

C6611623

MODEL 700<sup>TM</sup> M24

Model S&S<sup>TM</sup>

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><b>MODEL 700™ M24</b></p>                                                                                                                                         |  | <p><b>SERIAL NO.</b><br/>C6611623</p>                                                                |
| <p>MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat &amp; Tm. Off, Marca Registrada Marque Deposee.</p>                                                                      |  | <p><b>ORDER NO.</b><br/><b>5716</b></p>                                                              |



5716 C6611623



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611623

| 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 11     | 91      | KCD                |
|              | Magnaflux Bolt                                                 | 2 11     | 91      | KCD                |
| 615          | Rollmark Caliber                                               | 2 11     | 91      | GB                 |
| 617          | Drill and Tap Sight Holes                                      | 2 18     | 91      | FB                 |
| 618          | Polish Barrel <i>BBB</i>                                       | 2 18     | 91      | WB                 |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 91      | <del>WB</del>      |
|              | Apply Coating (Bolt)                                           |          | 91      | <del>WB</del>      |
| 625          | Final Assembly<br>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             |          | 4/3/91  | <i>[Signature]</i> |

| op. #        | BARBER - M24 0079759<br>OP. NAME                            | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 4/5/91  | JK   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |      |      | 4/5/91  | JK   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 4/3/91  | JK   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 4/5/91  | JK   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 4/10/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4/17/91 | JK   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 4/10/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 4/10/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 4/10/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 4/10/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 4/10/91 | RW   |
|              |                                                             |          |       |       |      |      |         |      |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4/11/91 | KS   |
|              | A) Time                                                     |          |       |       |      |      |         | KS   |
|              | B) Malfunctions                                             |          |       |       |      |      |         | KS   |
|              | C) Pierced Primers                                          |          |       |       |      |      |         | KS   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      |         | KS   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4/11/91 | KS   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 4-17-91 | AC   |
|              | B) Trigger Pull                                             | 2.45     | 2.52  | 2.50  | 2.53 | 2.45 | 4/16/91 | JK   |
|              | C) Function                                                 |          |       |       |      |      | 4-17-91 | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 4-18-91 | RV   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611623DATE 4/3/91TESTER JF

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.24             | 2.30                     | 2.36                           | 2.45 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.18             | 2.38                     | 2.39                           | 2.52 |                                                                        |
| PULL #3 | 2.20             | 2.29                     | 2.39                           | 2.50 |                                                                        |
| PULL #4 | 2.28             | 2.36                     | 2.37                           | 2.53 |                                                                        |
| PULL #5 | 2.30             | 2.39                     | 2.39                           | 2.45 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.55             | 3.36                     |  |          |
| PULL #2 | 3.35             | 3.35                     |  |          |
| PULL #3 | 3.36             | 3.36                     |  |          |
| PULL #4 | 3.30             | 3.38                     |  |          |
| PULL #5 | 3.34             | 3.37                     |  |          |
| 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 | 4.23             | 4.14                     |                                | 4.30                                 |
| PULL #2 | 4.18             | 4.17                     |                                | 4.28                                 |
| PULL #3 | 4.20             | 4.21                     |                                | 4.35                                 |
| PULL #4 | 4.25             | 4.23                     |                                | 4.22                                 |
| PULL #5 | 4.25             | 4.30                     |                                | 4.28                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
 FOR RIFLE # C6611623  
 11 Apr 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .245165  |
| 1 TO | 2 | .412685  |
| 1 TO | 3 | .215745  |
| 1 TO | 4 | .0180278 |
| 1 TO | 5 | .509927  |

5A K----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0476  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0264  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0544309  
 THE AMR FOR THIS RIFLE IS: .7782

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/08611623

## CENTERFIRE PATTERNS

# 1

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.498

VS = 1.607

GS = 2.521

CENTROID \*

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.411

1.058

.942

MINIMUM X

-1.087

-.930

-.746

MAXIMUM Y

.807

.783

.789

MINIMUM Y

-.800

-.824

-.898

CENTROID X

.241

.084

.200

CENTROID Y

.045

.069

.143

POA TO CENTROID in.

.245

.109

.246

MIN RADIUS

.263

.344

.354

MEAN RADIUS

.852

.773

.728

MAX RADIUS

1.429

1.274

1.136

HORIZONTAL SPREAD

2.498

1.988

1.688

VERTICAL SPREAD

1.607

1.607

1.607

EXTREME SPREAD

2.521

2.374

1.890

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

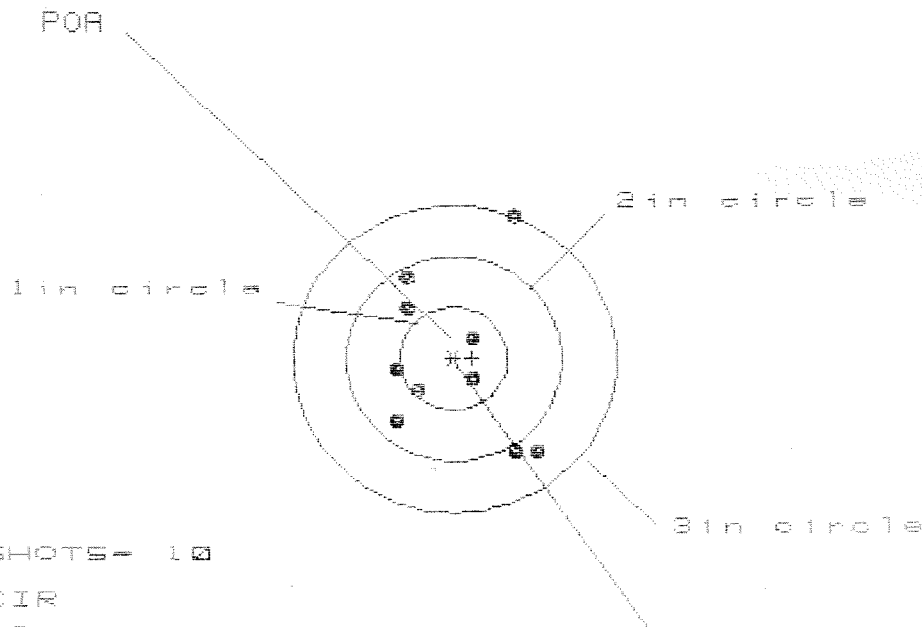
NUMBER IN THREE INCH CIRCLE =

10

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FILE:/PATTERNING/CENTERFIRE\_PATT/08811623

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.274

VS = 2.227

GS = 2.227

PATTERN #

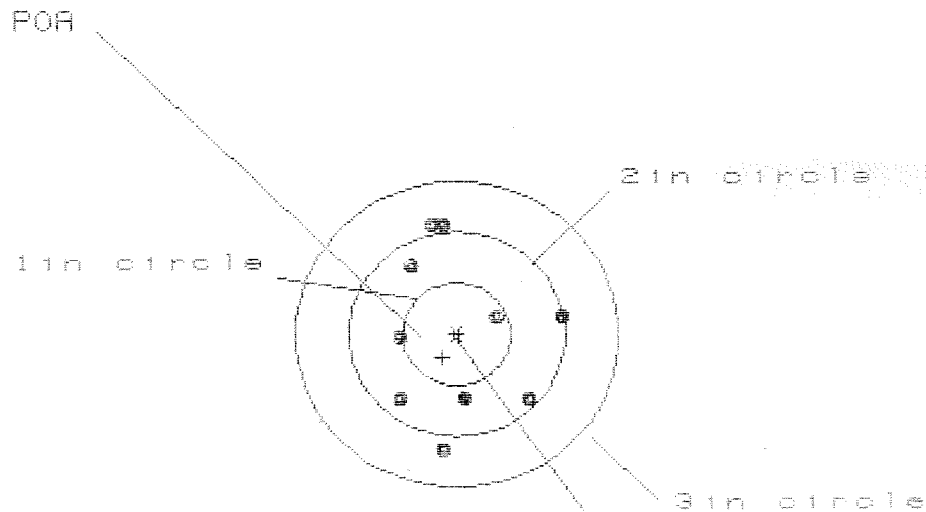
2

| SHOTS (BEST OF)               | 10    | 9     | 8     |
|-------------------------------|-------|-------|-------|
| MAXIMUM X                     | .764  | .831  | .742  |
| MINIMUM X                     | -.510 | -.443 | -.340 |
| MAXIMUM Y                     | 1.352 | .938  | .840  |
| MINIMUM Y                     | -.875 | -.724 | -.814 |
| CENTROID X                    | -.169 | -.236 | -.340 |
| CENTROID Y                    | -.002 | -.153 | -.063 |
| POA TO CENTROID in.           | .169  | .281  | .345  |
| MIN RADIUS                    | .249  | .202  | .259  |
| MEAN RADIUS                   | .744  | .641  | .569  |
| MAX RADIUS                    | 1.479 | 1.095 | 1.101 |
| HORIZONTAL SPREAD             | 1.274 | 1.274 | 1.081 |
| VERTICAL SPREAD               | 2.227 | 1.662 | 1.662 |
| EXTREME SPREAD                | 2.227 | 2.040 | 1.942 |
| NUMBER IN ONE INCH CIRCLE =   |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |       | 7     |       |
| NUMBER IN THREE INCH CIRCLE = |       | 10    |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.540

VS= 2.160

GS= 2.160

PATTERN #

3

| SHOTS (BEST OF)               | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| MAXIMUM X                     | .995   | .976  | .952  |
| MINIMUM X                     | -.545  | -.564 | -.588 |
| MAXIMUM Y                     | 1.042  | .918  | 1.013 |
| MINIMUM Y                     | -1.118 | -.756 | -.641 |
| CENTROID X                    | .130   | .149  | .173  |
| CENTROID Y                    | .230   | .354  | .239  |
| POA TO CENTROID in.           | .264   | .384  | .295  |
| MIN RADIUS                    | .363   | .315  | .321  |
| MEAN RADIUS                   | .826   | .788  | .758  |
| MAX RADIUS                    | 1.130  | .976  | 1.052 |
| HORIZONTAL SPREAD             | 1.540  | 1.540 | 1.540 |
| VERTICAL SPREAD               | 2.160  | 1.674 | 1.654 |
| EXTREME SPREAD                | 2.160  | 1.867 | 1.867 |
| NUMBER IN ONE INCH CIRCLE =   |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |

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## CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.588

VS= 2.340

GS= 2.344

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

:

.707

.734

.784

MINIMUM X

:

-.881

-.854

-.804

MAXIMUM Y

:

1.433

.955

.868

MINIMUM Y

:

-.907

-.748

-.835

CENTROID X

:

.240

.213

.163

CENTROID Y

:

.863

-.096

-.010

POA TO CENTROID in.

:

.248

.234

.164

MIN RADIUS

:

.218

.120

.180

MEAN RADIUS

:

.707

.604

.575

MAX RADIUS

:

1.452

.986

.891

HORIZONTAL SPREAD

:

1.588

1.588

1.588

VERTICAL SPREAD

:

2.340

1.703

1.703

EXTREME SPREAD

:

2.344

1.769

1.743

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

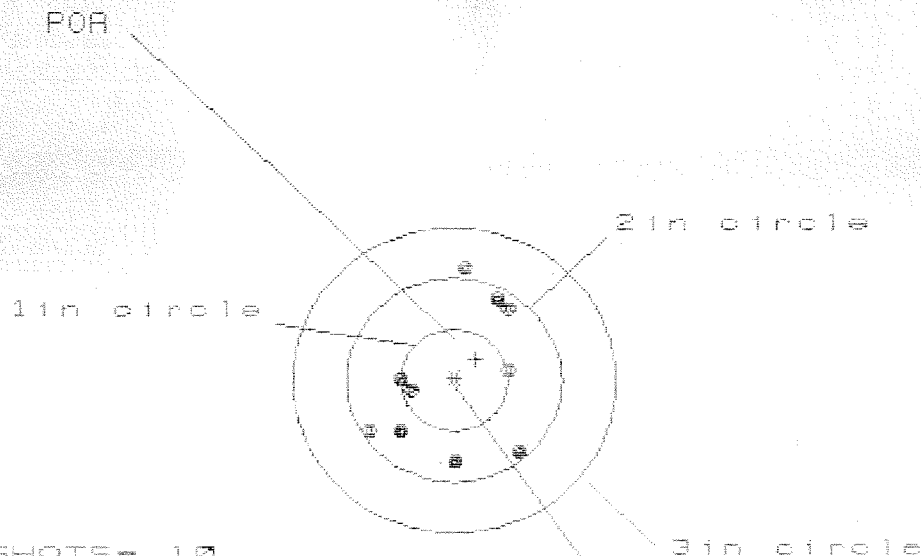
NUMBER IN THREE INCH CIRCLE =

10

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FILE:/PATTERNING/CENTERFIRE\_PATT/C8811623

## CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.457

VS= 1.858

GS= 1.904

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.628

.645

.613

MINIMUM X

-.829

-.812

-.731

MAXIMUM Y

1.101

.918

.840

MINIMUM Y

-.756

-.634

-.712

CENTROID X

-.204

-.221

-.302

CENTROID Y

-.204

-.327

-.249

POA TO CENTROID in.

.289

.395

.392

MIN RADIUS

.373

.357

.271

MEAN RADIUS

.762

.709

.672

MAX RADIUS

1.112

1.000

.967

HORIZONTAL SPREAD

1.457

1.457

1.344

VERTICAL SPREAD

1.858

1.552

1.552

EXTREME SPREAD

1.904

1.772

1.772

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

10