

C6523495

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M2400029121

CONFIDENTIAL - SUBJECT TO PROTECTIVE ORDER

2.57

2.62

2.53

2.49

2.53

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523495

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/21/90	KCD
	Magnaflux Bolt		8/21/90	KCD
615	Rollmark Caliber		8/21/90	CS
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel <i>RB</i>		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-21-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/12/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/90	WB
	C) Inspect Ejector Hole for Chamfer		9/12/90	WB
	D) Oil Firing Pin Ass'y		9/12/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/12/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/12/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/12/90	WB
	H) Trigger Pull Test & Retainability						9/12/90	WB
	I) Firing Pin Indent	.021 0225	.021 0225	.0205 0225			9/12/90	WB
	J) Assemble Stock						9/12/90	KA
	K) Assemble Swivel Studs						9/15/90	QA
	L) Attach Front and Rear Sight Assemblies						9/12/90	KA
	M) Iron Sight Alignment						9/12/90	KA
	N) Detach Front & Rear Sights & place in numbered container						9/12/90	KA
	O) Attach Scope to Rifle						9/12/90	KA
	P) Detach & Attach Scope 20 Times						9/12/90	KA
640	Gallery Target & Test						9/14/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/14/90	NF
655	Final Inspection						9/15/90	QA
	A) Headspace						9/15/90	QA
	B) Trigger Pull	2.10	2.03	2.05	2.07	2.10	9-15-90	QA
	C) Function						9/15/90	QA
660	Pack						9-18-90	QA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523495
DATE 9/12/80
TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.37	2.49 ³	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.40	2.46	2.03	
PULL #3	2.27	2.48	2.42	2.05	
PULL #4	2.31	2.50	2.39	2.07	
PULL #5	2.30	2.44	2.38	2.10	
TOTAL	11.56	12.19	12.14	10.35	
AVG.	2.31	2.44	2.43	2.07	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	2.95		
PULL #2	3.14	3.00		
PULL #3	3.15	3.03		
PULL #4	3.14	3.06		
PULL #5	3.21	2.98		
TOTAL	15.72	15.02		
AVG.	3.14	3.00		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	3.90		3.90
PULL #2	4.03	3.95		3.80
PULL #3	4.21	4.03		3.90
PULL #4	4.01	4.14		3.92
PULL #5	4.15	4.08		3.95
TOTAL	20.52	20.10		19.47
AVG.	4.10	4.02		3.89

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523495
14 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.244641
1 TO	2	.117175
1 TO	3	.196291
1 TO	4	.207617
1 TO	5	.390623

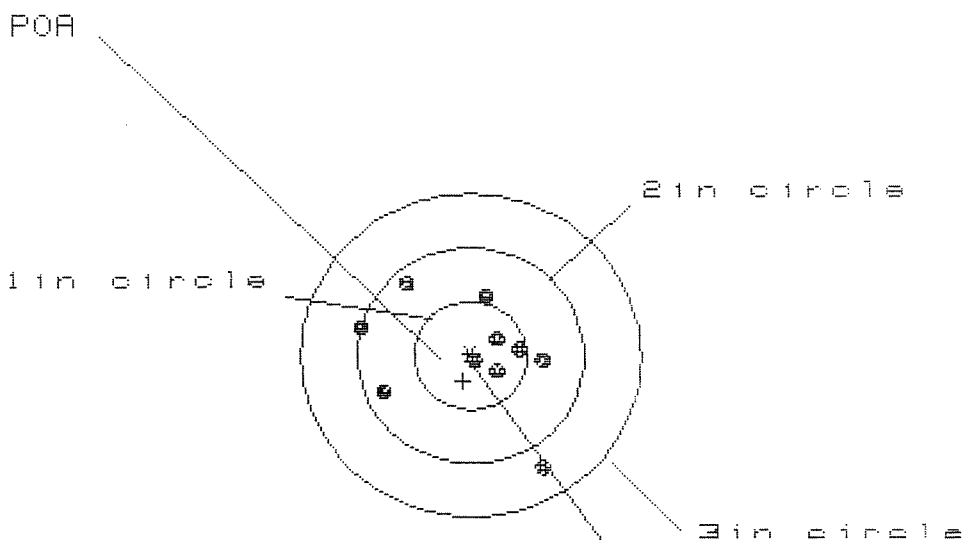
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0881821
THE AMR FOR THIS RIFLE IS: .7018

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523495

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.672

VS= 1.684

GS= 2.068

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.677	.745	.629
MINIMUM X	:	-.995	-.927	-.829
MAXIMUM Y	:	.622	.584	.516
MINIMUM Y	:	-1.062	-.454	-.442
CENTROID X	:	.068	-.000	.115
CENTROID Y	:	.235	.353	.341
POA TO CENTROID in.	:	.245	.353	.360
MIN RADIUS	:	.071	.198	.182
MEAN RADIUS	:	.627	.573	.491
MAX RADIUS	:	1.227	.932	.939
HORIZONTAL SPREAD	:	1.672	1.672	1.458
VERTICAL SPREAD	:	1.684	.958	.958
EXTREME SPREAD	:	2.068	1.686	1.496
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523495

CENTERFIRE PATTERNS # 2

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.488

VS= 1.827

GS= 2.093

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.739	.656	.680
MINIMUM X	:	-.749	-.571	-.547
MAXIMUM Y	:	.950	.748	.652
MINIMUM Y	:	-.877	-.772	-.695
CENTROID X	:	.037	.120	.096
CENTROID Y	:	.122	.017	.113
POB TO CENTROID in.	:	.128	.121	.149
MIN RADIUS	:	.245	.138	.188
MEAN RADIUS	:	.646	.574	.539
MAX RADIUS	:	1.210	.795	.727
HORIZONTAL SPREAD	:	1.488	1.227	1.227
VERTICAL SPREAD	:	1.827	1.520	1.347
EXTREME SPREAD	:	2.093	1.550	1.355
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523495

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.270

VS= 1.747

GS= 1.983

CENTROID #

PATTERN #

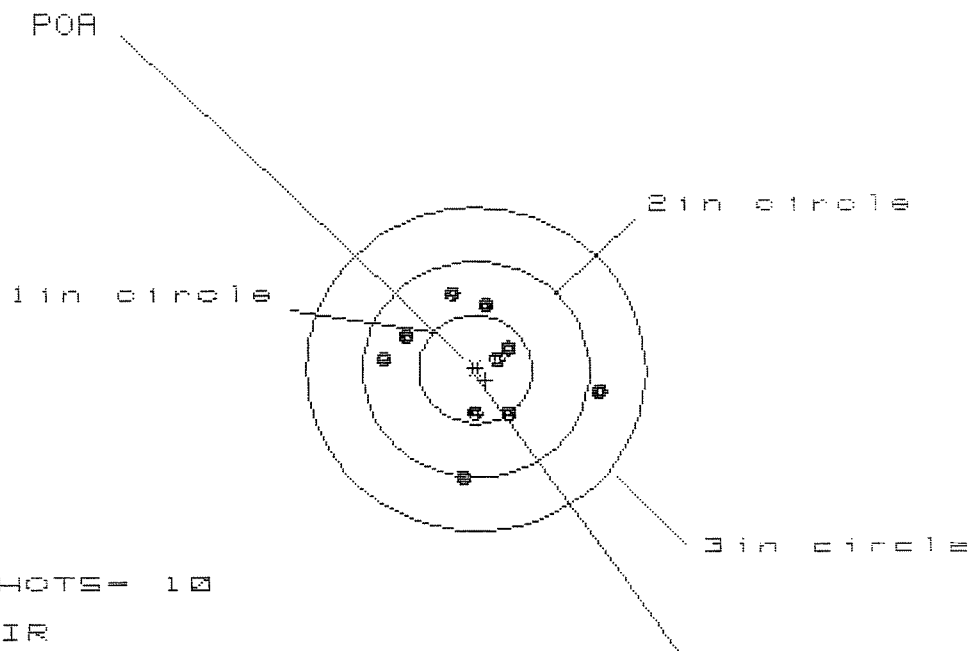
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SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.596	.525	.432
MINIMUM X	:	-.674	-.745	-.400
MAXIMUM Y	:	.674	.555	.580
MINIMUM Y	:	-1.073	-.605	-.580
CENTROID X	:	.015	.086	.179
CENTROID Y	:	.046	.166	.141
POA TO CENTROID in.	:	.049	.187	.228
MIN RADIUS	:	.191	.199	.139
MEAN RADIUS	:	.599	.512	.467
MAX RADIUS	:	1.249	.770	.595
HORIZONTAL SPREAD	:	1.270	1.270	.832
VERTICAL SPREAD	:	1.747	1.160	1.160
EXTREME SPREAD	:	1.983	1.271	1.180
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523495

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.942

VS= 1.764

GS= 1.968

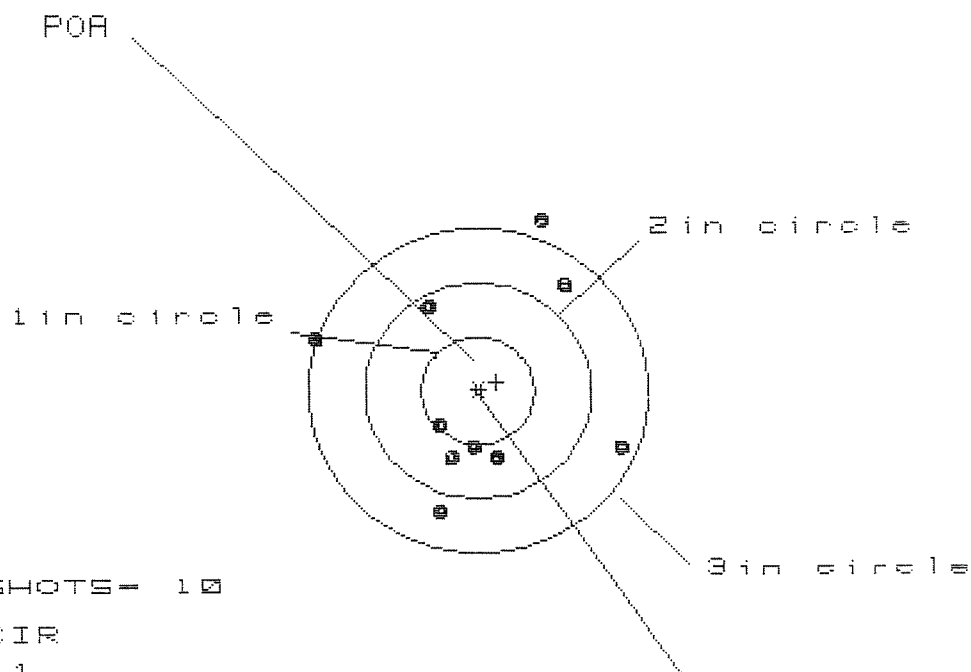
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	.394	.392
MINIMUM X	:	-.861	-.741	-.743
MAXIMUM Y	:	.717	.692	.558
MINIMUM Y	:	-1.047	-1.072	-.524
CENTROID X	:	-.088	-.208	-.206
CENTROID Y	:	.098	.123	.257
POA TO CENTROID in.	:	.132	.241	.329
MIN RADIUS	:	.169	.279	.289
MEAN RADIUS	:	.633	.586	.511
MAX RADIUS	:	1.103	1.072	.745
HORIZONTAL SPREAD	:	1.942	1.135	1.135
VERTICAL SPREAD	:	1.764	1.764	1.082
EXTREME SPREAD	:	1.968	1.766	1.194
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523495

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.686

VS= 2.666

GS= 2.864

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.308	1.136
MINIMUM X	:	-1.438	-1.378	-1.530
MAXIMUM Y	:	1.536	1.121	1.203
MINIMUM Y	:	-1.130	-1.959	-1.877
CENTROID X	:	-.163	-.223	-.051
CENTROID Y	:	-.080	-.251	-.333
POA TO CENTROID in.	:	.181	.336	.337
MIN RADIUS	:	.457	.294	.303
MEAN RADIUS	:	1.004	.877	.783
MAX RADIUS	:	1.630	1.526	1.391
HORIZONTAL SPREAD	:	2.686	2.686	1.666
VERTICAL SPREAD	:	2.666	2.080	2.080
EXTREME SPREAD	:	2.864	2.864	2.370
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523495
17 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.208806
1 TO	2	.166628
1 TO	3	.299897
1 TO	4	.248294
1 TO	5	.245459

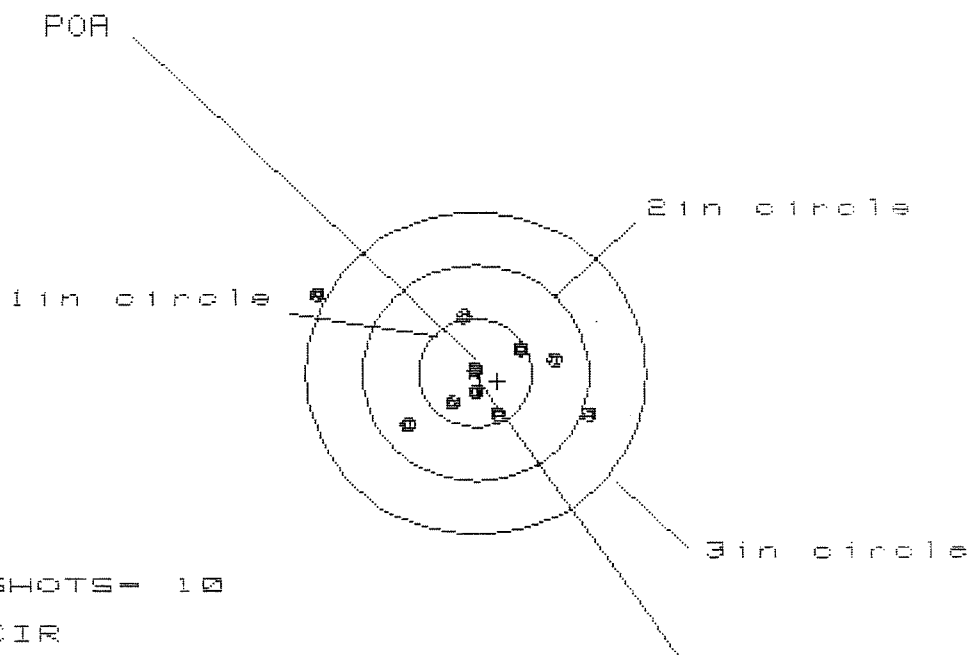
54 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0784
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0234
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0818176
THE AMR FOR THIS RIFLE IS: .7726

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523495.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.379

VS= 1.274

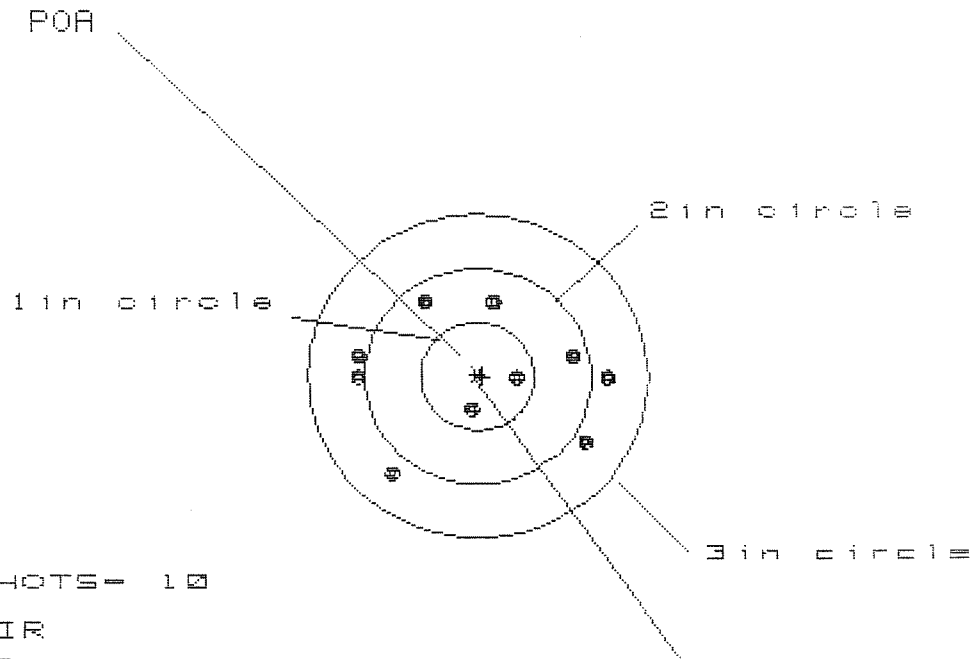
GS= 2.652

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	.847	.631
MINIMUM X	:	-1.378	-.715	-.609
MAXIMUM Y	:	.771	.624	.585
MINIMUM Y	:	-.503	-.417	-.457
CENTROID X	:	-.196	-.042	-.148
CENTROID Y	:	.072	-.014	.026
POA TO CENTROID in.	:	.208	.045	.151
MIN RADIUS	:	.044	.192	.108
MEAN RADIUS	:	.608	.494	.425
MAX RADIUS	:	1.579	.904	.761
HORIZONTAL SPREAD	:	2.379	1.562	1.240
VERTICAL SPREAD	:	1.274	1.041	1.041
EXTREME SPREAD	:	2.652	1.565	1.404
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523495.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.207

VS= 1.631

GS= 2.217

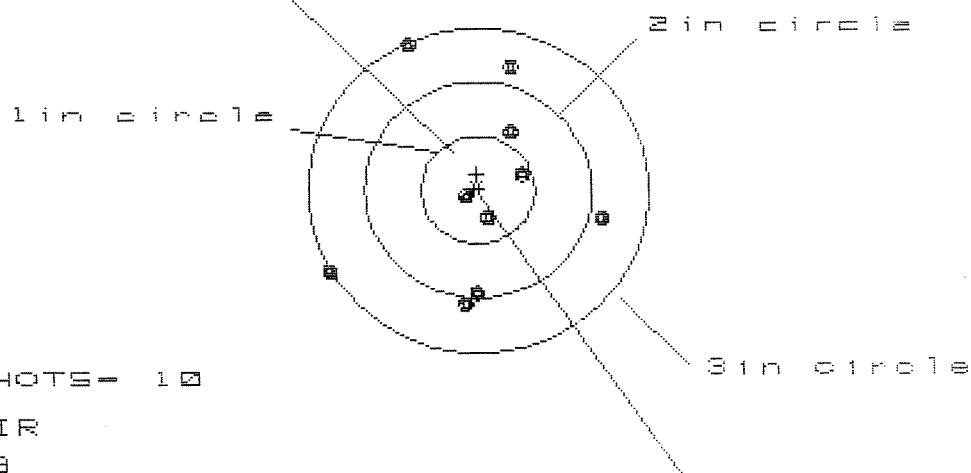
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.103	1.020	1.126
MINIMUM X	:	-1.104	-1.187	-1.081
MAXIMUM Y	:	.707	.604	.513
MINIMUM Y	:	-.924	-.727	-.455
CENTROID X	:	-.043	.039	-.067
CENTROID Y	:	.006	.109	.200
POA TO CENTROID in.	:	.044	.116	.211
MIN RADIUS	:	.272	.309	.443
MEAN RADIUS	:	.861	.813	.776
MAX RADIUS	:	1.184	1.190	1.148
HORIZONTAL SPREAD	:	2.207	2.207	2.207
VERTICAL SPREAD	:	1.631	1.331	.968
EXTREME SPREAD	:	2.217	2.217	2.217
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Sep 1998

FILE://PATTERNING/CENTERFIRE_PATT/C8523495.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.458

VS= 2.343

GS= 2.512

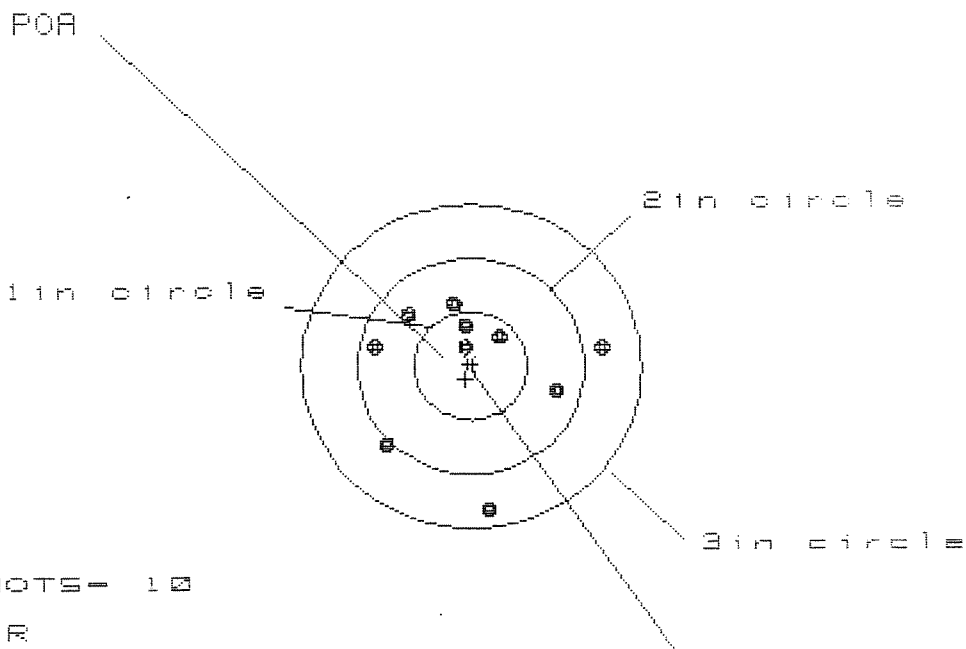
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.112	.962	.864
MINIMUM X	:	-1.346	-.791	-.398
MAXIMUM Y	:	1.298	1.216	1.226
MINIMUM Y	:	-1.045	-1.127	-.975
CENTROID X	:	.011	.161	.259
CENTROID Y	:	-.145	-.063	-.215
POA TO CENTROID in.:	:	.145	.173	.337
MIN RADIUS	:	.161	.262	.176
MEAN RADIUS	:	.878	.791	.692
MAX RADIUS	:	1.533	1.451	1.228
HORIZONTAL SPREAD	:	2.458	1.753	1.262
VERTICAL SPREAD	:	2.343	2.343	2.201
EXTREME SPREAD	:	2.512	2.394	2.248
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523495.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.918

VS= 1.902

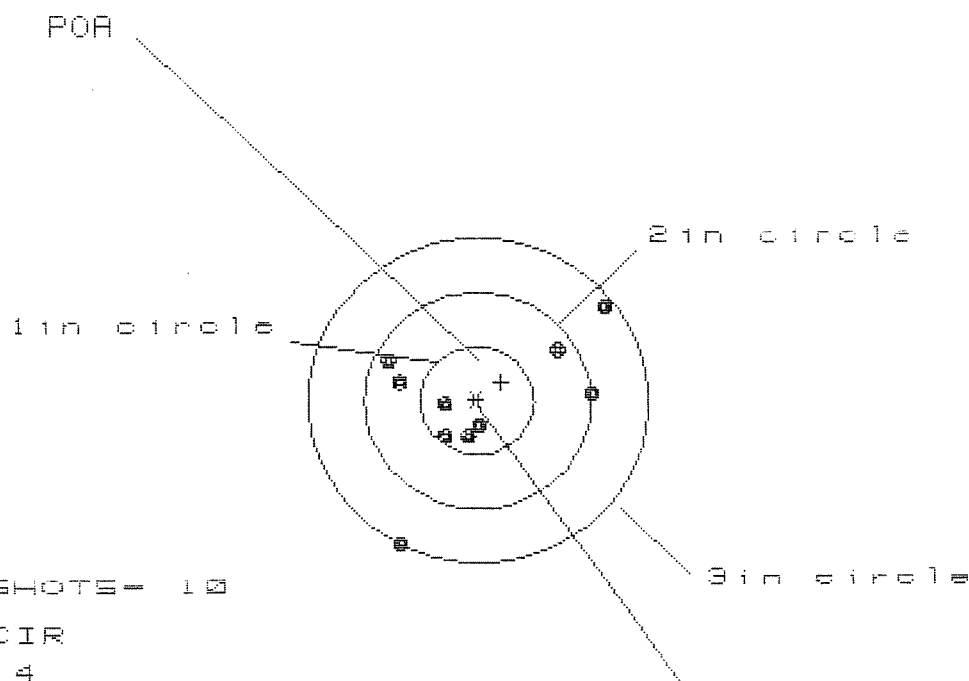
GS= 2.082

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	1.136	.962
MINIMUM X	:	-.804	-.782	-.640
MAXIMUM Y	:	.576	.428	.429
MINIMUM Y	:	-1.326	-.858	-.857
CENTROID X	:	.047	.025	-.117
CENTROID Y	:	.123	.271	.270
POA TO CENTROID in.	:	.132	.272	.294
MIN RADIUS	:	.166	.057	.085
MEAN RADIUS	:	.754	.639	.572
MAX RADIUS	:	1.341	1.144	1.055
HORIZONTAL SPREAD	:	1.918	1.918	1.602
VERTICAL SPREAD	:	1.902	1.286	1.286
EXTREME SPREAD	:	2.082	2.082	1.651
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523495.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.978

VS= 2.153

GS= 2.853

CENTROID #

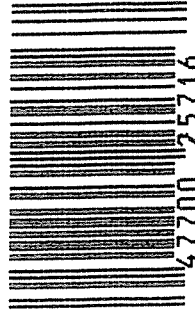
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.146	1.065	1.111
MINIMUM X	:	-.832	-.913	-.780
MAXIMUM Y	:	.875	.733	.423
MINIMUM Y	:	-1.278	-.428	-.337
CENTROID X	:	-.211	-.130	-.263
CENTROID Y	:	-.173	-.031	-.122
POA TO CENTROID in.	:	.272	.134	.290
MIN RADIUS	:	.202	.339	.239
MEAN RADIUS	:	.762	.713	.587
MAX RADIUS	:	1.470	1.293	1.112
HORIZONTAL SPREAD	:	1.978	1.978	1.891
VERTICAL SPREAD	:	2.153	1.161	.760
EXTREME SPREAD	:	2.853	2.038	1.912
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington REG. U.S. PAT. & TM. OFF.		DUPONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6523495		ORDER NO. 5716	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.		01			



5716 C6523495

LPC



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