

C6649139

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

Remington®

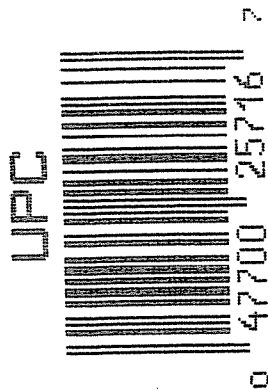
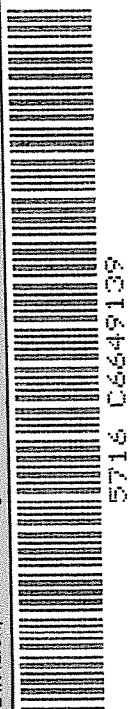
MODEL 700™ M24

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

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

SERIAL NO.
C6649139

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649139**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	Kel
600	Proof		6/24/91	Kel
607	Check Headspace		6/24/91	Kel
610	Dis-assemble Gun		6/24/91	Kel
612	Magnaflux Barrel Action	.1111	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS.
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/91	HA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/91	Kel
	C) Inspect Ejector Hole for Chamfer		8/1/91	Kel
	D) Oil Firing Pin Ass'y		8/1/91	Kel
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-6-91	DH
	G) Safety Off Force	3	3	3			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-5-91	DH
	I) Firing Pin Indent	.021	.021	.022			8-6-91	DH
	J) Assemble Stock						8/9/91	KH
	K) Assemble Swivel Studs						8-14-91	DH
	L) Attach Front and Rear Sight Assemblies						8/9/91	KH
	M) Iron Sight Alignment						8/9/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	KH
	O) Attach Scope to Rifle						8/9/91	KH
	P) Detach & Attach Scope 20 Times						8/9/91	KH
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	DH
	B) Trigger Pull	2.62	2.60	2.57	2.60	2.31	8-14-91	KH
	C) Function						8-14-91	DH
660	Pack						9-18-91	NF

T14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649139
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.119017
1 TO 2	.211929
1 TO 3	.27862
1 TO 4	.212236
1 TO 5	.210412

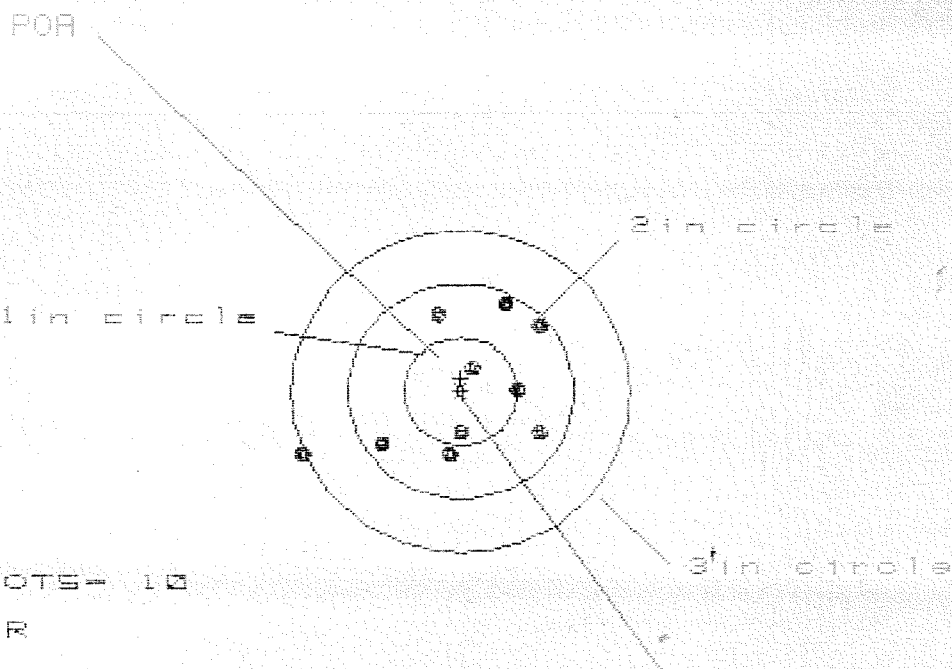
$\bar{x}_3$ <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0372
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0606
AVERAGE POI RADIUS FOR THIS RIFLE IS: .071107
OF THIS RIFLE IS: .9136

10-45 (91)

FILE:/PATTERNING/CENTERFIRE_PATT/C6649139

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 9

3 in = 9

HS= 2.075

VS= 1.413

GS= 2.404

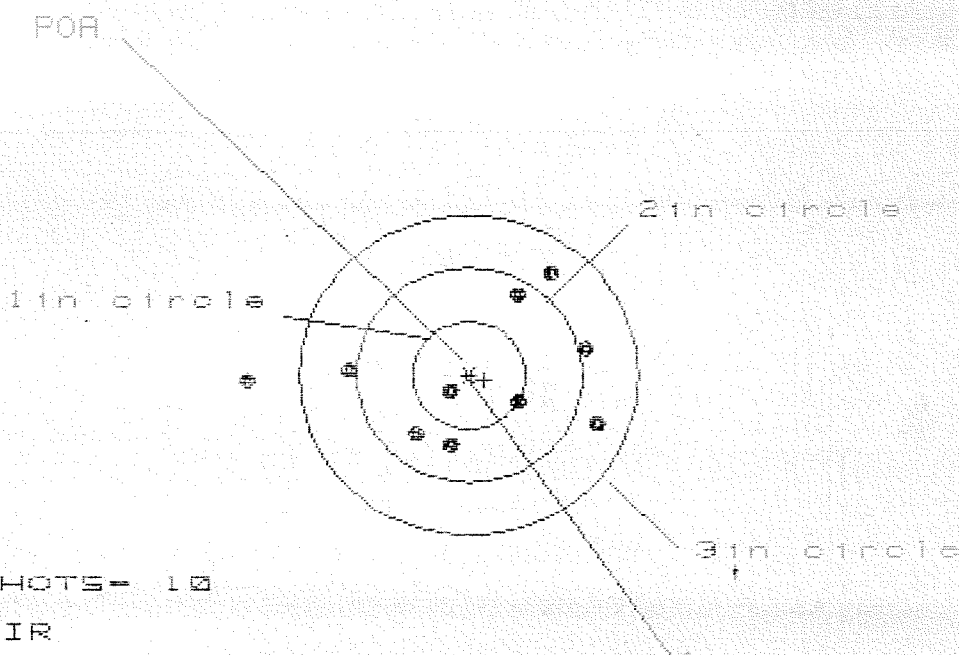
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.692	.538	.575
MINIMUM X	:	-1.383	-.836	-.789
MAXIMUM Y	:	.794	.725	.790
MINIMUM Y	:	-.619	-.634	-.569
CENTROID X	:	.002	.156	.088
CENTROID Y	:	-.119	-.050	-.115
POR TO CENTROID in.	:	.119	.164	.145
MIN RADIUS	:	.208	.123	.178
MEAN RADIUS	:	.731	.616	.598
MAX RADIUS	:	1.515	.986	.894
HORIZONTAL SPREAD	:	2.075	1.374	1.343
VERTICAL SPREAD	:	1.413	1.359	1.359
EXTREME SPREAD	:	2.404	1.728	1.641
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	9		

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649139

CENTERFIRE PATTERNS # 2



* OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.004

VS= 1.588

GS= 3.026

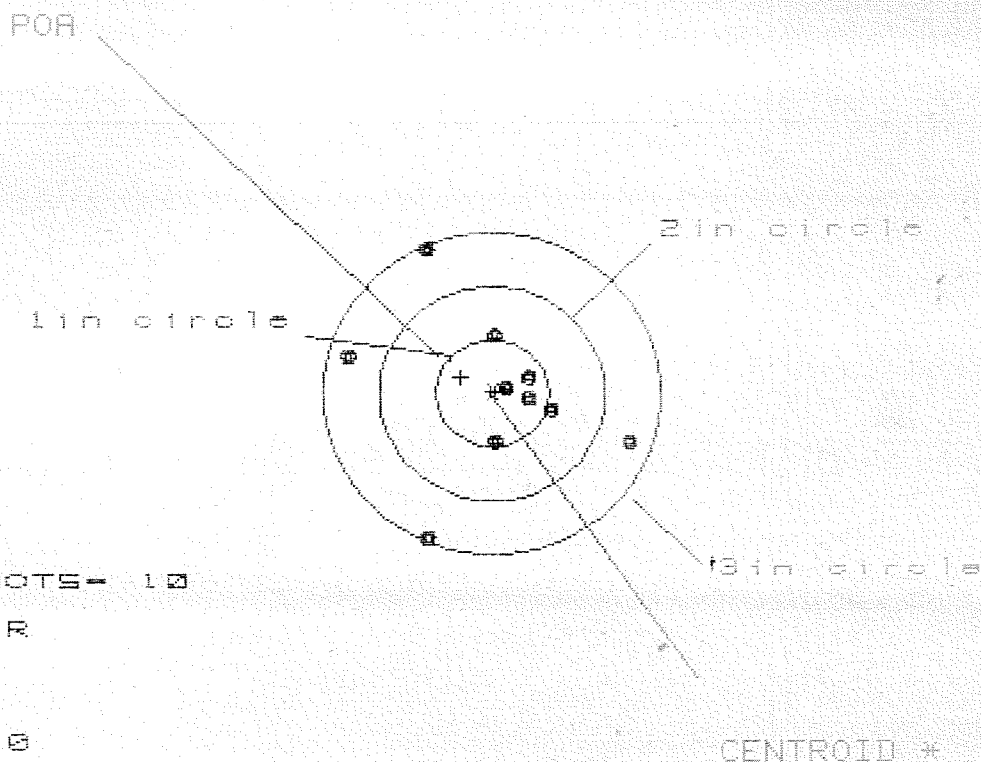
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.085	.872	.939
MINIMUM X	-1.919	-1.239	-1.172
MAXIMUM Y	.919	.913	.905
MINIMUM Y	-.669	-.675	-.561
CENTROID X	-.131	.082	.015
CENTROID Y	.046	.052	-.062
POA TO CENTROID in.	.139	.097	.063
MIN RADIUS	.226	.384	.329
MEAN RADIUS	.955	.834	.786
MAX RADIUS	1.919	1.241	1.188
HORIZONTAL SPREAD	3.004	2.111	2.111
VERTICAL SPREAD	1.588	1.588	1.466
EXTREME SPREAD	3.026	2.170	2.170
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1in = 5
 2in = 6
 3in = 10
 HS= 2.465
 VS= 2.682
 GS= 2.682

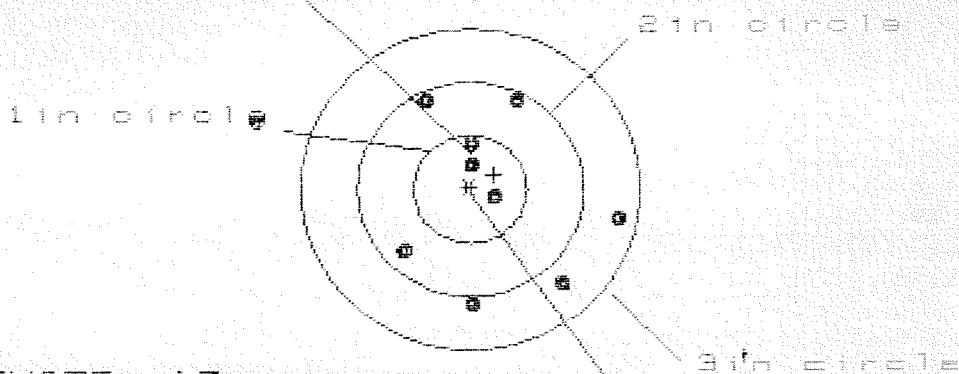
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.207	1.138	1.058
MINIMUM X	:	-1.258	-1.327	-1.407
MAXIMUM Y	:	1.331	.746	.596
MINIMUM Y	:	-1.351	-1.203	-.495
CENTROID X	:	.279	.348	.428
CENTROID Y	:	-.149	-.297	-.147
POA TO CENTROID in.	:	.316	.457	.452
MIN RADIUS	:	.091	.167	.062
MEAN RADIUS	:	.784	.696	.562
MAX RADIUS	:	1.469	1.408	1.443
HORIZONTAL SPREAD	:	2.465	2.465	2.465
VERTICAL SPREAD	:	2.682	1.949	1.091
EXTREME SPREAD	:	2.682	2.577	2.577
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 3.216

VS= 1.935

GS= 3.336

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.321	1.111	.739
MINIMUM X	:	-1.895	-.750	-.612
MAXIMUM Y	:	.833	.899	.870
MINIMUM Y	:	-1.102	-1.036	-1.065
CENTROID X	:	-.210	.000	-.138
CENTROID Y	:	-.129	-.195	-.166
POA TO CENTROID in.	:	.247	.195	.216
MIN RADIUS	:	.216	.033	.135
MEAN RADIUS	:	.916	.781	.726
MAX RADIUS	:	1.985	1.134	1.149
HORIZONTAL SPREAD	:	3.216	1.861	1.351
VERTICAL SPREAD	:	1.935	1.935	1.935
EXTREME SPREAD	:	3.336	2.107	2.107
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

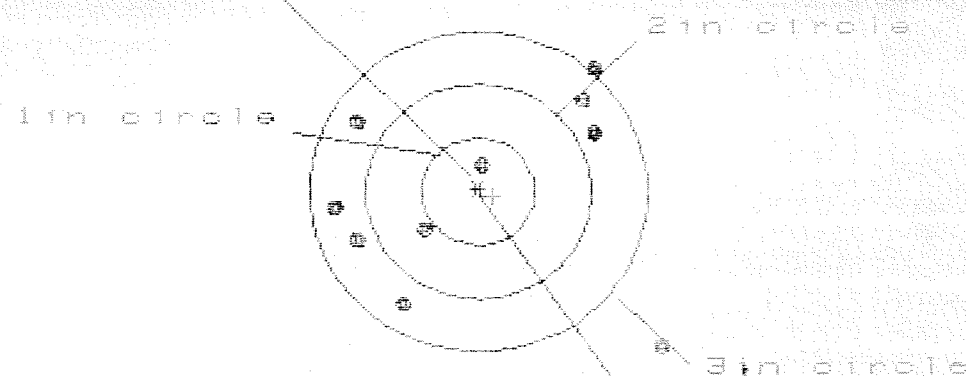
23 AUG 1991

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CENTERFIRE PATTERNS

5

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 9

HS= 2.880

VS= 2.549

GS= 3.373

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.602

1.180

1.325

MINIMUM X

-1.278

-1.100

-.955

MAXIMUM Y

1.104

.944

.813

MINIMUM Y

-1.445

-1.233

-1.115

CENTROID X

-.126

-.304

-.449

CENTROID Y

.048

.208

.091

FOR TO CENTROID in.

.135

.369

.458

MIN RADIUS

.253

.196

.379

MEAN RADIUS

1.182

1.040

.955

MAX RADIUS

2.157

1.495

1.528

HORIZONTAL SPREAD

2.880

2.280

2.280

VERTICAL SPREAD

2.549

2.177

1.928

EXTREME SPREAD

3.373

2.713

2.511

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

2

NUMBER IN THREE INCH CIRCLE =

9

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C-6649139

DATE 8-5-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.23	2.42	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.22	2.12	2.60	
PULL #3	2.38	2.20	2.14	2.57	
PULL #4	2.36	2.29	2.35	2.60	
PULL #5	2.43	2.23	2.47	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.04		
PULL #2	3.09	3.01		
PULL #3	3.09	3.04		
PULL #4	3.02	2.89		
PULL #5	3.05	3.05		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.06		4.32
PULL #2	3.93	4.01		4.10
PULL #3	3.93	4.02		4.10
PULL #4	4.03	4.02		4.10
PULL #5	4.11	4.03		3.90
TOTAL				
AVG.				