

C6611618

MODEL 700TM 124

Model S&S TM

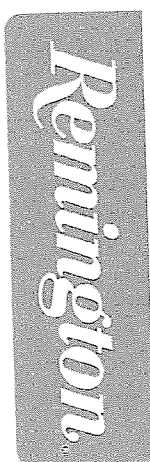
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Remington[®]

MODEL 700™ M24

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

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

SERIAL NO.
C6611618

ORDER NO.
5716

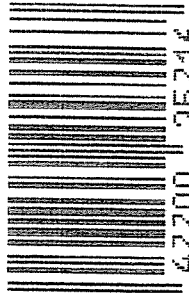
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611618

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611618

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		Rw
600	Proof	4 30 91		Rw
607	Check Headspace	30 91		Rw
610	Dis-assemble Gun	4 30 91		Rw
612	Magnaflux Barrel Action	5 6 91		Kck
	Magnaflux Bolt	5 6 91		Kck
615	Rollmark Caliber	5 6 91		G.B.
617	Drill and Tap Sight Holes	5 10 01		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/19/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	Rw
	C) Inspect Ejector Hole for Chamfer		6/19/91	Rw
	D) Oil Firing Pin Ass'y		6/19/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-22-91	YU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-23-91	DH
	G) Safety Off Force	3 3/4	4	4			7-23-91	DH
	H) Trigger Pull Test & Retainability						7-22-91	RL
	I) Firing Pin Indent	.022	.022	.022			7-23-91	DH
	J) Assemble Stock						7/25/91	RW
	K) Assemble Swivel Studs						7-29-91	DH
	L) Attach Front and Rear Sight Assemblies						7/25/91	RW
	M) Iron Sight Alignment						7/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/25/91	RW
	O) Attach Scope to Rifle						7/25/91	RW
	P) Detach & Attach Scope 20 Times						7/25/91	RW
640	Gallery Target & Test						7/25/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						7/25/91	KT
655	Final Inspection							
	A) Headspace						7-26-91	DH
	B) Trigger Pull	2.32	2.37	2.39	2.49	2.51	7-26-91	RL
	C) Function						7-26-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611618
DATE 7-22-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.47	2.44	2.32	MIN. SETTING,
PULL #2	2.33	2.36	2.40	2.37	NO AVG. OF 5
PULL #3	2.26	2.41	2.38	2.39	READINGS ACCEPT-
PULL #4	2.44	2.30	2.38	2.49	ABLE LESS THAN 2#
PULL #5	2.34	2.31	2.30	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.52		
PULL #2	3.48	3.56		
PULL #3	3.57	3.50		
PULL #4	3.58	3.42		
PULL #5	3.55	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.19		4.39
PULL #2	4.40	4.28		4.36
PULL #3	4.45	4.42		4.41
PULL #4	4.30	4.44		4.36
PULL #5	4.43	4.37		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611618
25 Jul 1991

CENTROIDAL DISTANCES

Ø TO	1	.330829
1 TO	2	.244205
1 TO	3	.328933
1 TO	4	.443353
1 TO	5	.299446

194 K----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0582
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0536
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0791214

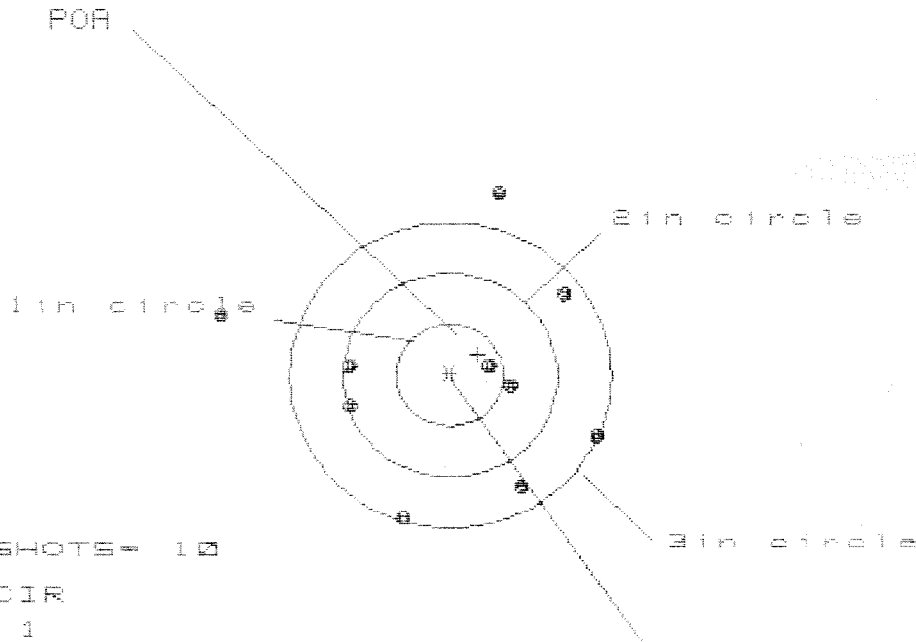
THE AMR FOR THIS RIFLE IS: .9714

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/26611610

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.488

VS= 3.180

GS= 3.676

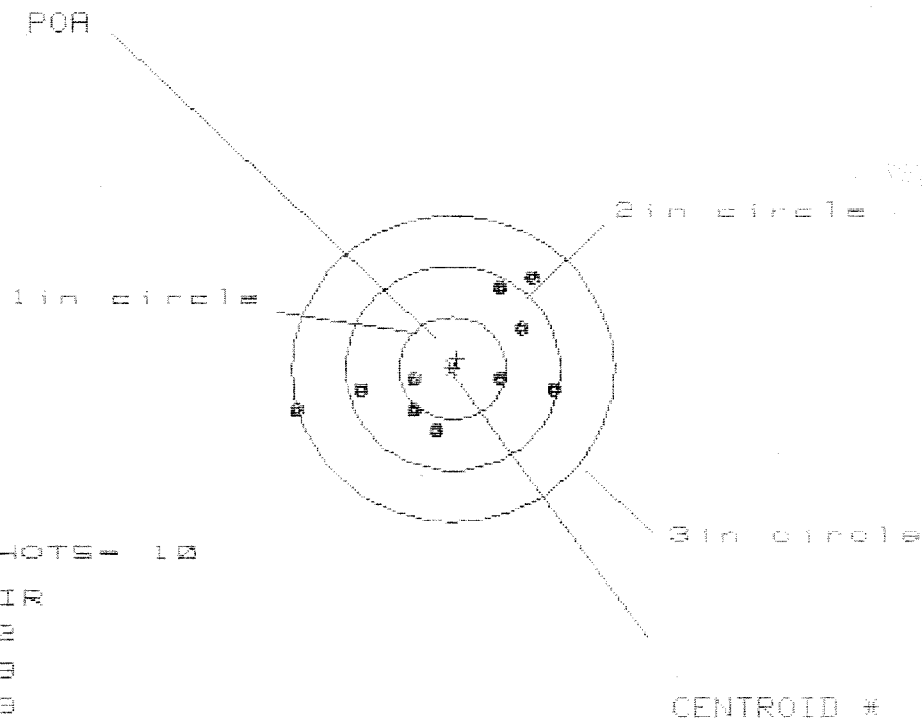
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.350	1.112	1.141
MINIMUM X	:	-2.138	-1.221	-1.192
MAXIMUM Y	:	1.786	1.852	1.130
MINIMUM Y	:	-1.394	-1.328	-1.096
CENTROID X	:	-.262	-.024	-.053
CENTROID Y	:	-.202	-.268	-.500
POA TO CENTROID in.	:	.331	.269	.503
MIN RADIUS	:	.403	.220	.429
MEAN RADIUS	:	1.264	1.107	1.013
MAX RADIUS	:	2.220	1.866	1.427
HORIZONTAL SPREAD	:	3.488	2.333	2.333
VERTICAL SPREAD	:	3.180	3.180	2.226
EXTREME SPREAD	:	3.676	3.314	2.711
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611818

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.387

VS= 1.417

GS= 2.545

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.927	.764	.835
MINIMUM X	-1.470	-.991	-.920
MAXIMUM Y	.851	.803	.881
MINIMUM Y	-.567	-.614	-.514
CENTROID X	-.042	.121	.050
CENTROID Y	-.096	-.048	-.148
POA TO CENTROID in.	.104	.130	.156
MIN RADIUS	.409	.366	.398
MEAN RADIUS	.815	.727	.680
MAX RADIUS	1.532	1.018	.935
HORIZONTAL SPREAD	2.397	1.755	1.755
VERTICAL SPREAD	1.417	1.417	1.395
EXTREME SPREAD	2.545	1.870	1.756
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611618

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 2.269

VS= 2.181

GS= 2.413

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.243	1.160	.897
MINIMUM X	:	-1.026	-1.109	-.965
MAXIMUM Y	:	1.202	.658	.655
MINIMUM Y	:	-.979	-.845	-.848
CENTROID X	:	-.036	.047	-.098
CENTROID Y	:	.037	-.097	-.094
POA TO CENTROID in.	:	.051	.108	.135
MIN RADIUS	:	.163	.223	.232
MEAN RADIUS	:	.734	.654	.565
MAX RADIUS	:	1.417	1.160	1.110
HORIZONTAL SPREAD	:	2.269	2.269	1.861
VERTICAL SPREAD	:	2.181	1.503	1.503
EXTREME SPREAD	:	2.413	2.274	1.936
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811618

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

2in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 5

HS = 2.406

VS = 3.515

GS = 3.524

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.282

1.263

1.209

MINIMUM X

-1.124

-1.143

-1.197

MAXIMUM Y

1.725

1.526

1.320

MINIMUM Y

-1.790

-1.612

-1.421

CENTROID X

.159

.178

.232

CENTROID Y

-.063

.136

-.055

POA TO CENTROID in.

.171

.224

.239

MIN RADIUS

.185

.158

.236

MEAN RADIUS

1.303

1.210

1.182

MAX RADIUS

1.798

1.871

1.740

HORIZONTAL SPREAD

2.406

2.406

2.406

VERTICAL SPREAD

3.515

3.138

2.741

EXTREME SPREAD

3.524

3.277

3.125

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

5

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06511610

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.871

VS = 1.947

GS = 2.220

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.882	.533
MINIMUM X	:	-1.036	-.943	-.842
MAXIMUM Y	:	.988	.882	.579
MINIMUM Y	:	-.959	-.844	-.734
CENTROID X	:	-.110	-.202	-.303
CENTROID Y	:	.056	.163	.053
POA TO CENTROID in.	:	.123	.260	.387
MIN RADIUS	:	.271	.239	.382
MEAN RADIUS	:	.741	.672	.603
MAX RADIUS	:	1.272	1.192	.876
HORIZONTAL SPREAD	:	1.871	1.745	1.375
VERTICAL SPREAD	:	1.947	1.726	1.313
EXTREME SPREAD	:	2.220	1.901	1.434
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	