

C5611453

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

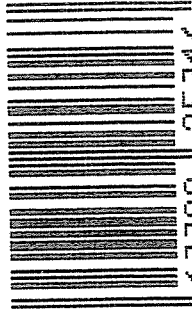
Remington

Remington® MODEL 700™ M24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
UPONT REG. U.S. PAT. & T.M. OFF.		SERIAL NO. C6611453
4S		ORDER NO. 5716



5716 C6611453

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611453

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	U
615	Rollmark Caliber	3 28	91	LS
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	LB
620	Apply Coatings (Barrel Action)		4-11-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/6/91	AL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/6/91	SL
	G) Safety Off Force	4	4	4			5/6/91	SL
	H) Trigger Pull Test & Retainability						5/6/91	SL
	I) Firing Pin Indent	.021	.021	.021			5/6/91	SL
	J) Assemble Stock						5/7/91	RW
	K) Assemble Swivel Studs						5-9-91	A
	L) Attach Front and Rear Sight Assemblies						5/7/91	RW
	M) Iron Sight Alignment						5/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	RW
	O) Attach Scope to Rifle						5/7/91	RW
	P) Detach & Attach Scope 20 Times						5/7/91	RW
640	Gallery Target & Test						5/7/91	KJ
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/7/91	KT
655	Final Inspection							
	A) Headspace						5-9-91	A
	B) Trigger Pull	2.18	2.19	2.22	2.24	2.18	5/9/91	SL
	C) Function						5-9-91	A
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611453
DATE 5/6/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.31	2.30	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.35	2.29	2.19	
PULL #3	2.28	2.28	2.20	2.22	
PULL #4	2.26	2.29	2.22	2.24	
PULL #5	2.30	2.25	2.19	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.30		
PULL #2	3.34	3.41		
PULL #3	3.35	3.42		
PULL #4	3.44	3.44		
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	4.42	4.16		4.23
PULL #2	4.44	4.21		4.23
PULL #3	4.26	4.25		4.16
PULL #4	4.22	4.22		4.29
PULL #5	4.25	4.32		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611453
7 May 1991

CENTROIDAL DISTANCES

0 TO	1	.498526
1 TO	2	.920385
1 TO	3	.600616
1 TO	4	.759458
1 TO	5	.304237

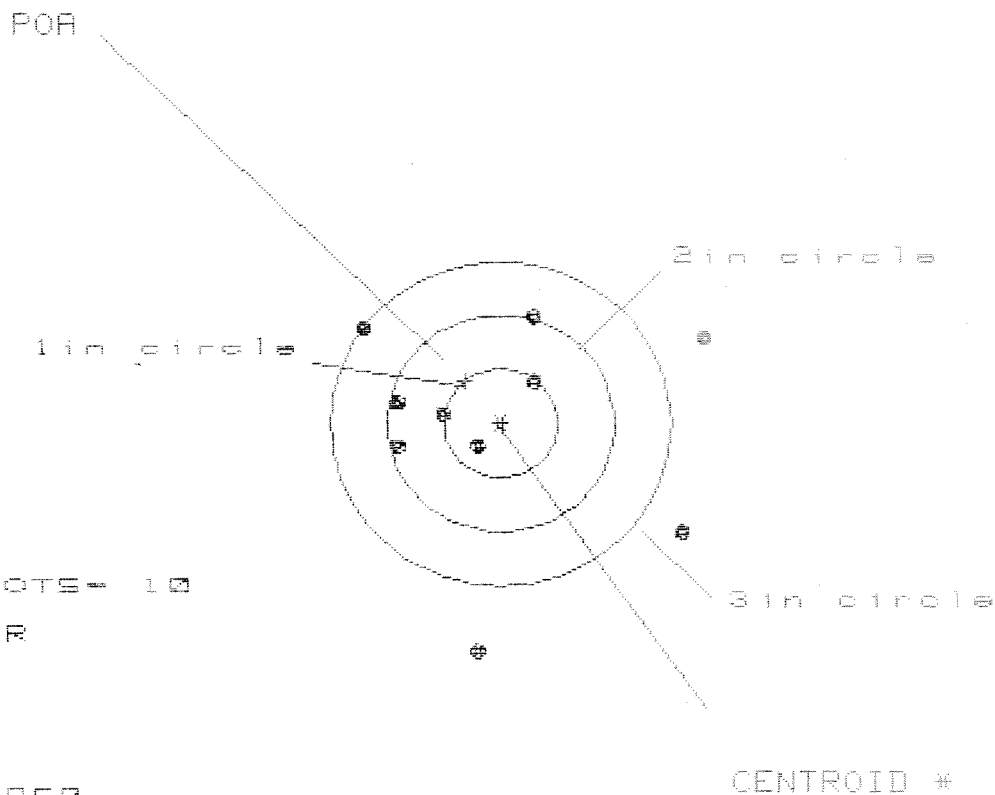
$\frac{1}{5} \begin{matrix} 2 \\ 4 \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3272
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0712
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .334857
THE AMR FOR THIS RIFLE IS: 1.252

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.968

VS= 3.094

GS= 3.493

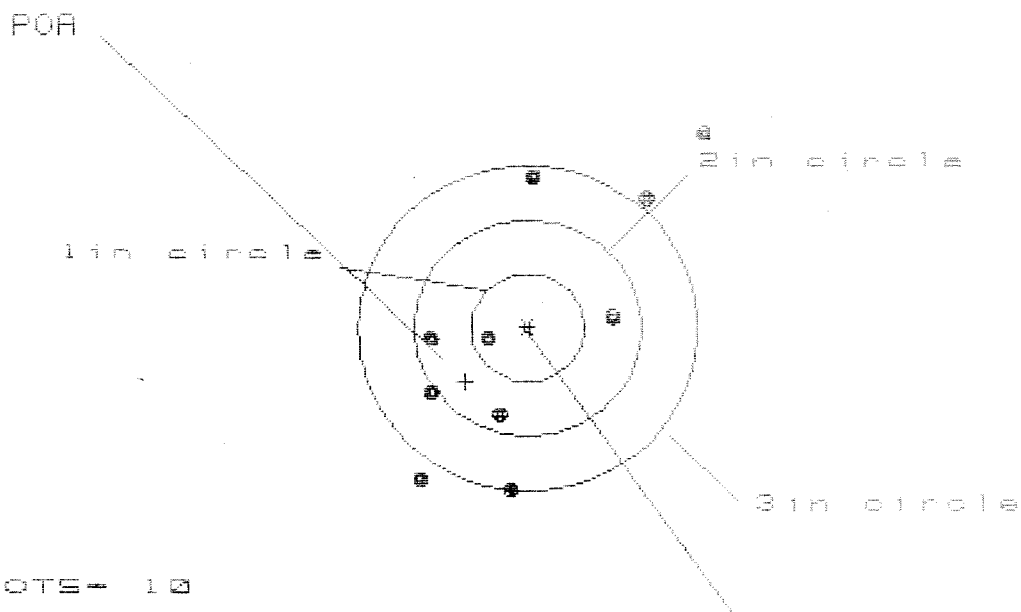
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.789	1.761	1.798
MINIMUM X	:	-1.179	-1.207	-.986
MAXIMUM Y	:	1.019	.789	.855
MINIMUM Y	:	-2.075	-1.239	-1.173
CENTROID X	:	.368	.336	.115
CENTROID Y	:	-.392	-.162	-.228
POA TO CENTROID in.	:	.499	.372	.256
MIN RADIUS	:	.241	.294	.271
MEAN RADIUS	:	1.159	1.034	.879
MAX RADIUS	:	2.089	2.006	2.146
HORIZONTAL SPREAD	:	2.968	2.968	2.784
VERTICAL SPREAD	:	3.094	2.028	2.028
EXTREME SPREAD	:	3.493	3.370	3.370
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611453

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 2.548

VS = 3.330

GS = 4.137

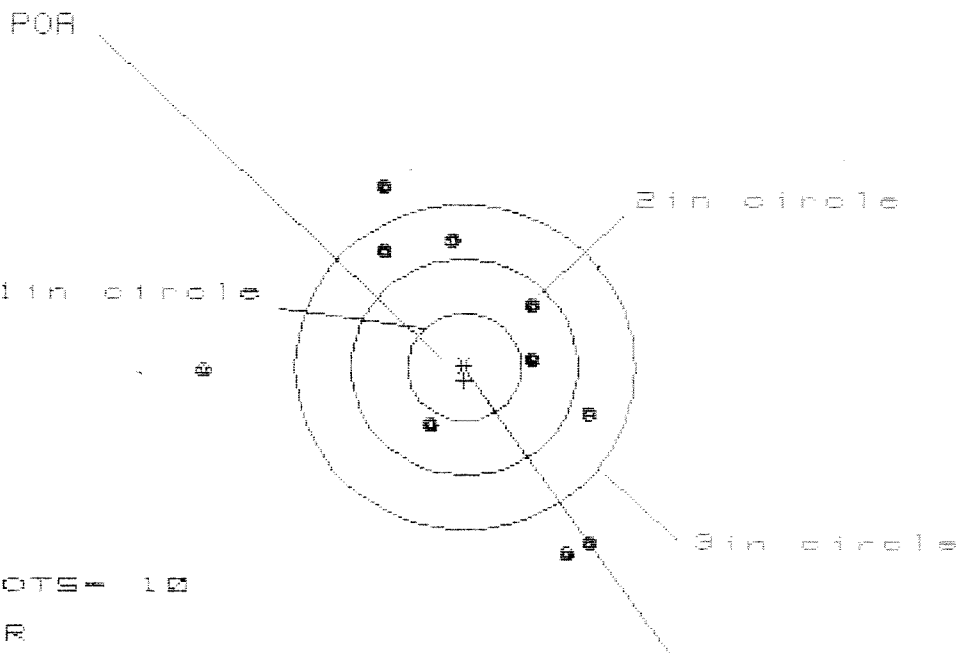
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.559	1.269	1.167
MINIMUM X	:	-.990	-.816	-.801
MAXIMUM Y	:	1.822	1.614	1.459
MINIMUM Y	:	-1.508	-1.305	-1.460
CENTROID X	:	.550	.376	.478
CENTROID Y	:	.496	.293	.448
POA TO CENTROID in.	:	.740	.477	.655
MIN RADIUS	:	.354	.220	.277
MEAN RADIUS	:	1.252	1.061	1.029
MAX RADIUS	:	2.398	1.859	1.677
HORIZONTAL SPREAD	:	2.549	2.085	1.968
VERTICAL SPREAD	:	3.330	2.919	2.919
EXTREME SPREAD	:	4.137	3.327	2.955
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 3.401

VS = 3.413

GS = 3.740

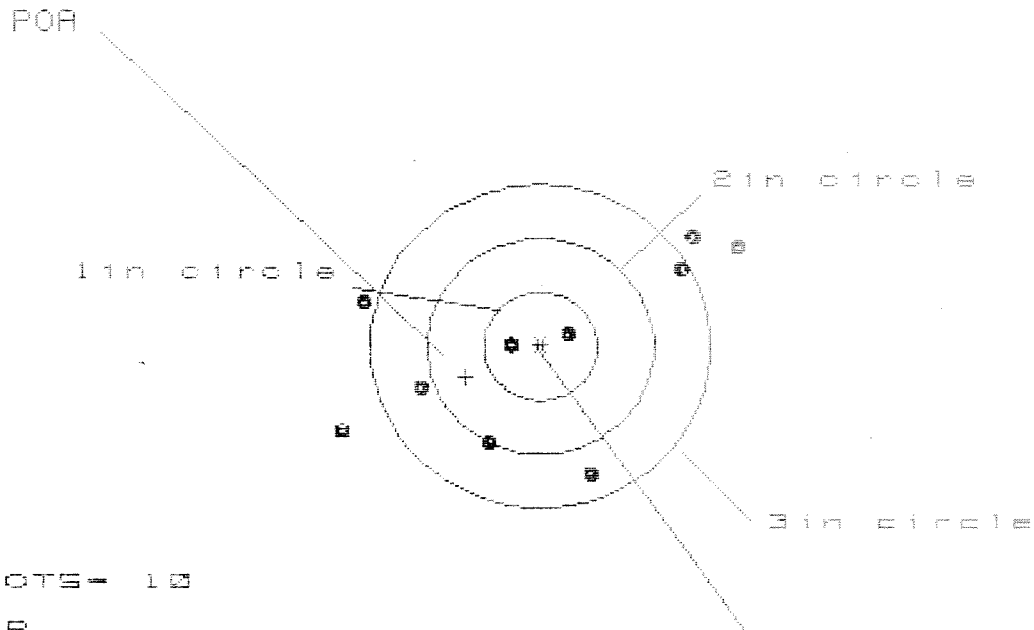
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.806	.883
MINIMUM X	:	-2.335	-1.005	-.928
MAXIMUM Y	:	1.643	1.636	1.414
MINIMUM Y	:	-1.770	-1.777	-1.821
CENTROID X	:	.004	.264	.187
CENTROID Y	:	.126	.134	.356
POR TO CENTROID in.	:	.127	.296	.402
MIN RADIUS	:	.640	.390	.474
MEAN RADIUS	:	1.363	1.212	1.109
MAX RADIUS	:	2.336	1.879	2.017
HORIZONTAL SPREAD	:	3.401	1.811	1.811
VERTICAL SPREAD	:	3.413	3.413	3.235
EXTREME SPREAD	:	3.740	3.740	3.659
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 2

3in = 6

HS= 3.519

VS= 2.254

GS= 3.902

CENTROID #

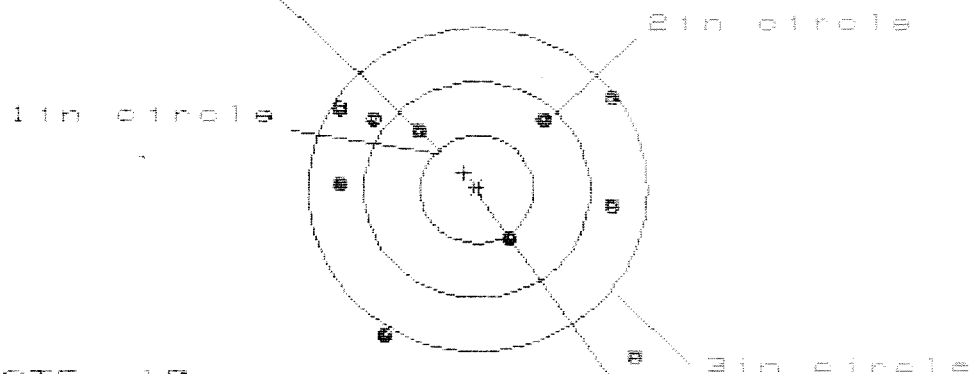
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.788	1.545	1.354
MINIMUM X	:	-1.731	-1.533	-1.521
MAXIMUM Y	:	1.044	1.146	1.062
MINIMUM Y	:	-1.210	-1.108	-1.192
CENTROID X	:	.658	.460	.651
CENTROID Y	:	.282	.180	.264
POA TO CENTROID in.	:	.716	.494	.703
MIN RADIUS	:	.218	.168	.232
MEAN RADIUS	:	1.251	1.144	1.075
MAX RADIUS	:	2.008	1.924	1.721
HORIZONTAL SPREAD	:	3.519	3.078	2.875
VERTICAL SPREAD	:	2.254	2.254	2.254
EXTREME SPREAD	:	3.902	3.573	2.942
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

7 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08611453

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.619

VS= 2.451

GS= 3.511

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.424	1.342	1.255
MINIMUM X	-1.195	-1.036	-1.123
MAXIMUM Y	.871	.695	.500
MINIMUM Y	-1.580	-1.561	-.826
CENTROID X	.116	-.043	.044
CENTROID Y	-.156	.020	.215
POA TO CENTROID in.	.194	.047	.220
MIN RADIUS	.540	.584	.541
MEAN RADIUS	1.237	1.107	1.014
MAX RADIUS	2.128	1.707	1.349
HORIZONTAL SPREAD	2.619	2.378	2.378
VERTICAL SPREAD	2.451	2.256	1.326
EXTREME SPREAD	3.511	3.035	2.529
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611453
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.279158
1 TO	2	.0455412
1 TO	3	.380296
1 TO	4	.255096
1 TO	5	.426517

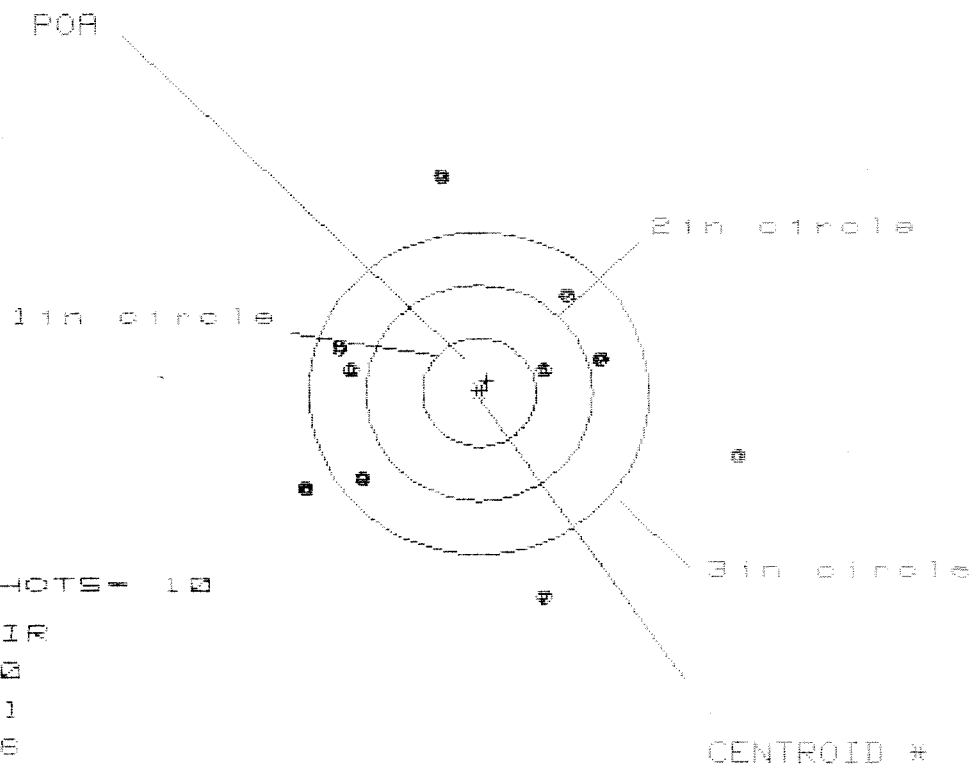
54 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .131
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131323
THE AMR FOR THIS RIFLE IS: 1.158

B May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11453.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 0

2in = 1

3in = 6

HS = 3.794

VS = 3.914

GS = 4.011

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.268	1.355	1.342
MINIMUM X	-1.526	-1.274	-1.287
MAXIMUM Y	2.046	1.982	1.886
MINIMUM Y	-1.868	-1.932	-1.684
CENTROID X	-.070	-.322	-.309
CENTROID Y	-.112	-.047	-.295
POA TO CENTROID in.	.131	.325	.427
MIN RADIUS	.636	.865	.925
MEAN RADIUS	1.479	1.362	1.280
MAX RADIUS	2.340	2.082	1.849
HORIZONTAL SPREAD	3.794	2.629	2.629
VERTICAL SPREAD	3.914	3.914	2.770
EXTREME SPREAD	4.011	4.011	2.901
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	6		

B May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453.1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 1.948

VS= 3.070

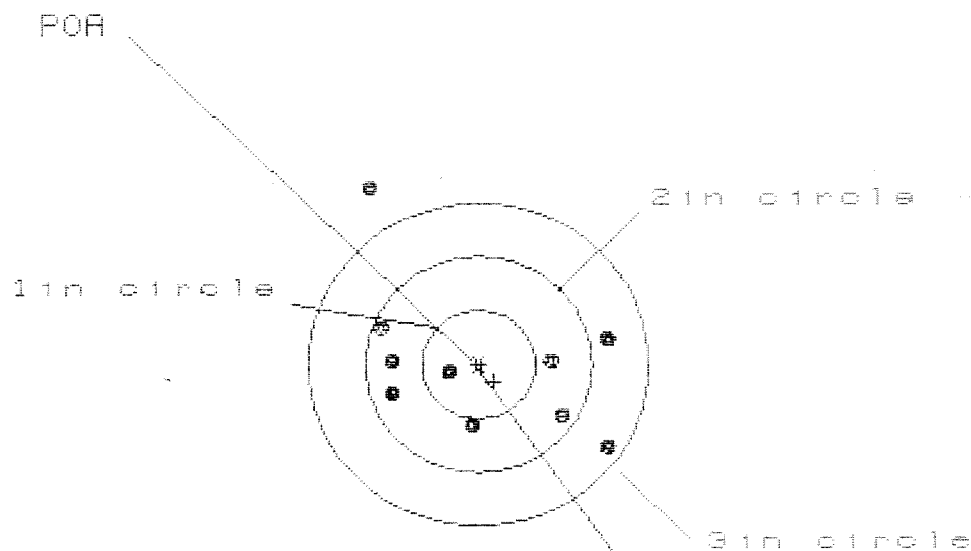
GS= 3.150

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.138	.815	.659
MINIMUM X	:	-.810	-.683	-.582
MAXIMUM Y	:	1.443	1.263	1.072
MINIMUM Y	:	-1.627	-1.528	-1.344
CENTROID X	:	.268	.141	.039
CENTROID Y	:	-.207	-.027	.164
POA TO CENTROID in.	:	.339	.144	.169
MIN RADIUS	:	.554	.359	.176
MEAN RADIUS	:	1.093	.941	.786
MAX RADIUS	:	1.985	1.732	1.392
HORIZONTAL SPREAD	:	1.948	1.498	1.241
VERTICAL SPREAD	:	3.070	2.791	2.416
EXTREME SPREAD	:	3.150	2.803	2.622
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

B May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811453.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.083

VS= 2.345

GS= 3.124

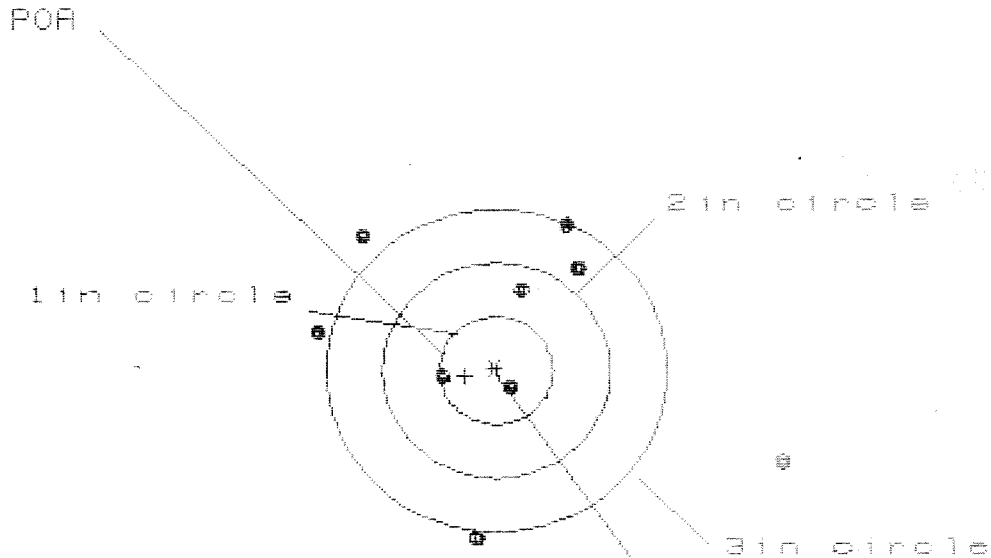
CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.164	1.062	1.192
MINIMUM X	-.919	-.992	-.862
MAXIMUM Y	1.597	.468	.397
MINIMUM Y	-.748	-.578	-.489
CENTROID X	-.136	-.034	-.164
CENTROID Y	.162	-.016	.056
POA TO CENTROID in.	.211	.037	.173
MIN RADIUS	.233	.350	.204
MEAN RADIUS	.935	.815	.750
MAX RADIUS	1.843	1.189	1.246
HORIZONTAL SPREAD	2.083	2.054	2.054
VERTICAL SPREAD	2.345	1.038	.886
EXTREME SPREAD	3.124	2.284	2.054
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 4

HS = 4.039

VS = 3.467

GS = 4.227

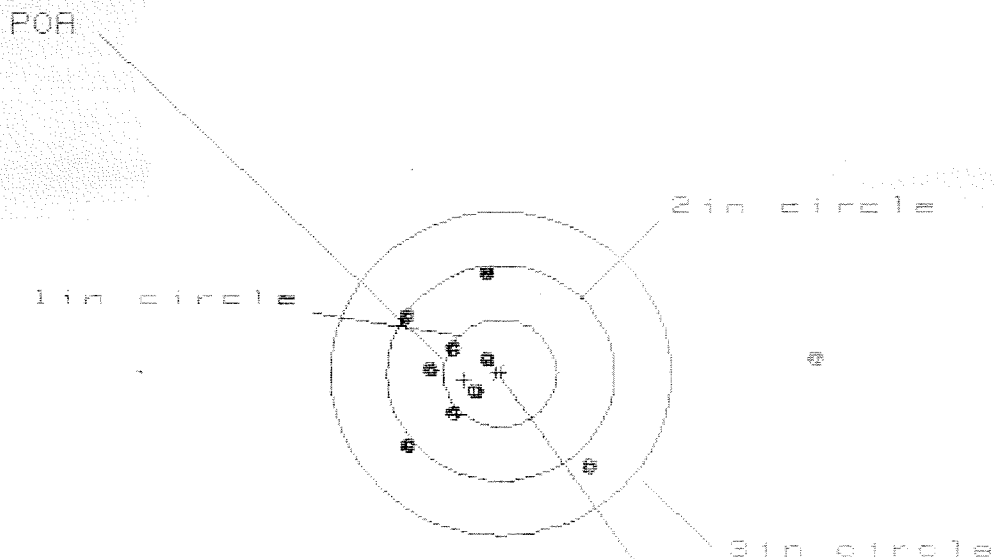
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.484	.961	.891
MINIMUM X	:	-1.555	-1.279	-1.349
MAXIMUM Y	:	1.373	1.275	1.001
MINIMUM Y	:	-2.094	-2.192	-1.911
CENTROID X	:	.275	-.001	.069
CENTROID Y	:	.048	.146	.420
POA TO CENTROID in.	:	.279	.146	.425
MIN RADIUS	:	.221	.229	.475
MEAN RADIUS	:	1.390	1.228	1.077
MAX RADIUS	:	2.635	2.262	1.911
HORIZONTAL SPREAD	:	4.039	2.240	2.240
VERTICAL SPREAD	:	3.467	3.467	2.912
EXTREME SPREAD	:	4.227	3.770	3.024
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C08611453.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.562

VS= 1.770

GS= 3.643

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.771	1.051	.331
MINIMUM X	:	-.791	-.483	-.352
MAXIMUM Y	:	.908	.921	.815
MINIMUM Y	:	-.862	-.849	-.737
CENTROID X	:	.318	.010	-.121
CENTROID Y	:	.063	.050	.156
POA TO CENTROID in.	:	.324	.051	.198
MIN RADIUS	:	.203	.159	.192
MEAN RADIUS	:	.894	.577	.464
MAX RADIUS	:	2.773	1.351	.869
HORIZONTAL SPREAD	:	3.562	1.534	.683
VERTICAL SPREAD	:	1.770	1.770	1.552
EXTREME SPREAD	:	3.643	2.058	1.685
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	