

C6649122

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington[®]

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

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

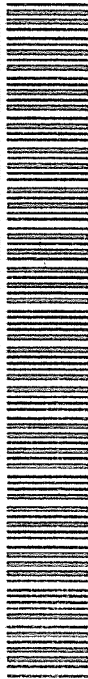
MODEL 700[™] H24

SERIAL NO.
C6649122

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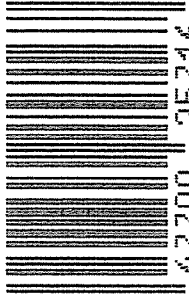
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649122

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649122**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	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		8-10-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7	8	10-91	DH	
	G) Safety Off Force	3	3	3 3/4		8-10-91	DH	
	H) Trigger Pull Test & Retainability					8-10-91	DH	
	I) Firing Pin Indent	.022	.022	.021		8-10-91	DH	
	J) Assemble Stock					8/12/91	KL	
	K) Assemble Swivel Studs					8-14-91	DH	
	L) Attach Front and Rear Sight Assemblies					8/12/91	KL	
	M) Iron Sight Alignment					8/12/91	KL	
	N) Detach Front & Rear Sights & place in numbered container					8/12/91	KL	
	O) Attach Scope to Rifle					8/12/91	KL	
	P) Detach & Attach Scope 20 Times					8/12/91	KL	
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					8-14-91	DH	
	A) Headspace							
	B) Trigger Pull	2.48	2.55	2.44	2.39	2.43	8-14-91	KL
	C) Function					8-14-91	DH	
660	Pack					9-18-91	NF	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649122
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.182937
1 TO 2	.186698
1 TO 3	.257049
1 TO 4	.17623
1 TO 5	.209172

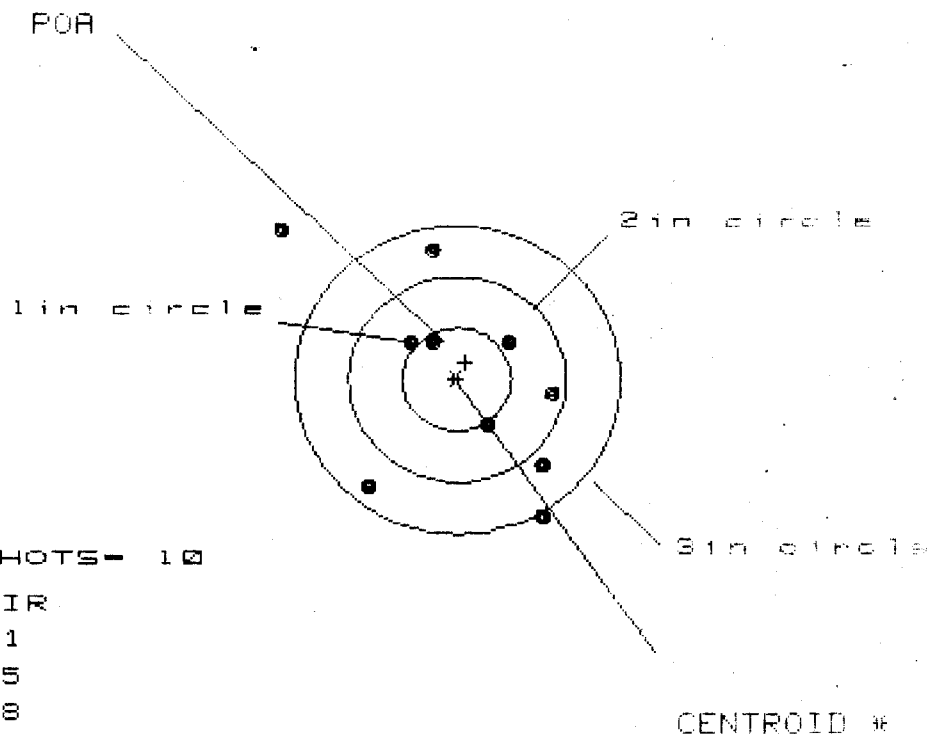
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0994
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0994016
THE AMR FOR THIS RIFLE IS: .802

02 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649122

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.480

VS= 2.779

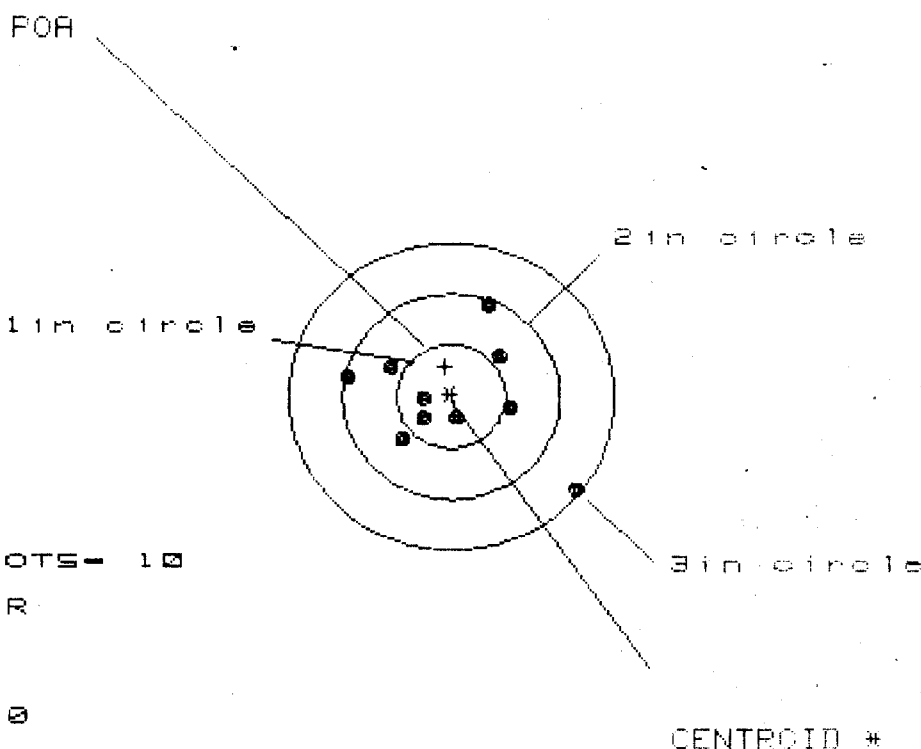
GS= 3.675

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.896	.720	.800
MINIMUM X	:	-1.584	-1.004	-.923
MAXIMUM Y	:	1.425	1.439	1.289
MINIMUM Y	:	-1.354	-1.195	-1.040
CENTROID X	:	-.079	.097	.016
CENTROID Y	:	-.165	-.324	-.174
POA TO CENTROID in.	:	.183	.338	.175
MIN RADIUS	:	.404	.312	.461
MEAN RADIUS	:	1.046	.904	.835
MAX RADIUS	:	2.131	1.505	1.391
HORIZONTAL SPREAD	:	2.480	1.724	1.724
VERTICAL SPREAD	:	2.779	2.634	2.329
EXTREME SPREAD	:	3.675	2.849	2.396
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 2.068

VS = 1.818

GS = 2.339

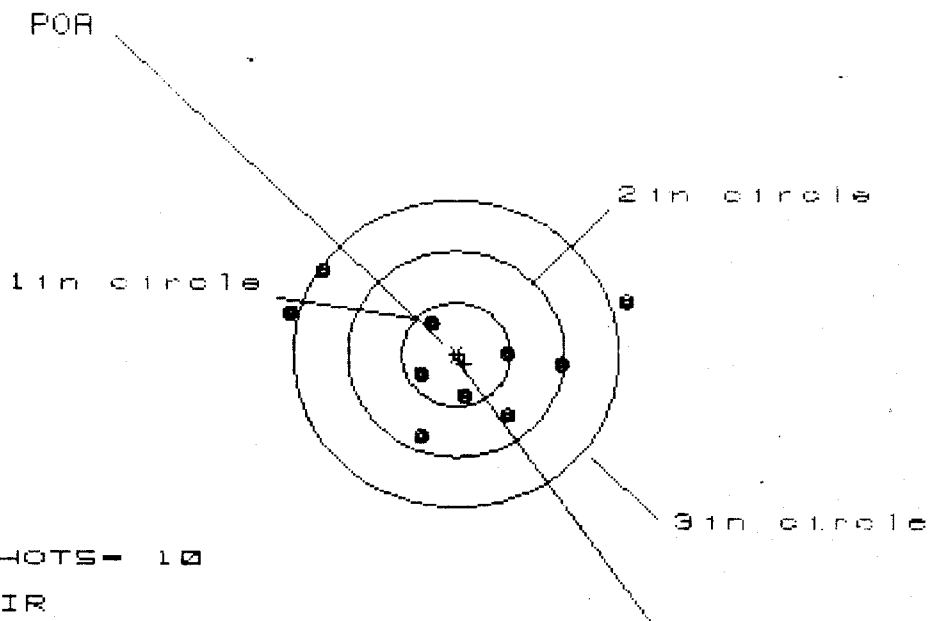
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	.629	.685
MINIMUM X	:	-.928	-.801	-.745
MAXIMUM Y	:	.935	.837	.976
MINIMUM Y	:	-.883	-.459	-.354
CENTROID X	:	.055	-.072	-.128
CENTROID Y	:	-.295	-.197	-.302
FOR TO CENTROID in.	:	.300	.210	.328
MIN RADIUS	:	.169	.176	.058
MEAN RADIUS	:	.641	.547	.459
MAX RADIUS	:	1.442	.952	.776
HORIZONTAL SPREAD	:	2.068	1.430	1.430
VERTICAL SPREAD	:	1.818	1.296	.730
EXTREME SPREAD	:	2.339	1.516	1.475
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	9		
NUMBER IN THREE INCH CIRCLE =	:	10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.049

VS= 1.566

GS= 3.050

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	1.163	.995
MINIMUM X	:	-1.514	-1.343	-1.177
MAXIMUM Y	:	.778	.838	.902
MINIMUM Y	:	-.788	-.728	-.664
CENTROID X	:	-.074	-.245	-.077
CENTROID Y	:	.092	.032	-.032
POA TO CENTROID in.	:	.119	.247	.084
MIN RADIUS	:	.330	.216	.307
MEAN RADIUS	:	.882	.789	.678
MAX RADIUS	:	1.629	1.438	1.483
HORIZONTAL SPREAD	:	3.049	2.506	2.172
VERTICAL SPREAD	:	1.566	1.566	1.566
EXTREME SPREAD	:	3.050	2.561	2.334
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= .998

VS= 2.321

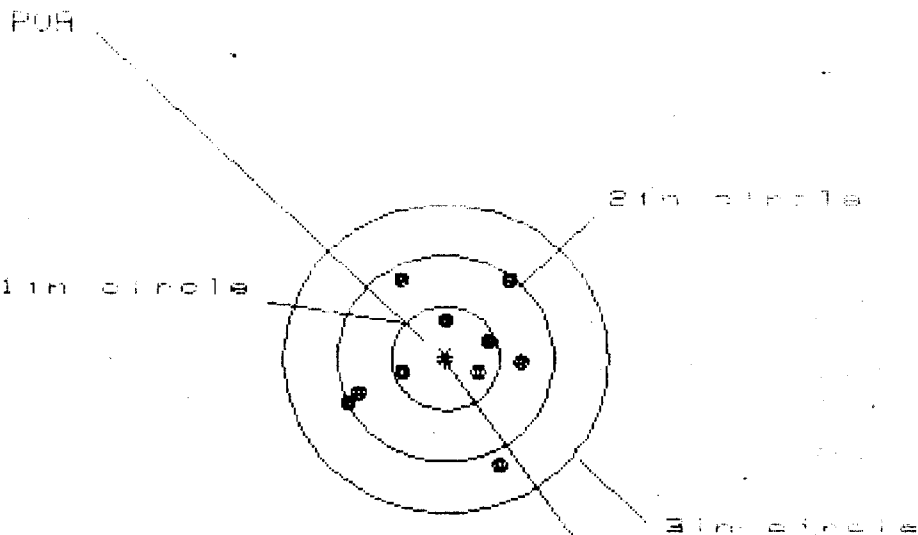
GS= 2.380

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.468	.409	.401
MINIMUM X	:	-.530	-.544	-.552
MAXIMUM Y	:	1.116	1.046	.911
MINIMUM Y	:	-1.205	-1.081	-.625
CENTROID X	:	.097	.156	.164
CENTROID Y	:	-.156	-.280	-.145
POA TO CENTROID in.	:	.184	.320	.219
MIN RADIUS	:	.308	.303	.240
MEAN RADIUS	:	.725	.642	.590
MAX RADIUS	:	1.235	1.142	1.023
HORIZONTAL SPREAD	:	.998	.953	.953
VERTICAL SPREAD	:	2.321	2.127	1.536
EXTREME SPREAD	:	2.380	2.163	1.646
3IN IN ONE INCH CIRCLE	=	3		
2IN IN TWO INCH CIRCLE	=	7		
3IN IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

ME = 1.617

MS = 1.848

GS = 2.017

CENTROID #

PATTERN #	:	5		
LOADS (BEST OF)	:	10	9	8
MAXIMUM X	:	.713	.766	.849
MINIMUM X	:	-.904	-.851	-.768
MAXIMUM Y	:	.790	.673	.711
MINIMUM Y	:	-1.055	-.592	-.419
CENTROID X	:	.064	-.040	-.132
CENTROID Y	:	.027	.145	.061
FOR TO CENTROID in.	:	.028	.153	.146
1IN RADIUS	:	.241	.247	.274
2IN RADIUS	:	.716	.658	.621
3IN RADIUS	:	1.158	.989	.874
CENTRAL SPREAD	:	1.617	1.617	1.617
SPREAD	:	1.848	1.176	1.130
SPREAD	:	2.017	1.922	1.654
ONE INCH CIRCLE	=		4	
TWO INCH CIRCLE	=		8	
THREE INCH CIRCLE	=		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-6649122
DATE 8-10-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.35	2.34	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.34	2.30	2.55	
PULL #3	2.35	2.35	2.38	2.44	
PULL #4	2.34	2.33	2.44	2.39	
PULL #5	2.35	2.36	2.40	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.18		
PULL #2	3.32	3.24		
PULL #3	3.29	3.24		
PULL #4	3.15	3.30		
PULL #5	3.25	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.43		4.45
PULL #2	4.39	4.37		4.39
PULL #3	4.40	4.39		4.35
PULL #4	4.36	4.39		4.43
PULL #5	4.38	4.35		4.43
TOTAL				
AVG.				