

C6636152

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington




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

MODEL 700TM H24

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

SERIAL NO.
C6636152

ORDER NO.
5716

20

UPC



0 47700 25716 2



5716 C6636152

CONTRACT # DAAA21-87-C-0086

B

GUN SERIAL # C6636152

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 2 0 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		EB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/29/91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/7/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6/7/91	WB
	G) Safety Off Force	3	3	3			6/7/91	WB
	H) Trigger Pull Test & Retainability						6/7/91	WB
	I) Firing Pin Indent	.0725	.0715	.022			6/7/91	WB
	J) Assemble Stock						6/7/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/7/91	RW
	M) Iron Sight Alignment						6/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/7/91	RW
	O) Attach Scope to Rifle						6/7/91	RW
	P) Detach & Attach Scope 20 Times						6/7/91	RW
640	Gallery Target & Test						6/7/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/7/91	KT
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.32	2.30	2.20	2.46	2.57	6-8-91	RP
	C) Function						6-8-91	DH
660	Pack						6-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636152
DATE 6/7/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.36	2.49	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.27	2.57	2.30	
PULL #3	2.47	2.42	2.52	2.20	
PULL #4	2.53	2.48	2.51	2.46	
PULL #5	2.42	2.46	2.59	2.51	
TOTAL	12.51	11.99	12.68		
AVG.	2.50	2.40	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.47		
PULL #2	3.11	3.07		
PULL #3	3.17	3.25		
PULL #4	3.23	3.28		
PULL #5	3.14	3.23		
TOTAL	15.78	16.26		
AVG.	3.16	3.25		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.05		4.31
PULL #2	4.18	4.22		4.12
PULL #3	4.18	4.20		4.22
PULL #4	4.21	4.26		4.18
PULL #5	4.15	4.15		4.08
TOTAL	20.87	20.88		20.91
AVG.	4.17	4.17		4.18

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636152
7 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.221382
1 TO	2	.368982
1 TO	3	.355106
1 TO	4	.415202
1 TO	5	.159113

34
P <----POA

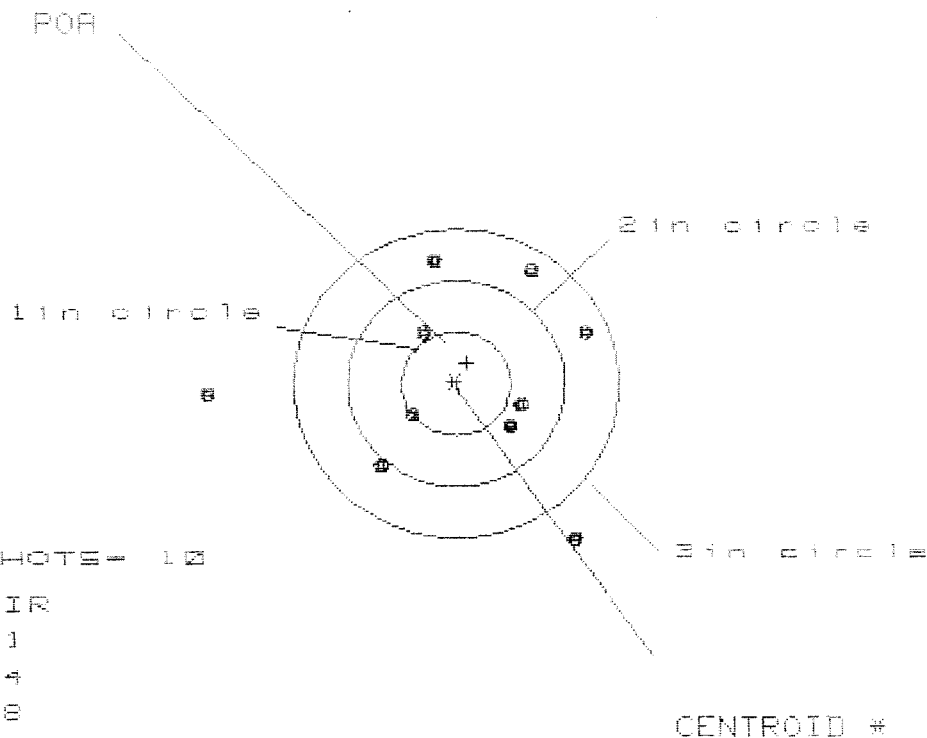
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1214
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0362
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .126682

THE AMR FOR THIS RIFLE IS: 1.072

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06638152

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.532

VS = 2.744

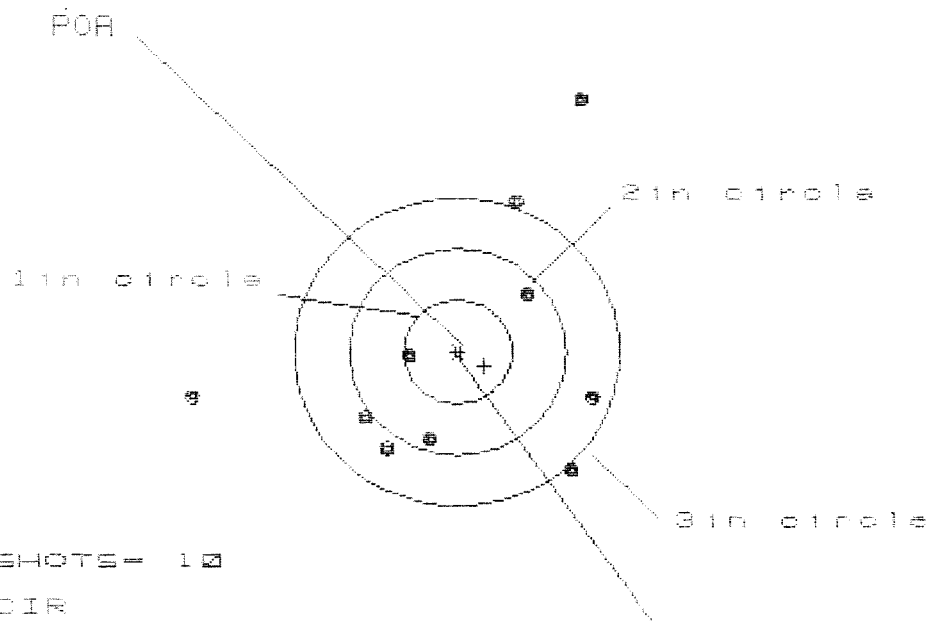
GS = 3.695

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.214	.957	1.061
MINIMUM X	-2.318	-.998	-.894
MAXIMUM Y	1.225	1.214	1.023
MINIMUM Y	-1.519	-1.530	-1.035
CENTROID X	-.097	.160	.056
CENTROID Y	-.199	-.188	.003
POA TO CENTROID in.	.222	.247	.056
MIN RADIUS	.482	.390	.588
MEAN RADIUS	1.152	.998	.901
MAX RADIUS	2.320	1.743	1.367
HORIZONTAL SPREAD	3.532	1.955	1.955
VERTICAL SPREAD	2.744	2.744	2.058
EXTREME SPREAD	3.695	3.049	2.375
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636152

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.735

VS= 3.610

GS= 4.587

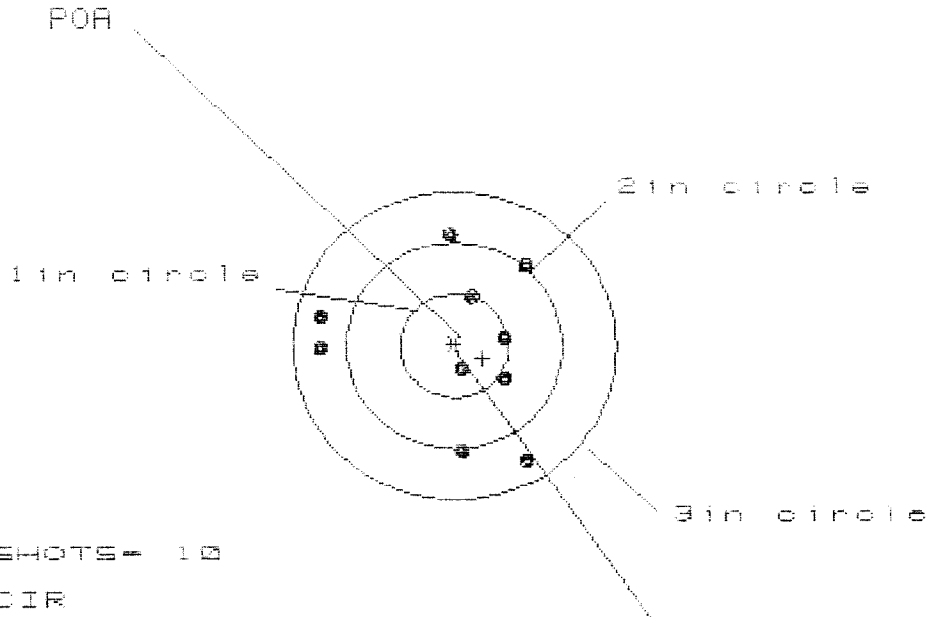
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.278	1.400	1.108
MINIMUM X	:	-2.458	-2.335	-1.048
MAXIMUM Y	:	2.490	1.721	1.705
MINIMUM Y	:	-1.120	-.843	-.859
CENTROID X	:	-.245	-.368	-.076
CENTROID Y	:	.139	-.138	-.122
POA TO CENTROID in.	:	.282	.393	.144
MIN RADIUS	:	.416	.368	.619
MEAN RADIUS	:	1.409	1.208	1.078
MAX RADIUS	:	2.724	2.338	1.753
HORIZONTAL SPREAD	:	3.735	3.735	2.156
VERTICAL SPREAD	:	3.610	2.564	2.564
EXTREME SPREAD	:	4.587	3.736	2.711
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.885

VS = 2.206

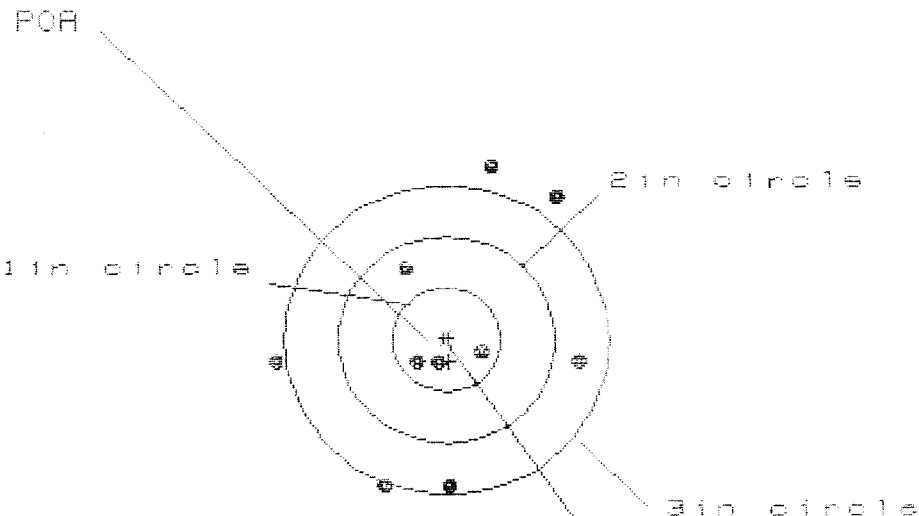
GS = 2.300

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.632	.493	.552
MINIMUM X	:	-1.253	-1.375	-1.316
MAXIMUM Y	:	1.099	1.126	.990
MINIMUM Y	:	-1.107	-1.080	-1.129
CENTROID X	:	-.259	-.120	-.179
CENTROID Y	:	.117	.090	.225
POA TO CENTROID in.	:	.284	.150	.288
MIN RADIUS	:	.251	.216	.345
MEAN RADIUS	:	.874	.797	.756
MAX RADIUS	:	1.276	1.376	1.320
HORIZONTAL SPREAD	:	1.885	1.868	1.868
VERTICAL SPREAD	:	2.206	2.206	2.119
EXTREME SPREAD	:	2.300	2.300	2.122
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 6

HS= 2.725

VS= 3.190

GS= 3.289

CENTROID #

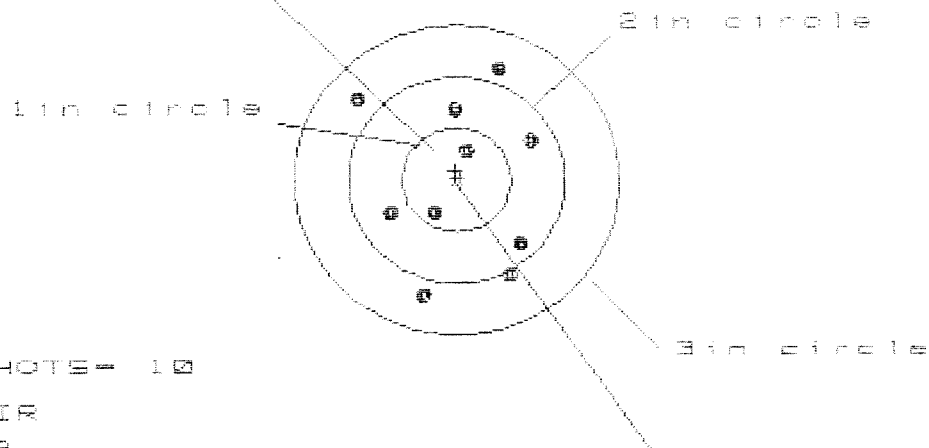
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.233	1.363
MINIMUM X	:	-1.539	-1.492	-1.362
MAXIMUM Y	:	1.739	1.584	1.044
MINIMUM Y	:	-1.451	-1.258	-1.060
CENTROID X	:	-.020	-.067	-.197
CENTROID Y	:	.209	.016	-.182
POR TO CENTROID in.	:	.210	.069	.268
MIN RADIUS	:	.215	.018	.226
MEAN RADIUS	:	1.094	.976	.876
MAX RADIUS	:	1.789	1.897	1.379
HORIZONTAL SPREAD	:	2.725	2.725	2.725
VERTICAL SPREAD	:	3.190	2.842	2.104
EXTREME SPREAD	:	3.289	3.208	2.725
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			6	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.5334

VS = 2.214

GS = 2.323

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.690
MINIMUM X	-.944
MAXIMUM Y	1.103
MINIMUM Y	-1.111
CENTROID X	.014
CENTROID Y	-.085
POA TO CENTROID in.	.086
MIN RADIUS	.298
MEAN RADIUS	.831
MAX RADIUS	1.251
HORIZONTAL SPREAD	1.634
VERTICAL SPREAD	2.214
EXTREME SPREAD	2.323
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10