

C6611571

MODEL 700TM M24

Model S&S TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6611571
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611571

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	2/1/91	KJ
600	Proof		2/1/91	KJ
607	Check Headspace		2/1/91	KJ
610	Dis-assemble Gun		2/1/91	KJ
612	Magnaflux Barrel Action	2 11 91		Ked
	Magnaflux Bolt	2 11 91		WCR
615	Rollmark Caliber	2 11 91		GS
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2/2/91	TS
	Apply Coating (Bolt)			
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		3/25/91	WB

op. #	BARBER - M24 0078978 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			3/25/91	W.B.
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			3/25/91	W.B.
	H) Trigger Pull Test & Retainability						3/25/91	W.B.
	I) Firing Pin Indent	.0215	.0205	.021			3/25/91	W.B.
	J) Assemble Stock						9/25/91	K.S.
	K) Assemble Swivel Studs						4-22-91	E
	L) Attach Front and Rear Sight Assemblies						9/25/91	K.S.
	M) Iron Sight Alignment						9/25/91	K.S.
	N) Detach Front & Rear Sights & place in numbered container						9/25/91	K.S.
	O) Attach Scope to Rifle						9/25/91	K.S.
	P) Detach & Attach Scope 20 Times						9/25/91	K.S.
640	Gallery Target & Test						4/4/91	128
	A) Time							29
	B) Malfunctions							13
	C) Pierced Primers							10
	D) Optical Clarity of Scope							12
645	Inspect for Live Ammo						4/4/91	14
655	Final Inspection						4-22-91	K
	A) Headspace							
	B) Trigger Pull	2.45	2.50	2.37	2.56	2.44	4/5/91	24
	C) Function						2-22-91	K
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611527

DATE 3/25/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.48	2.59	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.42	2.58	2.50	
PULL #3	2.57	2.50	2.59	2.37	
PULL #4	2.37	2.48	2.57	2.56	
PULL #5	2.65	2.52	2.48	2.44	
TOTAL	12.57	12.41	12.81	12.81	
AVG.	2.51	2.48	2.56		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.72	3.25		
PULL #2	3.27	3.23		
PULL #3	3.28	3.11		
PULL #4	3.17	3.29		
PULL #5	3.32	3.29		
TOTAL	16.16	16.17		
AVG.	3.23	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.13		4.33
PULL #2	4.06	3.95		4.34
PULL #3	4.12	4.09		4.09
PULL #4	4.01	4.14		4.28
PULL #5	4.16	4.00		4.39
TOTAL	20.48	20.31		21.41
AVG.	4.09	4.06		4.28

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611571
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.276154
1 TO	2	.0610737
1 TO	3	.300193
1 TO	4	.175026
1 TO	5	.154029

POA <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .22773
THE AMR FOR THIS RIFLE IS: .7744

4 Apr 1991

FILE://PATTERNING/CENTERFIRE_PATT/C661157

CENTERFIRE PATTERNS

1

FOR

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.321

VS = 2.160

GS = 2.321

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.267	.821	.810
MINIMUM X	-1.054	-.913	-.925
MAXIMUM Y	.944	.975	.827
MINIMUM Y	-1.216	-1.185	-1.811
CENTROID X	.255	.114	.126
CENTROID Y	-.106	-.137	.011
FOR TO CENTROID (in)	.276	.178	.126
MIN RADIUS	.215	.309	.069
MEAN RADIUS	.813	.750	.701
MAX RADIUS	1.297	1.188	.941
HORIZONTAL SPREAD	2.321	1.734	1.734
VERTICAL SPREAD	2.160	2.160	1.638
EXTREME SPREAD	2.321	2.182	1.759
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6811571

CENTERFIRE PATTERNS # 2

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 0

3 in = 0

IS = 2.593

VS = 1.836

GS = 2.606

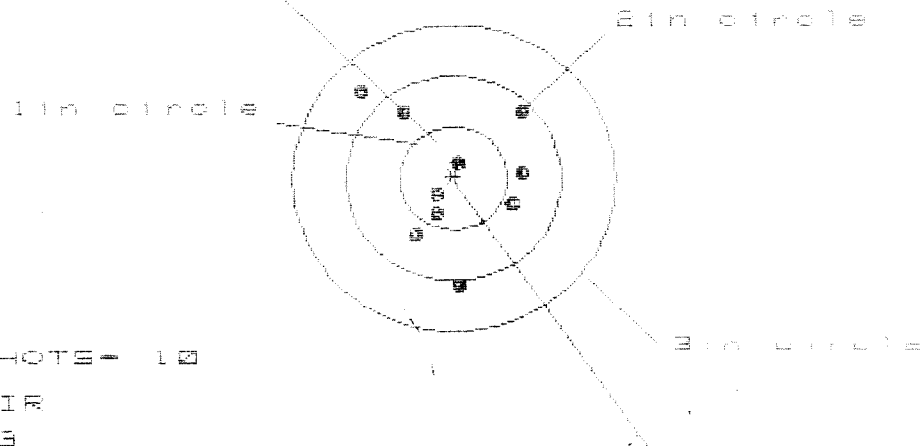
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.649	.618
MINIMUM X	-1.750	-.920	-.951
MAXIMUM Y	1.155	1.171	.653
MINIMUM Y	-.681	-.665	-.519
CENTROID X	.302	.496	.527
CENTROID Y	-.067	-.083	-.229
FOR TO CENTROID in.	.309	.503	.675
MIN RADIUS	.432	.239	.212
MEAN RADIUS	.863	.716	.645
MAX RADIUS	1.756	1.197	.957
HORIZONTAL SPREAD	2.593	1.569	1.569
VERTICAL SPREAD	1.836	1.836	1.172
EXTREME SPREAD	2.606	1.966	1.569
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	

4 Apr 1991

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

LS = 1.500

VS = 1.811

GS = 2.016

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.659	.565	.558
MINIMUM X	-.849	-.513	-.520
MAXIMUM Y	.812	.784	.671
MINIMUM Y	-.999	-.909	-.588
CENTROID X	-.041	.053	.060
CENTROID Y	-.156	-.246	-.133
FOR TO CENTROID in.	.162	.252	.146
MIN RADIUS	.123	.211	.144
MEAN RADIUS	.662	.599	.560
MAX RADIUS	1.175	.966	.871
HORIZONTAL SPREAD	1.500	1.078	1.078
VERTICAL SPREAD	1.811	1.693	1.251
EXTREME SPREAD	2.016	1.803	1.631
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11571

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.3000

VS = 1.349

GS = 1.672

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.797	.558	.388
MINIMUM X	:	-.503	-.414	-.345
MAXIMUM Y	:	.685	.615	.663
MINIMUM Y	:	-.664	-.734	-.657
CENTROID X	:	.102	.013	-.056
CENTROID Y	:	-.021	.049	-.028
POR TO CENTROID in.	:	.104	.051	.053
MIN RADIUS	:	.317	.351	.399
MEAN RADIUS	:	.641	.591	.554
MAX RADIUS	:	1.015	.830	.742
HORIZONTAL SPREAD	:	1.300	.972	.731
VERTICAL SPREAD	:	1.349	1.349	1.320
EXTREME SPREAD	:	1.672	1.494	1.362
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Apr 1931

FILE:/PATTERNING/CENTERFIRE_PATT/06611571

CENTERFIRE PATTERNS # 5

FOR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.345

VS = 2.540

GS = 2.549

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.741	.345	.388
MINIMUM X	-.504	-.422	-.379
MAXIMUM Y	1.299	1.437	1.210
MINIMUM Y	-1.241	-1.103	-.923
CENTROID X	.396	.314	.271
CENTROID Y	-.158	-.306	-.486
POA TO CENTROID in.	.431	.439	.556
MIN RADIUS	.338	.180	.018
MEAN RADIUS	.893	.790	.651
MAX RADIUS	1.444	1.477	1.235
HORIZONTAL SPREAD	1.245	.767	.767
VERTICAL SPREAD	2.540	2.540	2.133
EXTREME SPREAD	2.549	2.542	2.197
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	