

05594520

MODEL 700™ M24

Model **S4S**™

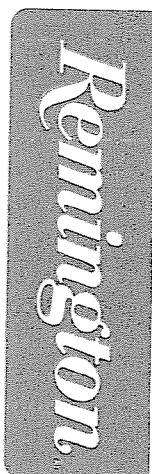
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

Remington®

REG. U.S. PAT. & TM. OFF.

DUPONT

MODEL 700™ H24

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

SERIAL NO.
C6594520

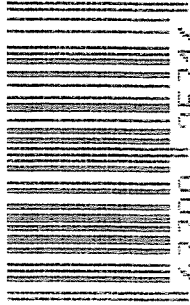
ORDER NO.
5716

20



5716 C6594520

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594520

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	YS
617	Drill and Tap Sight Holes	1	10 91	LB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-12-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			4/4/91	WB
	G) Safety Off Force	2 ¹ / ₂	2 ¹ / ₂	2 ¹ / ₂			4/4/91	WB
	H) Trigger Pull Test & Retainability						1/30/90	JL
	I) Firing Pin Indent	.0225	.022	.022			4/4/91	WB
	J) Assemble Stock						2/6/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/6/91	RW
	M) Iron Sight Alignment						2/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/6/91	RW
	O) Attach Scope to Rifle						2/6/91	RW
	P) Detach & Attach Scope 20 Times						2/6/91	RW
640	Gallery Target & Test						2/6/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						2/6/91	KS
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.37	2.26	2.15	2.11	2.34	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C 6594520

DATE 1-30-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.40	2.30	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.38	2.26	
PULL #3	2.47	2.31	2.30	2.15	
PULL #4	2.30	2.40	2.35	2.11	
PULL #5	2.41	2.33	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.34		
PULL #2	3.43	3.33		
PULL #3	3.30	3.11		
PULL #4	3.43	3.24		
PULL #5	3.39	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.34		4.27
PULL #2	4.44	4.28		4.49
PULL #3	4.25	4.22		4.38
PULL #4	4.40	4.23		4.15
PULL #5	4.27	4.20		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C659 4520
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.223647
1 TO	2	.106888
1 TO	3	.239353
1 TO	4	.0430465
1 TO	5	.173416

3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0316
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162502
THE BMR FOR THIS RIFLE IS: .8866

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594520

CENTERFIRE PATTERNS

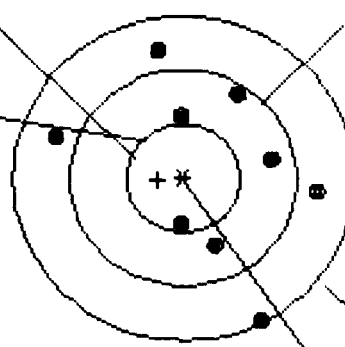
1

POA

1in circle

2in circle

3in circle



* OF SHOTS- 10

* IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.169

VS= 2.511

GS= 3.201

CENTROID *

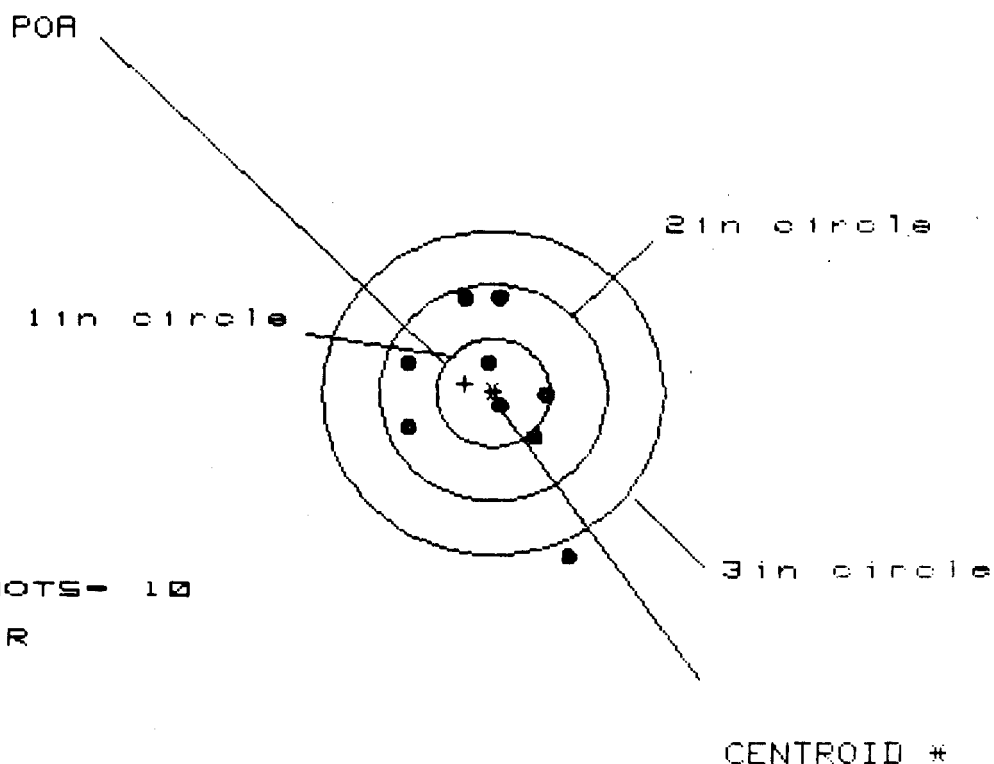
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	.942	1.000
MINIMUM X	:	-2.004	-1.317	-1.259
MAXIMUM Y	:	1.185	1.119	.945
MINIMUM Y	:	-1.326	-1.392	-.870
CENTROID X	:	.223	.446	.388
CENTROID Y	:	.017	.083	.257
POA TO CENTROID in.	:	.224	.453	.466
MIN RADIUS	:	.461	.549	.402
MEAN RADIUS	:	1.053	.903	.817
MAX RADIUS	:	2.091	1.465	1.270
HORIZONTAL SPREAD	:	3.169	2.259	2.259
VERTICAL SPREAD	:	2.511	2.511	1.815

EXTREME	SPREAD :	3.201	2.654	2.325
NUMBER IN ONE	INCH CIRCLE	=	1	
NUMBER IN TWO	INCH CIRCLE	=	5	
NUMBER IN THREE	INCH CIRCLE	=	9	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594520

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.401

VS= 2.375

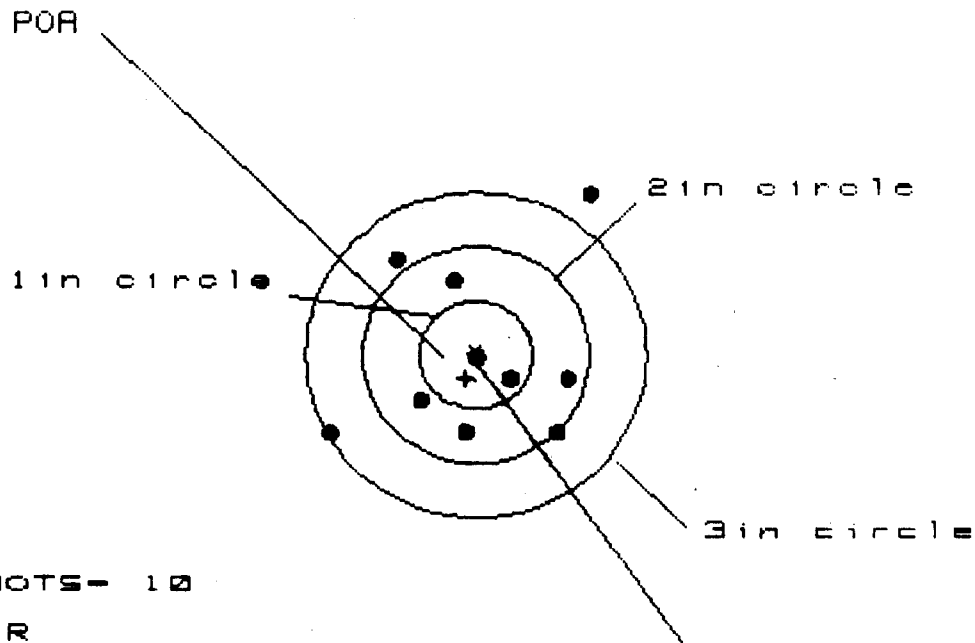
GS= 2.547

PATTERN #			
SHOTS (BEST OF)	:	10	9
MAXIMUM X	:	.689	.548
MINIMUM X	:	-.712	-.635
MAXIMUM Y	:	.897	.733
MINIMUM Y	:	-1.478	-.577
CENTROID X	:	.243	.166
CENTROID Y	:	-.088	.076
POA TO CENTROID in.	:	.258	.183
MIN RADIUS	:	.098	.142
MEAN RADIUS	:	.652	.547
MAX RADIUS	:	1.631	.782
HORIZONTAL SPREAD	:	1.401	1.183
VERTICAL SPREAD	:	2.375	1.310
EXTREME SPREAD	:	2.547	1.416
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	9	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594520

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.296

VS= 2.168

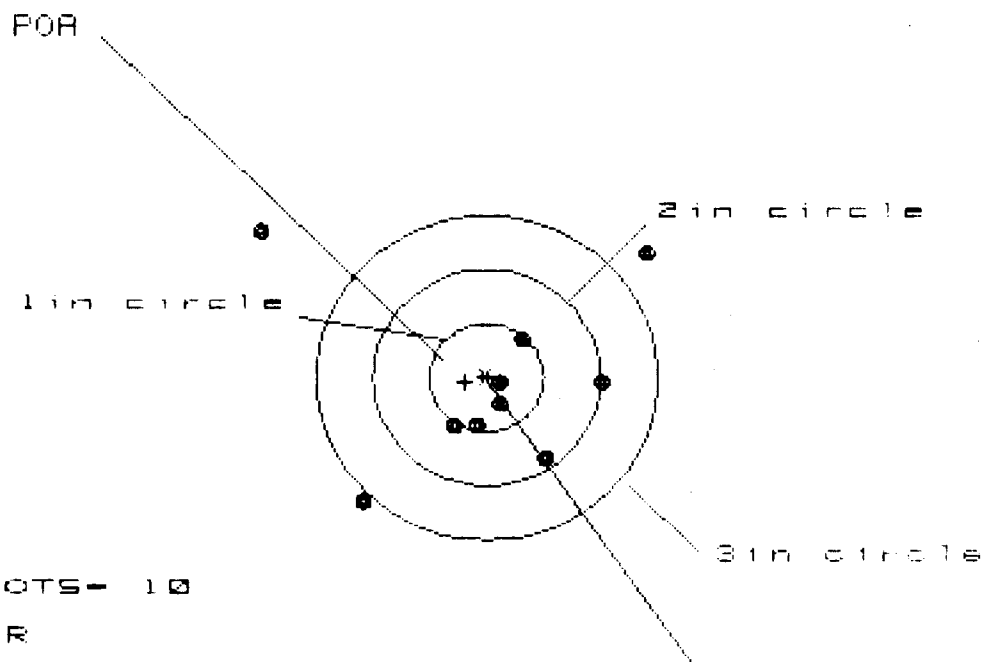
GS= 3.158

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.005	.878	.731
MINIMUM X	:	-1.291	-1.179	-.759
MAXIMUM Y	:	1.444	1.087	1.016
MINIMUM Y	:	-.724	-.563	-.604
CENTROID X	:	.090	-.022	.125
CENTROID Y	:	.216	.055	.126
POA TO CENTROID in.	:	.234	.060	.178
MIN RADIUS	:	.045	.200	.064
MEAN RADIUS	:	.065	.759	.662
MAX RADIUS	:	1.760	1.307	1.269
HORIZONTAL SPREAD	:	2.296	2.057	1.490
VERTICAL SPREAD	:	2.168	1.650	1.620
EXTREME SPREAD	:	3.158	2.171	2.171
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Feb 1991

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CENTERFIRE PATTERNS # 4



+ OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 3.320

VS= 2.463

GS= 3.330

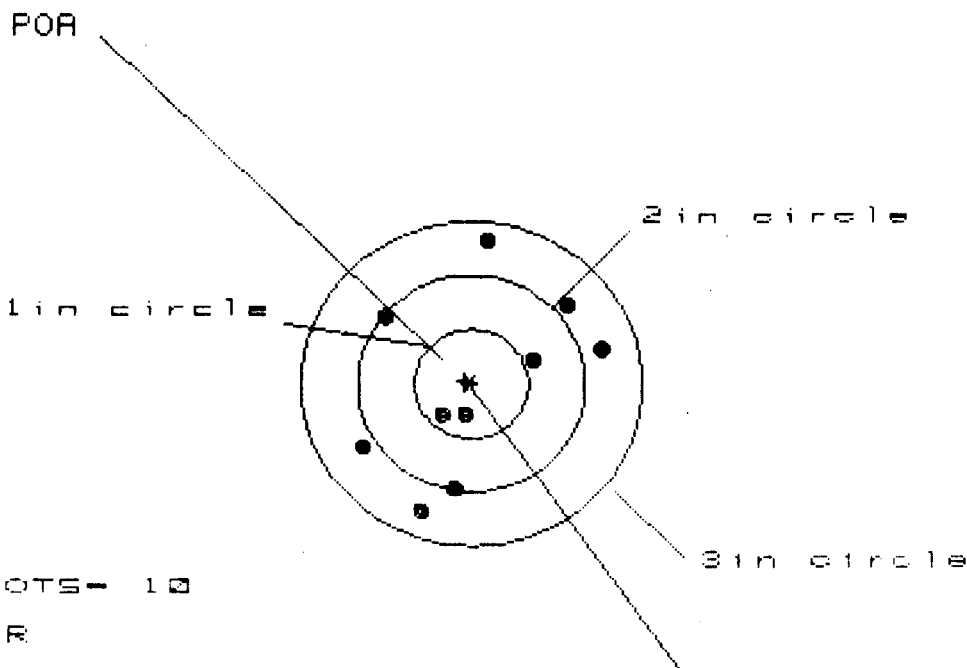
CENTROID +

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.159	.962
MINIMUM X	:	-1.945	-1.303	-1.158
MAXIMUM Y	:	1.374	1.268	.715
MINIMUM Y	:	-1.089	-.937	-.778
CENTROID X	:	.186	.402	.257
CENTROID Y	:	.039	-.113	-.272
FOR TO CENTROID in.	:	.190	.418	.374
MIN RADIUS	:	.070	.150	.100
MEAN RADIUS	:	.937	.742	.589
MAX RADIUS	:	2.381	1.718	1.395
HORIZONTAL SPREAD	:	3.320	2.462	2.120
VERTICAL SPREAD	:	2.463	2.205	1.493
EXTREME SPREAD	:	3.330	3.305	2.382
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ 06594520

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 10

HS= 2.095

VS= 2.424

GS= 2.491

CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.146	1.159	1.103
MINIMUM X	:	-.949	-.936	-.992
MAXIMUM Y	:	1.298	.895	.772
MINIMUM Y	:	-1.126	-.981	-.997
CENTROID X	:	.055	.042	.098
CENTROID Y	:	-.026	-.171	-.048
POA TO CENTROID in.	:	.061	.176	.110
MIN RADIUS	:	.250	.110	.244
MEAN RADIUS	:	.926	.854	.841
MAX RADIUS	:	1.303	1.267	1.164
HORIZONTAL SPREAD	:	2.095	2.095	2.095
VERTICAL SPREAD	:	2.424	1.876	1.769
EXTREME SPREAD	:	2.491	2.308	2.283
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	