

C6611710

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

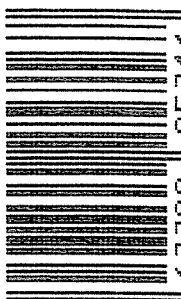
Remington

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. C6611710	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			



5716 C6611710

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611710

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	23	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	11
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/23/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/23/91	OC
	G) Safety Off Force	3	3	3			4/23/91	OC
	H) Trigger Pull Test & Retainability						4/23/91	OC
	I) Firing Pin Indent	.023	.023.5	.0235			4/23/91	OC
	J) Assemble Stock						4/23/91	RW
	K) Assemble Swivel Studs						5-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/23/91	RW
	M) Iron Sight Alignment						4/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/91	RW
	O) Attach Scope to Rifle						4/23/91	RW
	P) Detach & Attach Scope 20 Times						4/23/91	RW
640	Gallery Target & Test						4-24-91	DH
	A) Time						4-24-91	DH
	B) Malfunctions						4-24-91	DH
	C) Pierced Primers						4-24-91	DH
	D) Optical Clarity of Scope						4-24-91	DH
645	Inspect for Live Ammo						4-24-91	DH
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.24	2.15	2.18	2.21	2.16	4/26/91	OC
	C) Function						5-2-91	DH
660	Pack						6-18-91	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-6611710

DATE 4/23/91

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.63	2.43	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.37	2.43	2.15	
PULL #3	2.19	2.25	2.52	2.18	
PULL #4	2.64	2.28	2.51	2.21	
PULL #5	2.41	2.19	2.55	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.50		
PULL #2	3.49	3.50		
PULL #3	3.48	3.52		
PULL #4	3.47	3.56		
PULL #5	4.46	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.34		4.34
PULL #2	4.30	4.40		4.50
PULL #3	4.31	4.31		4.48
PULL #4	4.36	4.33		4.60
PULL #5	4.26	4.36		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611710
24 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.404634
1 TO	2	.489449
1 TO	3	.426823
1 TO	4	.274204
1 TO	5	.438564

$\bar{y}_1^2$ <----POA

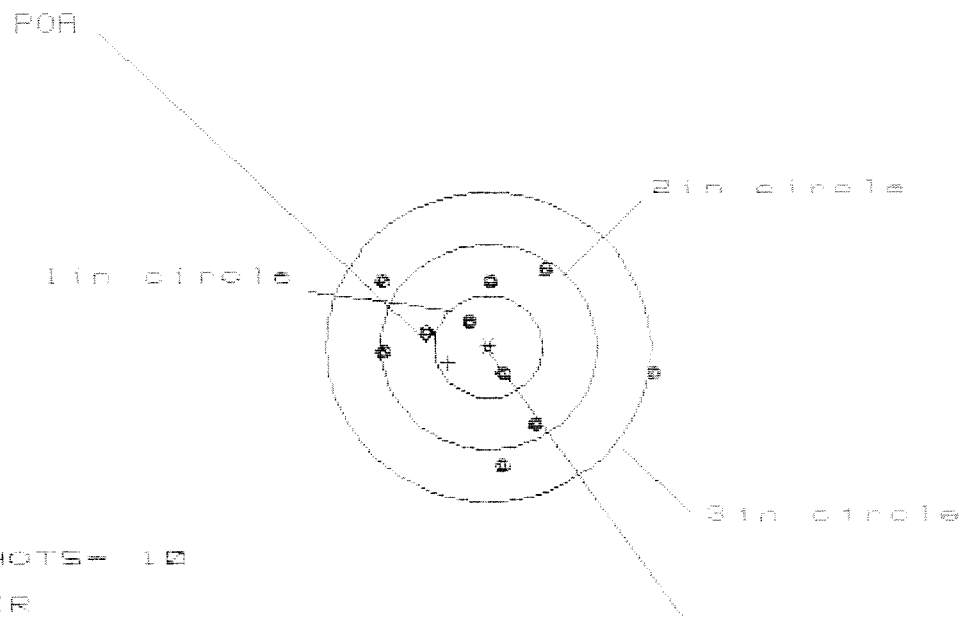
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .329325

THE AMR FOR THIS RIFLE IS: .8478

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611710

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.426

VS = 1.909

GS = 2.543

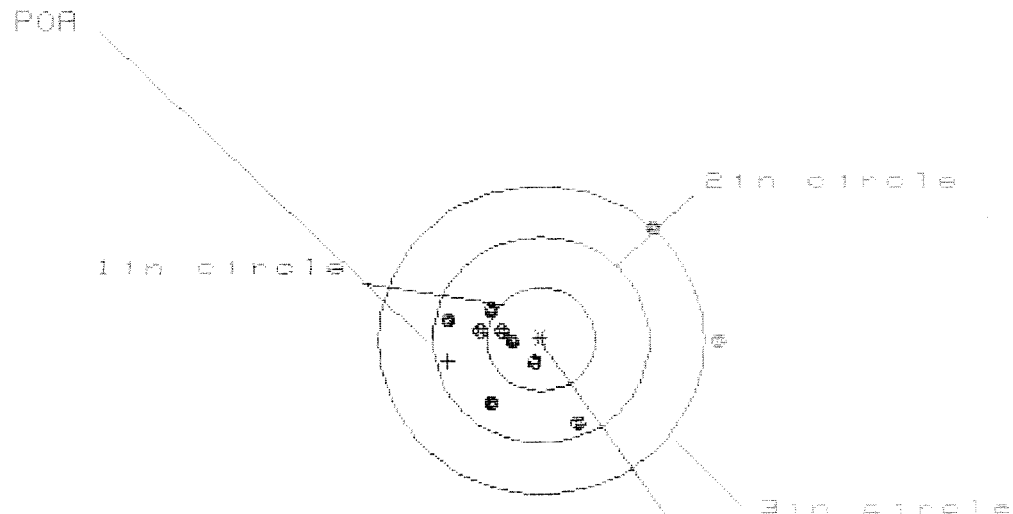
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.476	.661	.703
MINIMUM X	-.950	-.786	-.744
MAXIMUM Y	.767	.742	.596
MINIMUM Y	-1.142	-1.167	-.887
CENTROID X	.375	.211	.169
CENTROID Y	.152	.177	.323
FOR TO CENTROID in.	.404	.275	.364
MIN RADIUS	.299	.245	.122
MEAN RADIUS	.834	.740	.654
MAX RADIUS	1.494	1.215	1.068
HORIZONTAL SPREAD	2.426	1.447	1.447
VERTICAL SPREAD	1.909	1.909	1.483
EXTREME SPREAD	2.543	2.061	1.863
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611710

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 2.466

VS= 1.928

GS= 2.474

CENTROID *

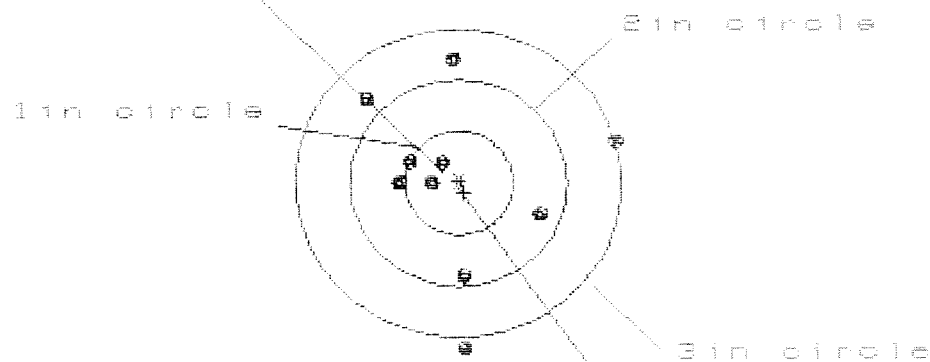
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.647	1.230	.643
MINIMUM X	:	-.819	-.636	-.483
MAXIMUM Y	:	1.106	1.100	.425
MINIMUM Y	:	-.822	-.828	-.690
CENTROID X	:	.861	.678	.535
CENTROID Y	:	.210	.216	.078
POA TO CENTROID in.	:	.887	.712	.531
MIN RADIUS	:	.269	.126	.148
MEAN RADIUS	:	.770	.594	.434
MAX RADIUS	:	1.647	1.650	.944
HORIZONTAL SPREAD	:	2.466	1.866	1.126
VERTICAL SPREAD	:	1.928	1.928	1.115
EXTREME SPREAD	:	2.474	2.284	1.483
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.251

VS = 2.846

GS = 2.849

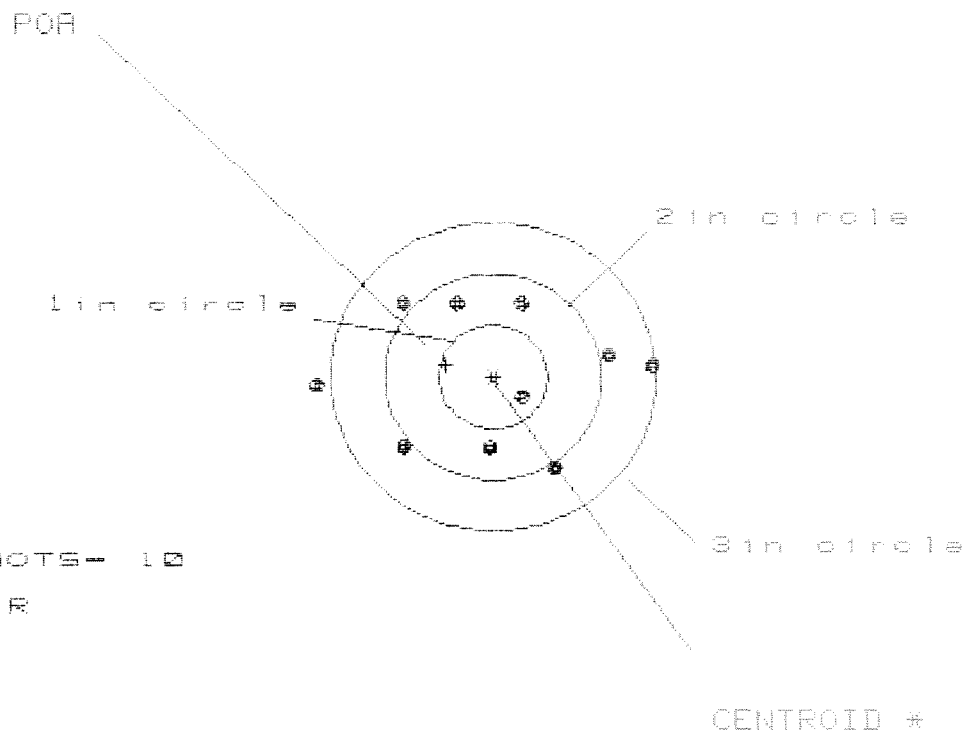
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.429	1.435	.930
MINIMUM X	-.822	-.816	-.637
MAXIMUM Y	1.235	1.056	1.079
MINIMUM Y	-1.611	-1.073	-1.050
CENTROID X	-.049	-.054	-.233
CENTROID Y	.095	.274	.251
POA TO CENTROID in.	.107	.279	.343
MIN RADIUS	.265	.140	.086
MEAN RADIUS	.872	.772	.629
MAX RADIUS	1.612	1.447	1.085
HORIZONTAL SPREAD	2.251	2.251	1.567
VERTICAL SPREAD	2.846	2.129	2.129
EXTREME SPREAD	2.849	2.289	2.132
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 3.098

VS = 1.624

GS = 3.103

PATTERN #

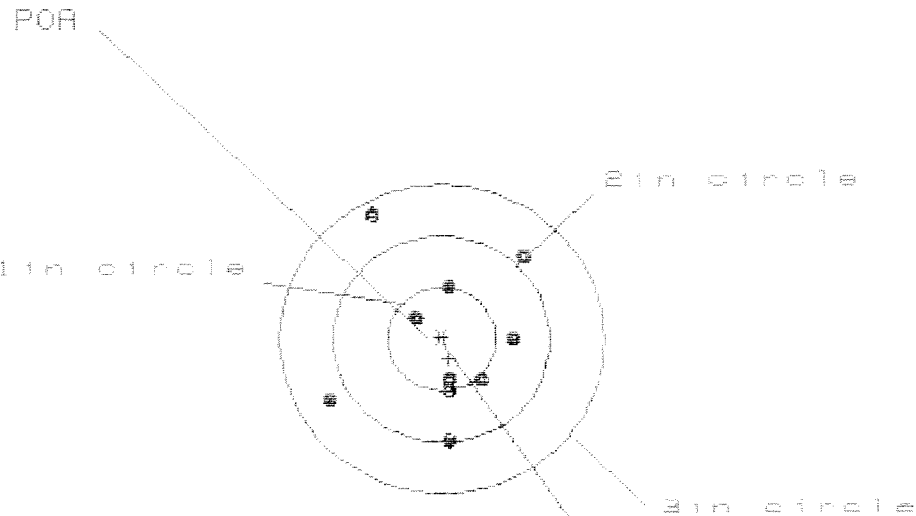
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.498	1.320	1.066
MINIMUM X	-1.600	-1.048	-0.883
MAXIMUM Y	.755	.751	.768
MINIMUM Y	-0.869	-0.873	-0.856
CENTROID X	.433	.611	.446
CENTROID Y	-.116	-.112	-.129
POA TO CENTROID in.	.448	.621	.464
MIN RADIUS	.315	.179	.297
MEAN RADIUS	1.007	.918	.889
MAX RADIUS	1.600	1.328	1.158
HORIZONTAL SPREAD	3.098	2.368	1.949
VERTICAL SPREAD	1.624	1.624	1.624
EXTREME SPREAD	3.103	2.521	2.147
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.785

VS= 2.212

GS= 2.314

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.723	.651	.510
MINIMUM X	-1.062	-1.134	-.489
MAXIMUM Y	1.241	.929	.869
MINIMUM Y	-.971	-.833	-.893
CENTROID X	-.062	.010	.151
CENTROID Y	.189	.051	.111
POA TO CENTROID in.	.199	.052	.188
MIN RADIUS	.298	.243	.331
MEAN RADIUS	.756	.656	.581
MAX RADIUS	1.399	1.231	1.007
HORIZONTAL SPREAD	1.785	1.785	.919
VERTICAL SPREAD	2.212	1.762	1.782
EXTREME SPREAD	2.314	2.273	1.893
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	