

C6611559

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

MODEL 700™ H24

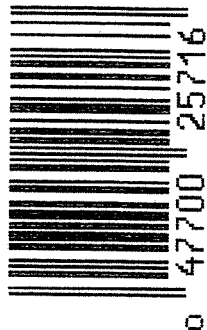
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO. C6611559	46
ORDER NO. 5716	



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611559

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KS
600	Proof		2/1/91	KS
607	Check Headspace		2/1/91	KS
610	Dis-assemble Gun		2/1/91	KS
612	Magnaflux Barrel Action	2 11 91		KS
	Magnaflux Bolt	2 11 91		KS
615	Rollmark Caliber	2 11 91		GS
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RBB	2 13 91		WLB
620	Apply Coatings (Barrel Action)		2/12/91	KS
	Apply Coating (Bolt)			KS
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/2/91	KS

op. #	BARBER M24 0078828	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-2-91	D/H
	G) Safety Off Force	2	2	2			4-2-91	D/H
	H) Trigger Pull Test & Retainability						4/2/91	JH
	I) Firing Pin Indent	.020	.0215	.021			4-2-91	D/H
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						4-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						4-5-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-5-91	AF
655	Final Inspection							
	A) Headspace						4-11-91	D/H
	B) Trigger Pull	2.34	2.38	2.37	2.33	2.37	4/10/91	JH
	C) Function						4-11-91	D/H
660	Pack						6-19-91	AF

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

SERIAL NO C-6611559DATE 4-2-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.28	2.32	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.28	2.30	2.38	
PULL #3	2.32	2.32	2.29	2.37	
PULL #4	2.29	2.32	2.38	2.33	
PULL #5	2.30	2.31	2.30	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.51		
PULL #2	3.49	3.47		
PULL #3	3.40	3.50		
PULL #4	3.47	3.49		
PULL #5	3.30	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.18		4.19
PULL #2	4.23	4.20		4.16
PULL #3	4.24	4.20		4.21
PULL #4	4.19	4.13		4.28
PULL #5	4.21	4.18		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611559
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.130138
1 TO	2	.202475
1 TO	3	.199279
1 TO	4	.272419
1 TO	5	.407443

$\frac{4}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0914
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0082
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0917671
THE AMR FOR THIS RIFLE IS: .761

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB1L559

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.399

VS= 1.777

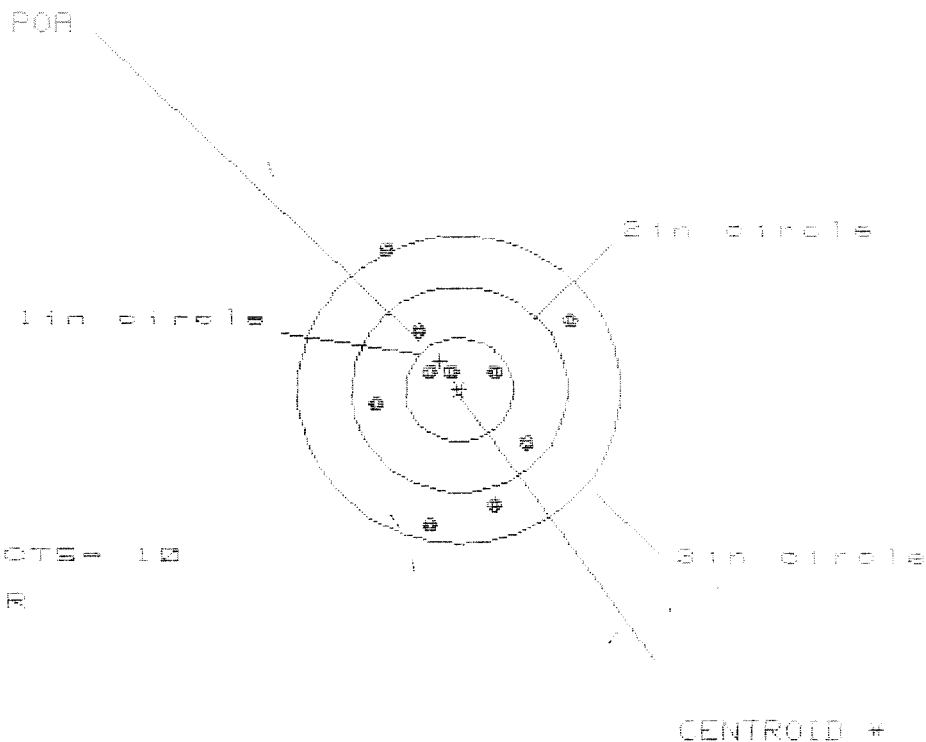
GS= 2.420

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.433	.584	.498
MINIMUM X	-.966	-.807	-.893
MAXIMUM Y	1.055	1.060	.970
MINIMUM Y	-.722	-.717	-.661
CENTROID X	.094	-.065	.021
CENTROID Y	-.090	-.095	-.085
POA TO CENTROID in.	.131	.115	.021
MIN RADIUS	.088	.131	.025
MEAN RADIUS	.704	.626	.564
MAX RADIUS	1.433	1.060	.974
HORIZONTAL SPREAD	2.399	1.391	1.391
VERTICAL SPREAD	1.777	1.777	1.631
EXTREME SPREAD	2.420	1.905	1.636
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/02611558

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.887

VS = 2.785

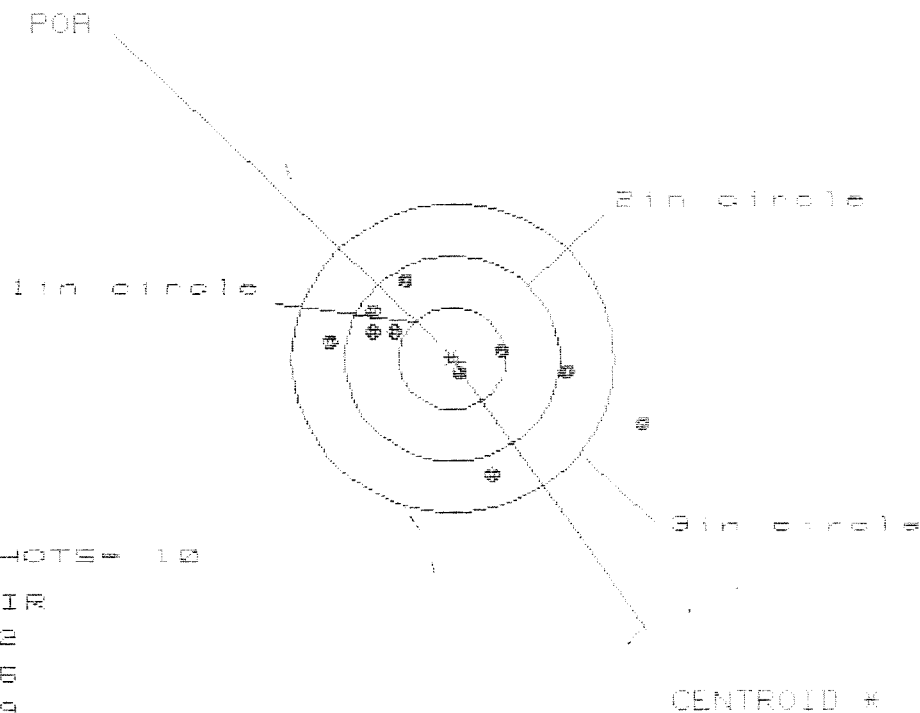
GS = 2.729

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	.999	.958
MINIMUM X	:	-.818	-.888	-.929
MAXIMUM Y	:	1.419	.824	.683
MINIMUM Y	:	-1.286	-1.128	-1.128
CENTROID X	:	.174	.244	.285
CENTROID Y	:	-.276	-.434	-.293
POA TO CENTROID in.	:	.327	.498	.409
MIN RADIUS	:	.150	.322	.225
MEAN RADIUS	:	.847	.788	.709
MAX RADIUS	:	1.551	1.295	1.176
HORIZONTAL SPREAD	:	1.887	1.887	1.887
VERTICAL SPREAD	:	2.785	1.952	1.803
EXTREME SPREAD	:	2.729	2.364	2.063
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611559

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.200

VS = 1.919

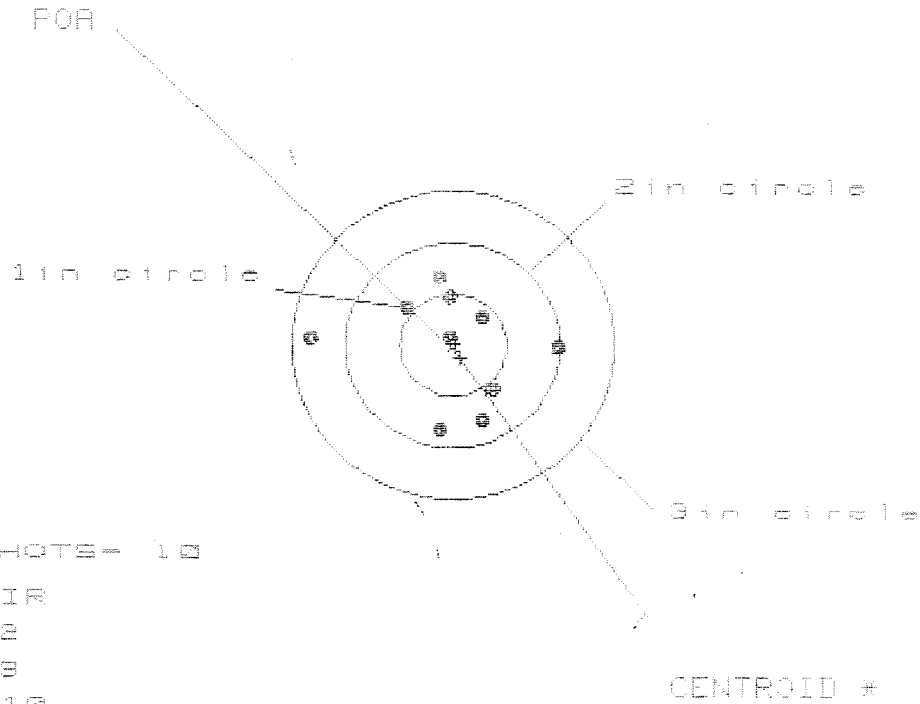
GS = 3.030

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.757	1.220	1.289
MINIMUM X	-1.152	-.956	-.887
MAXIMUM Y	.770	.698	.546
MINIMUM Y	-1.149	-1.221	-.990
CENTROID X	-.062	-.258	-.327
CENTROID Y	.034	.106	.258
POA TO CENTROID in.	.071	.278	.417
MIN RADIUS	.096	.275	.245
MEAN RADIUS	.098	.761	.656
MAX RADIUS	1.871	1.341	1.347
HORIZONTAL SPREAD	2.909	2.176	2.176
VERTICAL SPREAD	1.919	1.919	.936
EXTREME SPREAD	3.030	2.208	2.208
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 2.249

VS = 1.542

GS = 2.253

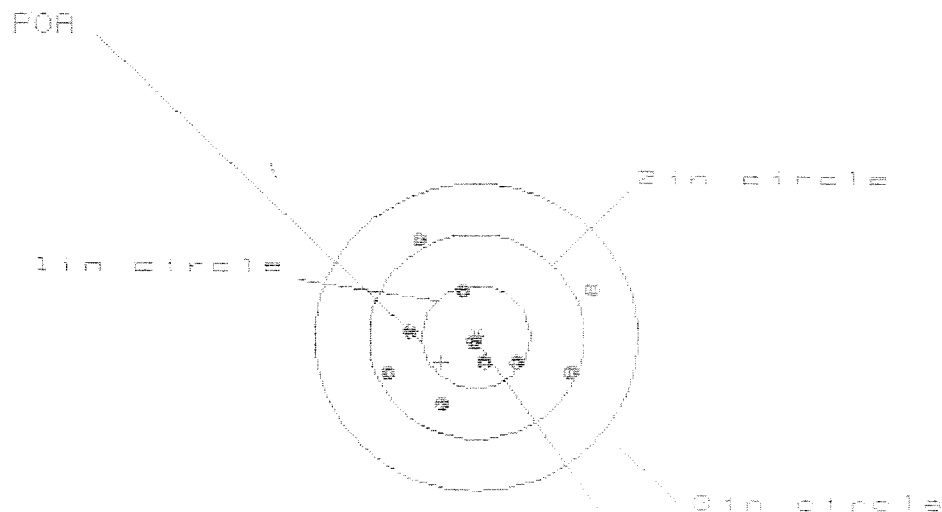
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.966	.823	.866
MINIMUM X	-1.284	-.618	-.515
MAXIMUM Y	.721	.728	.719
MINIMUM Y	-.821	-.814	-.823
CENTROID X	-.072	.071	-.082
CENTROID Y	.126	.119	.128
POA TO CENTROID in.	.145	.139	.132
MIN RADIUS	.075	.155	.078
MEAN RADIUS	.678	.602	.563
MAX RADIUS	1.285	.850	.835
HORIZONTAL SPREAD	2.249	1.441	.981
VERTICAL SPREAD	1.542	1.542	1.542
EXTREME SPREAD	2.253	1.542	1.542
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.926

VS = 1.616

GS = 2.102

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.098	.999	.950
MINIMUM X	-.828	-.706	-.755
MAXIMUM Y	.959	1.012	.610
MINIMUM Y	-.657	-.604	-.477
CENTROID X	.323	.201	.250
CENTROID Y	.247	.194	.068
POR TO CENTROID in.	.407	.280	.259
MIN RADIUS	.042	.093	.157
MEAN RADIUS	.678	.616	.548
MAX RADIUS	1.196	1.085	.969
HORIZONTAL SPREAD	1.926	1.705	1.705
VERTICAL SPREAD	1.616	1.616	1.087
EXTREME SPREAD	2.102	1.924	1.705
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	