

C6611522

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.

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

MODEL 700TM M24

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

SERIAL NO.
C6611522

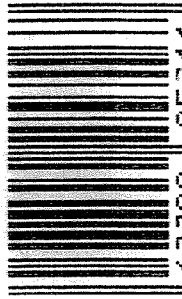
ORDER NO.
5716

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



5716 C6611522

LPC



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7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611522

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		3/24/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	JA
	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		4/18/91	JS

op. #	BARBER - M24 0078201	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-24-91	DH
	G) Safety Off Force	3	3	3			4-24-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	JK
	I) Firing Pin Indent	.021	.021	.022			4-19-91	DH
	J) Assemble Stock						4/25/91	KS
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	KS
	M) Iron Sight Alignment						4/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	KS
	O) Attach Scope to Rifle						4/25/91	KS
	P) Detach & Attach Scope 20 Times						4/25/91	KS
640	Gallery Target & Test						4-26-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-26-91	AF
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.42	2.18	2.20	2.29	2.20	5/10/91	JK
	C) Function						5-1-91	DH
660	Pack						6/18/91	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611522DATE 4/19/94TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.28	2.30	2.42	MIN. SETTING,
PULL #2	2.21	2.28	2.36	2.18	NO AVG. OF 5
PULL #3	2.34	2.34	2.36	2.20	READINGS ACCEPT-
PULL #4	2.31	2.32	2.34	2.29	ABLE LESS THAN 2#
PULL #5	2.31	2.34	2.31	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.46	3.35			
PULL #2	3.40	3.38			
PULL #3	3.35	3.35			
PULL #4	3.13	3.45			
PULL #5	3.31	3.13			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.40		4.25
PULL #2	4.41	4.49		4.39
PULL #3	4.44	4.47		4.35
PULL #4	4.46	4.56		4.50
PULL #5	4.39	4.39		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611522
25 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.060208
1 TO	2	.148637
1 TO	3	.226861
1 TO	4	.30399
1 TO	5	.129541

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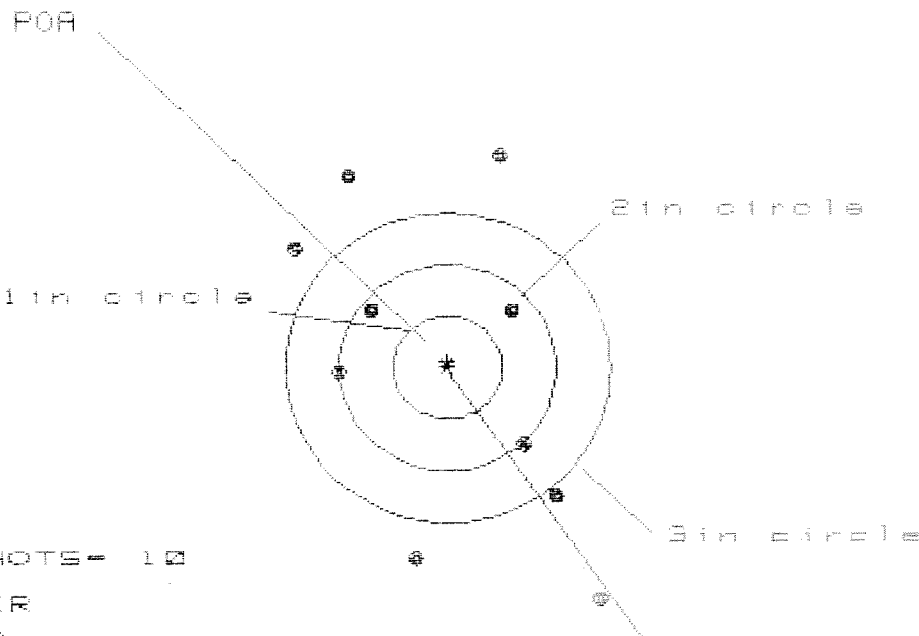
-----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.091
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141
THE AME FOR THIS RIFLE IS: .9214

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGBD11522

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 4

HS = 2.748

VS = 4.295

GS = 4.643

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	1.160	1.246
MINIMUM X	-1.376	-1.224	-1.137
MAXIMUM Y	2.055	1.806	1.809
MINIMUM Y	-2.240	-2.093	-1.867
CENTROID X	.005	-.147	-.234
CENTROID Y	-.060	.189	-.037
POA TO CENTROID in.	.060	.240	.236
MIN RADIUS	.846	.631	.698
MEAN RADIUS	1.581	1.429	1.558
MAX RADIUS	2.627	2.099	1.911
HORIZONTAL SPREAD	2.748	2.384	2.334
VERTICAL SPREAD	4.295	3.899	3.676
EXTREME SPREAD	4.643	3.989	3.717
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 4		

26 Apr 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 6

2 in = 7

3 in = 8

CENTROID *

HS= 1.685

VS= 2.794

GS= 2.888

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.521	.474	.323
MINIMUM X	:	-1.164	-1.211	-.252
MAXIMUM Y	:	1.236	1.063	1.110
MINIMUM Y	:	-1.558	-.640	-.593
CENTROID X	:	.027	.074	.225
CENTROID Y	:	.087	.260	.213
POA TO CENTROID in.	:	.091	.270	.310
MIN RADIUS	:	.104	.094	.125
MEAN RADIUS	:	.666	.566	.446
MAX RADIUS	:	1.613	1.268	1.116
HORIZONTAL SPREAD	:	1.685	1.685	.575
VERTICAL SPREAD	:	2.794	1.703	1.703
EXTREME SPREAD	:	2.888	1.758	1.742
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Apr 1991

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CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.700

VS= 3.066

GS= 3.069

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.871
MINIMUM X	:	-.829
MAXIMUM Y	:	1.066
MINIMUM Y	:	-2.000
CENTROID X	:	-.024
CENTROID Y	:	-.285
POR TO CENTROID IN.	:	.286
MIN RADIUS	:	.232
MEAN RADIUS	:	.835
MAX RADIUS	:	2.025
HORIZONTAL SPREAD	:	1.700
VERTICAL SPREAD	:	3.066
EXTREME SPREAD	:	3.069
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	8
NUMBER IN THREE INCH CIRCLE	=	9

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 9

HS= 2.675

VS= 1.622

GS= 2.678

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.626	.688
MINIMUM X	:	-1.844	-.795	-.741
MAXIMUM Y	:	.747	.791	.836
MINIMUM Y	:	-.875	-.831	-.732
CENTROID X	:	-.278	-.873	-.127
CENTROID Y	:	-.171	-.215	-.314
POA TO CENTROID in.	:	.327	.227	.338
MIN RADIUS	:	.343	.390	.322
MEAN RADIUS	:	.852	.787	.672
MAX RADIUS	:	1.885	.980	.931
HORIZONTAL SPREAD	:	2.675	1.421	1.421
VERTICAL SPREAD	:	1.622	1.622	1.568
EXTREME SPREAD	:	2.678	1.878	1.703
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611522

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 2.070

VS= 2.017

GS= 2.519

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.821	.580	.434
MINIMUM X	:	-1.257	-1.166	-.545
MAXIMUM Y	:	.888	.754	.774
MINIMUM Y	:	-1.137	-.917	-.897
CENTROID X	:	.130	.039	.184
CENTROID Y	:	-.026	.100	.080
POR TO CENTROID in.	:	.133	.107	.201
MIN RADIUS	:	.181	.106	.094
MEAN RADIUS	:	.673	.586	.474
MAX RADIUS	:	1.402	1.177	.947
HORIZONTAL SPREAD	:	2.078	1.746	.980
VERTICAL SPREAD	:	2.017	1.671	1.671
EXTREME SPREAD	:	2.519	1.759	1.690
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	