		4.31
PULL #5	4.35	4.39		4.35
TOTAL				
AVG.				

1. DISTANCE CALCULATIONS
 RIFLE # C6611489
 Apr 1991

ENTROIDAL DISTANCES

3 TO	1	.276219
1 TO	2	.681317
1 TO	3	.162641
1 TO	4	.438799
1 TO	5	.246868

$\frac{d^2}{dt^2}$ <----POA

THE AVERAGE X-COORDINATE
 THE AVERAGE Y-COORDINATE
 THE RESULTING AVERAGE P

THE AMR FOR THIS RIFLE

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CENTERFIRE PATTERNS

:

POA

1in circle

2in circle

3in

CENT

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.482

VS = 1.523

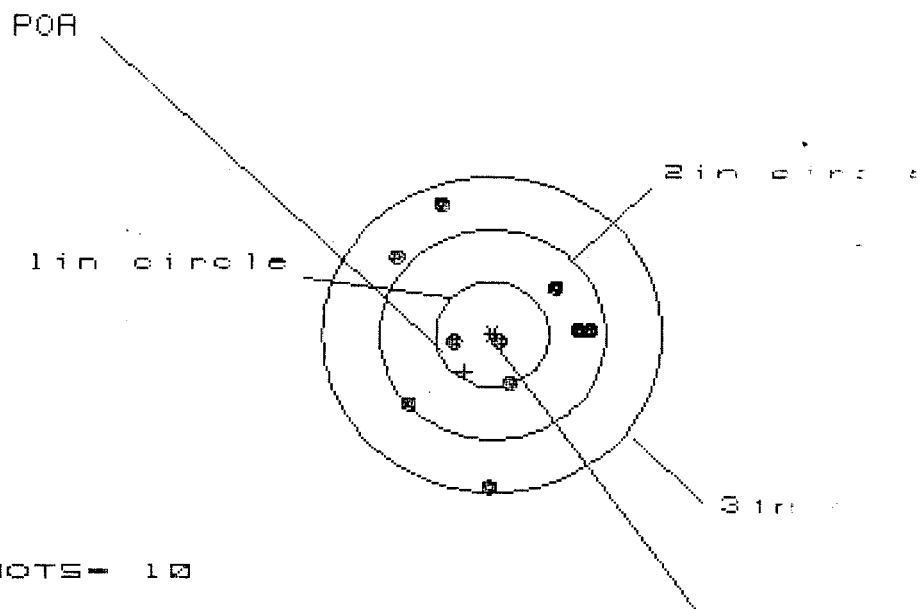
GS = 3.670

PATTERN #	:	10	9	10
SHOTS (BEST OF)	:	10	9	10
MAXIMUM X	:	1.861	1.511	1.861
MINIMUM X	:	-1.621	-1.211	-1.621
MAXIMUM Y	:	.493	.375	.493
MINIMUM Y	:	-1.033	-1.127	-1.033
CENTROID X	:	-.011	-.163	-.011
CENTROID Y	:	-.227	-.163	-.227
POA TO CENTROID in.	:	.237	.237	.237
MIN RADIUS	:	.344	.301	.344
MEAN RADIUS	:	1.013	.911	1.013
MAX RADIUS	:	1.344	1.614	1.344
HORIZONTAL SPREAD	:	3.482	2.914	3.482
VERTICAL SPREAD	:	1.523	1.375	1.523
EXTREME SPREAD	:	3.670	2.956	3.670
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	7	7	7

Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.678

VS= 2.725

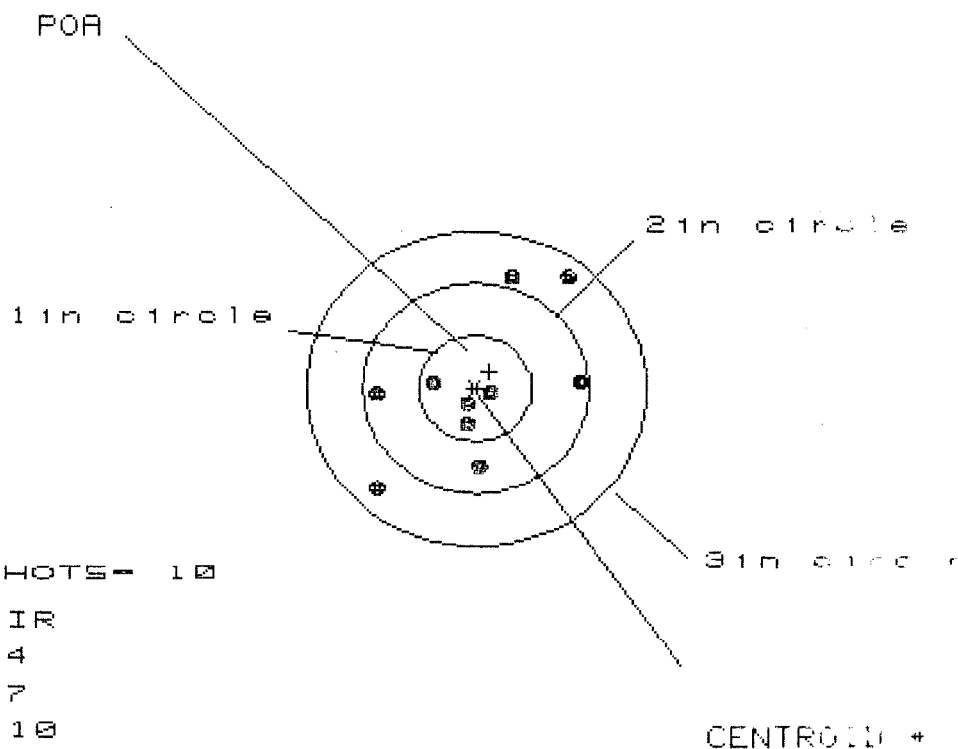
GS= 2.753

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.870	.862	.862
MINIMUM X	:	-.808	-.816	-.816
MAXIMUM Y	:	1.291	1.132	1.132
MINIMUM Y	:	-1.434	-.812	-.812
CENTROID X	:	.241	.249	.249
CENTROID Y	:	.357	.516	.516
POA TO CENTROID in.	:	.431	.501	.501
MIN RADIUS	:	.056	.202	.202
MEAN RADIUS	:	.824	.771	.771
MAX RADIUS	:	1.436	1.224	1.132
HORIZONTAL SPREAD	:	1.678	1.678	1.678
VERTICAL SPREAD	:	2.725	1.944	1.445
EXTREME SPREAD	:	2.753	1.961	1.442
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

25 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.817

VS = 1.965

GS = 2.631

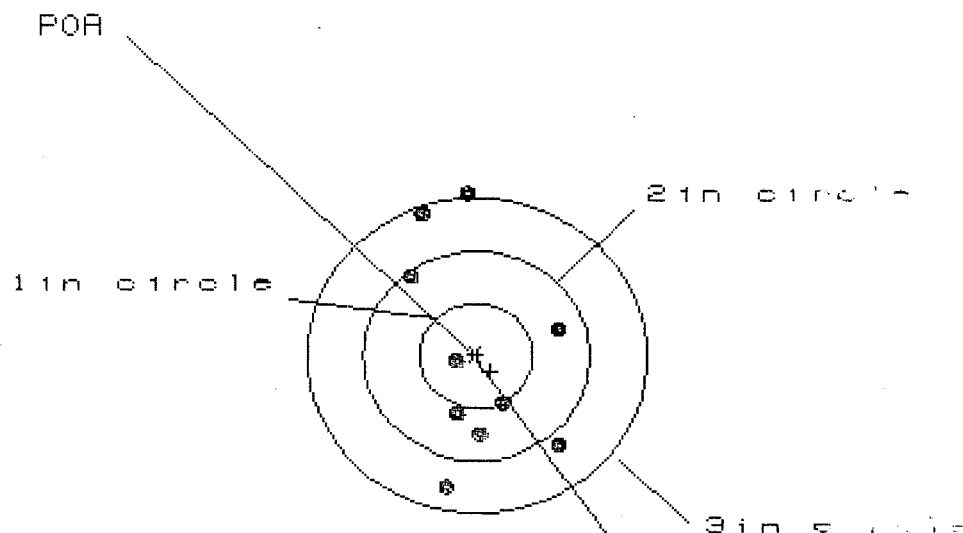
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.925	1.020	.901
MINIMUM X	:	-.892	-.797	-.844
MAXIMUM Y	:	1.053	1.136	1.015
MINIMUM Y	:	-.912	-.795	-.761
CENTROID X	:	-.125	-.220	-.121
CENTROID Y	:	-.160	-.277	-.177
POA TO CENTROID in.	:	.203	.354	.214
MIN RADIUS	:	.136	.030	.125
MEAN RADIUS	:	.726	.626	.575
MAX RADIUS	:	1.357	1.224	1.096
HORIZONTAL SPREAD	:	1.817	1.817	1.730
VERTICAL SPREAD	:	1.965	1.931	1.767
EXTREME SPREAD	:	2.631	2.302	1.805
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 1.308

VS- 2.715

GS- 2.720

CENTROID +

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.770	.759	.697
MINIMUM X	:	-.538	-.549	-.612
MAXIMUM Y	:	1.517	1.557	1.076
MINIMUM Y	:	-1.198	-1.030	-.845
CENTROID X	:	-.124	-.113	-.051
CENTROID Y	:	.148	-.020	.215
POA TO CENTROID in.	:	.193	.114	.221
MIN RADIUS	:	.177	.239	.210
MEAN RADIUS	:	.905	.801	.650
MAX RADIUS	:	1.520	1.635	1.233
HORIZONTAL SPREAD	:	1.308	1.308	1.006
VERTICAL SPREAD	:	2.715	2.587	1.913
EXTREME SPREAD	:	2.720	2.597	2.059
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

25 Apr 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 = 1

2 in = 6

3 in = 10

HS = 2.621

VS = 1.694

GS = 2.656

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.403	1.158	1.025
MINIMUM X	:	-1.218	-1.062	.815
MAXIMUM Y	:	.836	.886	.904
MINIMUM Y	:	-.858	.800	.600
CENTROID X	:	.177	.021	.154
CENTROID Y	:	-.116	-.166	.150
POA TO CENTROID in.	:	.212	.167	.150
MIN RADIUS	:	.479	.500	.475
MEAN RADIUS	:	.938	.870	.850
MAX RADIUS	:	1.472	1.161	1.067
HORIZONTAL SPREAD	:	2.621	2.220	1.841
VERTICAL SPREAD	:	1.694	1.694	1.694
EXTREME SPREAD	:	2.656	2.226	1.905
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	