

C6611504

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

MODEL 700TM H24

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

DU PONT

SERIAL NO.
C6611504

ORDER NO.
5716

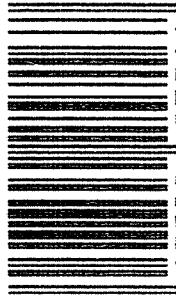
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611504

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6611504**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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		4/1	KR
615	Rollmark Caliber		3/21/91	LS.
617	Drill and Tap Sight Holes	APR	3 1991	EB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/23/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/23/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/23/91	K.S.
	D) Oil Firing Pin Ass'y		4/23/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	JS

op. #	BARBER - M24 0077932	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/24/91	RL
	G) Safety Off Force	3	3	3			4/24/91	RL
	H) Trigger Pull Test & Retainability						4/24/91	RL
	I) Firing Pin Indent.	.023	.0225	.022			4/24/91	RL
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-15-91	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						4-29-91	AC
	A) Time						4-29-91	AC
	B) Malfunctions						4-29-91	AC
	C) Pierced Primers						4-29-91	AC
	D) Optical Clarity of Scope						4-29-91	AC
645	Inspect for Live Ammo						4-29-91	AC
655	Final Inspection							
	A) Headspace						5-15-91	DH
	B) Trigger Pull	2.30	2.18	2.12	2.19	2.18	5/10/91	RL
	C) Function						5-15-91	DH
660	Pack						6-15-91	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6611504

DATE 4/24/91 (H)

TESTER JLT

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.59	2.42	2.30	MIN. SETTING
PULL #2	2.54	2.22	2.40	2.18	NO AVG. OF 5
PULL #3	2.45	2.30	2.38	2.12	READINGS ACCEPT-
PULL #4	2.49	2.22	2.30	2.19	ABLE LESS THAN 2#
PULL #5	2.54	2.27	2.29	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.32		
PULL #2	3.24	3.45		
PULL #3	3.13	3.24		
PULL #4	3.36	3.39		
PULL #5	3.39	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.33		4.34
PULL #2	4.52	4.29		4.34
PULL #3	4.46	4.28		4.28
PULL #4	4.47	4.30		4.34
PULL #5	4.54	4.23		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611504
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.207817
1 TO	2	.248566
1 TO	3	.297755
1 TO	4	.277218
1 TO	5	.309235

✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1444
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0104
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144774
THE AMR FOR THIS RIFLE IS: .9736

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611584

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 2

3 in = 0

HE = 0.000

VS = 0.000

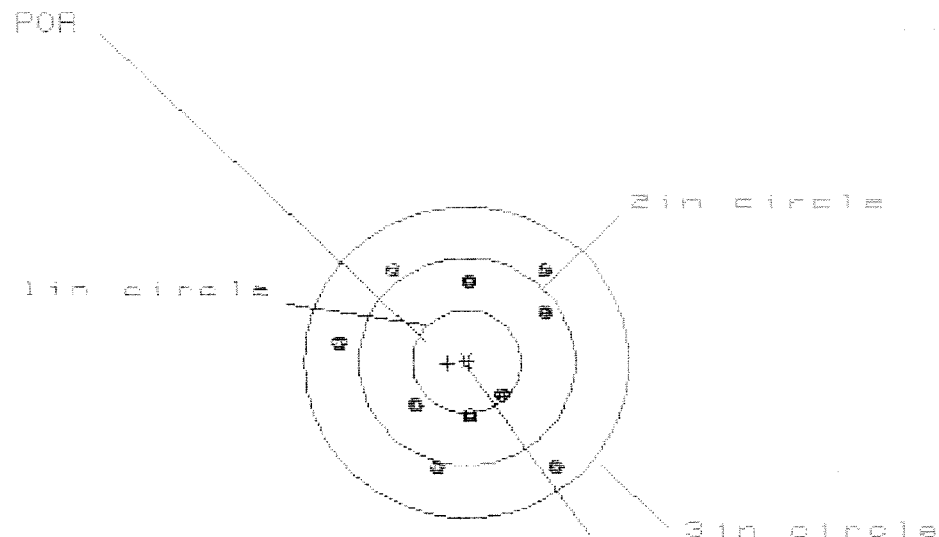
GS = 0.000

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.052	1.084	1.027
MINIMUM X		-1.280	-1.248	-1.305
MAXIMUM Y		1.353	1.138	1.164
MINIMUM Y		-1.939	-1.540	-1.398
CENTROID X		.052	.020	.077
CENTROID Y		-.201	.014	-.128
POA TO CENTROID in.		.208	.025	.149
MIN RADIUS		.302	.518	.377
MEAN RADIUS		1.169	1.080	1.039
MAX RADIUS		1.959	1.544	1.399
HORIZONTAL SPREAD		2.332	2.332	2.332
VERTICAL SPREAD		3.292	2.678	2.562
EXTREME SPREAD		3.380	2.735	2.577
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611504

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.898

VS= 1.884

GS= 2.401

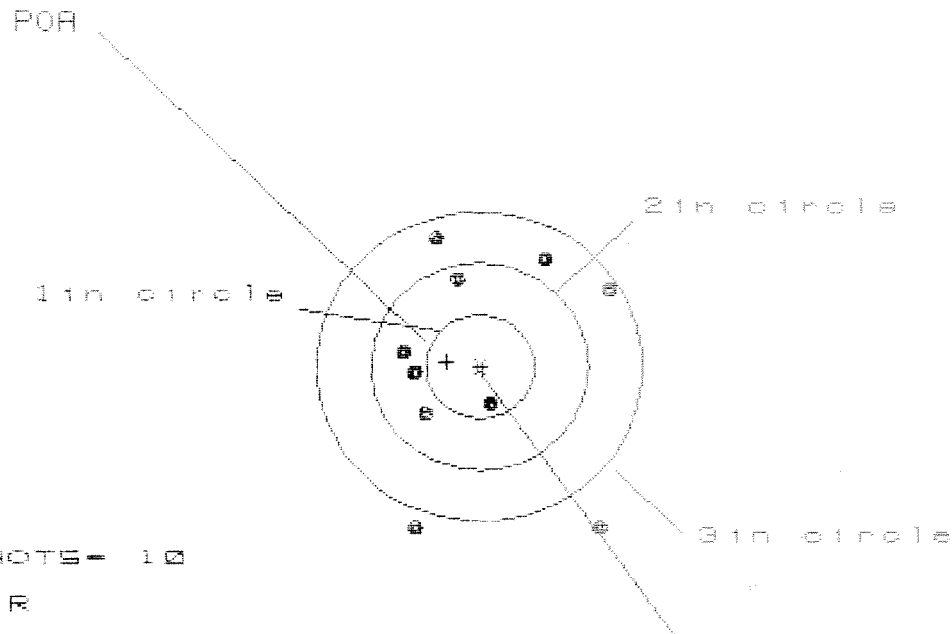
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.837	.830	.696
MINIMUM X	:	-1.161	-1.068	-.693
MAXIMUM Y	:	.893	.783	.791
MINIMUM Y	:	-.991	-1.090	-1.082
CENTROID X	:	.175	.082	.216
CENTROID Y	:	.015	.125	.117
POR TO CENTROID in.	:	.176	.150	.245
MIN RADIUS	:	.403	.546	.453
MEAN RADIUS	:	.892	.851	.809
MAX RADIUS	:	1.297	1.114	1.141
HORIZONTAL SPREAD	:	1.998	1.898	1.385
VERTICAL SPREAD	:	1.884	1.873	1.873
EXTREME SPREAD	:	2.401	2.105	2.105
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611504

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.910

VS= 2.804

GS= 3.186

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.205	1.331	1.271
MINIMUM X	:	-.705	-.579	-.639
MAXIMUM Y	:	1.243	1.070	.859
MINIMUM Y	:	-1.561	-1.686	-.850
CENTROID X	:	.305	.180	.240
CENTROID Y	:	-.044	.129	.340
POA TO CENTROID in.	:	.309	.222	.416
MIN RADIUS	:	.413	.515	.443
MEAN RADIUS	:	1.077	.953	.849
MAX RADIUS	:	1.925	1.752	1.328
HORIZONTAL SPREAD	:	1.910	1.910	1.910
VERTICAL SPREAD	:	2.804	2.756	1.705
EXTREME SPREAD	:	3.186	2.912	2.147
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611504

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 10

HS = 2.430

VS = 2.369

GS = 2.446

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.815	.820
MINIMUM X	:	-1.454	-.620	-.615
MAXIMUM Y	:	1.142	1.164	1.013
MINIMUM Y	:	-1.227	-1.205	-.830
CENTROID X	:	.087	.248	.243
CENTROID Y	:	.074	.052	.203
POA TO CENTROID in.	:	.114	.254	.317
MIN RADIUS	:	.124	.073	.051
MEAN RADIUS	:	.793	.690	.617
MAX RADIUS	:	1.467	1.296	1.160
HORIZONTAL SPREAD	:	2.430	1.435	1.435
VERTICAL SPREAD	:	2.369	2.369	1.843
EXTREME SPREAD	:	2.446	2.446	2.189
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11584

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.642

VS= 2.242

GS= 3.042

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.605

1.014

.945

MINIMUM X

-1.044

-.866

-.935

MAXIMUM Y

1.070

1.156

.944

MINIMUM Y

-1.172

-1.053

-.909

CENTROID X

.103

-.075

-.006

CENTROID Y

.104

-.015

-.159

POA TO CENTROID in.

.147

.077

.159

MIN RADIUS

.301

.185

.242

MEAN RADIUS

.937

.774

.713

MAX RADIUS

1.929

1.280

1.097

HORIZONTAL SPREAD

2.649

1.880

1.880

VERTICAL SPREAD

2.242

2.209

1.853

EXTREME SPREAD

3.042

2.402

1.914

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9