

C6611580

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

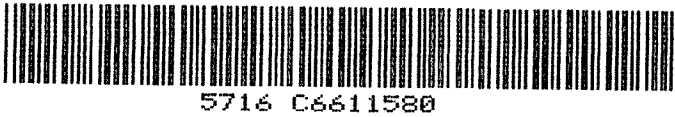
Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6611580	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		46	



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611580

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action		APR 2 1991	K.R.
	Magnaflux Bolt		APR 2 1991	11
615	Rollmark Caliber		APR 2 1991	928
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-15-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/10/91	K.S.
	D) Oil Firing Pin Ass'y		4/10/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/11/91	JM
	G) Safety Off Force	2	2	2			4/11/91	JM
	H) Trigger Pull Test & Retainability						4/11/91	JM
	I) Firing Pin Indent	022	022	022			4/11/91	JM
	J) Assemble Stock						4/12/91	KS
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/12/91	KS
	M) Iron Sight Alignment						4/12/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	KS
	O) Attach Scope to Rifle						4/12/91	KS
	P) Detach & Attach Scope 20 Times						4/12/91	KS
640	Gallery Target & Test						4/12/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/12/91	KS
655	Final Inspection						5-1-91	D/H
	A) Headspace							
	B) Trigger Pull	2.50	2.69	2.70	2.46	2.64	4/26/91	JM
	C) Function						5-1-91	D/H
660	Pack						6-18-91	V

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611580

DATE 4/11/91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.52	2.46	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.52	2.48	2.69	
PULL #3	2.42	2.49	2.45	2.70	
PULL #4	2.46	2.51	2.50	2.46	
PULL #5	2.43	2.45	2.46	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.25		
PULL #2	3.18	3.28		
PULL #3	3.28	3.48		
PULL #4	3.15	3.38		
PULL #5	3.20	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.19		4.42
PULL #2	4.55	4.24		4.51
PULL #3	4.26	4.29		4.34
PULL #4	4.45	4.55		4.43
PULL #5	4.27	4.27		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611580
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.276134
1 TO	2	.380916
1 TO	3	.298965
1 TO	4	.394899
1 TO	5	.169664

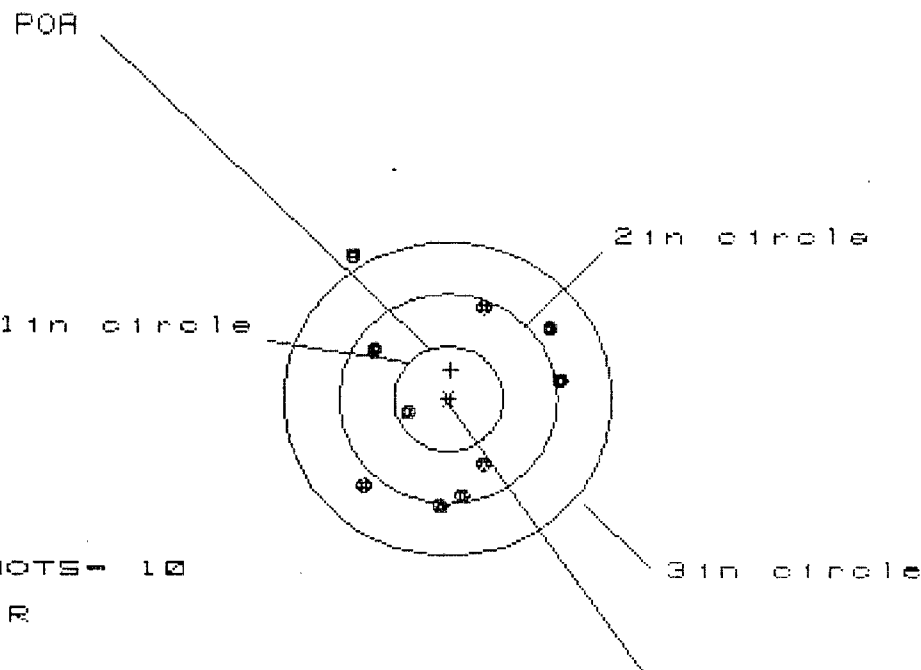
214 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1258
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12639
THE AMR FOR THIS RIFLE IS: .9266

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 1.930

VS = 2.411

GS = 2.523

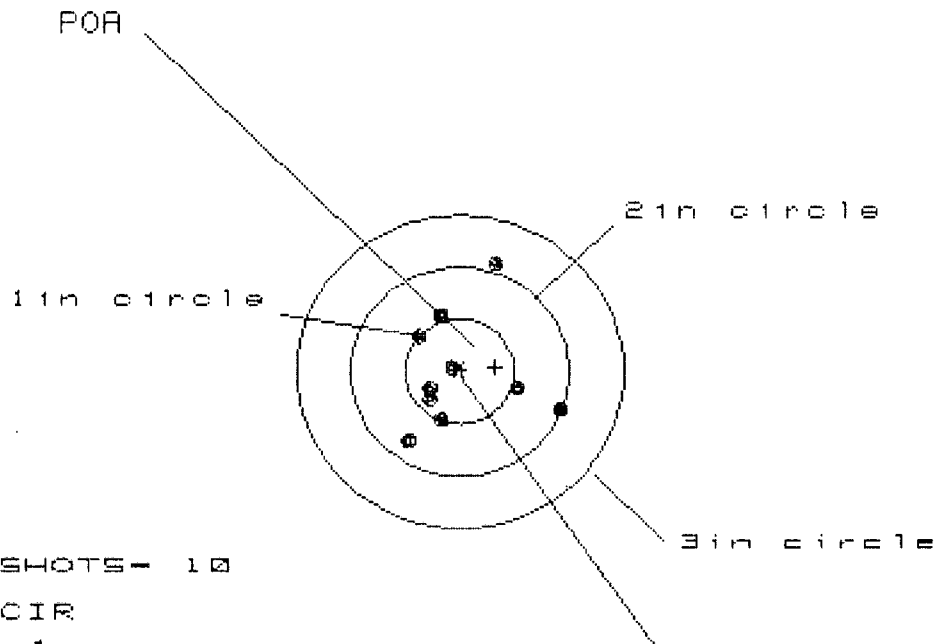
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.073	.978	1.080
MINIMUM X	-.857	-.845	-.743
MAXIMUM Y	1.347	.977	1.077
MINIMUM Y	-1.064	-.914	-.814
CENTROID X	-.025	.070	-.032
CENTROID Y	-.275	-.425	-.525
POA TO CENTROID in.	.276	.431	.526
MIN RADIUS	.408	.472	.381
MEAN RADIUS	.976	.888	.832
MAX RADIUS	1.597	1.143	1.178
HORIZONTAL SPREAD	1.930	1.823	1.823
VERTICAL SPREAD	2.411	1.891	1.891
EXTREME SPREAD	2.523	2.199	2.084
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10
IN CIR
1in = 4
2in = 8
3in = 10
HS= 1.413
VS= 1.690
GS= 1.860

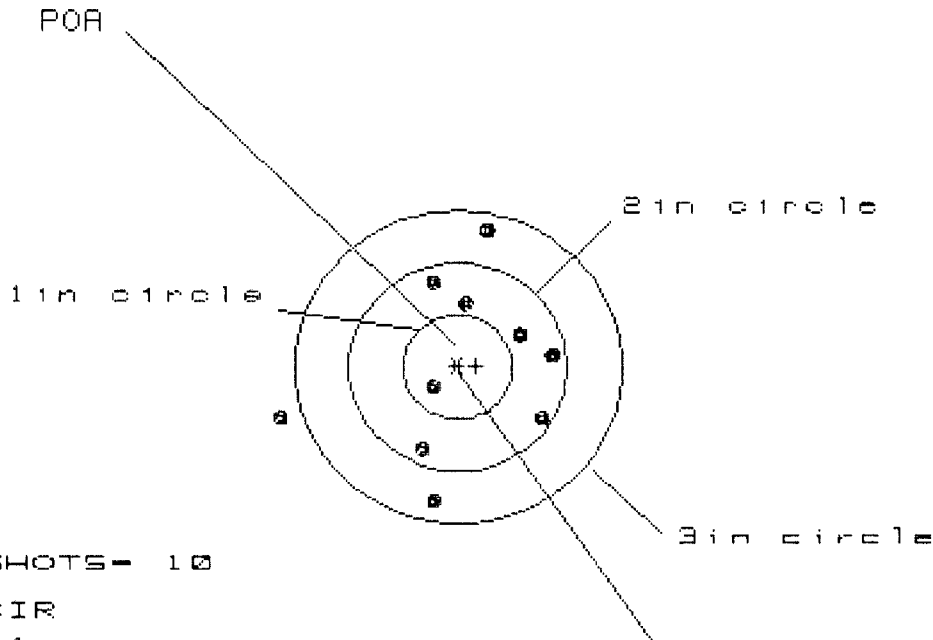
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	.989	.714
MINIMUM X	:	-.459	-.424	-.300
MAXIMUM Y	:	1.065	.684	.659
MINIMUM Y	:	-.625	-.507	-.532
CENTROID X	:	-.324	-.359	-.483
CENTROID Y	:	-.039	-.157	-.132
POA TO CENTROID in.	:	.326	.392	.501
MIN RADIUS	:	.115	.172	.082
MEAN RADIUS	:	.579	.501	.402
MAX RADIUS	:	1.111	1.009	.716
HORIZONTAL SPREAD	:	1.413	1.413	1.014
VERTICAL SPREAD	:	1.690	1.191	1.191
EXTREME SPREAD	:	1.860	1.471	1.214
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.478

VS= 2.594

GS= 2.642

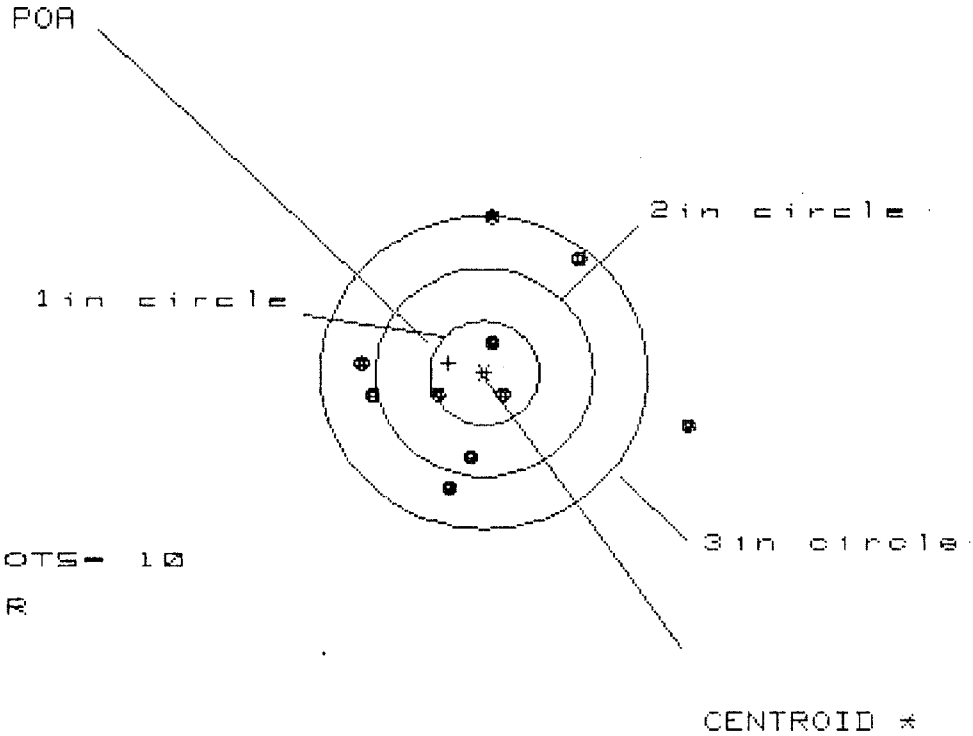
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.677	.690
MINIMUM X	:	-1.621	-.560	-.547
MAXIMUM Y	:	1.326	1.276	.885
MINIMUM Y	:	-1.268	-1.318	-1.158
CENTROID X	:	-.169	.011	-.002
CENTROID Y	:	-.013	.037	-.123
POA TO CENTROID in.	:	.170	.038	.123
MIN RADIUS	:	.265	.445	.384
MEAN RADIUS	:	.936	.832	.777
MAX RADIUS	:	1.682	1.376	1.220
HORIZONTAL SPREAD	:	2.478	1.237	1.237
VERTICAL SPREAD	:	2.594	2.594	2.043
EXTREME SPREAD	:	2.642	2.642	2.043
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580.1

CENTERFIRE PATTERNS # 4



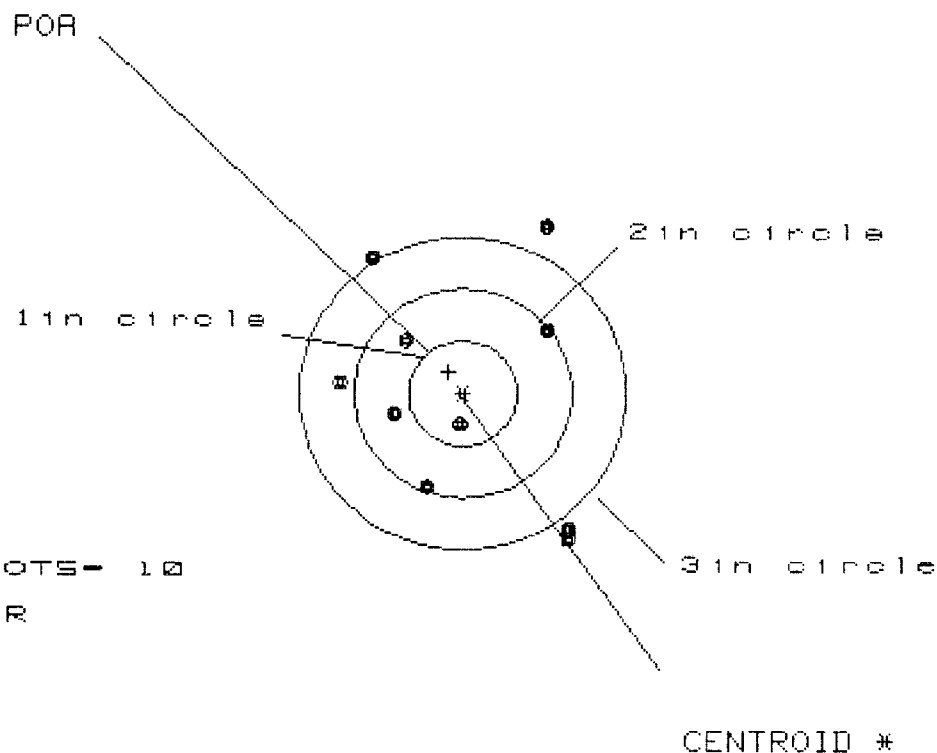
OF SHOTS- 10
IN CIR
1in = 3
2in = 4
3in = 9
HS= 3.049
VS= 2.542
GS= 3.115

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.907	1.051	1.087
MINIMUM X	:	-1.142	-.930	-.894
MAXIMUM Y	:	1.486	1.429	1.185
MINIMUM Y	:	-1.056	-1.113	-.934
CENTROID X	:	.327	.115	.079
CENTROID Y	:	-.096	-.039	-.218
POA TO CENTROID in.	:	.341	.121	.232
MIN RADIUS	:	.267	.354	.207
MEAN RADIUS	:	.995	.873	.762
MAX RADIUS	:	1.974	1.457	1.608
HORIZONTAL SPREAD	:	3.049	1.981	1.981
VERTICAL SPREAD	:	2.542	2.542	2.119
EXTREME SPREAD	:	3.115	2.578	2.435
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 2.053

VS= 3.000

GS= 3.295

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.967	1.054	1.184
MINIMUM X	-1.086	-.999	-.869
MAXIMUM Y	1.564	1.524	1.367
MINIMUM Y	-1.436	-1.263	-1.248
CENTROID X	.130	.043	-.087
CENTROID Y	-.206	-.379	-.222
POA TO CENTROID in.	.243	.382	.238
MIN RADIUS	.340	.170	.367
MEAN RADIUS	1.147	1.043	.952
MAX RADIUS	1.752	1.685	1.720
HORIZONTAL SPREAD	2.053	2.053	2.053
VERTICAL SPREAD	3.000	2.787	2.614
EXTREME SPREAD	3.295	3.295	3.158
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611580
12 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.393315
1 TO	2	.466203
1 TO	3	.542044
1 TO	4	.521245
1 TO	5	.245837

4 <----FOR
7

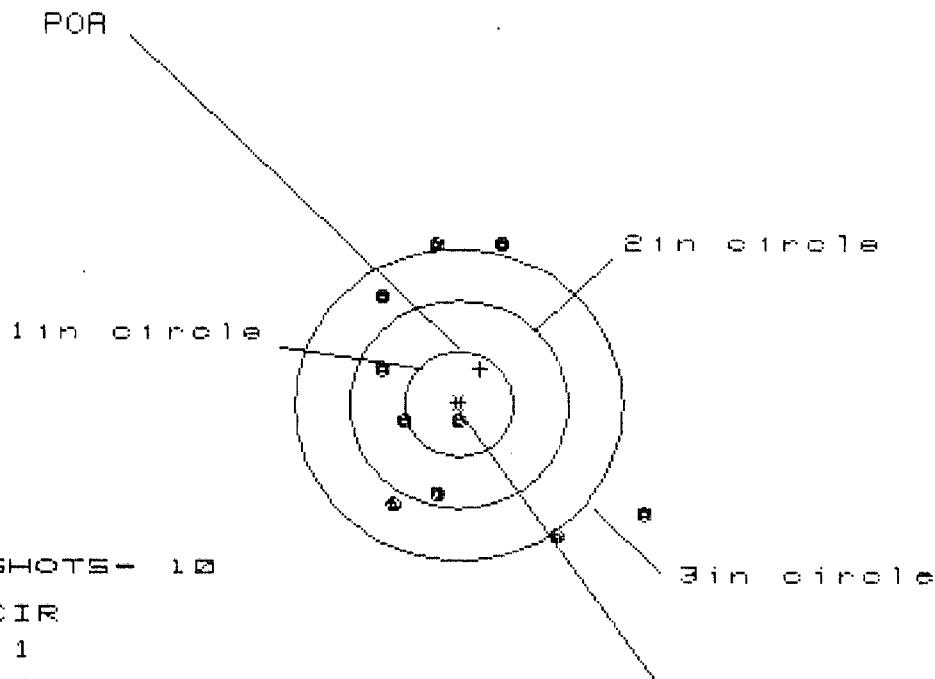
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1358
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0046
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .135878
THE AMR FOR THIS RIFLE IS: 1.258

Re Load / Retarget

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.466

VS= 2.766

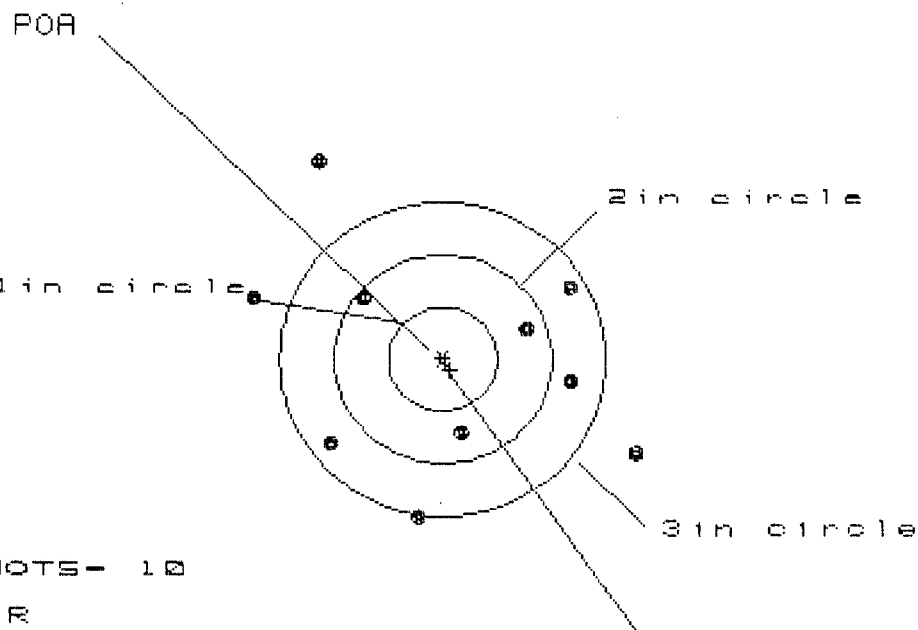
GS= 3.223

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.729	1.044	1.119
MINIMUM X	:	-.737	-.545	-.470
MAXIMUM Y	:	1.524	1.407	1.569
MINIMUM Y	:	-1.242	-1.359	-1.183
CENTROID X	:	-.196	-.388	-.463
CENTROID Y	:	-.341	-.224	-.400
POA TO CENTROID in.	:	.393	.448	.612
MIN RADIUS	:	.172	.328	.259
MEAN RADIUS	:	1.141	1.015	.911
MAX RADIUS	:	2.024	1.714	1.628
HORIZONTAL SPREAD	:	2.466	1.589	1.589
VERTICAL SPREAD	:	2.766	2.766	2.752
EXTREME SPREAD	:	3.223	2.956	2.956
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		4		
NUMBER IN THREE INCH CIRCLE =		5		

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611560

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 3.501

VS= 3.416

GS= 3.966

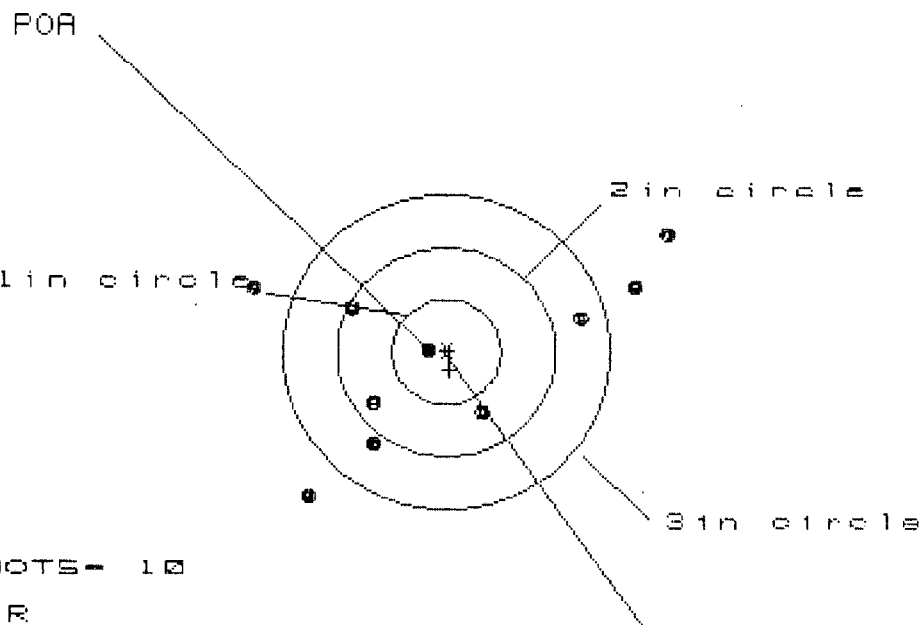
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.719	1.592	1.218
MINIMUM X	:	-1.782	-1.909	-1.710
MAXIMUM Y	:	1.886	.949	.868
MINIMUM Y	:	-1.530	-1.320	-1.401
CENTROID X	:	-.067	.060	-.139
CENTROID Y	:	.107	-.103	-.022
POA TO CENTROID in.	:	.126	.119	.140
MIN RADIUS	:	.731	.502	.632
MEAN RADIUS	:	1.393	1.268	1.219
MAX RADIUS	:	2.206	2.070	1.855
HORIZONTAL SPREAD	:	3.501	3.501	2.928
VERTICAL SPREAD	:	3.416	2.269	2.269
EXTREME SPREAD	:	3.966	3.789	3.045
NUMBER IN ONE INCH CIRCLE =	:	0		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	6		

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611580

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.766

VS= 2.527

GS= 4.171

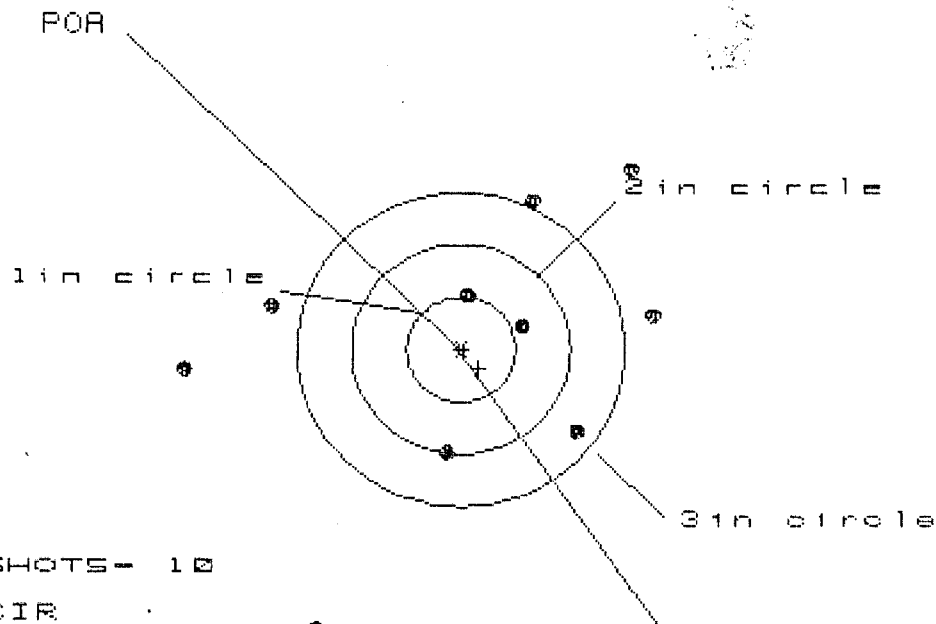
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.013	1.953	1.818
MINIMUM X	:	-1.753	-1.529	-1.664
MAXIMUM Y	:	1.162	.781	.627
MINIMUM Y	:	-1.365	-1.236	-.877
CENTROID X	:	-.030	-.254	-.118
CENTROID Y	:	.175	.046	.200
POA TO CENTROID in.	:	.177	.258	.232
MIN RADIUS	:	.134	.170	.046
MEAN RADIUS	:	1.278	1.116	1.055
MAX RADIUS	:	2.324	2.103	1.923
HORIZONTAL SPREAD	:	3.766	3.482	3.482
VERTICAL SPREAD	:	2.527	2.017	1.504
EXTREME SPREAD	:	4.171	3.643	3.482
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811580

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 4

HSI = 4.295

VS = 4.399

GS = 5.257

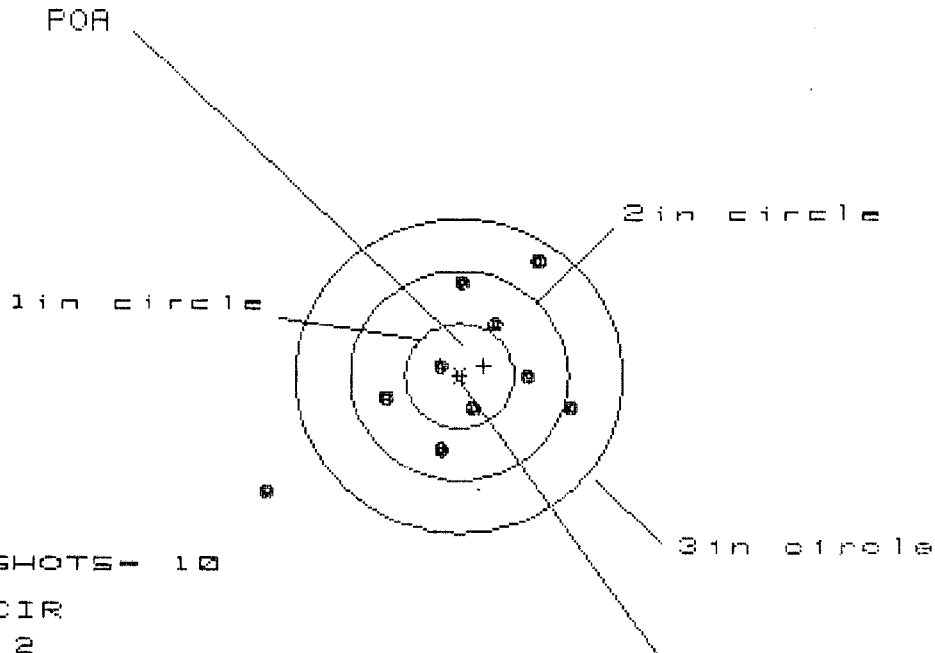
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.797	1.652	1.322
MINIMUM X	:	-2.498	-2.643	-2.209
MAXIMUM Y	:	1.720	1.423	1.362
MINIMUM Y	:	-2.679	-1.255	-1.316
CENTROID X	:	-.160	-.015	.315
CENTROID Y	:	.179	.476	.537
POA TO CENTROID in.	:	.240	.477	.623
MIN RADIUS	:	.499	.242	.133
MEAN RADIUS	:	1.640	1.427	1.218
MAX RADIUS	:	2.981	2.687	2.211
HORIZONTAL SPREAD	:	4.295	4.295	3.531
VERTICAL SPREAD	:	4.399	2.678	2.678
EXTREME SPREAD	:	5.257	4.495	3.542
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68115B0

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.789

VS= 2.167

GS= 3.320

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.980	.779	.842
MINIMUM X	:	-1.809	-.851	-.788
MAXIMUM Y	:	1.081	.961	.889
MINIMUM Y	:	-1.085	-.867	-.747
CENTROID X	:	-.226	-.025	-.088
CENTROID Y	:	-.097	.024	-.096
POA TO CENTROID in.	:	.246	.035	.130
MIN RADIUS	:	.207	.342	.286
MEAN RADIUS	:	.839	.676	.615
MAX RADIUS	:	2.110	1.085	.891
HORIZONTAL SPREAD	:	2.789	1.630	1.630
VERTICAL SPREAD	:	2.167	1.828	1.636
EXTREME SPREAD	:	3.320	2.014	1.650
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	