

C6648927

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

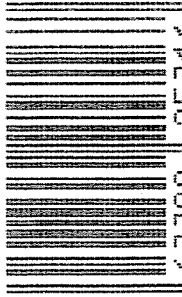
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6648927
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6648927

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648927

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	LG
	Magnaflux Bolt		JUL 22 1991	LG
615	Rollmark Caliber		JUL 22 1991	LB
617	Drill and Tap Sight Holes		JUL 22 1991	WB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8/2/91	AS
	Apply Coating (Bolt)		8/2/91	AS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-13-91	YH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4	4			8-13-91	DH
	G) Safety Off Force	2	2	2			8-13-91	DH
	H) Trigger Pull Test & Retainability						8-13-91	SH
	I) Firing Pin Indent	.022	.021	.021			8-13-91	DH
	J) Assemble Stock						8-16/91	RW
	K) Assemble Swivel Studs						8-22/91	SH
	L) Attach Front and Rear Sight Assemblies						8-16/91	RW
	M) Iron Sight Alignment						8-16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-16/91	RW
	O) Attach Scope to Rifle						8-16/91	RW
	P) Detach & Attach Scope 20 Times						8-16/91	RW
640	Gallery Target & Test						8-19-91	DH
	A) Time						8-19-91	PA
	B) Malfunctions						8-19-91	DH
	C) Pierced Primers						8-19-91	DH
	D) Optical Clarity of Scope						8-19-91	DH
645	Inspect for Live Ammo						8-19-91	DH
655	Final Inspection							
	A) Headspace						8-22/91	SH
	B) Trigger Pull	249	268	276	274	280	8-22-91	DH
	C) Function						8-22/91	SH
660	Pack						7-17-91	DH

SWS TRIGGER-PULL TEST

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

SERIAL NO. C-6648927

DATE 8-13-91

TESTER 921

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS	
PULL #1	2.23	2.33	2.48	2.49	MIN. SETTING.	
PULL #2	2.20	2.36	2.40	2.68	NO AVG. OF 5	000
PULL #3	2.32	2.31	2.38	2.76	READINGS ACCEPT-	000
PULL #4	2.29	2.43	2.44	2.74	ABLE LESS THAN 2#	
PULL #5	2.35	2.45	2.46	2.80		010
TOTAL						
AVG.						

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS	
PULL #1	3.32	3.25				
PULL #2	3.33	3.27				
PULL #3	3.27	3.24				
PULL #4	3.34	3.27				
PULL #5	3.32	3.49				
TOTAL						
AVG.						

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX. SETTING GREATER THAN 4#	RESET TO TARGET & ACCURACY	4# FOR
PULL #1	4.32	4.45		4.53	
PULL #2	4.41	4.30		4.49	
PULL #3	4.44	4.49		4.59	
PULL #4	4.41	4.46		4.53	
PULL #5	4.38	4.45		4.43	
TOTAL					
AVG.					

CENTROIDAL DISTANCE CALCULATION
FOR RIFLE # 06648927
23 Aug 1991

CENTROIDAL DISTANCE

0 TO	1	.125873
1 TO	2	.152742
1 TO	3	.152742
1 TO	4	.334521
1 TO	5	.319127

Fig 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS:
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS:
THE RESULTING AVERAGE POI RADIUS FOR THIS

THE AMR FOR THIS RIFLE IS: .3748

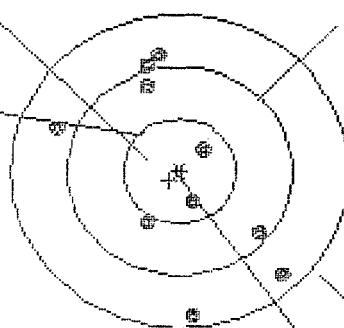
23 Aug 1991

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CENTERFIRE PATTERNS

POA

1 in circle



3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.054

VS = 2.584

GS = 2.595

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

.942

.953

-1.112

-1.101

1.156

.997

-1.428

-1.119

.090

.079

.088

.247

.126

.259

.265

.204

.913

.848

1.432

1.470

2.054

2.054

2.584

2.116

2.595

2.447

2

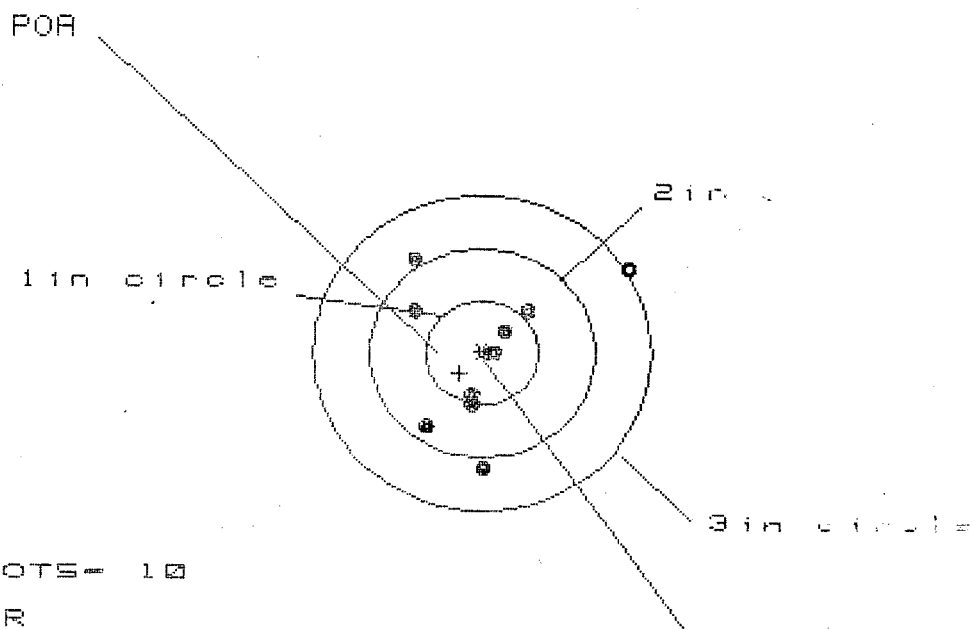
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10

23 Aug 1991

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CENTERFIRE PATTERNS



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 1.872

VS= 1.983

GS= 2.343

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.254	.547	.407
MINIMUM X	-.618	-.479	-.484
MAXIMUM Y	.910	1.001	.519
MINIMUM Y	-1.073	-.982	-.358
CENTROID X	.199	.060	.120
CENTROID Y	.195	.104	-.020
POA TO CENTROID in.	.279	.120	.122
MIN RADIUS	.074	.224	.213
MEAN RADIUS	.706	.618	.534
MAX RADIUS	1.502	1.110	.859
HORIZONTAL SPREAD	1.872	1.026	.971
VERTICAL SPREAD	1.983	1.983	1.475
EXTREME SPREAD	2.343	2.072	1.572
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

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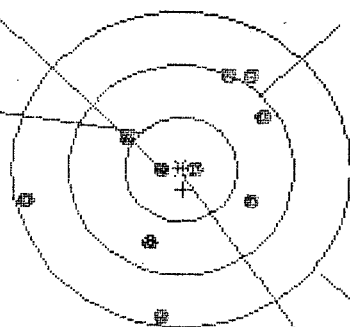
CENTERFIRE PATTERNS

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.173

VS= 2.367

GS= 2.444

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.748	.590	.550
MINIMUM X	-1.425	-.589	-.629
MAXIMUM Y	.947	.913	.731
MINIMUM Y	-1.420	-1.454	-.893
CENTROID X	-.019	.139	.179
CENTROID Y	.194	.228	.410
POA TO CENTROID in.	.195	.267	.447
MIN RADIUS	.163	.047	.232
MEAN RADIUS	.823	.738	.646
MAX RADIUS	1.457	1.489	1.031
HORIZONTAL SPREAD	2.173	1.179	1.179
VERTICAL SPREAD	2.367	2.367	1.624
EXTREME SPREAD	2.444	2.444	1.831
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.054

VS = 2.917

GS = 2.924

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.373	.341	.369
MINIMUM X	:	-.681	-.640	-.613
MAXIMUM Y	:	1.435	1.270	.826
MINIMUM Y	:	-1.482	-1.266	-1.107
CENTROID X	:	.342	.301	.274
CENTROID Y	:	-.132	.033	-.124
POA TO CENTROID in.	:	.366	.302	.291
MIN RADIUS	:	.461	.376	.510
MEAN RADIUS	:	.884	.789	.732
MAX RADIUS	:	1.529	1.310	1.155
HORIZONTAL SPREAD	:	1.054	.981	.981
VERTICAL SPREAD	:	2.917	2.536	1.933
EXTREME SPREAD	:	2.924	2.539	2.032
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.571

VS= 2.719

GS= 2.894

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.197	1.173
MINIMUM X	-1.327	-1.031	-1.055
MAXIMUM Y	1.028	.909	.592
MINIMUM Y	-1.691	-1.810	-1.011
CENTROID X	-.041	.106	.130
CENTROID Y	-.203	-.084	.142
POA TO CENTROID in.	.207	.135	.192
MIN RADIUS	.473	.284	.198
MEAN RADIUS	1.048	.921	.752
MAX RADIUS	1.705	1.820	1.324
HORIZONTAL SPREAD	2.671	2.228	2.228
VERTICAL SPREAD	2.719	2.719	1.694
EXTREME SPREAD	2.894	2.746	2.270
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		