

C6611768

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

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

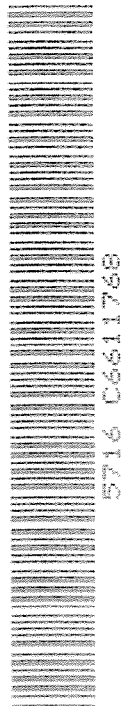
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6611768

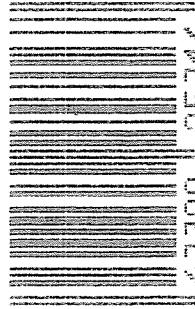
ORDER NO.
5716

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



5716 C6611768

UPC



0 4700 25716

7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611768

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 10 91	RW
600	Proof		1 10 91	RW
607	Check Headspace		1 10 91	RW
610	Dis-assemble Gun		1 10 91	RW
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS.
617	Drill and Tap Sight Holes		1 17 91	FB
618	Polish Barrel		1 17 91	WB
620	Apply Coatings (Barrel Action)		2-12-91	FA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/91	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/9/91	JH
	G) Safety Off Force	4	4	4			3/9/91	JH
	H) Trigger Pull Test & Retainability						3/8/91	JH
	I) Firing Pin Indent	0225	0225	0225			3/9/91	JH
	J) Assemble Stock						3/9/91	RW
	K) Assemble Swivel Studs						3-11-91	DH
	L) Attach Front and Rear Sight Assemblies						3/9/91	RW
	M) Iron Sight Alignment						3/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/9/91	RW
	O) Attach Scope to Rifle						3/9/91	RW
	P) Detach & Attach Scope 20 Times						3/9/91	RW
640	Gallery Target & Test						3/9/91	JH
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						3/9/91	KJ
655	Final Inspection							
	A) Headspace						3-11-91	DH
	B) Trigger Pull	3.31	2.20	2.34	2.35	2.22	3/11/91	JH
	C) Function						3-11-91	DH
660	Pack						3-11-91	JH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611768

DATE 3-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.39	2.28	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.41	2.30	2.20	
PULL #3	2.49	2.46	2.38	2.34	
PULL #4	2.43	2.44	2.40	2.35	
PULL #5	2.42	2.30	2.41	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.44		
PULL #2	3.33	3.45		
PULL #3	3.41	3.41		
PULL #4	3.41	3.39		
PULL #5	3.40	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.47		4.49
PULL #2	4.15	4.48		4.48
PULL #3	4.15	4.47		4.47
PULL #4	4.49	4.46		4.50
PULL #5	4.50	4.47		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611768
9 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.0366742
1 TO 2	.155081
1 TO 3	.356923
1 TO 4	.190536
1 TO 5	.138539

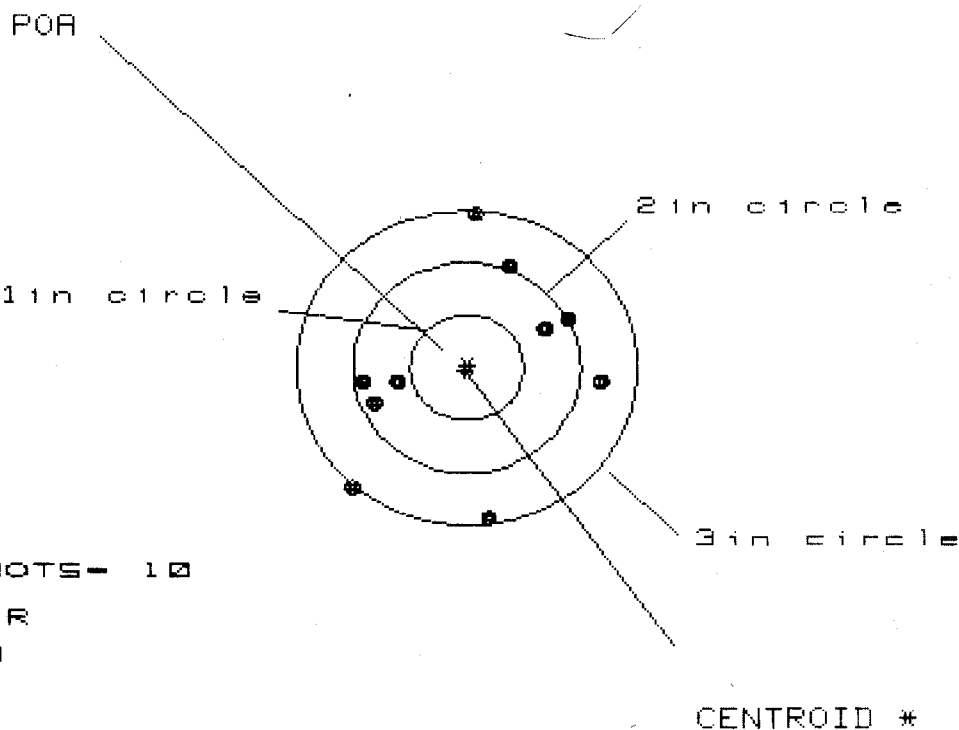
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0458
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.113
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .121929
THE RADIUS FOR THIS RIFLE IS: 1.168

9 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611768

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.238

VS= 2.944

GS= 2.946

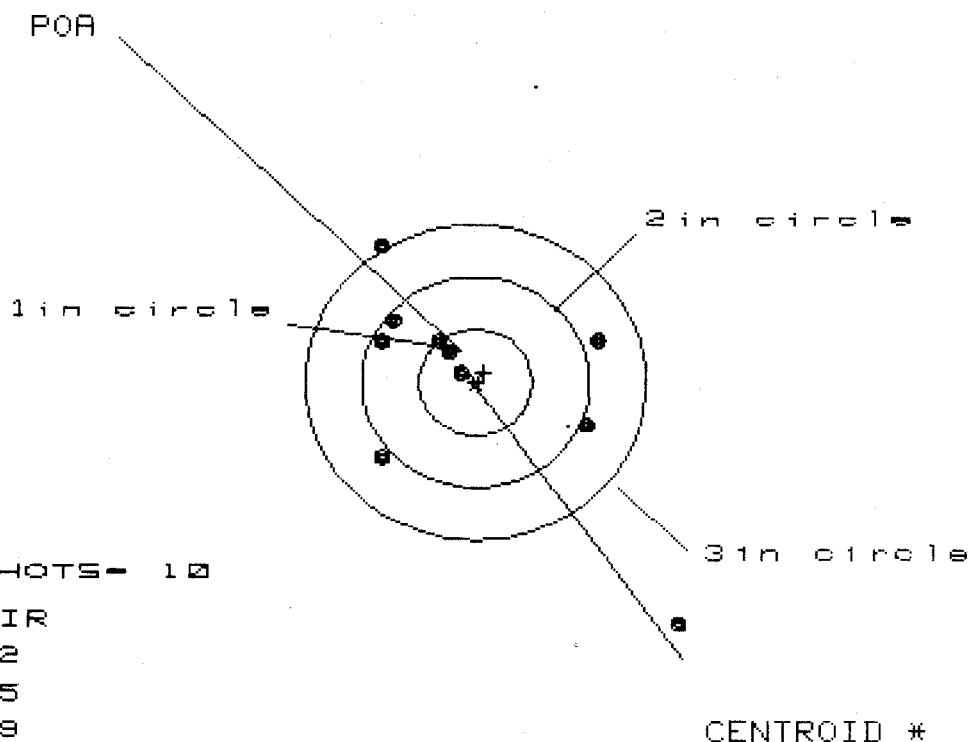
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.177	1.059	1.055
MINIMUM X	-1.061	-1.066	-1.070
MAXIMUM Y	1.485	1.363	1.053
MINIMUM Y	-1.459	-1.581	-1.410
CENTROID X	.016	.134	.138
CENTROID Y	.033	.155	-.016
POA TO CENTROID in.	.037	.205	.139
MIN RADIUS	.591	.603	.675
MEAN RADIUS	1.092	1.029	.987
MAX RADIUS	1.525	1.583	1.412
HORIZONTAL SPREAD	2.238	2.125	2.125
VERTICAL SPREAD	2.944	2.944	2.463
EXTREME SPREAD	2.946	2.946	2.472
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

9 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611768

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 9

HS- 2.580

VS- 3.511

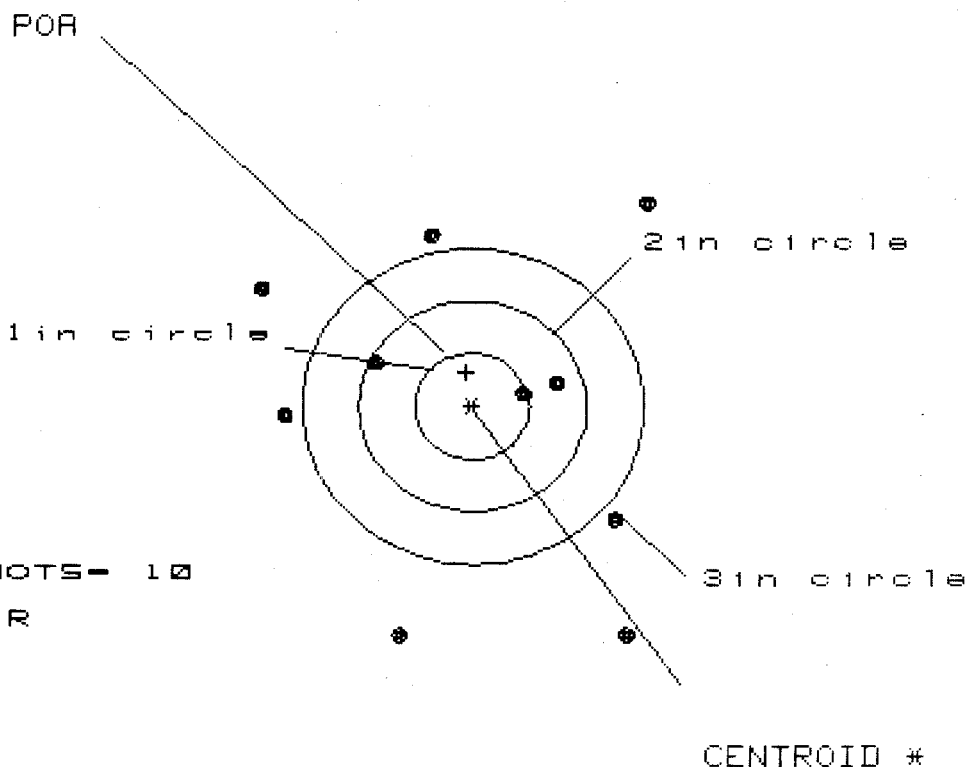
GS- 4.348

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.771	1.295	1.221
MINIMUM X	:	-.809	-.613	-.687
MAXIMUM Y	:	1.248	.997	.432
MINIMUM Y	:	-2.263	-.939	-.815
CENTROID X	:	-.073	-.269	-.195
CENTROID Y	:	-.094	.157	.033
POA TO CENTROID in.	:	.119	.312	.197
MIN RADIUS	:	.190	.062	.067
MEAN RADIUS	:	1.052	.733	.701
MAX RADIUS	:	2.873	1.347	1.241
HORIZONTAL SPREAD	:	2.580	1.908	1.908
VERTICAL SPREAD	:	3.511	1.936	1.247
EXTREME SPREAD	:	4.348	2.419	2.173
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 3

3 in - 3

HS- 3.381

VS- 4.066

GS- 4.598

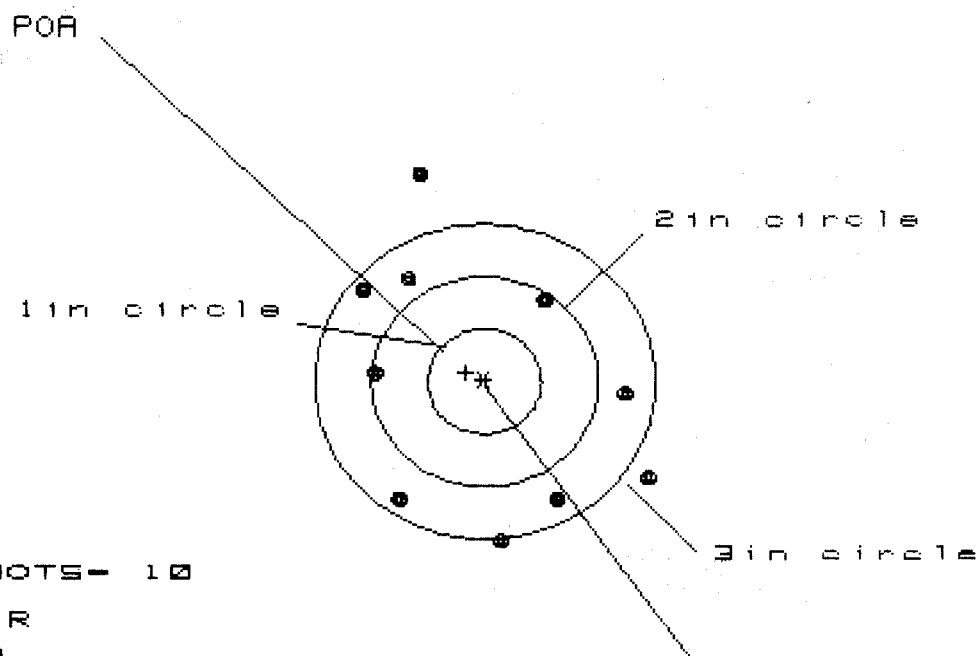
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.506	1.659	1.632
MINIMUM X	:	-1.875	-1.722	-1.514
MAXIMUM Y	:	1.925	1.687	1.628
MINIMUM Y	:	-2.141	-2.366	-2.155
CENTROID X	:	.053	-.100	-.308
CENTROID Y	:	-.322	-.084	-.295
POA TO CENTROID in.	:	.327	.131	.427
MIN RADIUS	:	.497	.636	.592
MEAN RADIUS	:	1.666	1.545	1.443
MAX RADIUS	:	2.546	2.417	2.174
HORIZONTAL SPREAD	:	3.381	3.381	3.146
VERTICAL SPREAD	:	4.066	4.053	3.783
EXTREME SPREAD	:	4.598	4.591	3.850
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		3	

9 Mar 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 2.512

VS= 3.474

GS= 3.540

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.387	1.347
MINIMUM X	:	-1.066	-1.125	-.952
MAXIMUM Y	:	2.002	1.171	1.089
MINIMUM Y	:	-1.472	-1.250	-1.333
CENTROID X	:	.164	.223	.050
CENTROID Y	:	-.087	-.309	-.226
POA TO CENTROID in.	:	.186	.381	.232
MIN RADIUS	:	.933	1.016	.856
MEAN RADIUS	:	1.350	1.257	1.208
MAX RADIUS	:	2.071	1.565	1.384
HORIZONTAL SPREAD	:	2.512	2.512	2.299
VERTICAL SPREAD	:	3.474	2.421	2.421
EXTREME SPREAD	:	3.540	3.060	2.633
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	2	2	2
NUMBER IN THREE INCH CIRCLE	=	8	8	8

9 Mar 1991

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 9

HS- 1.563

VS- 2.305

GS- 2.785

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.880	.549	.476
MINIMUM X	:	-.683	-.585	-.394
MAXIMUM Y	:	1.251	.916	.802
MINIMUM Y	:	-1.054	-.915	-.792
CENTROID X	:	.069	-.029	.044
CENTROID Y	:	-.095	-.234	-.120
POA TO CENTROID in.	:	.117	.236	.127
MIN RADIUS	:	.134	.092	.151
MEAN RADIUS	:	.682	.584	.504
MAX RADIUS	:	1.530	1.086	.893
HORIZONTAL SPREAD	:	1.563	1.134	.870
VERTICAL SPREAD	:	2.305	1.831	1.594
EXTREME SPREAD	:	2.785	1.850	1.617
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		