

C6649155

MODEL 780TM M24

Model S&S TM

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 700™ M24

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

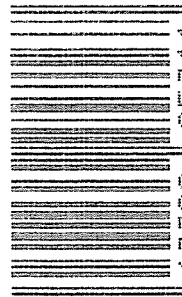
SERIAL NO.
C6649155

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C6649155

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649155

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-12-91	DL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-12-91	JH
	G) Safety Off Force	3	3	3			8-12-91	JH
	H) Trigger Pull Test & Retainability						8-12-91	JH
	I) Firing Pin Indent	1020	10215	10215			8-12-91	JH
	J) Assemble Stock						8/14/91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/14/91	RW
	M) Iron Sight Alignment						8/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/91	RW
	O) Attach Scope to Rifle						8/14/91	RW
	P) Detach & Attach Scope 20 Times						8/14/91	RW
640	Gallery Target & Test						8-15-91	AC
	A) Time						8-15-91	AC
	B) Malfunctions						8-15-91	AC
	C) Pierced Primers						8-15-91	AC
	D) Optical Clarity of Scope						8-15-91	AC
645	Inspect for Live Ammo						8-15-91	AC
655	Final Inspection						8-17-91	D/H
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	2.44	2.60	2.56	2.53	2.64	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						9-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649155
DATE 8-12-91
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.32	2.33	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.31	2.44	2.60	
PULL #3	2.35	2.25	2.30	2.56	
PULL #4	2.15	2.23	2.33	2.53	
PULL #5	2.38	2.28	2.20	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.47		
PULL #2	3.20	3.41		
PULL #3	3.31	3.26		
PULL #4	3.42	3.28		
PULL #5	3.37	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.35		4.32
PULL #2	4.32	4.36		4.42
PULL #3	4.32	4.39		4.47
PULL #4	4.35	4.33		4.40
PULL #5	4.38	4.20		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649155
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.214441
1 TO 2	.0765506
1 TO 3	.0864928
1 TO 4	.0863713
1 TO 5	.0300167

4 <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0446
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1552
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .161481
AMP FOR THIS RIFLE IS: .8288

23 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B49155

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

* OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.620

VS= 1.700

GS= 2.122

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.817	.889	.827
MINIMUM X	-.803	-.712	-.774
MAXIMUM Y	.860	.779	.593
MINIMUM Y	-.848	-.929	-.832
CENTROID X	-.948	-.139	-.077
CENTROID Y	.209	.290	.193
POA TO CENTROID in.	.214	.322	.208
MIN RADIUS	.218	.178	.187
MEAN RADIUS	.693	.627	.597
MAX RADIUS	1.899	.990	.984
HORIZONTAL SPREAD	1.620	1.601	1.601
VERTICAL SPREAD	1.700	1.708	1.365
EXTREME SPREAD	2.122	1.902	1.902
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

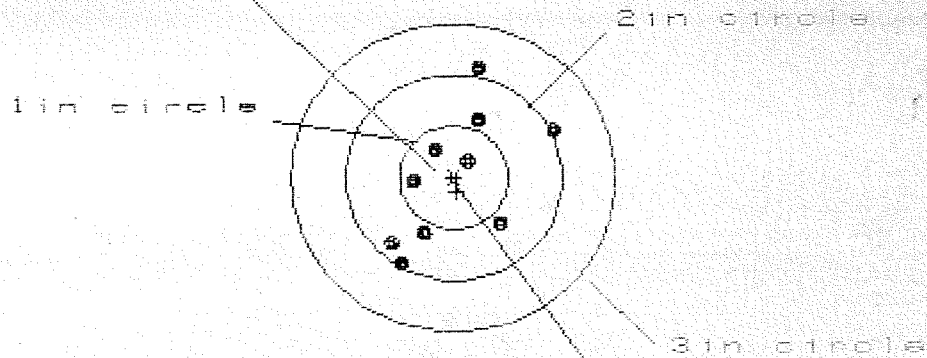
23 Aug 1991

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CENTERFIRE PATTERNS

2

POR



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.477

VS= 1.851

GS= 1.980

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X : .875

.905

.589

MINIMUM X : -.602

-.572

-.459

MAXIMUM Y : 1.029

.637

.712

MINIMUM Y : -.822

-.708

-.633

CENTROID X : -.022

-.052

-.166

CENTROID Y : .137

.023

-.052

POR TO CENTROID in. : .139

.057

.173

MIN RADIUS : .152

.266

.289

MEAN RADIUS : .645

.601

.531

MAX RADIUS : 1.064

1.085

.736

HORIZONTAL SPREAD : 1.477

1.477

1.047

VERTICAL SPREAD : 1.851

1.345

1.345

EXTREME SPREAD : 1.980

1.849

1.482

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

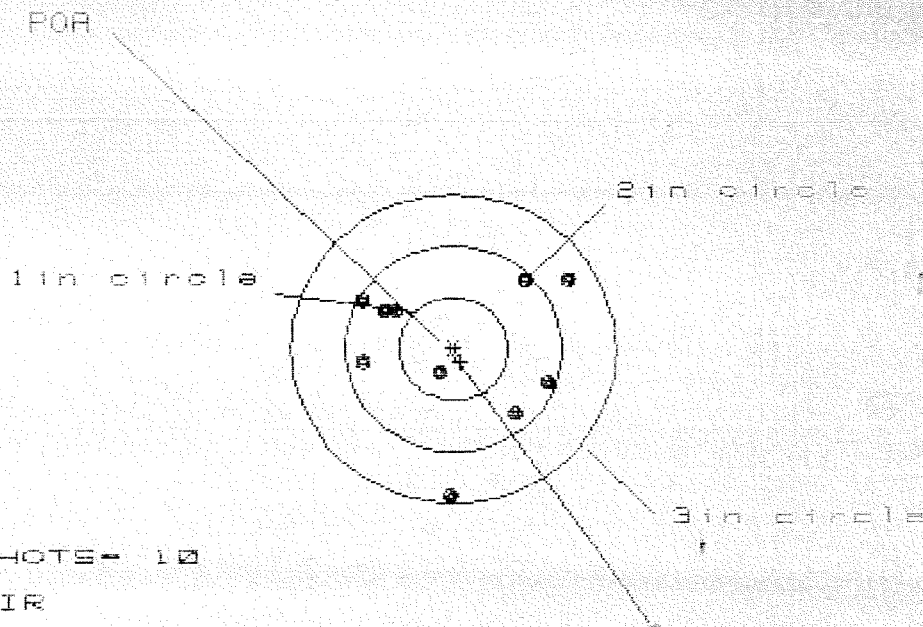
NUMBER IN THREE INCH CIRCLE =

10

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.967

VS= 2.136

GS= 2.399

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.091	1.087	.970
MINIMUM X	-.876	-.880	-.745
MAXIMUM Y	.710	.560	.628
MINIMUM Y	-1.418	-.759	-.691
CENTROID X	-.064	-.060	-.195
CENTROID Y	.124	.282	.214
POA TO CENTROID in.	.139	.288	.290
MIN RADIUS	.309	.447	.341
MEAN RADIUS	.981	.840	.761
MAX RADIUS	1.419	1.214	1.051
HORIZONTAL SPREAD	1.967	1.967	1.715
VERTICAL SPREAD	2.136	1.319	1.319
EXTREME SPREAD	2.399	2.119	1.899
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649155

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 1.491

VS= 3.009

GS= 3.049

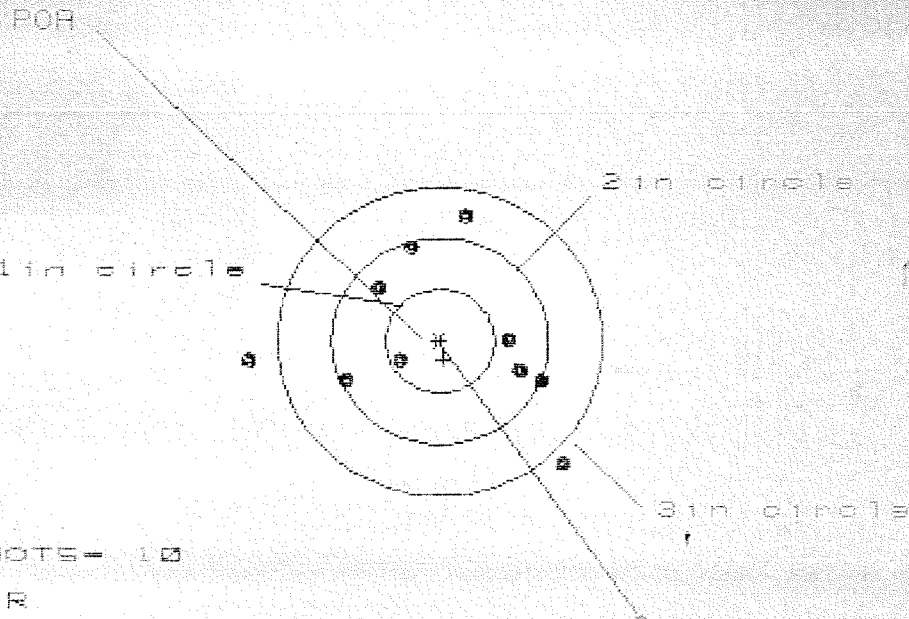
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.795
MINIMUM X	-.696
MAXIMUM Y	1.327
MINIMUM Y	-1.683
CENTROID X	-.056
CENTROID Y	.123
POR TO CENTROID in.	.135
MIN RADIUS	.267
MEAN RADIUS	.897
MAX RADIUS	1.695
HORIZONTAL SPREAD	1.491
VERTICAL SPREAD	3.009
EXTREME SPREAD	3.049
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

28 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CS64B155

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.932

VS= 2.415

GS= 3.120

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	.940	.825
MINIMUM X	:	-1.793	-1.019	-.902
MAXIMUM Y	:	1.200	1.184	1.030
MINIMUM Y	:	-1.215	-1.231	-1.001
CENTROID X	:	-.033	.166	.049
CENTROID Y	:	.183	.199	.353
POA TO CENTROID in.	:	.186	.259	.356
MIN RADIUS	:	.372	.457	.527
MEAN RADIUS	:	1.008	.907	.816
MAX RADIUS	:	1.799	1.549	1.084
HORIZONTAL SPREAD	:	2.932	1.959	1.727
VERTICAL SPREAD	:	2.415	2.415	1.631
EXTREME SPREAD	:	3.120	2.566	1.952
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	