

06611525

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

\* Includes 1 in chamber.

*Remington*

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

**MODEL 700™ M24**

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

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

**SERIAL NO.**  
 C6611525

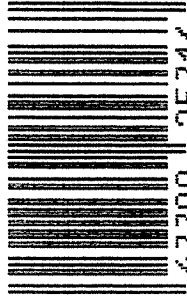
**ORDER NO.**  
**5716**

46



5716 C6611525

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611525

| OP. #        | OP. NAME                                                       | READINGS   | DATE    | INIT |
|--------------|----------------------------------------------------------------|------------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 25 91    |         | Rw   |
| 600          | Proof                                                          | 3 25 91    |         | Rw   |
| 607          | Check Headspace                                                | 3 25 91    |         | Rw   |
| 610          | Dis-assemble Gun                                               | 3 25 91    |         | Rw   |
| 612          | Magnaflux Barrel<br>Action                                     | 3 28 91    |         | KR   |
|              | Magnaflux Bolt                                                 | 3 28 91    |         | 11   |
| 615          | Rollmark Caliber                                               | 3 28 91    |         | LS   |
| 617          | Drill and Tap Sight Holes                                      | APR 3 1991 |         | FB   |
| 618          | Polish Barrel                                                  | APR 3 1991 |         | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |            | 4-11-91 | TJH  |
|              | Apply Coating (Bolt)                                           |            |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |            | 4/16/91 | Rw   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |            | 4/16/91 | Rw   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |            | 4/16/91 | Rw   |
|              | D) Oil Firing Pin Ass'y                                        |            | 4/16/91 | Rw   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |            | 5/4/91  | JH   |

| op. #        | BARBER - M24 0078255                                        | READINGS        |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|-----------------|------|------|------|------|---------|------|
|              | OP. NAME                                                    |                 |      |      |      |      |         |      |
| 625<br>cont. | F) Safety On Force                                          | 6 $\frac{1}{4}$ | 6    | 6    |      |      | 5-4-91  | DH   |
|              | G) Safety Off Force                                         | 3 $\frac{1}{4}$ | 3    | 3    |      |      | 5-4-91  | DH   |
|              | H) Trigger Pull Test & Retainability                        |                 |      |      |      |      | 5/4/91  | JH   |
|              | I) Firing Pin Indent                                        | .020            | .020 | .020 |      |      | 5-4-91  | DH   |
|              | J) Assemble Stock                                           |                 |      |      |      |      | 5/6/91  | RW   |
|              | K) Assemble Swivel Studs                                    |                 |      |      |      |      | 5-9-91  | A    |
|              | L) Attach Front and Rear Sight Assemblies                   |                 |      |      |      |      | 5/6/91  | RW   |
|              | M) Iron Sight Alignment                                     |                 |      |      |      |      | 5/6/91  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |                 |      |      |      |      | 5/6/91  | RW   |
|              | O) Attach Scope to Rifle                                    |                 |      |      |      |      | 5/6/91  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |                 |      |      |      |      | 5/6/91  | RW   |
| 640          | Gallery Target & Test                                       |                 |      |      |      |      | 5-6-91  | DH   |
|              | A) Time                                                     |                 |      |      |      |      | 5-6-91  | DH   |
|              | B) Malfunctions                                             |                 |      |      |      |      | 5-6-91  | DH   |
|              | C) Pierced Primers                                          |                 |      |      |      |      | 5-6-91  | DH   |
|              | D) Optical Clarity of Scope                                 |                 |      |      |      |      | 5-6-91  | DH   |
| 645          | Inspect for Live Ammo                                       |                 |      |      |      |      | 5-6-91  | DH   |
| 655          | Final Inspection                                            |                 |      |      |      |      |         |      |
|              | A) Headspace                                                |                 |      |      |      |      | 5-9-91  | A    |
|              | B) Trigger Pull                                             | 2.36            | 2.35 | 2.36 | 2.33 | 2.34 | 5/9/91  | JH   |
|              | C) Function                                                 |                 |      |      |      |      | 5-9-91  | A    |
| 660          | Pack                                                        |                 |      |      |      |      | 6-18-91 | N    |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611525

DATE 5-4-91

TESTER JM.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.41             | 2.25                     | 2.30                           | 2.36 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.36             | 2.32                     | 2.31                           | 2.35 |                                                                        |
| PULL #3 | 2.36             | 2.43                     | 2.38                           | 2.36 |                                                                        |
| PULL #4 | 2.45             | 2.36                     | 2.36                           | 2.33 |                                                                        |
| PULL #5 | 2.36             | 2.20                     | 2.36                           | 2.34 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.44             | 3.44                     |  |          |
| PULL #2 | 3.50             | 3.49                     |  |          |
| PULL #3 | 3.37             | 3.46                     |  |          |
| PULL #4 | 3.33             | 3.41                     |  |          |
| PULL #5 | 3.22             | 3.49                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.14             | 4.38                     |                                | 4.46                                 |
| PULL #2 | 4.56             | 4.50                     |                                | 4.51                                 |
| PULL #3 | 4.53             | 4.27                     |                                | 4.43                                 |
| PULL #4 | 4.52             | 4.45                     |                                | 4.57                                 |
| PULL #5 | 4.40             | 4.48                     |                                | 4.58                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611525  
6 May 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .24244   |
| 1 TO | 2 | .0855249 |
| 1 TO | 3 | .257049  |
| 1 TO | 4 | .337831  |
| 1 TO | 5 | .838452  |

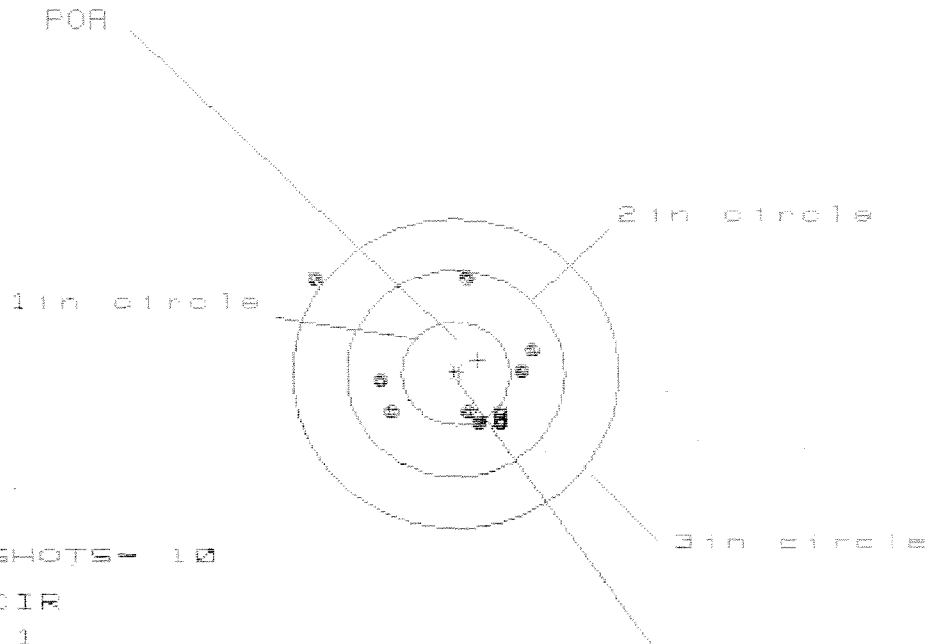
4 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .039  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0372  
THE RESULTING AVERAGE PCI RADIUS FOR THIS RIFLE IS: .0538960  
THE AMR FOR THIS RIFLE IS: 1.000

8 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611525

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.998

VS= 1.438

GS= 2.194

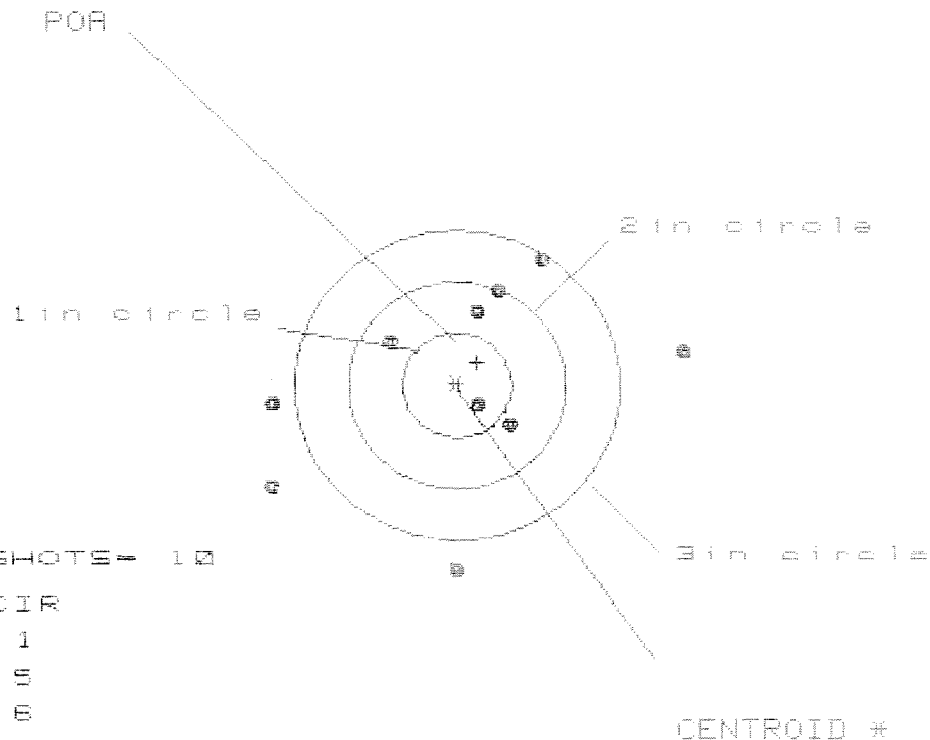
CENTROID \*

| PATTERN #                     | 1      | 2     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .735   | .595  | .586  |
| MINIMUM X                     | -1.263 | -.857 | -.866 |
| MAXIMUM Y                     | .933   | 1.029 | .494  |
| MINIMUM Y                     | -.505  | -.401 | -.273 |
| CENTROID X                    | -.204  | -.064 | -.055 |
| CENTROID Y                    | -.131  | -.235 | -.363 |
| POA TO CENTROID in.           | .243   | .243  | .367  |
| MIN RADIUS                    | .359   | .248  | .129  |
| MEAN RADIUS                   | .745   | .600  | .506  |
| MAX RADIUS                    | 1.570  | 1.031 | .877  |
| HORIZONTAL SPREAD             | 1.998  | 1.452 | 1.452 |
| VERTICAL SPREAD               | 1.438  | 1.430 | .767  |
| EXTREME SPREAD                | 2.194  | 1.494 | 1.494 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 5

3 in = 6

HS = 3.793

VS = 3.002

GS = 4.014

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 2.066  | .985   | .797   |
| MINIMUM X                     | -1.727 | -1.497 | -1.660 |
| MAXIMUM Y                     | 1.183  | 1.216  | 1.094  |
| MINIMUM Y                     | -1.819 | -1.786 | -1.908 |
| CENTROID X                    | -.187  | -.417  | -.229  |
| CENTROID Y                    | -.225  | -.258  | -.136  |
| POA TO CENTROID in.           | .292   | .490   | .267   |
| MIN RADIUS                    | .255   | .455   | .343   |
| MEAN RADIUS                   | 1.232  | 1.156  | 1.025  |
| MAX RADIUS                    | 2.088  | 1.798  | 1.908  |
| HORIZONTAL SPREAD             | 3.793  | 2.482  | 2.458  |
| VERTICAL SPREAD               | 3.002  | 3.002  | 3.002  |
| EXTREME SPREAD                | 4.014  | 3.312  | 3.100  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 6      |        |        |

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## CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 1

2in = 5

3in = 6

HS = 3.677

VS = 3.701

GS = 4.326

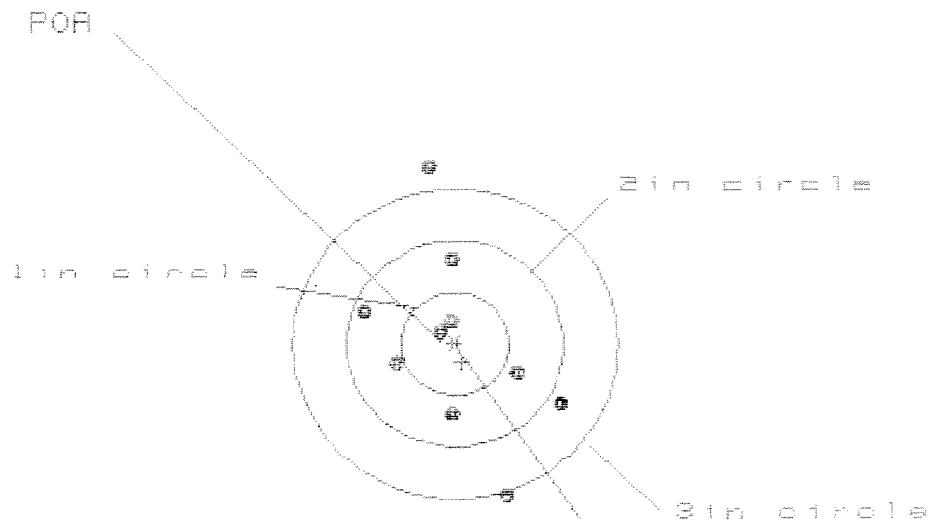
CENTROID #

| PATTERN #                     | 3      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.925  |
| MINIMUM X                     | -1.752 |
| MAXIMUM Y                     | 1.691  |
| MINIMUM Y                     | -2.010 |
| CENTROID X                    | .053   |
| CENTROID Y                    | -.126  |
| POA TO CENTROID in.           | .137   |
| MIN RADIUS                    | .428   |
| MEAN RADIUS                   | 1.370  |
| MAX RADIUS                    | 2.442  |
| HORIZONTAL SPREAD             | 3.677  |
| VERTICAL SPREAD               | 3.701  |
| EXTREME SPREAD                | 4.326  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |
| NUMBER IN TWO INCH CIRCLE =   | 3      |
| NUMBER IN THREE INCH CIRCLE = | 6      |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.774

VS= 3.290

GS= 3.376

CENTROID #

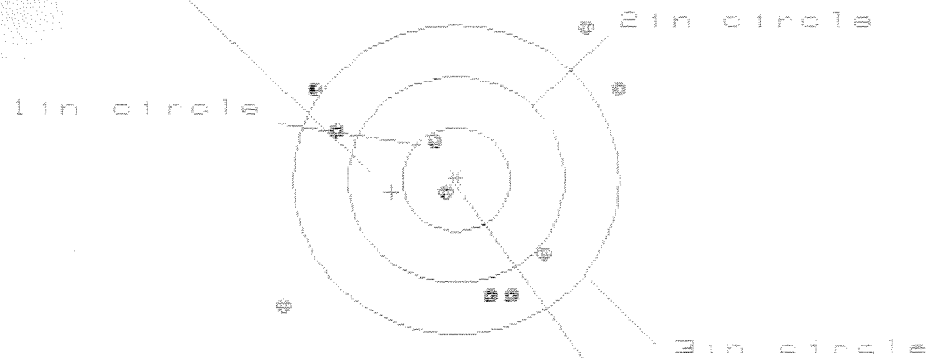
| PATTERN #                     | 4      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .917   | .886   | .941  |
| MINIMUM X                     | -.857  | -.888  | -.833 |
| MAXIMUM Y                     | 1.768  | 1.037  | .871  |
| MINIMUM Y                     | -1.522 | -1.326 | -.672 |
| CENTROID X                    | -.863  | -.832  | -.887 |
| CENTROID Y                    | .176   | -.020  | .146  |
| POA TO CENTROID in.           | .187   | .037   | .178  |
| MIN RADIUS                    | .174   | .364   | .198  |
| MEAN RADIUS                   | .858   | .766   | .651  |
| MAX RADIUS                    | 1.790  | 1.398  | 1.099 |
| HORIZONTAL SPREAD             | 1.774  | 1.774  | 1.774 |
| VERTICAL SPREAD               | 3.290  | 2.363  | 1.543 |
| EXTREME SPREAD                | 3.376  | 2.424  | 1.997 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |

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## CENTERFIRE PATTERNS # 5

POA



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 2

3in = 6

HS= 3.141

VS= 2.698

GS= 3.887

CENTROID \*

| PATTERN #                   | : | 5      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.501  | 1.319  | 1.441  |
| MINIMUM X                   | : | -1.640 | -1.443 | -1.321 |
| MAXIMUM Y                   | : | 1.524  | 1.394  | .953   |
| MINIMUM Y                   | : | -1.174 | -1.236 | -1.062 |
| CENTROID X                  | : | .596   | .778   | .656   |
| CENTROID Y                  | : | .120   | .250   | .076   |
| POA TO CENTROID in.         | : | .608   | .818   | .661   |
| MIN RADIUS                  | : | .142   | .366   | .178   |
| MEAN RADIUS                 | : | 1.234  | 1.163  | 1.054  |
| MAX RADIUS                  | : | 2.017  | 1.701  | 1.727  |
| HORIZONTAL SPREAD           | : | 3.141  | 2.762  | 2.762  |
| VERTICAL SPREAD             | : | 2.698  | 2.630  | 2.015  |
| EXTREME SPREAD              | : | 3.887  | 2.769  | 2.763  |
| NUMBER IN ONE INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 6      |        |        |