

C6611621

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

|                                                                                                                                                                      |  |                                                                                                      |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------|
|   |  | <p>VERY IMPORTANT:<br/>Instruction Book<br/>enclosed to assure<br/>safe use of this<br/>firearm.</p> |
| <p>MODEL 700<sup>TM</sup> M24</p>                                                                                                                                    |  | <p>SERIAL NO.<br/>C6611621</p>                                                                       |
| <p>MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat &amp; Tm. Off, Marca Registrada Marque Deposee.</p>                                                                      |  | <p>ORDER NO.<br/>5716</p>                                                                            |



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611621

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 2 1 91   |         | RW   |
| 600          | Proof                                                          | 2 1 91   |         | RW   |
| 607          | Check Headspace                                                | 2 1 91   |         | RW   |
| 610          | Dis-assemble Gun                                               | 2 1 91   |         | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | 2 1 1 91 |         | KCR  |
|              | Magnaflux Bolt                                                 | 2 1 1 91 |         | KCR  |
| 615          | Rollmark Caliber                                               | 2 1 1 91 |         | CS   |
| 617          | Drill and Tap Sight Holes                                      | 2 1 3 91 |         | FB   |
| 618          | Polish Barrel RAB                                              | 2 1 3 91 |         | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 3/25/91 | WB   |
|              | Apply Coating (Bolt)                                           |          | 3/25/91 | WB   |
| 625          | Final Assembly                                                 |          |         |      |
|              | A) Clean inside of<br>Bolt Assembly                            |          | 3/25/91 | WB   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 3/25/91 | WB   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 3/25/91 | WB   |
|              | D) Oil Firing Pin Ass'y                                        |          | 3/25/91 | WB   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 4/8/91  | JL   |

| op. #        | BARBER - M24 0079727<br>OP. NAME                            | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5 1/4    | 5 1/4 | 5     |      |      | 4-10-91 | DH   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/4 | 2 1/4 |      |      | 4-10-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 4/8/91  | RU   |
|              | I) Firing Pin Indent                                        | .022     | .022  | .022  |      |      | 4-10-91 | DH   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 4/10/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4-22-91 | A    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 4/12/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 4/12/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 4/12/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 4/12/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 4/12/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4/12/91 | KJ   |
|              | A) Time                                                     |          |       |       |      |      |         | KJ   |
|              | B) Malfunctions                                             |          |       |       |      |      |         | KJ   |
|              | C) Pierced Primers                                          |          |       |       |      |      |         | KJ   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      |         | KJ   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4/12/91 | KJ   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 4-22-91 | A    |
|              | B) Trigger Pull                                             | 2.28     | 2.20  | 2.26  | 2.28 | 2.27 | 4/16/91 | RU   |
|              | C) Function                                                 |          |       |       |      |      | 4-22-91 | A    |
| 660          | Pack                                                        |          |       |       |      |      | 6-18-91 | AF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611621

DATE 4/8/91

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.22             | 2.29                     | 2.38                           | 2.28 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.20             | 2.18                     | 2.30                           | 2.20 |                                                                        |
| PULL #3 | 2.40             | 2.27                     | 2.26                           | 2.26 |                                                                        |
| PULL #4 | 2.28             | 2.36                     | 2.38                           | 2.28 |                                                                        |
| PULL #5 | 2.27             | 2.30                     | 2.35                           | 2.27 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.45             | 3.42                     |  |          |
| PULL #2 | 3.21             | 3.58                     |  |          |
| PULL #3 | 3.22             | 3.51                     |  |          |
| PULL #4 | 3.38             | 3.56                     |  |          |
| PULL #5 | 3.40             | 3.58                     |  |          |
| 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 | 4.30             | 4.50                     |                                | 4.25                                 |
| PULL #2 | 4.20             | 4.57                     |                                | 4.34                                 |
| PULL #3 | 4.22             | 4.24                     |                                | 4.39                                 |
| PULL #4 | 4.50             | 4.37                     |                                | 4.30                                 |
| PULL #5 | 4.30             | 4.27                     |                                | 4.22                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611621  
12 Apr 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .186132 |
| 1 TO | 2 | .273222 |
| 1 TO | 3 | .152118 |
| 1 TO | 4 | .349326 |
| 1 TO | 5 | .211873 |

21 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .001  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0182  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0182275  
THE AMR FOR THIS RIFLE IS: 1.013

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## CENTERFIRE PATTERNS

# 1

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.896

VS= 1.788

GS= 2.922

CENTROID \*

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.337

1.164

.558

-1.559

-.458

-.313

.938

.897

.894

-.850

-.891

-.894

.137

.310

.165

.126

.167

.178

.186

.352

.236

.246

.211

.261

.711

.605

.517

1.602

1.164

.947

2.896

1.622

.871

1.788

1.788

1.788

2.922

1.840

1.818

5

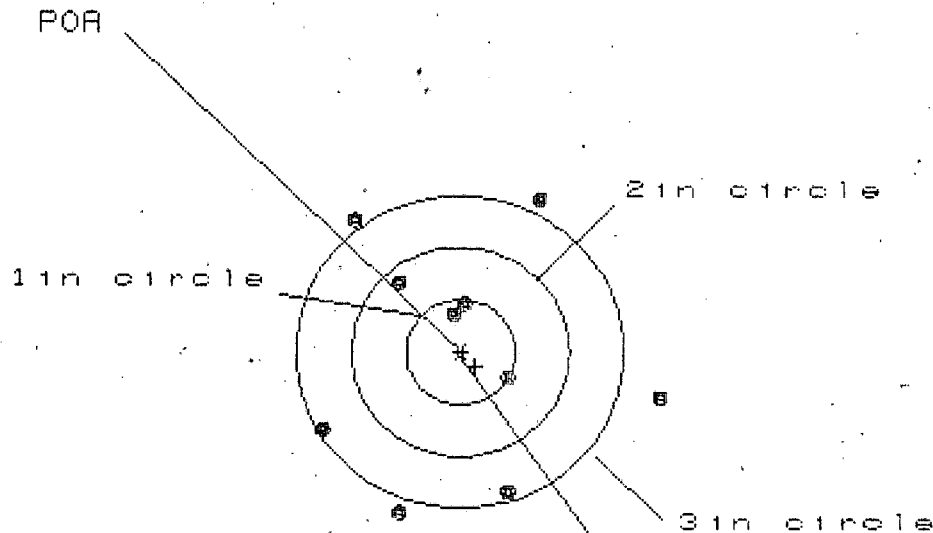
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9

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.082

VS= 3.029

GS= 3.268

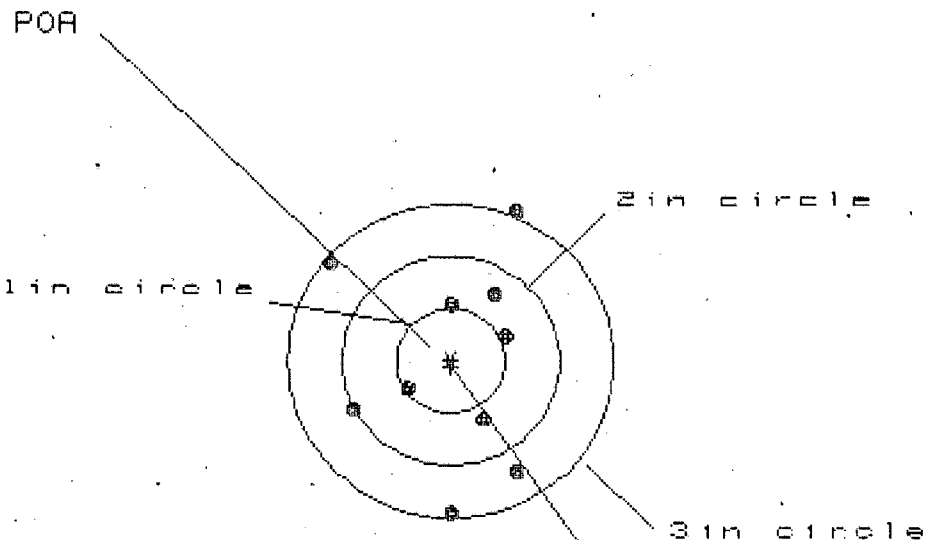
CENTROID \*

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.791  | .891   | .768   |
| MINIMUM X                     | -1.291 | -1.092 | -.980  |
| MAXIMUM Y                     | 1.500  | 1.451  | 1.405  |
| MINIMUM Y                     | -1.529 | -1.578 | -1.396 |
| CENTROID X                    | -.136  | -.335  | -.447  |
| CENTROID Y                    | .137   | .186   | .004   |
| POA TO CENTROID in.           | .193   | .383   | .447   |
| MIN RADIUS                    | .364   | .325   | .535   |
| MEAN RADIUS                   | 1.178  | 1.091  | 1.041  |
| MAX RADIUS                    | 1.844  | 1.703  | 1.535  |
| HORIZONTAL SPREAD             | 3.082  | 1.983  | 1.748  |
| VERTICAL SPREAD               | 3.029  | 3.029  | 2.801  |
| EXTREME SPREAD                | 3.268  | 3.268  | 2.937  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 6      |        |        |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.767

VS= 2.819

GS= 2.877

CENTROID \*

| PATTERN #                     | 1      | 3      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .650   | .712   | .580   |
| MINIMUM X                     | -1.117 | -1.055 | -.973  |
| MAXIMUM Y                     | 1.404  | 1.082  | .932   |
| MINIMUM Y                     | -1.415 | -1.259 | -1.123 |
| CENTROID X                    | -.001  | -.063  | .069   |
| CENTROID Y                    | .062   | -.094  | -.230  |
| POA TO CENTROID in.           | .062   | .113   | .240   |
| MIN RADIUS                    | .486   | .351   | .353   |
| MEAN RADIUS                   | .962   | .893   | .802   |
| MAX RADIUS                    | 1.510  | 1.512  | 1.127  |
| HORIZONTAL SPREAD             | 1.767  | 1.767  | 1.553  |
| VERTICAL SPREAD               | 2.819  | 2.341  | 2.055  |
| EXTREME SPREAD                | 2.877  | 2.678  | 2.099  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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## CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 2

3in = 8

HS= 2.544

VS= 2.581

GS= 2.777

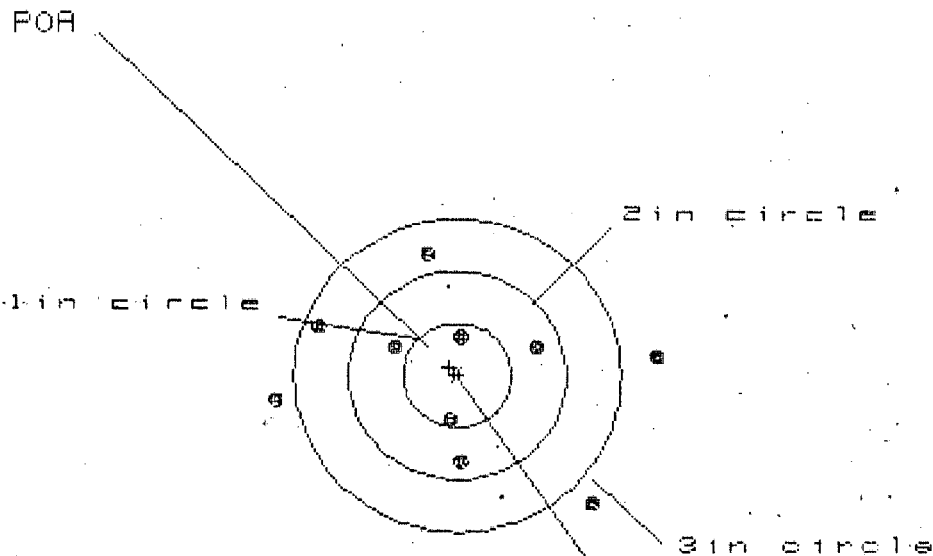
CENTROID \*

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.235  | 1.136  | 1.141  |
| MINIMUM X                     | -1.309 | -1.408 | -1.403 |
| MAXIMUM Y                     | 1.245  | 1.176  | 1.026  |
| MINIMUM Y                     | -1.336 | -1.198 | -1.143 |
| CENTROID X                    | -.065  | .034   | .029   |
| CENTROID Y                    | -.159  | -.297  | -.147  |
| POA TO CENTROID in.           | .172   | .299   | .150   |
| MIN RADIUS                    | .320   | .444   | .295   |
| MEAN RADIUS                   | 1.130  | 1.072  | 1.045  |
| MAX RADIUS                    | 1.531  | 1.469  | 1.429  |
| HORIZONTAL SPREAD             | 2.544  | 2.544  | 2.544  |
| VERTICAL SPREAD               | 2.581  | 2.374  | 2.169  |
| EXTREME SPREAD                | 2.777  | 2.582  | 2.582  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 2      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.516

VS= 2.314

GS= 3.530

CENTROID #

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.658  | 1.399  | 1.132  |
| MINIMUM X                     | -1.658 | -1.451 | -1.276 |
| MAXIMUM Y                     | 1.131  | 1.146  | 1.000  |
| MINIMUM Y                     | -1.183 | -1.168 | -0.986 |
| CENTROID X                    | .070   | -.137  | -.312  |
| CENTROID Y                    | -.075  | -.090  | .056   |
| POA TO CENTROID in.           | .102   | .164   | .317   |
| MIN RADIUS                    | .385   | .426   | .270   |
| MEAN RADIUS                   | 1.083  | .982   | .856   |
| MAX RADIUS                    | 1.863  | 1.823  | 1.313  |
| HORIZONTAL SPREAD             | 3.516  | 2.850  | 2.408  |
| VERTICAL SPREAD               | 2.314  | 2.314  | 1.986  |
| EXTREME SPREAD                | 3.530  | 3.022  | 2.442  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |