

C6649119

MODEL 700™ M24

Model S&S™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

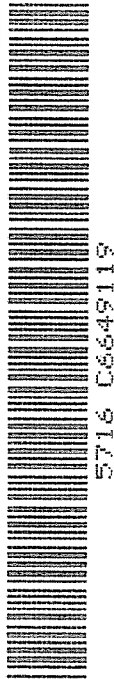
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marca Deposee.

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

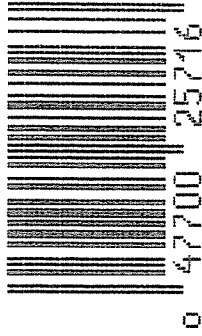
SERIAL NO.
C6649119

ORDER NO.
5716

20



UPC



MOD. _____ GA. CAL. _____ GUN # 9119

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
NF	1st	Shaver Brass	KS
	8/13		
	2nd	Polish face of Bolt 100 Rd Test	RW
	8/14		
	91		
	3rd		
	4th		

FUNCTION

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT

ASSEM.
#

PROOF	<i>shot OK</i> <i>test</i> <i>8-14-91 AH</i>	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649119

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-9-91	JK
	G) Safety Off Force	4	4	4			8-9-91	JK
	H) Trigger Pull Test & Retainability						8-9-91	JK
	I) Firing Pin Indent	.0215	.022	.022			8-9-91	JK
	J) Assemble Stock						8-12-91	JK
	K) Assemble Swivel Studs						8-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-12-91	JK
	M) Iron Sight Alignment						8-12-91	JK
	N) Detach Front & Rear Sights & place in numbered container						8-12-91	JK
	O) Attach Scope to Rifle						8-12-91	JK
	P) Detach & Attach Scope 20 Times						8-12-91	JK
640	Gallery Target & Test						8-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-13-91	NF
655	Final Inspection							
	A) Headspace						8-14-91	D/H
	B) Trigger Pull	2.61	2.69	2.39	2.67	2.66	8-14-91	JK
	C) Function						8-14-91	D/H
660	Pack						9-19-91	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649119
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.101237
1 TO	2	.272738
1 TO	3	.279501
1 TO	4	.189652
1 TO	5	.153447

4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0374
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110332
THE AMR FOR THIS RIFLE IS: .8268

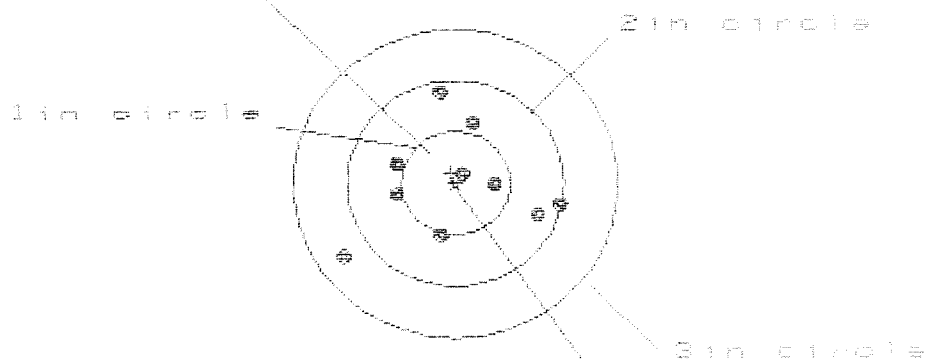
23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849119

CENTERFIRE PATTERNS

1

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 2.030

VS = 1.622

GS = 2.166

CENTROID #

PATTERN #

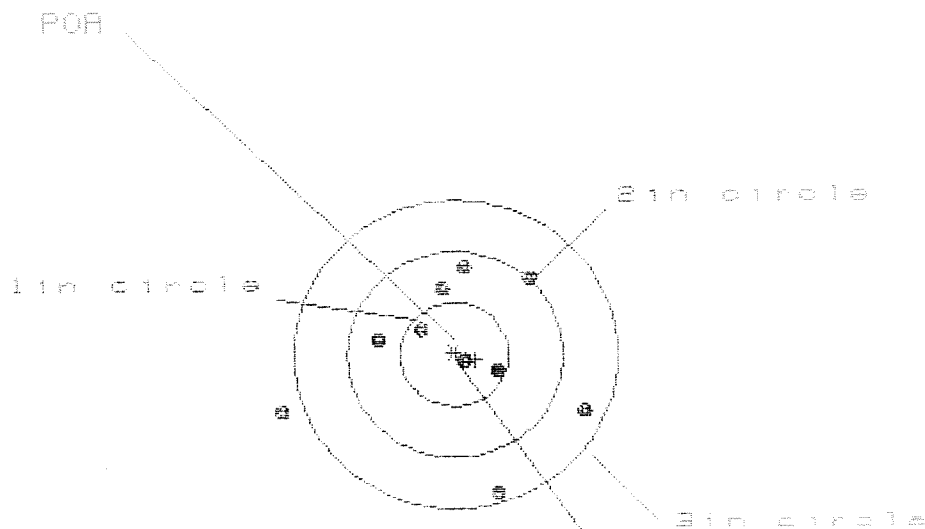
	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.996	.884	.743
MINIMUM X	-1.032	-.622	-.512
MAXIMUM Y	.983	.823	.793
MINIMUM Y	-.719	-.636	-.666
CENTROID X	.040	.154	.044
CENTROID Y	-.093	-.013	.017
POA TO CENTROID in.	.101	.135	.047
MIN RADIUS	.056	.089	.071
MEAN RADIUS	.671	.598	.551
MAX RADIUS	1.250	.915	.847
HORIZONTAL SPREAD	2.030	1.586	1.255
VERTICAL SPREAD	1.622	1.459	1.459
EXTREME SPREAD	2.166	1.588	1.818
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

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CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1in = 5

2in = 6

3in = 9

IS = 2.787

VS = 2.234

GS = 2.787

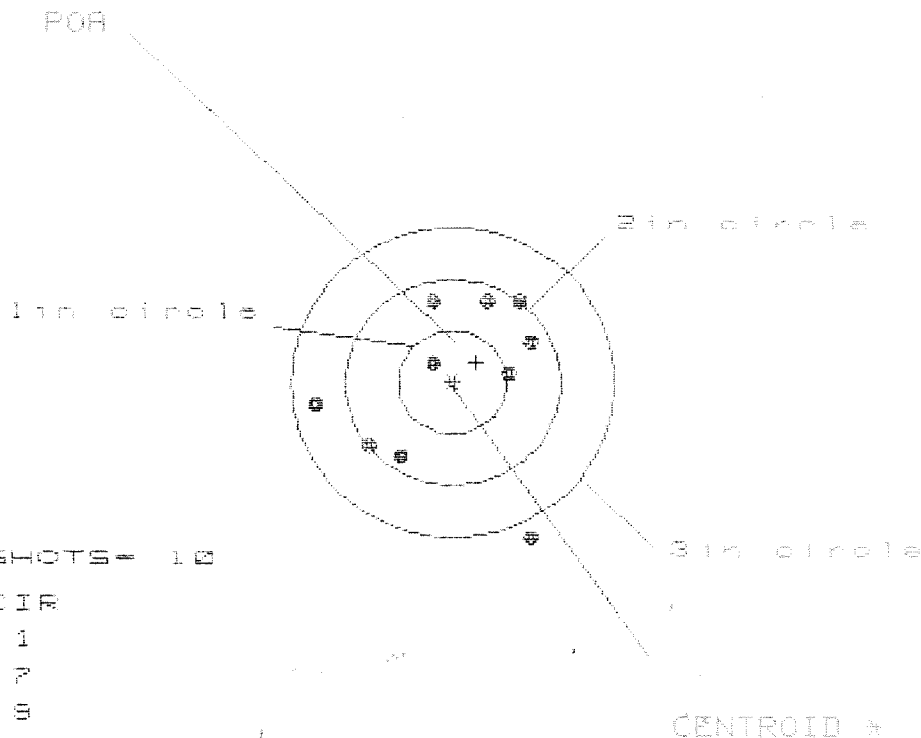
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.178	.999	1.024
MINIMUM X	-1.689	-.859	-.834
MAXIMUM Y	.888	.832	.656
MINIMUM Y	-1.346	-1.402	-1.776
CENTROID X	-.191	-.012	-.037
CENTROID Y	.052	.108	.284
POR TO CENTROID in.	.198	.109	.286
MIN RADIUS	.062	.161	.289
MEAN RADIUS	.046	.749	.651
MAX RADIUS	1.607	1.417	1.285
HORIZONTAL SPREAD	2.787	1.858	1.958
VERTICAL SPREAD	2.234	2.234	1.432
EXTREME SPREAD	2.787	2.256	1.984
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



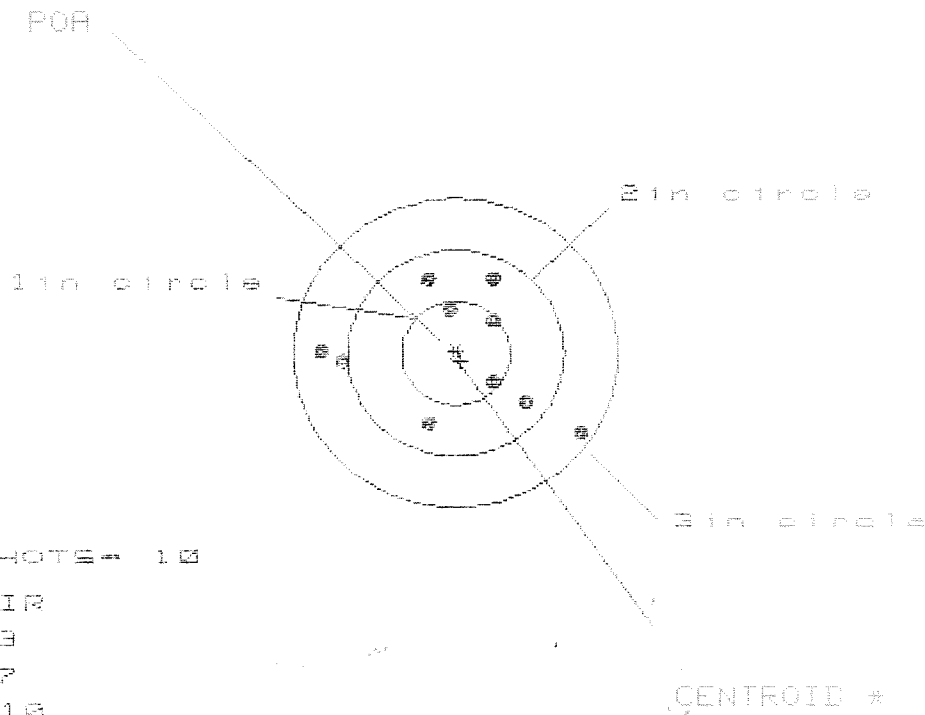
OF SHOTS = 10
 # IN CIR
 1 in = 1
 2 in = 7
 3 in = 9
 HG = 1.883
 VS = 2.345
 GS = 2.500

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.732	.889	.662
MINIMUM X	-1.251	-1.174	-.815
MAXIMUM Y	.821	.652	.606
MINIMUM Y	-1.524	-.883	-.929
CENTROID X	-.221	-.298	-.151
CENTROID Y	-.193	-.024	.022
POA TO CENTROID in.	.294	.299	.152
MIN RADIUS	.283	.136	.283
MEAN RADIUS	.917	.801	.728
MAX RADIUS	1.671	1.232	1.192
HORIZONTAL SPREAD	1.983	1.983	1.477
VERTICAL SPREAD	2.345	1.535	1.535
EXTREME SPREAD	2.500	2.123	2.000
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.436

VS= 1.572

GS= 2.583

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.154	.823	.679
MINIMUM X	:	-1.282	-1.154	-1.069
MAXIMUM Y	:	.768	.679	.675
MINIMUM Y	:	-.804	-.729	-.735
CENTROID X	:	-.048	-.176	-.032
CENTROID Y	:	.075	.164	.168
POA TO CENTROID in.	:	.089	.241	.171
MIN RADIUS	:	.400	.342	.346
MEAN RADIUS	:	.818	.749	.672
MAX RADIUS	:	1.406	1.154	1.089
HORIZONTAL SPREAD	:	2.436	1.977	1.748
VERTICAL SPREAD	:	1.572	1.408	1.408
EXTREME SPREAD	:	2.583	2.045	1.784
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.198

VS= 1.997

GS= 2.515

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

1.142

.965

.966

-1.056

-.929

-.928

.718

.794

.644

-1.279

-1.203

-1.122

-.099

-.226

-.227

-.028

-.104

.046

.102

.249

.231

.137

.095

.218

.882

.831

.777

1.334

1.222

1.249

2.198

1.894

1.894

1.997

1.997

1.786

2.515

2.205

1.981

1

6

10

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649119
DATE 8-9-91
TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.65	2.61	2.38	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.68	2.44	2.40	2.69	
PULL #3	2.56	2.43	2.49	2.39	
PULL #4	2.68	2.40	2.44	2.67	
PULL #5	2.69	2.44	2.40	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.43		
PULL #2	3.55	3.39		
PULL #3	3.53	3.38		
PULL #4	3.47	3.37		
PULL #5	3.39	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.44		4.38
PULL #2	4.60	4.52		4.35
PULL #3	4.38	4.43		4.56
PULL #4	4.53	4.48		4.36
PULL #5	4.53	4.49		4.54
TOTAL				
AVG.				