

06611494

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

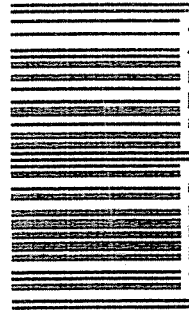
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. C6611494	46
ORDER NO. 5716	



5716 C6611494

LPC



0 47700 25716 2

GUN SERIAL #

C 6611494

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	K.R.
	Magnaflux Bolt		11	K.R.
615	Rollmark Caliber		3/27/91	Q.S.
617	Drill and Tap Sight Holes	APR 3 1991		ES
618	Polish Barrel	APR 3 1991		WK
620	Apply Coatings (Barrel Action)		4-19-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	KS
	C) Inspect Ejector Hole for Chamfer		4/30/91	KS
	D) Oil Firing Pin Ass'y		4/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/2/91	SL

Op. #	Op. Name	Readings					Date	Init
625 cont.	F) Safety On Force	6	6	6			5-2-91	DH
	G) Safety Off Force	3	3	3			5-2-91	DH
	H) Trigger Pull Test & Retainability						5/2/91	JK
	I) Firing Pin Indent	.021	.022	.022			5-2-91	DH
	J) Assemble Stock						5/4/91	KS
	K) Assemble Swivel Studs						5-9-91	A
	L) Attach Front and Rear Sight Assemblies						5/4/91	KS
	M) Iron Sight Alignment						5/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/4/91	KS
	O) Attach Scope to Rifle						5/4/91	KS
	P) Detach & Attach Scope 20 Times						5/4/91	KS
640	Gallery Target & Test						5-6-91	AC
	A) Time						5-6-91	AC
	B) Malfunctions						5-6-91	AC
	C) Pierced Primers						5-6-91	AC
	D) Optical Clarity of Scope						5-6-91	AC
645	Inspect for Live Ammo						5-6-91	AC
655	Final Inspection							
	A) Headspace						5-9-91	A
	B) Trigger Pull	2.41	2.48	2.47	2.49	2.34	5/9/91	JK
	C) Function						5-9-91	A
660	Pack						6-20-91	W

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611484DATE 5/2/91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.42	2.45	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.43	2.48	2.48	
PULL #3	2.53	2.44	2.43	2.47	
PULL #4	2.45	2.45	2.43	2.49	
PULL #5	2.44	2.43	2.41	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.46		
PULL #2	3.48	3.48		
PULL #3	3.55	3.45		
PULL #4	3.51	3.47		
PULL #5	3.50	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.29		4.30
PULL #2	4.25	4.34		4.35
PULL #3	4.24	4.27		4.25
PULL #4	4.33	4.20		4.35
PULL #5	4.23	4.32		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611494
MAR 1991

CENTROIDAL DISTANCES

0 TO	1	.209296
1 TO	2	.557001
1 TO	3	.0505964
1 TO	4	.0927793
1 TO	5	.773217

2 5 <-----POA

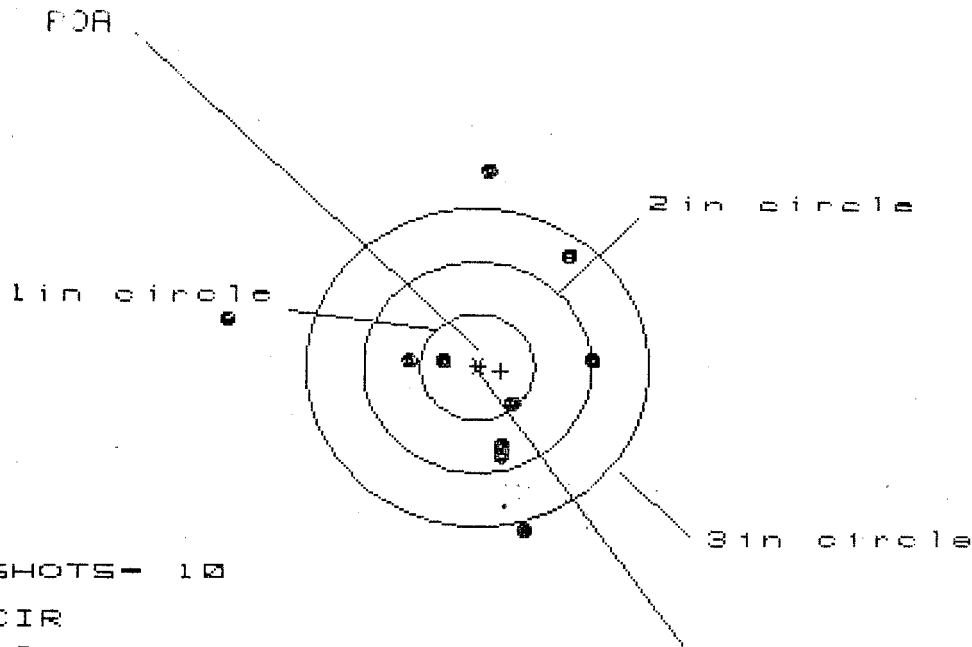
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0834
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .177
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .195664
THE AMP FOR THIS RIFLE IS: .8726

6 12, 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611494

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in = 7

HS- 3.189

VS= 3.382

GS= 3.392

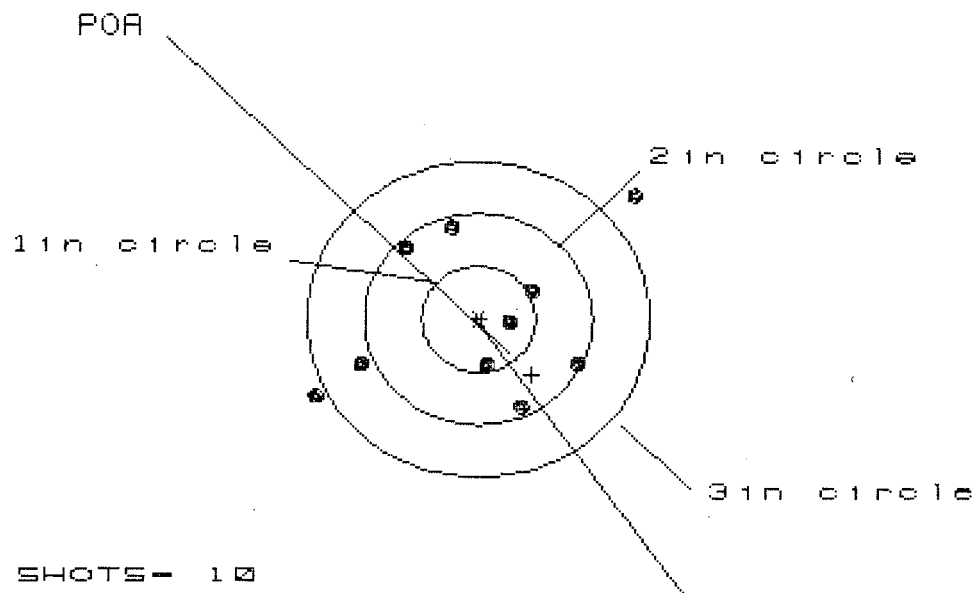
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.803	.785
MINIMUM X	:	-2.147	-.833	-.851
MAXIMUM Y	:	1.822	1.871	1.329
MINIMUM Y	:	-1.560	-1.511	-1.278
CENTROID X	:	-.206	.033	.051
CENTROID Y	:	.037	-.012	-.245
POA TO CENTROID in.	:	.209	.035	.251
MIN RADIUS	:	.262	.250	.016
MEAN RADIUS	:	1.086	.944	.764
MAX RADIUS	:	2.191	1.876	1.430
HORIZONTAL SPREAD	:	3.189	1.636	1.636
VERTICAL SPREAD	:	3.382	3.382	2.607
EXTREME SPREAD	:	3.392	3.392	2.642
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.802

VS= 2.061

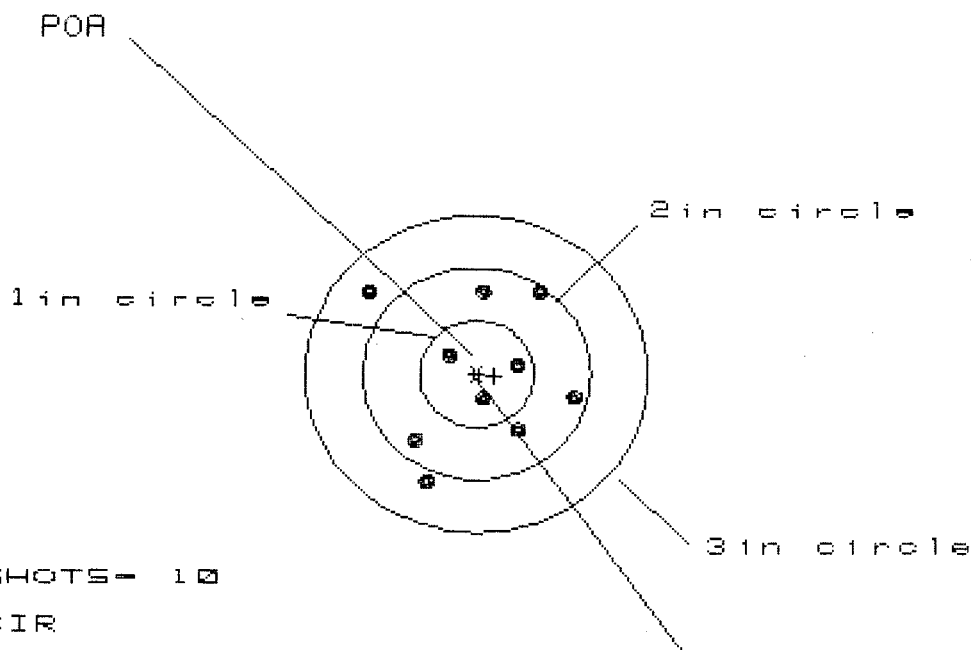
GS= 3.380

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.354	.995	.833
MINIMUM X	:	-1.448	-1.298	-1.081
MAXIMUM Y	:	1.207	.965	.897
MINIMUM Y	:	-.854	-.720	-.788
CENTROID X	:	-.469	-.619	-.457
CENTROID Y	:	.528	.394	.462
POA TO CENTROID in.	:	.706	.734	.650
MIN RADIUS	:	.297	.392	.281
MEAN RADIUS	:	.946	.859	.750
MAX RADIUS	:	1.814	1.409	1.151
HORIZONTAL SPREAD	:	2.802	2.293	1.914
VERTICAL SPREAD	:	2.061	1.685	1.685
EXTREME SPREAD	:	3.380	2.304	1.914
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS- 1.865

VS- 1.778

GS- 2.091

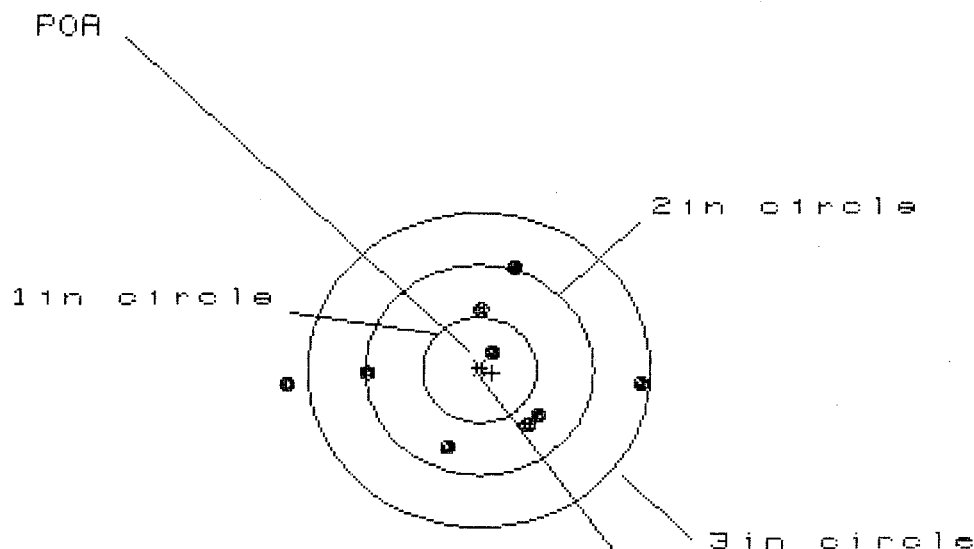
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.883	.774	.705
MINIMUM X	:	-.982	-.677	-.746
MAXIMUM Y	:	.789	.875	.762
MINIMUM Y	:	-.989	-.903	-.681
CENTROID X	:	-.158	-.049	.020
CENTROID Y	:	.021	-.065	.048
POA TO CENTROID in.	:	.159	.081	.052
MIN RADIUS	:	.182	.137	.235
MEAN RADIUS	:	.735	.663	.609
MAX RADIUS	:	1.251	1.057	1.010
HORIZONTAL SPREAD	:	1.865	1.451	1.451
VERTICAL SPREAD	:	1.778	1.778	1.443
EXTREME SPREAD	:	2.091	2.008	1.807
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 3.100

VS = 1.707

GS = 3.100

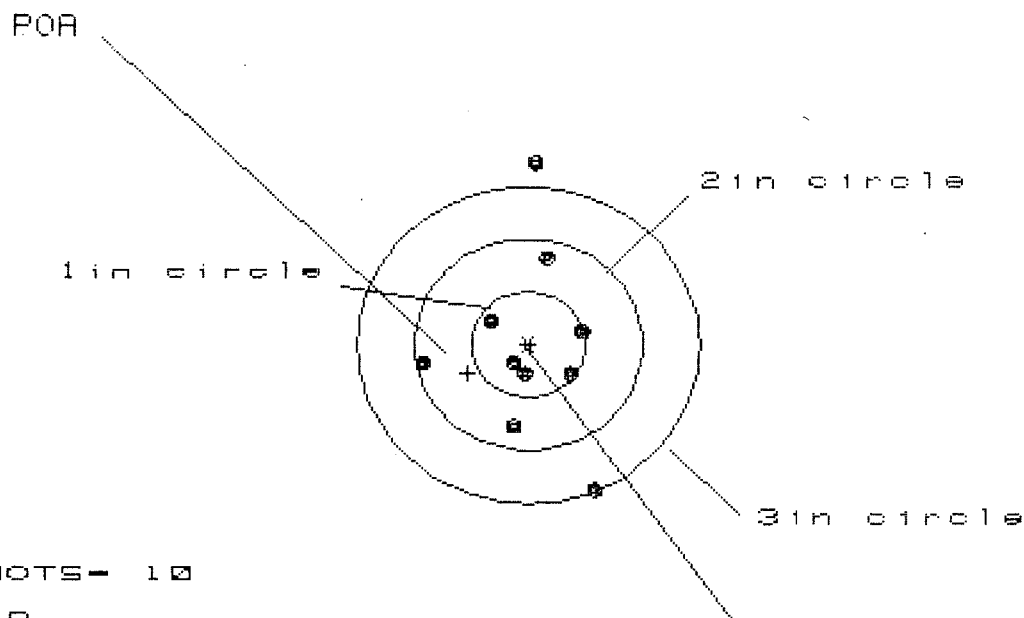
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.453	1.270	.483
MINIMUM X	:	-1.647	-1.143	-.985
MAXIMUM Y	:	.976	.967	.953
MINIMUM Y	:	-.731	-.740	-.754
CENTROID X	:	-.114	.069	-.089
CENTROID Y	:	.025	.034	.048
POA TO CENTROID in.	:	.116	.077	.101
MIN RADIUS	:	.203	.145	.169
MEAN RADIUS	:	.828	.717	.640
MAX RADIUS	:	1.649	1.275	.986
HORIZONTAL SPREAD	:	3.100	2.413	1.468
VERTICAL SPREAD	:	1.707	1.707	1.707
EXTREME SPREAD	:	3.100	2.415	1.799
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS- 1.497

VS- 3.165

GS- 3.206

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.546	.550	.527
MINIMUM X	:	-.951	-.947	-.879
MAXIMUM Y	:	1.775	.998	.849
MINIMUM Y	:	-1.390	-1.193	-.691
CENTROID X	:	.530	.526	.458
CENTROID Y	:	.274	.077	.226
POA TO CENTROID in.	:	.597	.532	.510
MIN RADIUS	:	.248	.077	.164
MEAN RADIUS	:	.768	.623	.540
MAX RADIUS	:	1.775	1.313	.882
HORIZONTAL SPREAD	:	1.497	1.497	1.406
VERTICAL SPREAD	:	3.165	2.191	1.540
EXTREME SPREAD	:	3.206	2.227	1.563
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		