

C6611450

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

**Remington**  
 MODEL 700™ M24

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

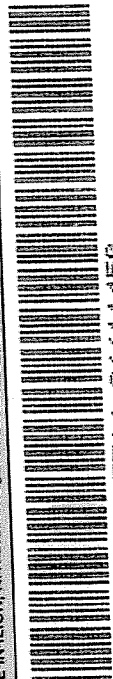
**DUPONT**  
 REG. U.S. PAT. & TM. OFF.

SERIAL NO.  
 C6611450

ORDER NO.  
**5716**

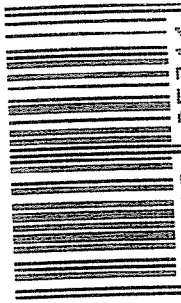
46

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



5716 C6611450

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611450

| OP. #        | OP. NAME                                                       | READINGS                                                                                                  | DATE    | INIT |
|--------------|----------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | <div style="border: 1px solid black; padding: 10px; text-align: center;"> <b>QUALITY<br/>AUDIT</b> </div> | 3/13/91 | K.S. |
| 600          | Proof                                                          |                                                                                                           | 3/13/91 | K.S. |
| 607          | Check Headspace                                                |                                                                                                           | 3/13/91 | K.S. |
| 610          | Dis-assemble Gun                                               |                                                                                                           | 3/13/91 | K.S. |
| 612          | Magnaflux Barrel<br>Action                                     |                                                                                                           | 3/27/91 | KR   |
|              | Magnaflux Bolt                                                 |                                                                                                           | 3/27/91 | KR   |
| 615          | Rollmark Caliber                                               |                                                                                                           | 3/27/91 | GL   |
| 617          | Drill and Tap Sight Holes                                      | APR                                                                                                       | 3 1991  | FB   |
| 618          | Polish Barrel                                                  | APR                                                                                                       | 3 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |                                                                                                           | 4/18/91 | TA   |
|              | Apply Coating (Bolt)                                           |                                                                                                           |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |                                                                                                           | 4/18/91 | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |                                                                                                           | 4/18/91 | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |                                                                                                           | 4/18/91 | KS   |
|              | D) Oil Firing Pin Ass'y                                        |                                                                                                           | 4/18/91 | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |                                                                                                           | 4/19/91 | JK   |

| op. #        | OP. NAME                                                    | READINGS |      |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5     |      |      | 4-22-91 | DH   |
|              | G) Safety Off Force                                         | 2        | 2    | 2 1/4 |      |      | 4-22-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |      |      | 4/19/91 | 98   |
|              | I) Firing Pin Indent                                        | .022     | .021 | .022  |      |      | 4-22-91 | DH   |
|              | J) Assemble Stock                                           |          |      |       |      |      | 4/24/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |       |      |      | 5-1-91  | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |      |      | 4/24/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |       |      |      | 4/24/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |      |      | 4/24/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |       |      |      | 4/24/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |      |      | 4/24/91 | KS   |
| 640          | Gallery Target & Test                                       |          |      |       |      |      | 4-25-91 | DH   |
|              | A) Time                                                     |          |      |       |      |      | 4-25-91 | DH   |
|              | B) Malfunctions                                             |          |      |       |      |      | 4-25-91 | DH   |
|              | C) Pierced Primers                                          |          |      |       |      |      | 4-25-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |       |      |      | 4-25-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |       |      |      | 4-25-91 | DH   |
| 655          | Final Inspection                                            |          |      |       |      |      |         |      |
|              | A) Headspace                                                |          |      |       |      |      | 5-1-91  | DH   |
|              | B) Trigger Pull                                             | 2.28     | 2.27 | 2.42  | 2.44 | 2.45 | 4/26/91 | 98   |
|              | C) Function                                                 |          |      |       |      |      | 5-1-91  | DH   |
| 660          | Pack                                                        |          |      |       |      |      | 6-17-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611450

DATE: 4/19/91

TESTER: [Signature]

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS          |
|---------|------------------|--------------------------|--------------------------------|------|-------------------|
| PULL #1 | 2.41             | 2.39                     | 2.36                           | 2.28 | MINIMUM SETTING,  |
| PULL #2 | 2.33             | 2.27                     | 2.28                           | 2.27 | NO AVG. OF 5      |
| PULL #3 | 2.42             | 2.42                     | 2.30                           | 2.42 | READINGS (ACCEPT- |
| PULL #4 | 2.51             | 2.42                     | 2.45                           | 2.44 | ABLE LESS THAN 2# |
| PULL #5 | 2.55             | 2.40                     | 2.45                           | 2.45 |                   |
| TOTAL   |                  |                          |                                |      |                   |
| AVG.    |                  |                          |                                |      |                   |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |  |
|---------|------------------|--------------------------|----------|--|
| PULL #1 | 3.53             | 3.39                     |          |  |
| PULL #2 | 3.32             | 3.48                     |          |  |
| PULL #3 | 3.44             | 3.12                     |          |  |
| PULL #4 | 3.34             | 3.52                     |          |  |
| PULL #5 | 3.48             | 3.36                     |          |  |
| TOTAL   |                  |                          |          |  |
| AVG.    |                  |                          |          |  |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.15             | 4.52                     |                                | 4.59                                 |
| PULL #2 | 4.51             | 4.40                     |                                | 4.59                                 |
| PULL #3 | 4.17             | 4.24                     |                                | 4.26                                 |
| PULL #4 | 4.17             | 4.33                     |                                | 4.59                                 |
| PULL #5 | 4.63             | 4.58                     |                                | 4.18                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611450  
25 Apr 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .366958 |
| 1 TO 2 | .371576 |
| 1 TO 3 | .541554 |
| 1 TO 4 | .302152 |
| 1 TO 5 | .3539   |

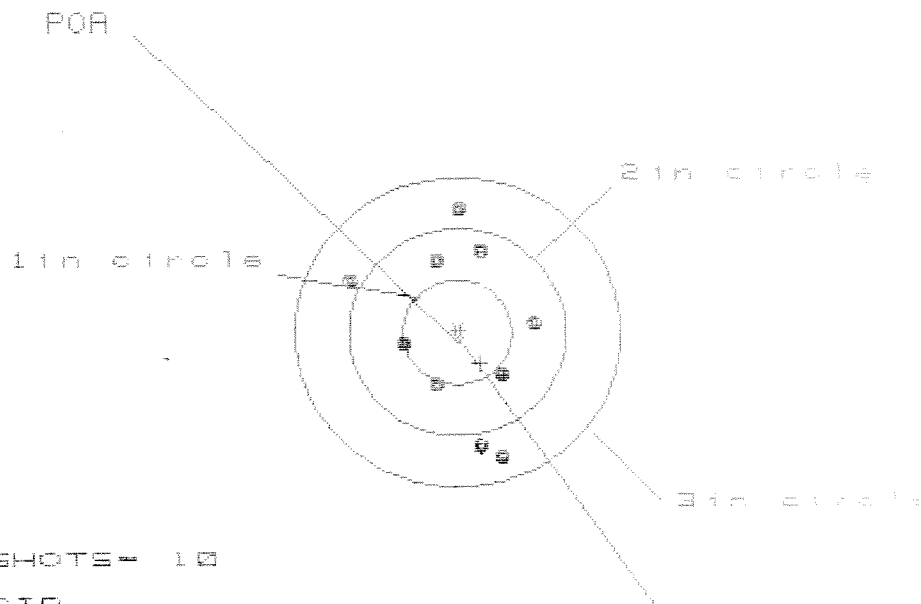
1.63  
\* (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .036  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1678  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .171618  
THE AMR FOR THIS RIFLE IS: .9462

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/08611150

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 0

2in = 6

3in = 10

HS= 1.737

VS= 2.472

GS= 2.506

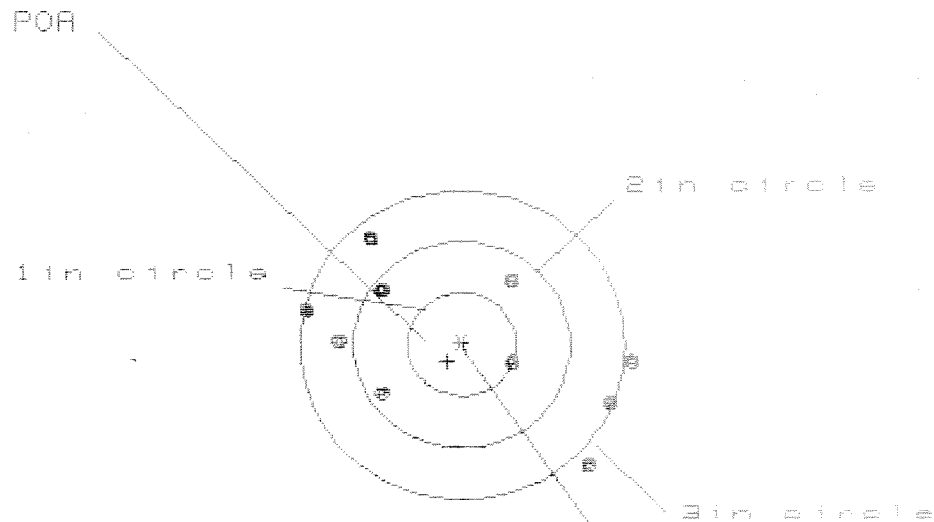
CENTROID +

| PATTERN #                   | 1      | 2      | 3      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | .704   | .745   | .746   |
| MINIMUM X                   | -1.033 | -.992  | -.991  |
| MAXIMUM Y                   | 1.224  | 1.086  | .797   |
| MINIMUM Y                   | -1.248 | -1.226 | -1.091 |
| CENTROID X                  | -.207  | -.248  | -.249  |
| CENTROID Y                  | .303   | .441   | .306   |
| POA TO CENTROID in.         | .366   | .506   | .394   |
| MIN RADIUS                  | .518   | .526   | .477   |
| MEAN RADIUS                 | .866   | .810   | .766   |
| MAX RADIUS                  | 1.303  | 1.245  | 1.123  |
| HORIZONTAL SPREAD           | 1.737  | 1.737  | 1.737  |
| VERTICAL SPREAD             | 2.472  | 2.312  | 1.868  |
| EXTREME SPREAD              | 2.506  | 2.322  | 2.019  |
| NUMBER IN ONE INCH CIRCLE   | = 0    |        |        |
| NUMBER IN TWO INCH CIRCLE   | = 6    |        |        |
| NUMBER IN THREE INCH CIRCLE | = 10   |        |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/08511450

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 0

HS= 2.971

VS= 2.151

GS= 3.012

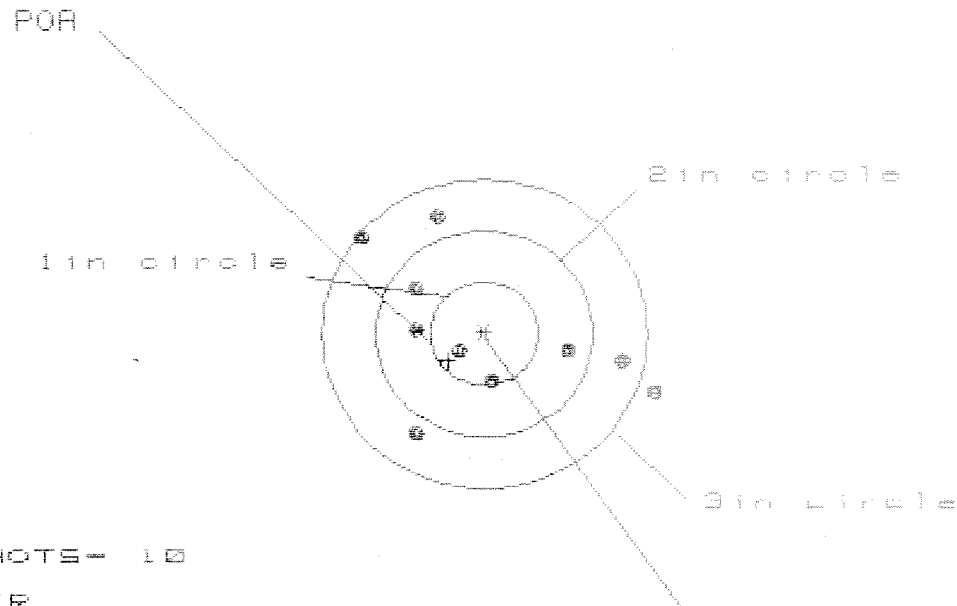
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.570  | 1.695  | 1.658  |
| MINIMUM X                     | -1.401 | -1.276 | -1.064 |
| MAXIMUM Y                     | 1.024  | .899   | .863   |
| MINIMUM Y                     | -1.127 | -.650  | -.686  |
| CENTROID X                    | .138   | .013   | -.199  |
| CENTROID Y                    | .165   | .290   | .326   |
| POA TO CENTROID in.           | .215   | .290   | .382   |
| MIN RADIUS                    | .453   | .617   | .534   |
| MEAN RADIUS                   | 1.149  | 1.081  | .965   |
| MAX RADIUS                    | 1.589  | 1.719  | 1.794  |
| HORIZONTAL SPREAD             | 2.971  | 2.971  | 2.722  |
| VERTICAL SPREAD               | 2.151  | 1.549  | 1.549  |
| EXTREME SPREAD                | 3.012  | 3.012  | 2.853  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |

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CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.715

VS = 2.055

GS = 3.108

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.572  | 1.472  | 1.351 |
| MINIMUM X                   | : | -1.143 | -.968  | -.568 |
| MAXIMUM Y                   | : | 1.105  | 1.044  | 1.155 |
| MINIMUM Y                   | : | -.950  | -1.011 | -.900 |
| CENTROID X                  | : | .333   | .158   | .279  |
| CENTROID Y                  | : | .262   | .323   | .212  |
| POB TO CENTROID in.         | : | .423   | .360   | .350  |
| MIN RADIUS                  | : | .287   | .206   | .218  |
| MEAN RADIUS                 | : | .974   | .867   | .807  |
| MAX RADIUS                  | : | 1.668  | 1.514  | 1.373 |
| HORIZONTAL SPREAD           | : | 2.715  | 2.440  | 1.919 |
| VERTICAL SPREAD             | : | 2.055  | 2.055  | 2.055 |
| EXTREME SPREAD              | : | 3.108  | 2.741  | 2.258 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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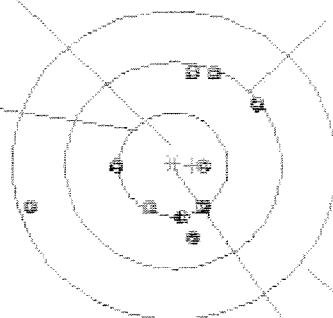
# CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 9

3in = 10

CENTROID #

HS= 2.036

VS= 1.602

GS= 2.294

PATTERN #

4

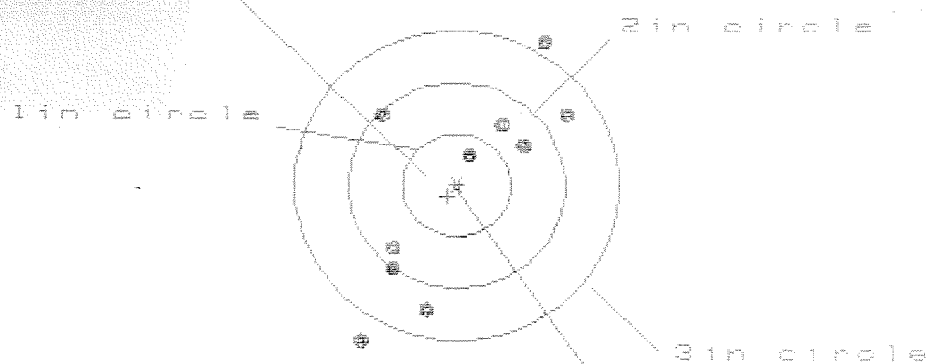
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .749   | .606  | .284  |
| MINIMUM X                   | : | -1.287 | -.689 | -.613 |
| MAXIMUM Y                   | : | .931   | .884  | .959  |
| MINIMUM Y                   | : | -.671  | -.718 | -.643 |
| CENTROID X                  | : | -.171  | -.028 | -.104 |
| CENTROID Y                  | : | .003   | .050  | -.025 |
| POA TO CENTROID in.         | : | .171   | .057  | .107  |
| MIN RADIUS                  | : | .228   | .096  | .164  |
| MEAN RADIUS                 | : | .717   | .635  | .593  |
| MAX RADIUS                  | : | 1.352  | .885  | .964  |
| HORIZONTAL SPREAD           | : | 2.036  | 1.295 | .897  |
| VERTICAL SPREAD             | : | 1.602  | 1.602 | 1.602 |
| EXTREME SPREAD              | : | 2.294  | 1.602 | 1.602 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C8611450

# CENTERFIRE PATTERNS # 5

POB



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.872

VS= 2.866

GS= 3.287

CENTROID #

PATTERN #

5

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.026  | .932   | 1.016  |
| MINIMUM X                     | : | -.846  | -.738  | -.654  |
| MAXIMUM Y                     | : | 1.365  | 1.198  | .715   |
| MINIMUM Y                     | : | -1.502 | -1.323 | -1.174 |
| CENTROID X                    | : | .087   | .181   | .097   |
| CENTROID Y                    | : | .106   | .273   | .124   |
| POB TO CENTROID in.           | : | .137   | .328   | .157   |
| MIN RADIUS                    | : | .313   | .136   | .294   |
| MEAN RADIUS                   | : | 1.025  | .906   | .868   |
| MAX RADIUS                    | : | 1.723  | 1.384  | 1.235  |
| HORIZONTAL SPREAD             | : | 1.872  | 1.670  | 1.670  |
| VERTICAL SPREAD               | : | 2.866  | 2.521  | 1.889  |
| EXTREME SPREAD                | : | 3.287  | 2.740  | 2.302  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |