

C6594507

MODEL 700™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

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

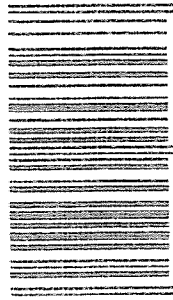
DUPONT
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm

MODEL 700™ M24

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

SERIAL NO. C6594507	ORDER NO. 5716
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UPC



0 47700 25716



5716 C6594507

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594507

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	Rw
600	Proof	1228	90	Rw
607	Check Headspace	1228	90	Rw
610	Dis-assemble Gun	1228	90	Rw
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		(1)	KR
615	Rollmark Caliber		(1)	28
617	Drill and Tap Sight Holes	1 10 91		LB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-26-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	Rw
	C) Inspect Ejector Hole for Chamfer		1/28/91	Rw
	D) Oil Firing Pin Ass'y		1/28/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		2/11/91	JH

op. #	BARBER - M24 0018301 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4			2/11/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/11/91	WB
	H) Trigger Pull Test & Retainability						2/11/91	DL
	I) Firing Pin Indent	.022	.022	.022			2/11/91	WB
	J) Assemble Stock						2/12/91	RW
	K) Assemble Swivel Studs						2-21-91	AC
	L) Attach Front and Rear Sight Assemblies						2/12/91	RW
	M) Iron Sight Alignment						2/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/12/91	RW
	O) Attach Scope to Rifle						2/12/91	RW
		P) Detach & Attach Scope 20 Times						2/12/91
640	Gallery Target * & Test						2-12-91	DH
	A) Time						2-12-91	DH
	B) Malfunctions						2-12-91	DH
	C) Pierced Primers						2-12-91	DH
	D) Optical Clarity of Scope						2-12-91	DH
645	Inspect for Live Ammo						2-12-91	DH
655	Final Inspection							
	A) Headspace						2-21-91	AC
	B) Trigger Pull	2.22	2.27	2.26	2.27	2.26	2/20/91	WB
	C) Function						2-21-91	AC
660	Pack						3-15-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594307

DATE 2/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.13	2.28	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.23	2.21	2.27	
PULL #3	2.36	2.18	2.20	2.26	
PULL #4	2.31	2.21	2.22	2.27	
PULL #5	2.32	2.21	2.22	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.32		
PULL #2	3.38	3.42		
PULL #3	3.35	3.40		
PULL #4	3.17	3.40		
PULL #5	3.40	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.34		4.34
PULL #2	4.49	4.32		4.34
PULL #3	4.48	4.32		4.35
PULL #4	4.45	4.33		4.36
PULL #5	4.44	4.35		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594507
12 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.384948
1 TO	2	.159625
1 TO	3	.587824
1 TO	4	.296056
1 TO	5	.421475

3
3.4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0094
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .239584
THE AMR FOR THIS RIFLE IS: .8354

12 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08534587

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.597

VS = 1.452

GS = 2.686

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.206	1.051	1.134
MINIMUM X	-1.391	-1.298	-1.166
MAXIMUM Y	.490	.468	.504
MINIMUM Y	-.963	-.984	-.926
CENTROID X	.384	.539	.407
CENTROID Y	.027	.049	-.009
POA TO CENTROID in.	.385	.541	.407
MIN RADIUS	.331	.440	.315
MEAN RADIUS	.918	.845	.807
MAX RADIUS	1.405	1.318	1.202
HORIZONTAL SPREAD	2.597	2.349	2.300
VERTICAL SPREAD	1.452	1.452	1.430
EXTREME SPREAD	2.686	2.361	2.308
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

12 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594507

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.392

VS = 2.701

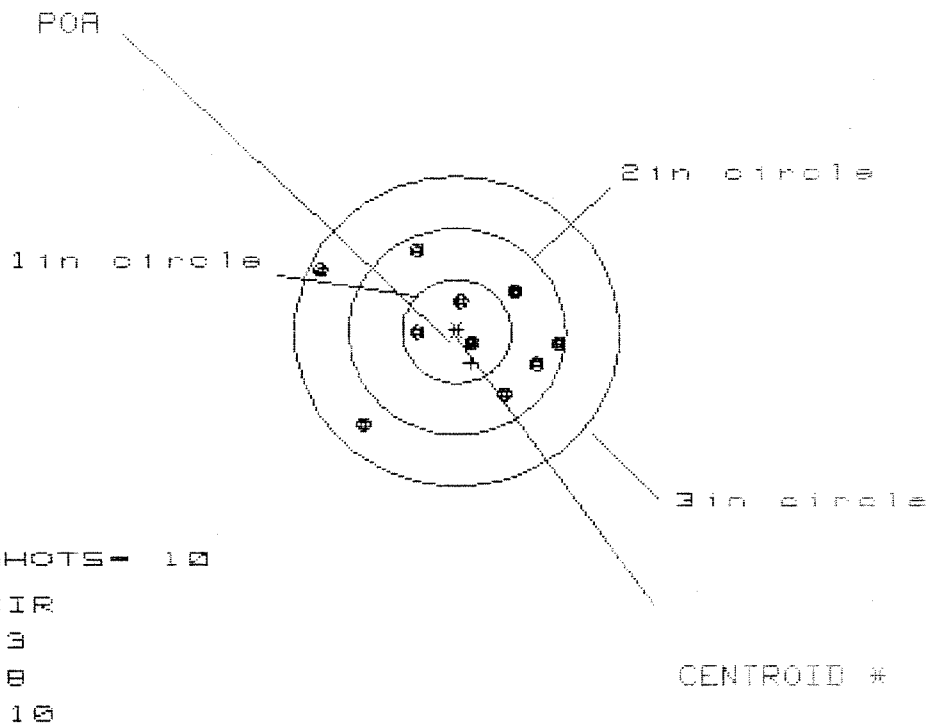
GS = 2.713

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.646	.640	.546
MINIMUM X	:	-.746	-.752	-.418
MAXIMUM Y	:	1.148	.976	1.082
MINIMUM Y	:	-1.553	-1.050	-.944
CENTROID X	:	.286	.292	.386
CENTROID Y	:	-.099	.073	-.033
POA TO CENTROID in.	:	.303	.301	.388
MIN RADIUS	:	.191	.237	.120
MEAN RADIUS	:	.815	.722	.645
MAX RADIUS	:	1.554	1.222	1.156
HORIZONTAL SPREAD	:	1.392	1.392	.964
VERTICAL SPREAD	:	2.701	2.026	2.026
EXTREME SPREAD	:	2.713	2.346	2.230
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06594507

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 2.229

VS = 1.731

GS = 2.337

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.983	.844	.715
MINIMUM X	-1.246	-1.038	-.672
MAXIMUM Y	.817	.880	.774
MINIMUM Y	-.914	-.851	-.612
CENTROID X	-.135	.004	.133
CENTROID Y	.303	.240	.346
POA TO CENTROID in.	.332	.240	.371
MIN RADIUS	.191	.051	.191
MEAN RADIUS	.759	.664	.572
MAX RADIUS	1.371	1.342	.990
HORIZONTAL SPREAD	2.229	1.882	1.387
VERTICAL SPREAD	1.731	1.731	1.386
EXTREME SPREAD	2.337	2.038	1.635
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8594507

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 2.603

VS = 2.545

GS = 2.738

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.773	1.419	1.353
MINIMUM X	:	-.830	-.633	-.699
MAXIMUM Y	:	1.373	1.399	.924
MINIMUM Y	:	-1.172	-1.146	-.971
CENTROID X	:	.649	.452	.518
CENTROID Y	:	-.105	-.131	-.306
POA TO CENTROID in.	:	.658	.471	.602
MIN RADIUS	:	.526	.419	.313
MEAN RADIUS	:	1.023	.904	.797
MAX RADIUS	:	1.789	1.494	1.426
HORIZONTAL SPREAD	:	2.603	2.052	2.052
VERTICAL SPREAD	:	2.545	2.545	1.895
EXTREME SPREAD	:	2.738	2.660	2.101
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	

BARBER - M24 0018308

NUMBER IN THREE INCH CIRCLE =

8

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

BARBER - M24 0018308 **M24 0018347**

12 Feb 1991

FILE: /PATTERNING/CENTERFIRE_PATT/06534507

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 9

HS= 2.002

VS= 1.793

GS= 2.303

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.871	.745	.538
MINIMUM X	-1.132	-.718	-.625
MAXIMUM Y	.712	.592	.584
MINIMUM Y	-1.081	-.652	-.660
CENTROID X	.013	.139	.046
CENTROID Y	-.173	-.053	-.045
POA TO CENTROID in.	.174	.149	.065
MIN RADIUS	.170	.165	.095
MEAN RADIUS	.662	.539	.503
MAX RADIUS	1.565	.826	.742
HORIZONTAL SPREAD	2.002	1.463	1.163
VERTICAL SPREAD	1.793	1.244	1.244
EXTREME SPREAD	2.303	1.537	1.449
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	