

C6648930

MODEL 700TM M24

Model **S&S** TM

Action _____

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.

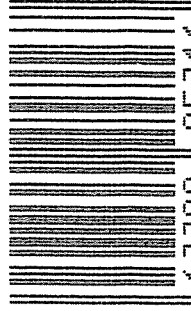


Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ H24		SERIAL NO. C6648930	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	



5716 C6648930

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648930

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	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	LS
	Apply Coating (Bolt)			
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		8-15-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-15-91	JH
	G) Safety Off Force	2	2	2			8-15-91	JH
	H) Trigger Pull Test & Retainability						8-15-91	JH
	I) Firing Pin Indent	.0215	.021	.021			8-15-91	JH
	J) Assemble Stock						8-16-91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	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						8-16-91	AC
	A) Time						8-16-91	AC
	B) Malfunctions						8-16-91	AC
	C) Pierced Primers						8-16-91	AC
	D) Optical Clarity of Scope						8-16-91	AC
645	Inspect for Live Ammo						8-16-91	AC
655	Final Inspection							
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	272	268	277	277	280	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6648930

DATE 8-15-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.15	2.40	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.39	2.44	2.68	
PULL #3	2.42	2.49	2.39	2.77	
PULL #4	2.32	2.44	2.20	2.77	
PULL #5	2.45	2.39	2.41	2.80	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.22		
PULL #2	3.54	3.20		
PULL #3	3.54	3.18		
PULL #4	3.29	3.20		
PULL #5	3.60	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.45		4.48
PULL #2	4.52	4.47		4.49
PULL #3	4.44	4.48		4.44
PULL #4	4.49	4.43		4.15
PULL #5	4.49	4.44		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648930
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.285007
1 TO	2	.310105
1 TO	3	.445892
1 TO	4	.355844
1 TO	5	.448657

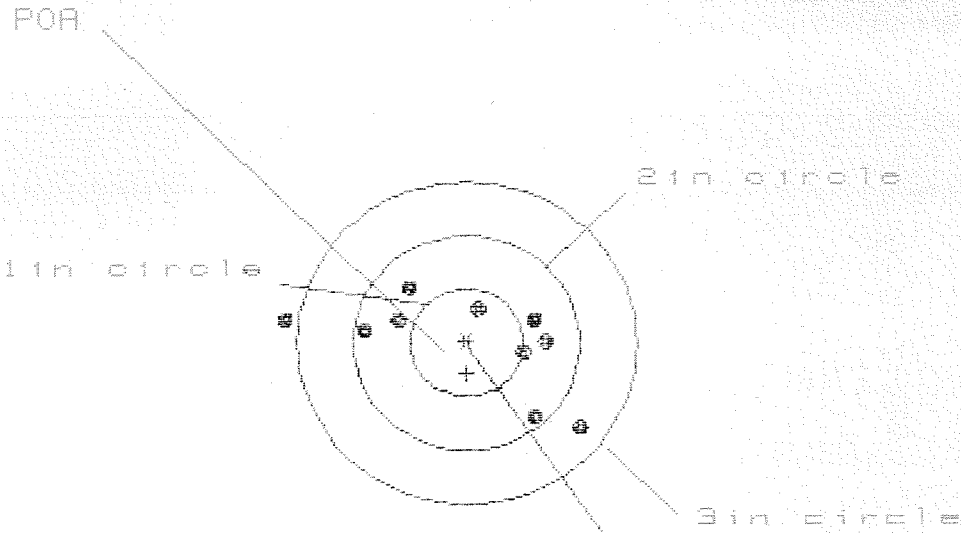
1
95 <----FOR

THIS RIFLE IS: -.044
THIS RIFLE IS: -.0064
PLUS FOR THIS RIFLE IS: .044463
.7842

28 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C864B930

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 = 1
2 = 8
3 = 6

CM = 0.528

DM = 0.828

EM = 0.738

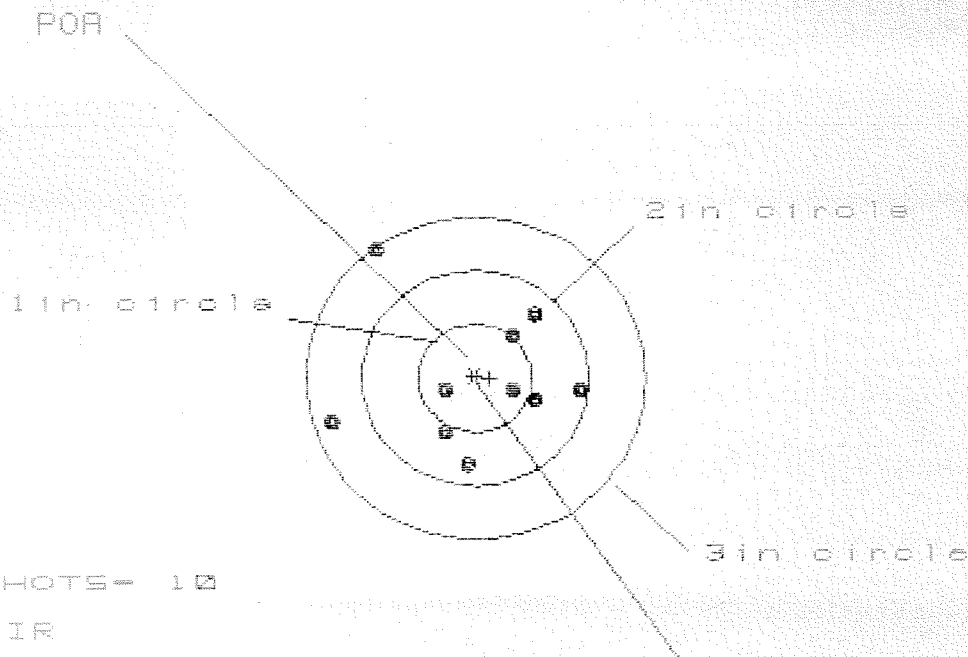
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MINIMUM X	.948	.771	.655
MINIMUM Y	-1.590	-1.044	-.948
MAXIMUM X	.556	.585	.492
MAXIMUM Y	-.772	-.744	-.767
CENTROID X	.002	.179	.083
CENTROID Y	.285	.256	.349
POR TO CENTROID in.	.285	.313	.359
MIN RADIUS	.315	.309	.224
MEAN RADIUS	.811	.690	.638
MAX RADIUS	1.611	1.072	.948
HORIZONTAL SPREAD	2.538	1.815	1.603
VERTICAL SPREAD	1.329	1.329	1.259
DIAGN. SPREAD	2.738	1.999	1.656
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	

22 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8648930

CENTERFIRE PATTERNS # 2



* OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 2.156

VS= 1.988

CS= 2.238

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.907	.809	.641
MINIMUM X	-1.249	-1.347	-.521
MAXIMUM Y	1.212	.685	.649
MINIMUM Y	-.776	-.641	-.677
CENTROID X	-.127	-.029	.139
CENTROID Y	.003	-.132	-.096
POA TO CENTROID in.	.127	.135	.169
MIN RADIUS	.268	.258	.086
MEAN RADIUS	.755	.645	.517
MAX RADIUS	1.498	1.377	.767
HORIZONTAL SPREAD	2.156	2.156	1.162
VERTICAL SPREAD	1.988	1.326	1.326
EXTREME SPREAD	2.238	2.175	1.457
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B330

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.475

VS= 1.244

GS= 1.536

CENTROID *

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

8

.727

.644

.492

-.748

-.502

-.421

.794

.747

.685

-.450

-.497

-.442

-.142

-.059

-.140

-.137

-.090

-.028

.197

.108

.142

.122

.209

.111

.523

.489

.438

.860

.814

.709

1.475

1.146

.913

1.244

1.244

1.127

1.536

1.411

1.206

5

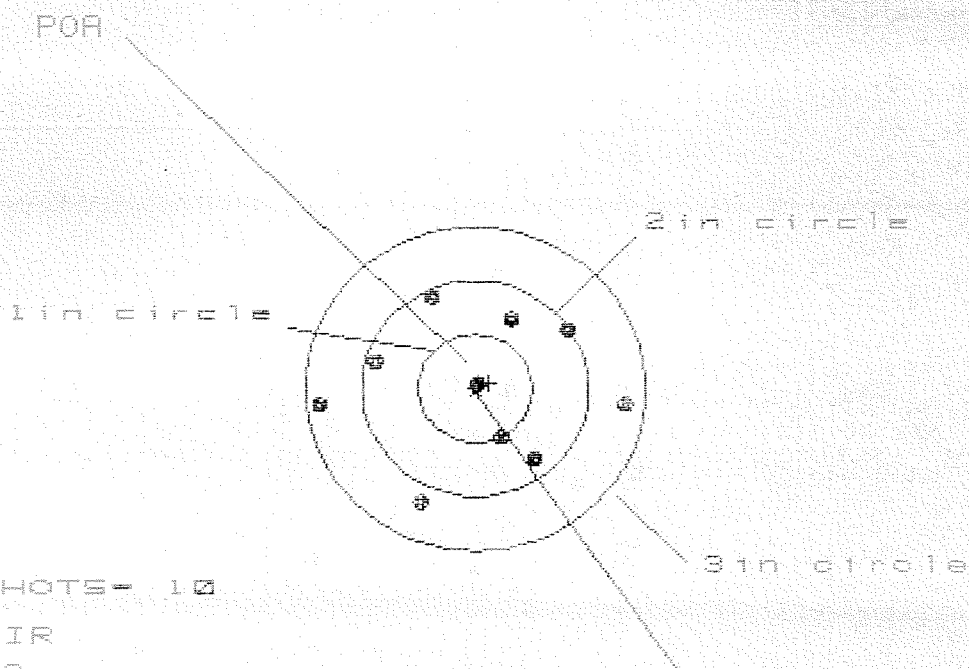
10

10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8646930

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.713

VS = 1.899

GS = 2.713

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.363	.925	.775
MINIMUM X	-1.350	-1.199	-1.890
MAXIMUM Y	.873	.855	.838
MINIMUM Y	-1.026	-1.044	-1.060
CENTROID X	-.118	-.269	-.119
CENTROID Y	-.050	-.032	-.016
POA TO CENTROID in.	.128	.271	.120
MIN RADIUS	.033	.137	.015
MEAN RADIUS	.878	.832	.754
MAX RADIUS	1.373	1.206	1.171
HORIZONTAL SPREAD	2.713	2.124	1.665
VERTICAL SPREAD	1.899	1.899	1.899
EXTREME SPREAD	2.713	2.235	2.051
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

22 Aug 1991

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CENTERFIRE PATTERNS

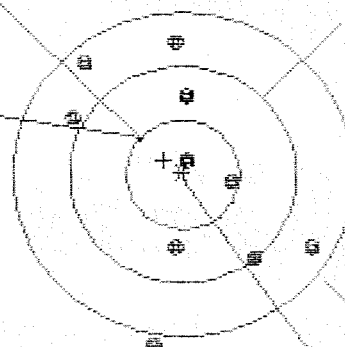
5

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.136

VS= 2.751

GS= 2.754

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.130	1.103	.986
MINIMUM X	-1.006	-1.033	-1.149
MAXIMUM Y	1.209	1.037	1.142
MINIMUM Y	-1.542	-.945	-.848
CENTROID X	.165	.192	.308
CENTROID Y	-.133	.039	-.066
POA TO CENTROID in.	.212	.196	.315
MIN RADIUS	.185	.035	.135
MEAN RADIUS	.954	.859	.803
MAX RADIUS	1.561	1.382	1.234
HORIZONTAL SPREAD	2.136	2.136	2.136
VERTICAL SPREAD	2.751	1.982	1.982
EXTREME SPREAD	2.754	2.630	2.439
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		