

C6636134

MODEL 700TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

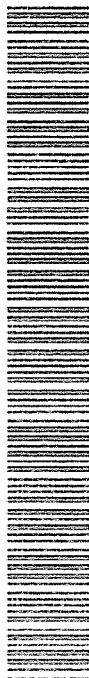
MODEL 700™ M24

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

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

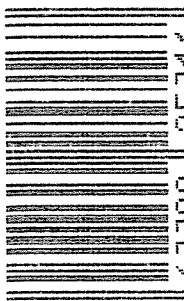
DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.	C6636134
ORDER NO.	5716



5716 C6636134

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636134

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3 28 91	Rw
600	Proof		3 28 91	Rw
607	Check Headspace		3 28 91	Rw
610	Dis-assemble Gun		3 28 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	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	JH
	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		4/24/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/29/91	JM
	G) Safety Off Force	4	4	4			4/29/91	JM
	H) Trigger Pull Test & Retainability						4/24/91	JM
	I) Firing Pin Indent	1021	10215	10255			4/29/91	JM
	J) Assemble Stock						4/29/91	RW
	K) Assemble Swivel Studs						5-13-91	+
	L) Attach Front and Rear Sight Assemblies						4/29/91	RW
	M) Iron Sight Alignment						4/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/29/91	RW
	O) Attach Scope to Rifle						4/29/91	RW
	P) Detach & Attach Scope 20 Times						4/29/91	RW
640	Gallery Target & Test						4-29-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-29-91	NF
655	Final Inspection							
	A) Headspace						5-13-91	AC
	B) Trigger Pull	260	259	262	260	265	5/10/91	JM
	C) Function						5-13-91	AC
660	Pack						6-14-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636134

DATE 4/24/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.44	2.40	2.60	MIN. SETTING,
PULL #2	2.28	2.32	2.44	2.59	NO AVG. OF 5
PULL #3	2.37	2.38	2.42	2.62	READINGS ACCEPT-
PULL #4	2.38	2.37	2.39	2.60	ABLE LESS THAN 2#
PULL #5	2.39	2.39	2.40	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.53		
PULL #2	3.49	3.57		
PULL #3	3.50	3.52		
PULL #4	3.55	3.52		
PULL #5	3.52	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.38		4.30
PULL #2	4.25	4.35		4.35
PULL #3	4.28	4.35		4.27
PULL #4	4.30	4.32		4.33
PULL #5	4.26	4.33		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636134
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.07
1 TO	2	.222081
1 TO	3	.16792
1 TO	4	.174451
1 TO	5	.0926489

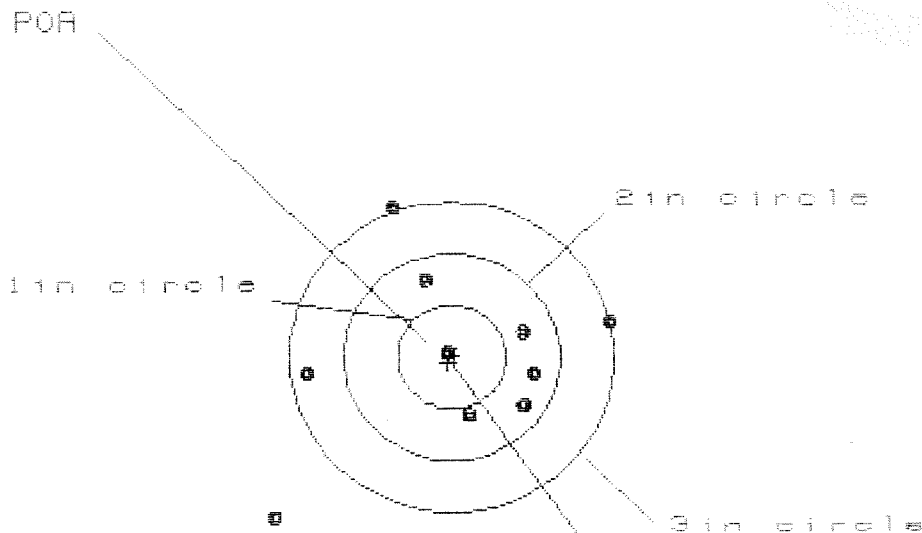
$\bar{x}$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0626
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0854751
THE AMR FOR THIS RIFLE IS: .8366

29 Apr 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 3

HS = 3.092

VS = 3.039

GS = 3.644

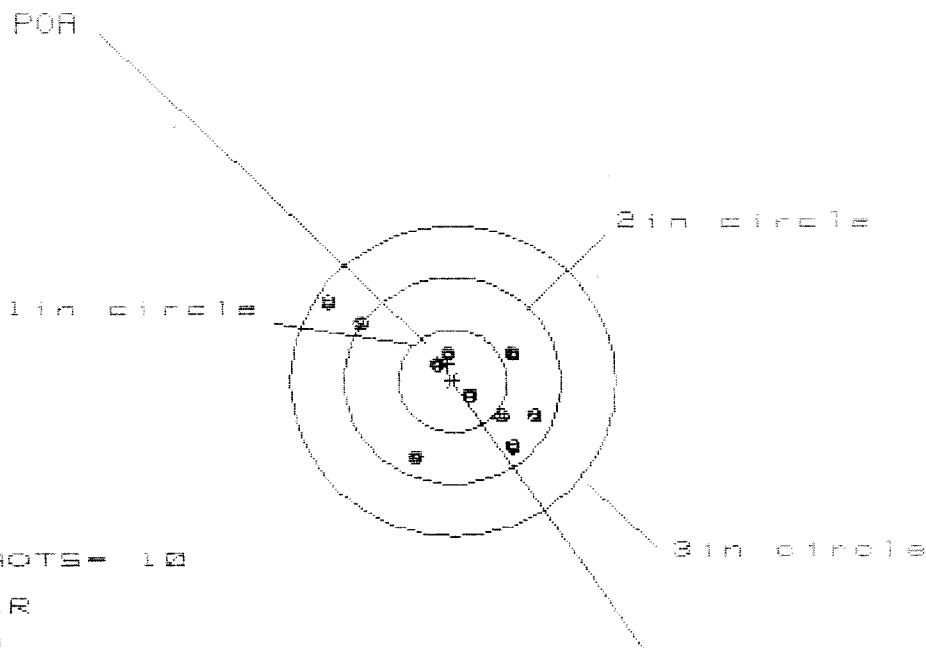
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.473	1.293	1.285
MINIMUM X	-1.619	-1.540	-1.628
MAXIMUM Y	1.443	1.266	.735
MINIMUM Y	-1.596	-1.788	-1.558
CENTROID X	.042	.222	.310
CENTROID Y	.056	.233	.075
POA TO CENTROID in.	.070	.322	.319
MIN RADIUS	.093	.203	.283
MEAN RADIUS	1.044	.881	.781
MAX RADIUS	2.273	1.571	1.635
HORIZONTAL SPREAD	3.092	2.833	2.833
VERTICAL SPREAD	3.039	1.974	1.285
EXTREME SPREAD	3.644	2.871	2.871
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

29 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.927

VS= 1.524

GS= 2.214

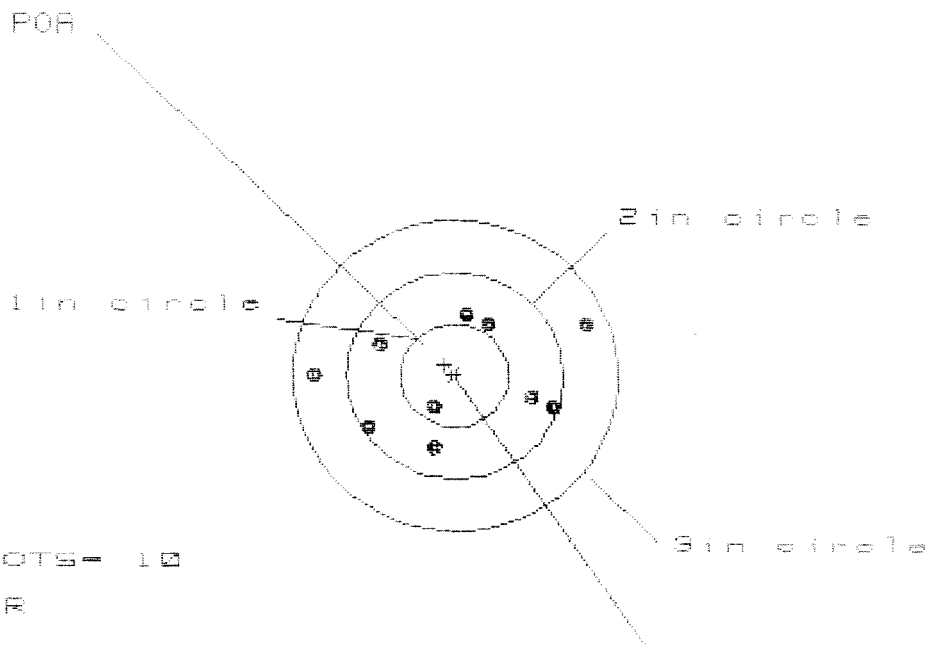
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.760	.630	.510
MINIMUM X	:	-1.167	-.965	-.574
MAXIMUM Y	:	.775	.680	.481
MINIMUM Y	:	-.749	-.663	-.578
CENTROID X	:	.048	.178	.298
CENTROID Y	:	-.166	-.252	-.337
POA TO CENTROID in.	:	.173	.309	.450
MIN RADIUS	:	.164	.019	.141
MEAN RADIUS	:	.676	.566	.485
MAX RADIUS	:	1.401	1.180	.815
HORIZONTAL SPREAD	:	1.927	1.595	1.084
VERTICAL SPREAD	:	1.524	1.343	1.059
EXTREME SPREAD	:	2.214	1.836	1.345
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 3.473

VS= 1.310

GS= 2.531

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.219
MINIMUM X	-1.254
MAXIMUM Y	.579
MINIMUM Y	-.731
CENTROID X	.096
CENTROID Y	-.103
POA TO CENTROID in.	.141
MIN RADIUS	.344
MEAN RADIUS	.817
MAX RADIUS	1.338
HORIZONTAL SPREAD	2.473
VERTICAL SPREAD	1.310
EXTREME SPREAD	2.531
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 8
NUMBER IN THREE INCH CIRCLE	= 10

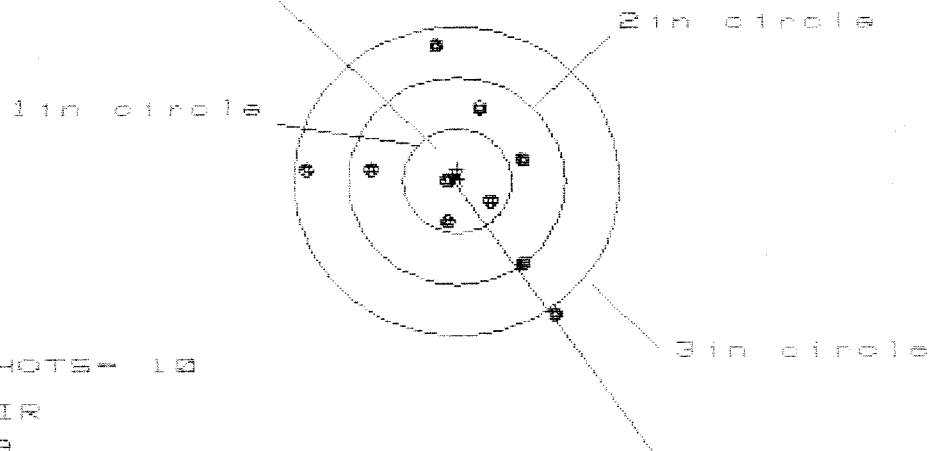
29 Apr 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

CENTROID *

HS= 2.311

VS= 2.613

GS= 2.808

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.880	.689	.522
MINIMUM X	-1.431	-1.333	-.842
MAXIMUM Y	1.354	1.214	1.209
MINIMUM Y	-1.259	-.897	-.902
CENTROID X	-.005	-.103	.064
CENTROID Y	-.112	.028	.033
POA TO CENTROID in.	.112	.106	.072
MIN RADIUS	.131	.122	.233
MEAN RADIUS	.839	.769	.685
MAX RADIUS	1.536	1.334	1.228
HORIZONTAL SPREAD	2.311	2.022	1.364
VERTICAL SPREAD	2.613	2.111	2.111
EXTREME SPREAD	2.808	2.232	2.232
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 8

HS= 3.438

VS= 2.312

GS= 3.589

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.977	.814	.502
MINIMUM X	:	-2.361	-.499	-.397
MAXIMUM Y	:	1.318	1.288	1.076
MINIMUM Y	:	-.994	-1.055	-.488
CENTROID X	:	.132	.395	.293
CENTROID Y	:	.034	.144	.276
POA TO CENTROID in.	:	.137	.420	.482
MIN RADIUS	:	.222	.073	.146
MEAN RADIUS	:	.807	.582	.475
MAX RADIUS	:	2.562	1.333	1.099
HORIZONTAL SPREAD	:	3.438	1.313	.899
VERTICAL SPREAD	:	2.312	2.263	1.564
EXTREME SPREAD	:	3.589	2.367	1.684
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	