

C6594532

MODEL 780™ M24

Model **S4S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

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

MODEL 700TM H24

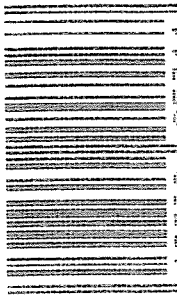
SERIAL NO.
C6594532

ORDER NO.
5716

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

20

LPC



0 47700 25716 7



5716 C6594532

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594532

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	GB
617	Drill and Tap Sight Holes		11/6/90	FB
618	Polish Barrel <i>RB</i>		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	FA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/18/91	KS
	C) Inspect Ejector Hole for Chamfer		1/18/91	KS
	D) Oil Firing Pin Ass'y		1/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-21-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			1/21/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			1/21/91	WB
	H) Trigger Pull Test & Retainability						1-21-91	JLL
	I) Firing Pin Indent	.021	.0215	.021			1/21/91	WB
	J) Assemble Stock						1/21/91	KS
	K) Assemble Swivel Studs						2-4-91	A
	L) Attach Front and Rear Sight Assemblies						1/21/91	KS
	M) Iron Sight Alignment						1/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/21/91	KS
	O) Attach Scope to Rifle						1/21/91	KS
	P) Detach & Attach Scope 20 Times						1/21/91	KS
640	Gallery Target & Test						1-21-91	AC
	A) Time						1-21-91	AC
	B) Malfunctions						1-21-91	AC
	C) Pierced Primers						1-21-91	AC
	D) Optical Clarity of Scope						1-21-91	AC
645	Inspect for Live Ammo						1-21-91	AC
655	Final Inspection							
	A) Headspace						2-4-91	A
	B) Trigger Pull	2.27	2.17	2.27	2.25	2.30	1-22-91	JLL
	C) Function						2-4-91	AC
660	Pack						3-19-91	V

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6594532

DATE 1-21-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.18	2.20	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.27	2.22	2.17	
PULL #3	2.32	2.28	2.25	2.27	
PULL #4	2.32	2.22	2.20	2.25	
PULL #5	2.33	2.26	2.28	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.34		
PULL #2	3.35	3.35		
PULL #3	3.36	3.35		
PULL #4	3.38	3.34		
PULL #5	3.37	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.16		4.38
PULL #2	4.33	4.36		4.29
PULL #3	4.35	4.32		4.30
PULL #4	4.34	4.34		4.21
PULL #5	4.35	4.35		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594532
22 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.200205
1 TO	2	.371139
1 TO	3	.221165
1 TO	4	.464263
1 TO	5	.52811

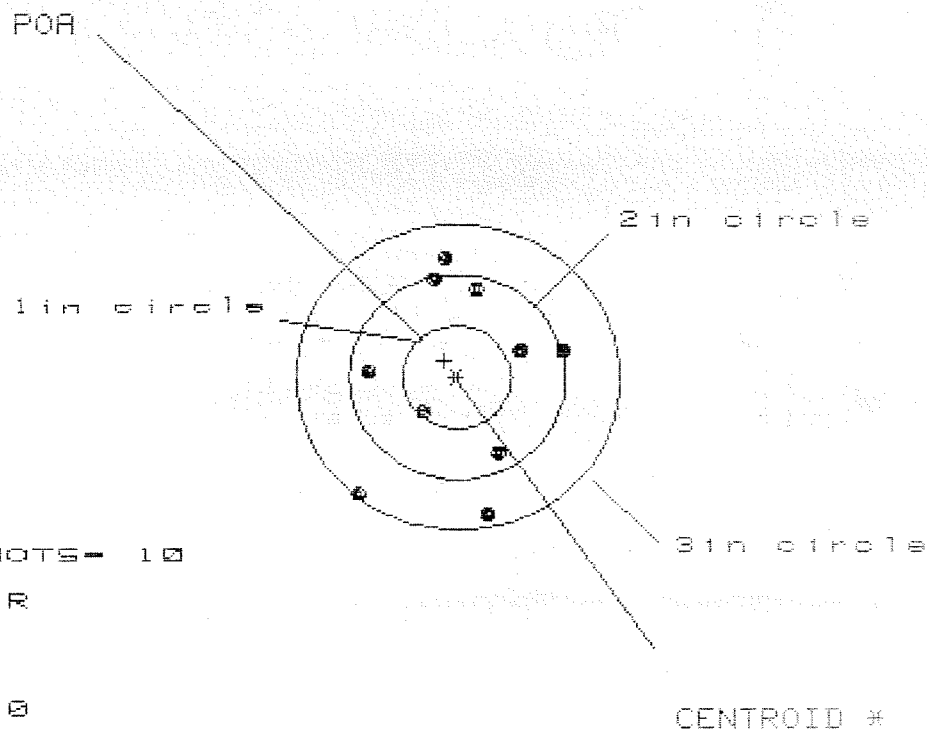
POI <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0772
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0878854
THE AMR FOR THIS RIFLE IS: .9052

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594532

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.871

VS= 2.485

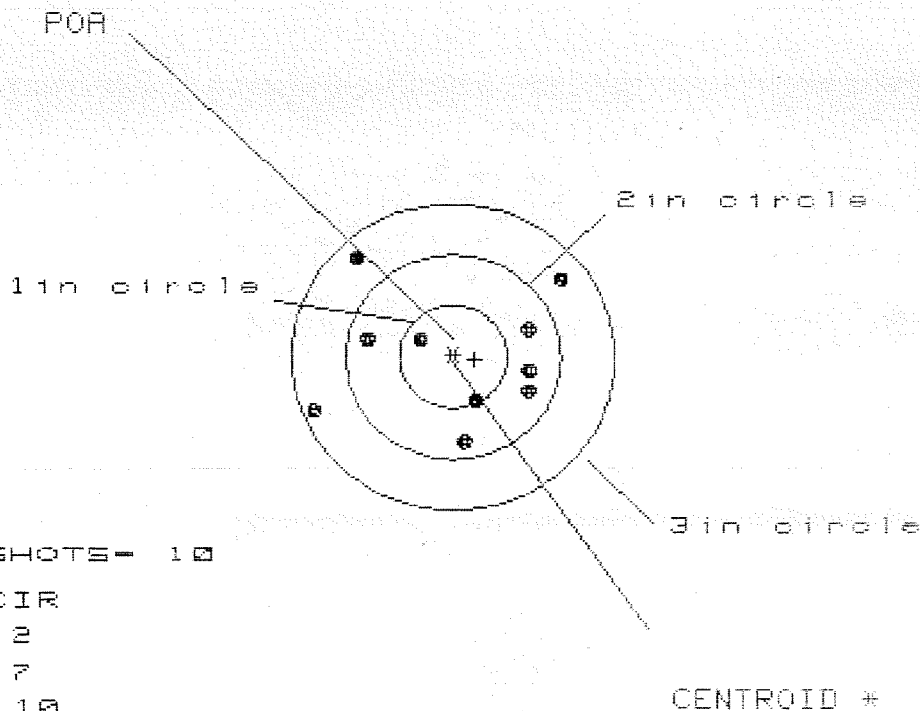
GS= 2.513

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.953	.851	.872
MINIMUM X	:	-.918	-.885	-.864
MAXIMUM Y	:	1.112	.990	.803
MINIMUM Y	:	-1.373	-1.495	-1.002
CENTROID X	:	.119	.221	.200
CENTROID Y	:	-.161	-.039	.147
POA TO CENTROID in.	:	.201	.225	.249
MIN RADIUS	:	.466	.480	.474
MEAN RADIUS	:	.945	.873	.769
MAX RADIUS	:	1.432	1.504	1.039
HORIZONTAL SPREAD	:	1.871	1.736	1.736
VERTICAL SPREAD	:	2.485	2.485	1.805
EXTREME SPREAD	:	2.513	2.513	1.863
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594532

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.313

VS= 1.787

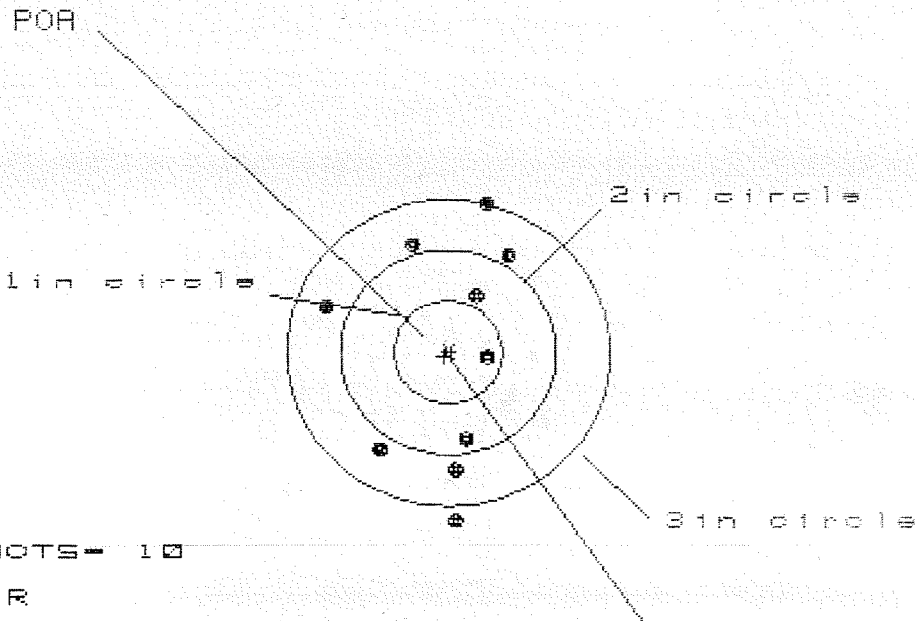
GS= 2.629

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	.842	.717
MINIMUM X	:	-1.324	-.999	-1.117
MAXIMUM Y	:	.975	.919	.802
MINIMUM Y	:	-.812	-.868	-.753
CENTROID X	:	-.201	-.054	.071
CENTROID Y	:	.027	.083	-.032
POA TO CENTROID in.	:	.203	.099	.078
MIN RADIUS	:	.355	.477	.398
MEAN RADIUS	:	.866	.790	.682
MAX RADIUS	:	1.418	1.357	1.132
HORIZONTAL SPREAD	:	2.313	1.841	1.834
VERTICAL SPREAD	:	1.787	1.787	1.555
EXTREME SPREAD	:	2.629	2.029	1.935
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

22 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 3

3 in - 8

HS= 1.683

VS= 3.165

GS= 3.181

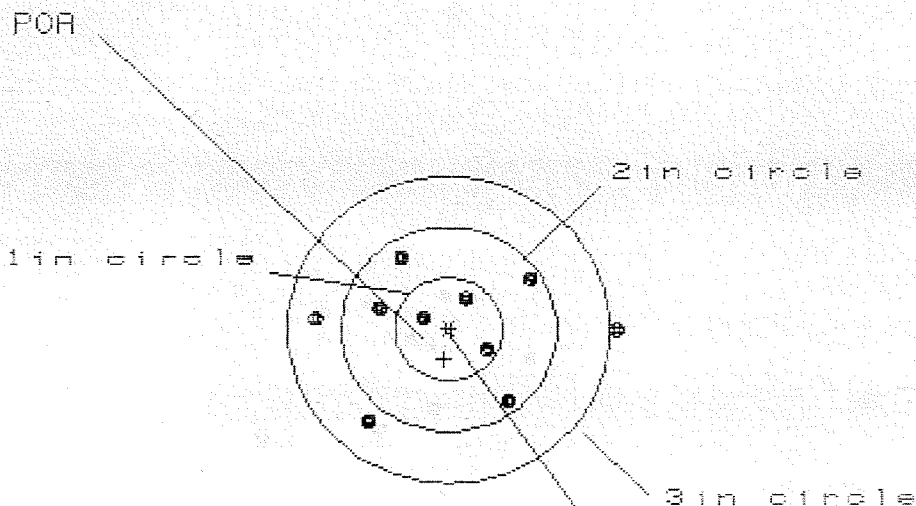
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.571	.582	.635
MINIMUM X	:	-1.112	-1.101	-1.048
MAXIMUM Y	:	1.485	1.298	1.006
MINIMUM Y	:	-1.680	-1.346	-1.184
CENTROID X	:	.036	.025	-.028
CENTROID Y	:	.044	.231	.069
POA TO CENTROID in.	:	.057	.232	.074
MIN RADIUS	:	.356	.417	.421
MEAN RADIUS	:	1.073	.989	.943
MAX RADIUS	:	1.683	1.366	1.193
HORIZONTAL SPREAD	:	1.683	1.683	1.683
VERTICAL SPREAD	:	3.165	2.644	2.190
EXTREME SPREAD	:	3.181	2.664	2.244
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	8		

22 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.750

VS= 1.613

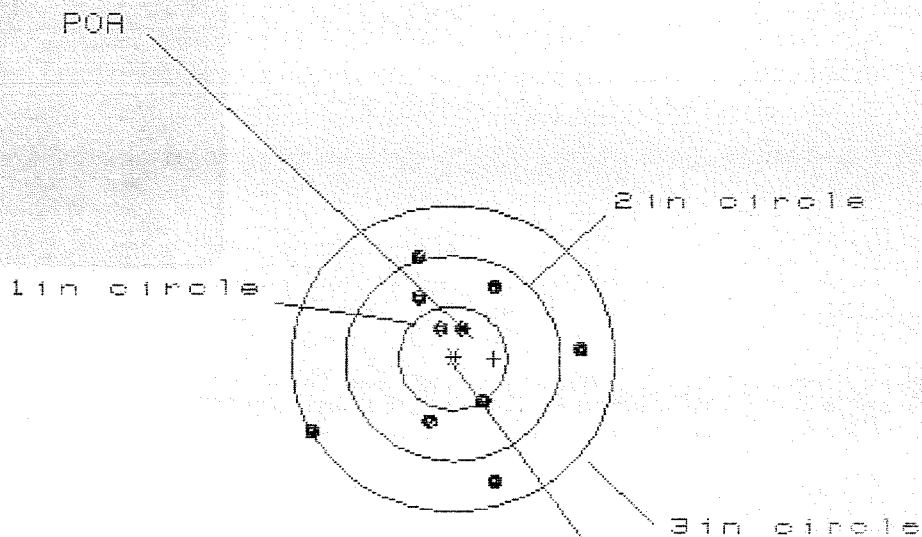
GS= 2.754

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.538	.912	.782
MINIMUM X	:	-1.212	-1.041	-.710
MAXIMUM Y	:	.698	.694	.708
MINIMUM Y	:	-.915	-.919	-.905
CENTROID X	:	.043	-.128	.002
CENTROID Y	:	.297	.301	.287
POA TO CENTROID in.	:	.300	.327	.288
MIN RADIUS	:	.265	.114	.231
MEAN RADIUS	:	.831	.737	.694
MAX RADIUS	:	1.539	1.087	1.151
HORIZONTAL SPREAD	:	2.750	1.953	1.492
VERTICAL SPREAD	:	1.613	1.613	1.613
EXTREME SPREAD	:	2.754	2.054	2.054
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.463

VS = 2.231

GS = 2.589

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.182	1.040	1.065
MINIMUM X	:	-1.281	-.468	-.443
MAXIMUM Y	:	.979	.902	.736
MINIMUM Y	:	-1.252	-1.329	-.818
CENTROID X	:	-.383	-.241	-.266
CENTROID Y	:	.003	.080	.246
POA TO CENTROID in.	:	.383	.253	.362
MIN RADIUS	:	.310	.247	.079
MEAN RADIUS	:	.811	.722	.598
MAX RADIUS	:	1.456	1.344	1.074
HORIZONTAL SPREAD	:	2.463	1.508	1.508
VERTICAL SPREAD	:	2.231	2.231	1.554
EXTREME SPREAD	:	2.589	2.319	1.712
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	