

C6611623

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

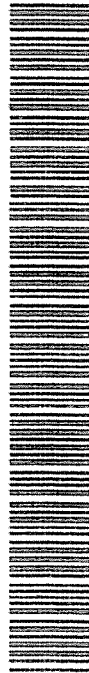
Order No. 5716

*Includes 1 in chamber.



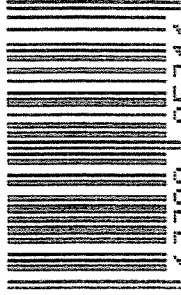
S&S
Snead®

Remington®		DUPONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6611629		ORDER NO. 5716	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		46			



5716 C6611629

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611629

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 Action	2 11	91	Kcd
	Magnaflux Bolt	2 11	91	Kcd
615	Rollmark Caliber	2 11	91	GS
617	Drill and Tap Sight Holes	2 12	91	LB
618	Polish Barrel RAB	2 12	91	WB
620	Apply Coatings (Barrel Action)		3/29/91	HA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/29/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/29/91	WB
	C) Inspect Ejector Hole for Chamfer		3/29/91	WB
	D) Oil Firing Pin Ass'y		3/29/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/8/91	HA

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/10/91	JK
	G) Safety Off Force	2	2	2			4/10/91	JK
	H) Trigger Pull Test & Retainability						4/8/91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			4/10/91	JK
	J) Assemble Stock						4/10/91	RW
	K) Assemble Swivel Studs						4-16-91	AC
	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	DH
	A) Time						4-11-91	DH
	B) Malfunctions						4-11-91	DH
	C) Pierced Primers						4-11-91	DH
	D) Optical Clarity of Scope						4-11-91	DH
645	Inspect for Live Ammo						4-11-91	DH
655	Final Inspection							
	A) Headspace						4-16-91	K
	B) Trigger Pull	2.25	2.45	2.45	2.59	2.38	4/16/91	JK
	C) Function						4-16-91	AC
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6611629

DATE 4/8/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.29	2.25	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.23	2.20	2.45	
PULL #3	2.46	2.30	2.21	2.45	
PULL #4	2.47	2.16	2.28	2.59	
PULL #5	2.50	2.35	2.34	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.37		
PULL #2	3.44	3.42		
PULL #3	3.57	3.40		
PULL #4	3.47	3.40		
PULL #5	3.37	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.24		4.49
PULL #2	4.26	4.34		4.51
PULL #3	4.33	4.51		4.58
PULL #4	4.25	4.42		4.53
PULL #5	4.40	4.41		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611629
11 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.464605
1 TO	2	.231398
1 TO	3	.41473
1 TO	4	.278948
1 TO	5	.480692

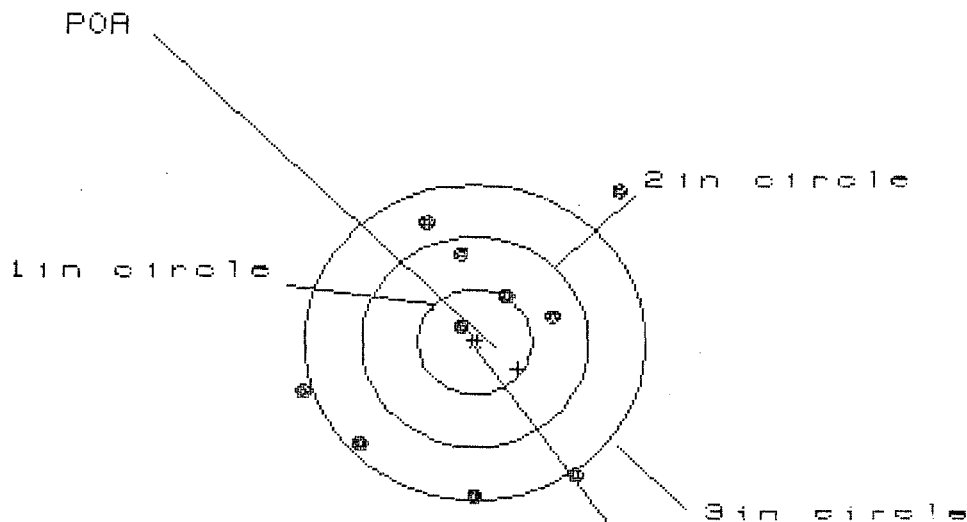
$\pm \frac{145}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .215
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .277851
THE AMR FOR THIS RIFLE IS: 1.073

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611629

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.797

VS = 2.819

GS = 3.338

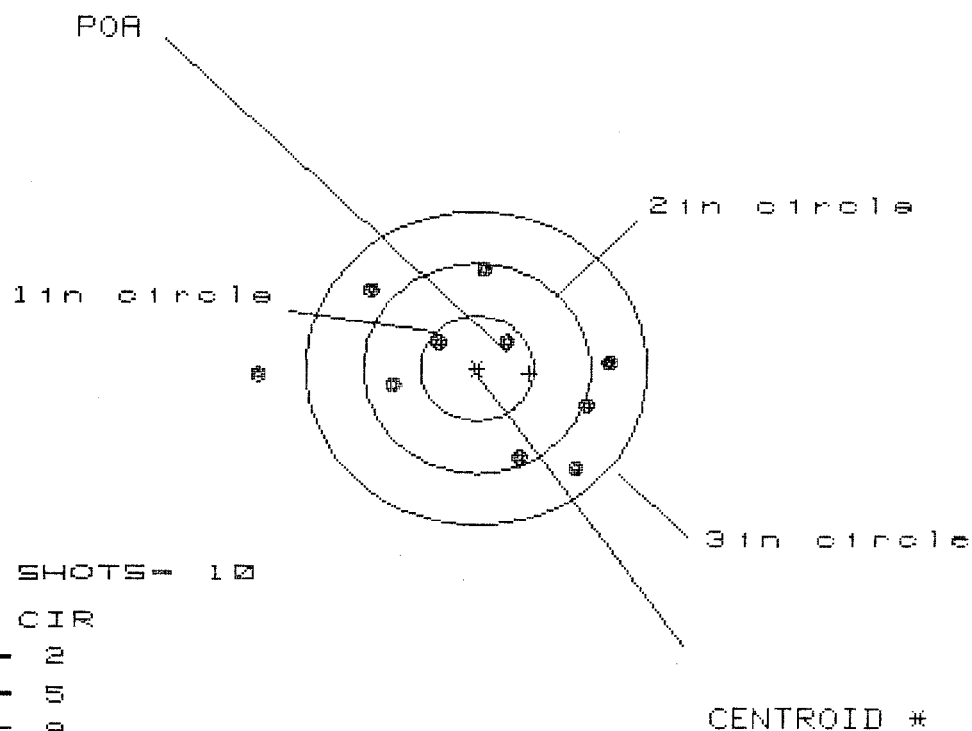
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.318	1.018	.967
MINIMUM X	:	-1.479	-1.333	-1.205
MAXIMUM Y	:	1.387	1.319	1.177
MINIMUM Y	:	-1.432	-1.278	-1.420
CENTROID X	:	-.383	-.529	-.657
CENTROID Y	:	.263	.109	.251
POA TO CENTROID in.	:	.464	.540	.703
MIN RADIUS	:	.195	.338	.270
MEAN RADIUS	:	1.131	1.070	.987
MAX RADIUS	:	1.914	1.530	1.435
HORIZONTAL SPREAD	:	2.797	2.351	2.172
VERTICAL SPREAD	:	2.819	2.597	2.597
EXTREME SPREAD	:	3.338	2.784	2.622
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 9

HS- 3.124

VS- 1.930

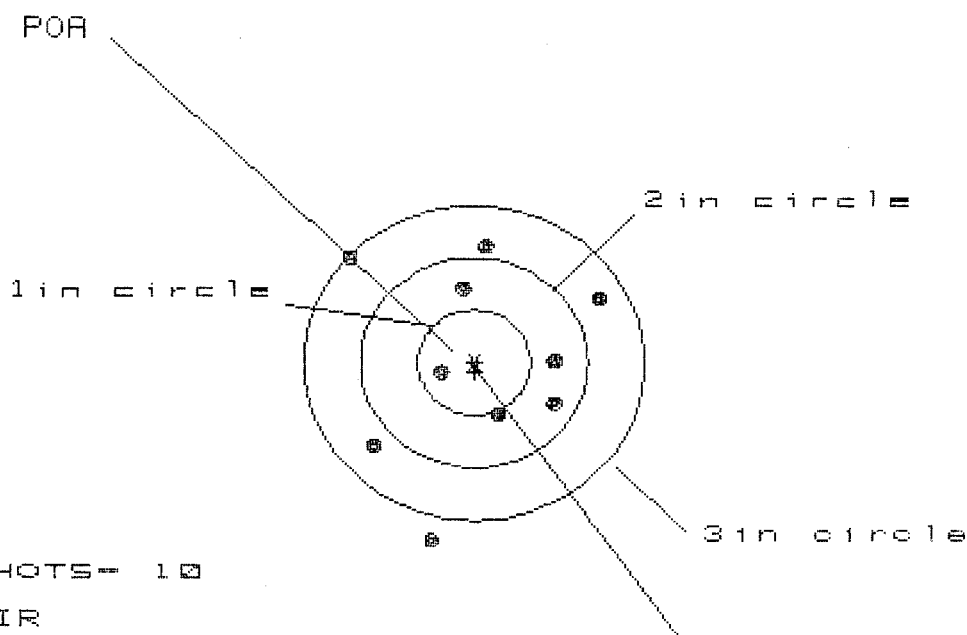
GS- 3.126

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	.990	1.076
MINIMUM X	:	-1.921	-1.156	-1.070
MAXIMUM Y	:	.992	.983	.865
MINIMUM Y	:	-.938	-.947	-.943
CENTROID X	:	-.466	-.252	-.338
CENTROID Y	:	.047	.056	.174
POA TO CENTROID in.	:	.468	.258	.380
MIN RADIUS	:	.382	.304	.249
MEAN RADIUS	:	1.015	.895	.843
MAX RADIUS	:	1.922	1.387	1.251
HORIZONTAL SPREAD	:	3.124	2.146	2.146
VERTICAL SPREAD	:	1.930	1.930	1.808
EXTREME SPREAD	:	3.126	2.516	2.266
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.231

VS= 2.781

GS= 2.816

CENTROID *

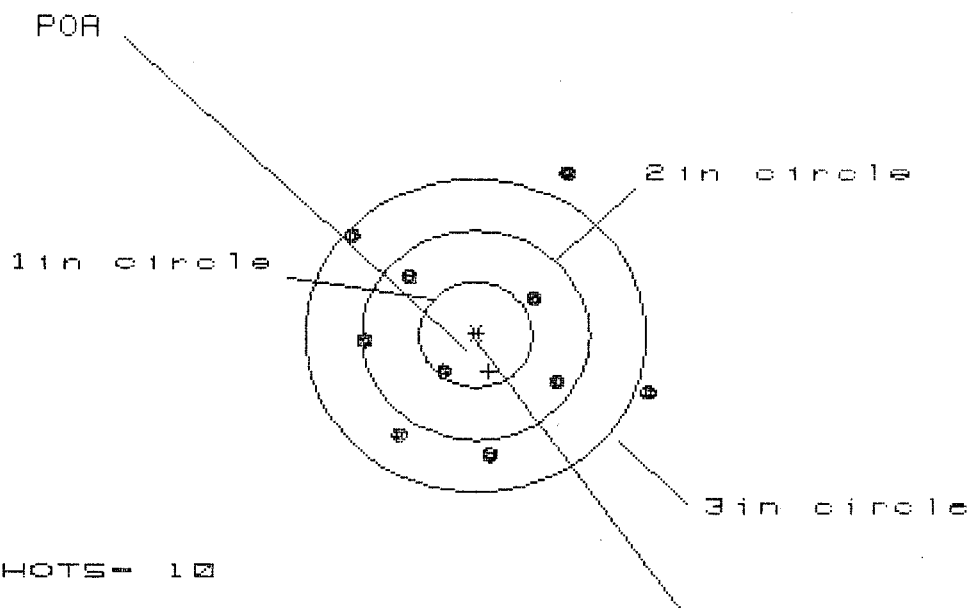
PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.101
MINIMUM X	:	-1.131
MAXIMUM Y	:	1.109
MINIMUM Y	:	-1.672
CENTROID X	:	-.007
CENTROID Y	:	.088
POA TO CENTROID in.	:	.088
MIN RADIUS	:	.307
MEAN RADIUS	:	.989
MAX RADIUS	:	1.717
HORIZONTAL SPREAD	:	2.231
VERTICAL SPREAD	:	2.781
EXTREME SPREAD	:	2.816
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



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 2.676

VS= 2.698

GS= 3.101

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.635	.976
MINIMUM X	:	-1.130	-1.041	-.837
MAXIMUM Y	:	1.525	1.165	1.115
MINIMUM Y	:	-1.173	-1.004	-1.054
CENTROID X	:	-.117	-.206	-.410
CENTROID Y	:	.347	.178	.228
POA TO CENTROID in.	:	.366	.272	.469
MIN RADIUS	:	.417	.240	.179
MEAN RADIUS	:	1.084	.985	.873
MAX RADIUS	:	1.723	1.683	1.394
HORIZONTAL SPREAD	:	2.676	2.676	1.813
VERTICAL SPREAD	:	2.698	2.169	2.169
EXTREME SPREAD	:	3.101	3.101	2.510
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.312

VS = 2.816

GS = 3.523

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.581
MINIMUM X	-1.731
MAXIMUM Y	1.419
MINIMUM Y	-1.397
CENTROID X	.093
CENTROID Y	.330
POA TO CENTROID in.	.343
MIN RADIUS	.206
MEAN RADIUS	1.147
MAX RADIUS	1.836
HORIZONTAL SPREAD	3.312
VERTICAL SPREAD	2.816
EXTREME SPREAD	3.523
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7