C652481

MODEL 700 TH M24

Model 5MG TH

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ M24

SERIAL NO.
C6523481

ORDER NO.
5716

01

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

5716 C6523481

UPC

0 47700 25716 7

M-24

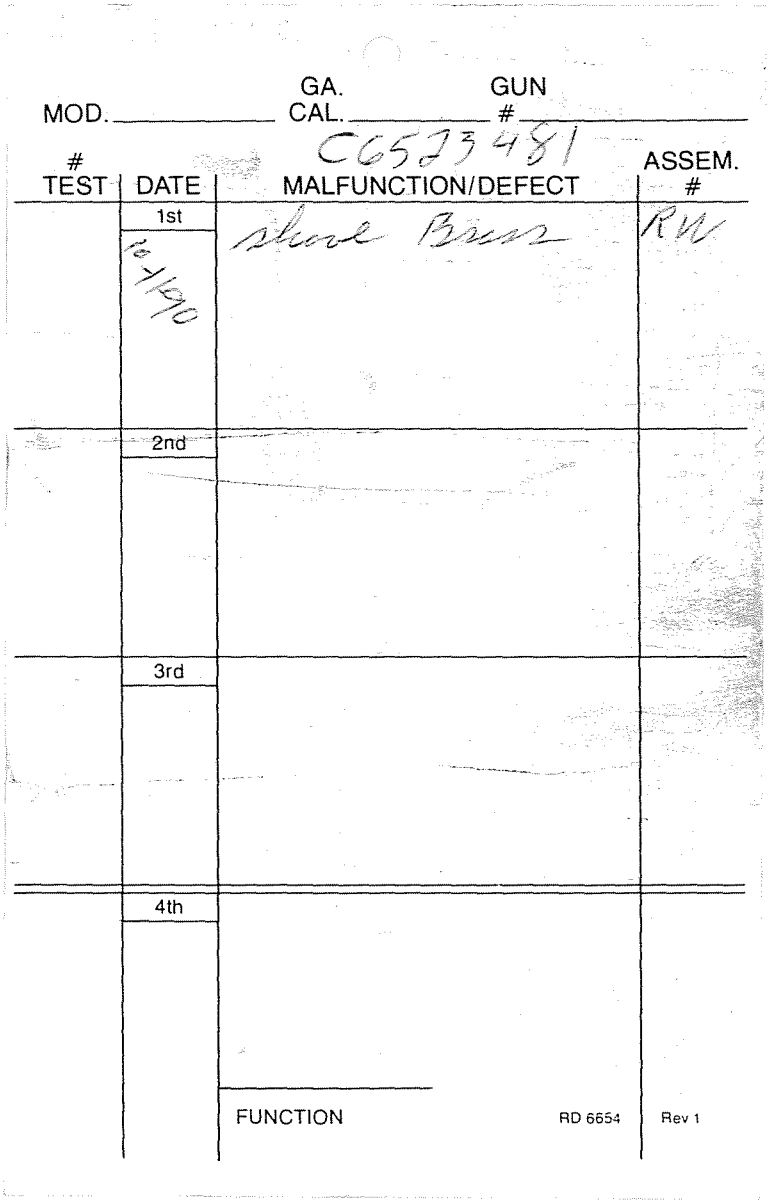
CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523481

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	GS
617	Drill and Tap Sight Holes		9/28/90	FB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/9/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			10/9/90	WB
	H) Trigger Pull Test & Retainability						10/9/90	WB
	I) Firing Pin Indent	.072	.0715	.0715			10/9/90	WB
	J) Assemble Stock						10/9/90	RW
	K) Assemble Swivel Studs						11/19/90	RW
	L) Attach Front and Rear Sight Assemblies						10/9/90	RW
	M) Iron Sight Alignment						10/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/90	RW
	O) Attach Scope to Rifle						10/9/90	RW
	P) Detach & Attach Scope 20 Times						10/9/90	RW
640	Gallery Target & Test						10-11-90	AC
	A) Time						10-11-90	AC
	B) Malfunctions						10-11-90	AC
	C) Pierced Primers						10-11-90	AC
	D) Optical Clearity of Scope						10-11-90	AC
645	Inspect for Live Ammo						10-11-90	AC
655	Final Inspection A) Headspace						11/19/90	RW
	B) Trigger Pull	202	202	200	205	202	11/19/90	RW
	C) Function	2.50	2.48	2.52	2.48	2.42	11/19/90	RW
660	Pack						12-17-90	DH

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF TEST TGT	Ream Ejector Hole & polish Ejector	RW 10/30/90
PROOF 10-26 TEST TGT	Short OT 190 RL DH	
PROOF TEST TGT	ENGINEER	
PROOF TEST TGT	ENGINEER	



MOD. _____ GA. _____ CAL. _____ GUN # C6523481

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shoot Burn	RW
	2nd		
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523481

DATE 10-9-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.27	2.02	MIN. SETTING,
PULL #2	2.51	2.39	2.31	207	NO AVG. OF 5
PULL #3	2.43	2.41	2.40	200	READINGS ACCEPT-
PULL #4	2.52	2.34	2.33	205	ABLE LESS THAN 2#
PULL #5	2.43	2.16	2.35	202	
TOTAL	12.30	11.69	11.66		
AVG.	2.46	2.338	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.48		
PULL #2	3.45	3.46		
PULL #3	3.41	3.48		
PULL #4	3.50	3.51		
PULL #5	3.49	3.50		
TOTAL	17.38	17.43		
AVG.	3.476	3.48		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.20		4.19
PULL #2	4.12	4.17		4.18
PULL #3	4.11	4.18		4.18
PULL #4	4.09	4.17		4.16
PULL #5	4.07	4.20		4.19
TOTAL	20.49	20.92		20.90
AVG.	4.10	4.18		4.18

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523481
12 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.101912
1	TO	2	.400065
1	TO	3	.347973
1	TO	4	.215539
1	TO	5	.331694

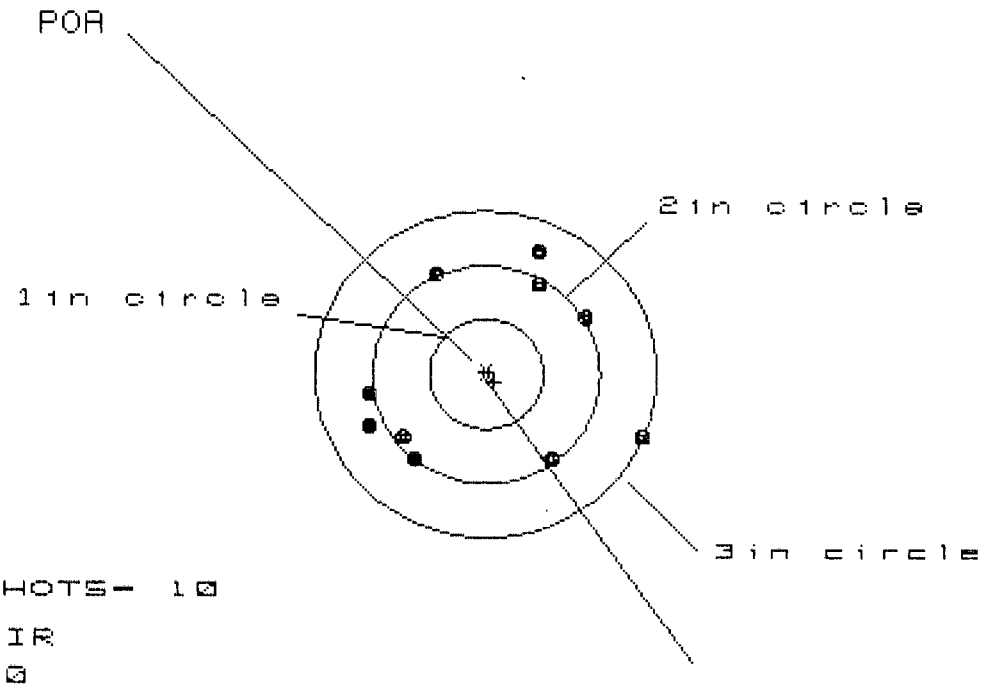
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0276
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148389

THE AMR FOR THIS RIFLE IS: 1.024

12 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523481

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 3
3in = 9
HS= 2.437
VS= 1.876
GS= 2.439

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.392	.992	1.069
MINIMUM X	:	-1.045	-.890	-.814
MAXIMUM Y	:	1.088	1.024	1.017
MINIMUM Y	:	-.788	-.852	-.724
CENTROID X	:	-.069	-.224	-.301
CENTROID Y	:	.075	.139	.011
POA TO CENTROID in.	:	.102	.264	.301
MIN RADIUS	:	.927	.872	.741
MEAN RADIUS	:	1.070	1.006	.960
MAX RADIUS	:	1.507	1.193	1.238
HORIZONTAL SPREAD	:	2.437	1.882	1.882
VERTICAL SPREAD	:	1.876	1.876	1.741
EXTREME SPREAD	:	2.439	2.166	2.146
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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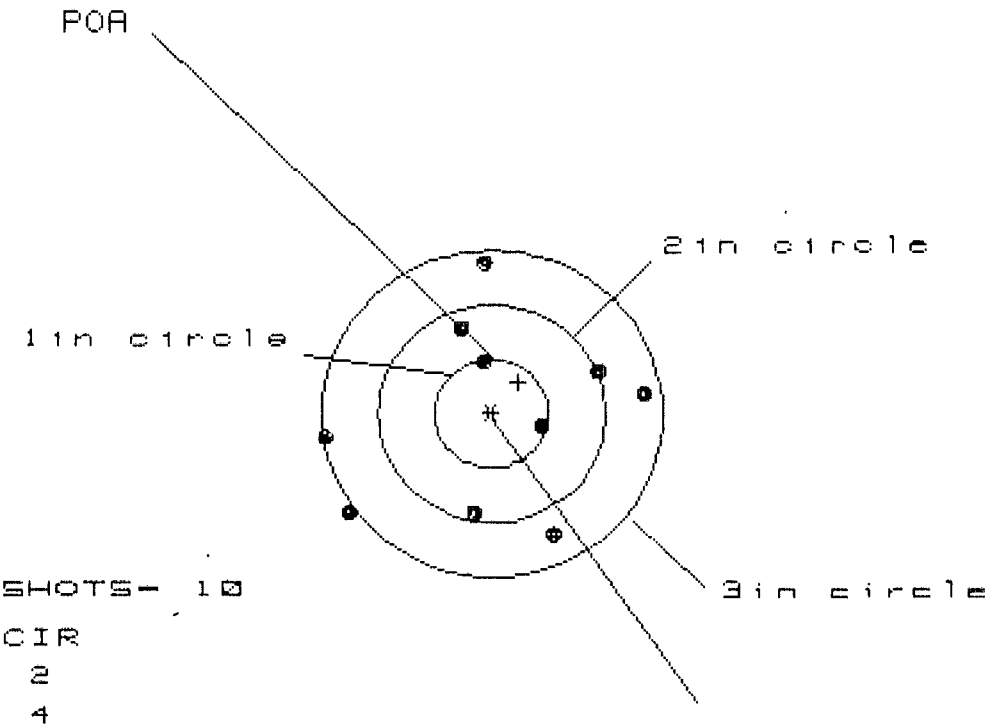
CENTERFIRE PATTERNS # 2

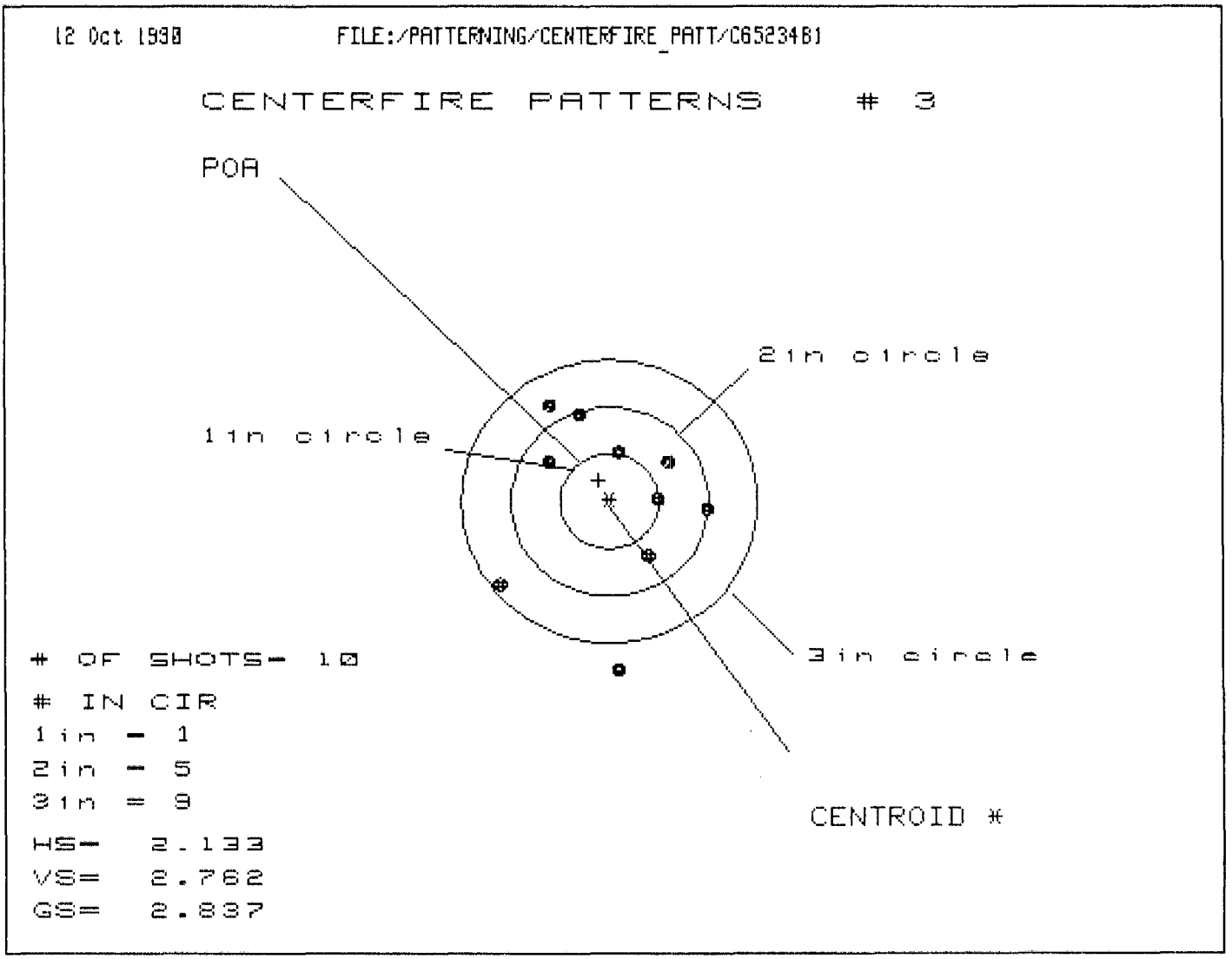


OF SHOTS= 10

# IN CIR
1in = 2
2in = 4
3in = 9

HS= 2.787
VS= 2.428
GS= 2.842

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.352	1.211	1.014
MINIMUM X	:	-1.435	-1.576	-.576
MAXIMUM Y	:	1.349	1.251	1.210
MINIMUM Y	:	-1.079	-1.177	-1.218
CENTROID X	:	-.235	-.094	.103
CENTROID Y	:	-.289	-.191	-.150
POA TO CENTROID in.	:	.373	.213	.182
MIN RADIUS	:	.418	.316	.216
MEAN RADIUS	:	1.053	.969	.862
MAX RADIUS	:	1.548	1.611	1.263
HORIZONTAL SPREAD	:	2.787	2.787	1.590
VERTICAL SPREAD	:	2.428	2.428	2.428
EXTREME SPREAD	:	2.842	2.822	2.483
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.019	1.026	.888
MINIMUM X	:	-1.114	-1.107	-.744
MAXIMUM Y	:	.975	.777	.647
MINIMUM Y	:	-1.787	-1.033	-.916
CENTROID X	:	.109	.102	.240
CENTROID Y	:	-.224	-.026	.103
POA TO CENTROID in.	:	.249	.105	.262
MIN RADIUS	:	.493	.300	.170
MEAN RADIUS	:	.952	.818	.690
MAX RADIUS	:	1.788	1.514	.962
HORIZONTAL SPREAD	:	2.133	2.133	1.632
VERTICAL SPREAD	:	2.762	1.810	1.564
EXTREME SPREAD	:	2.837	2.277	1.893
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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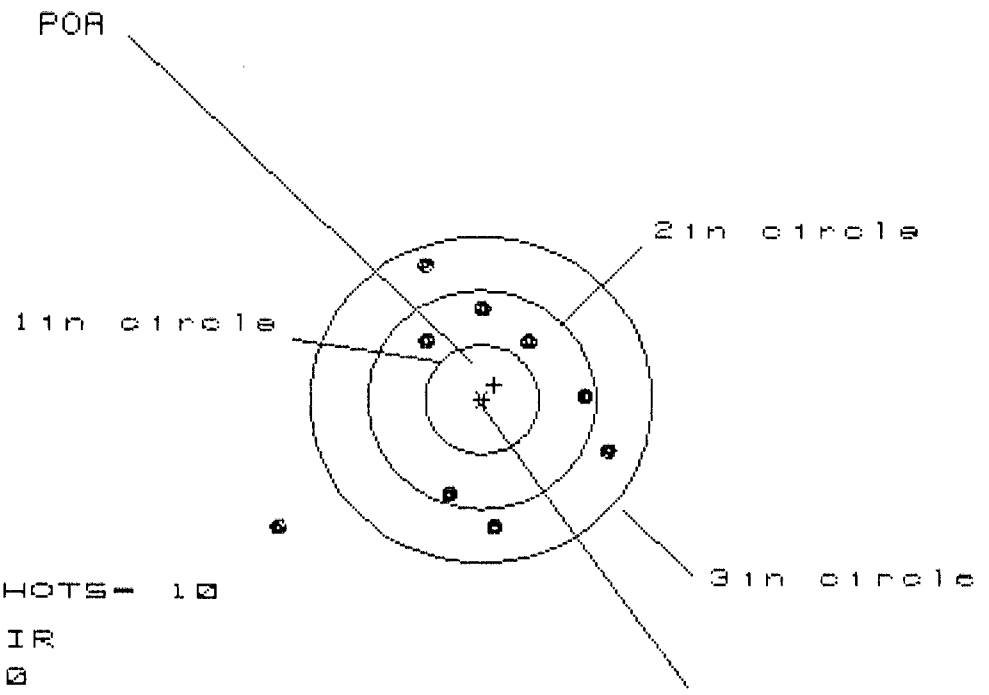
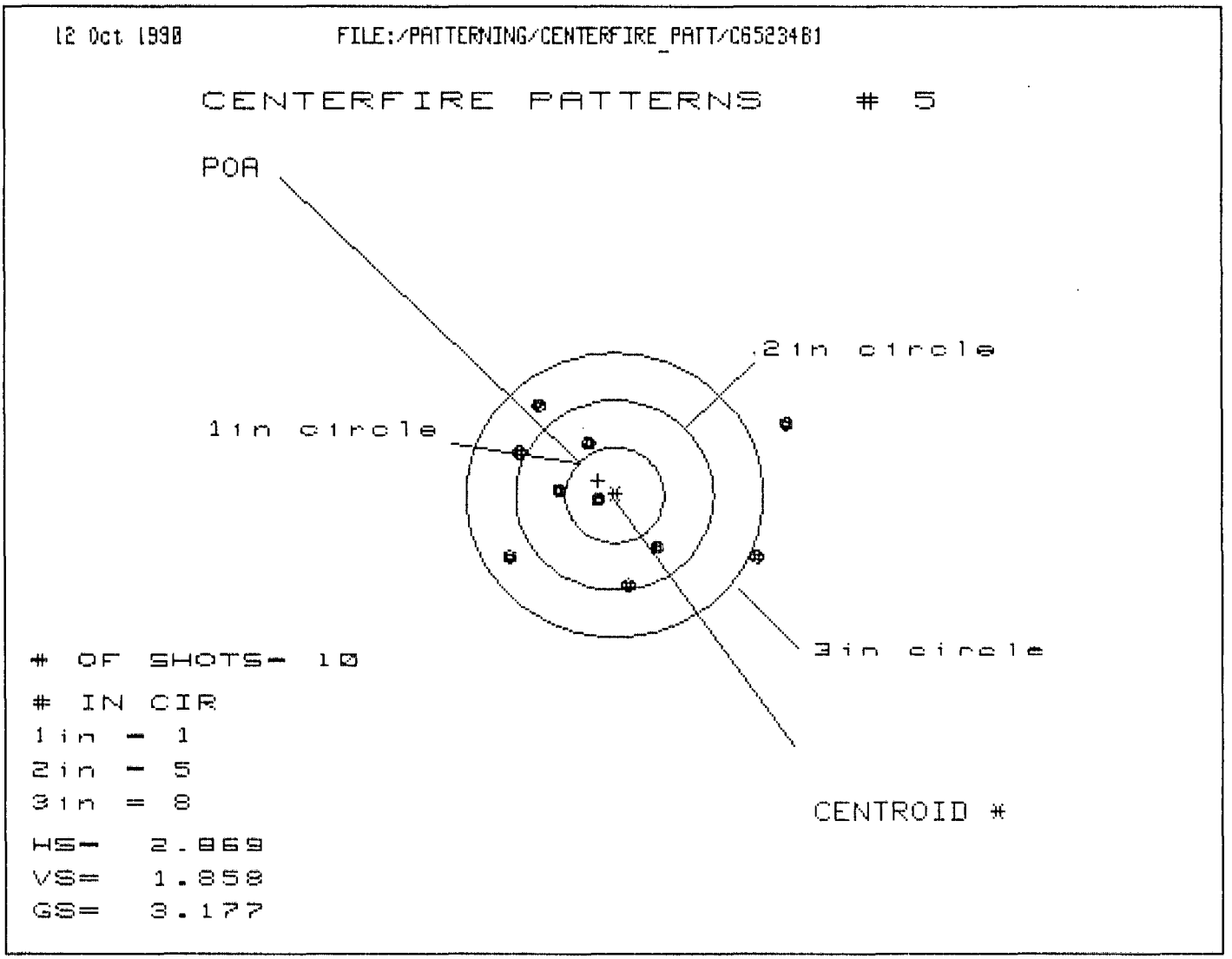
CENTERFIRE PATTERNS # 4



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 6
3in = 9
HS= 2.864
VS= 2.414
GS= 2.954

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	.915	.827
MINIMUM X	:	-1.754	-.708	-.776
MAXIMUM Y	:	1.209	1.082	.851
MINIMUM Y	:	-1.205	-1.332	-1.197
CENTROID X	:	-.113	.082	.171
CENTROID Y	:	-.136	-.009	-.144
POA TO CENTROID in.	:	.177	.083	.223
MIN RADIUS	:	.649	.430	.518
MEAN RADIUS	:	1.053	.883	.836
MAX RADIUS	:	2.093	1.335	1.211
HORIZONTAL SPREAD	:	2.864	1.623	1.603
VERTICAL SPREAD	:	2.414	2.414	2.048
EXTREME SPREAD	:	2.954	2.491	2.049
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.774	1.610	.842
MINIMUM X	:	-1.095	-.898	-.696
MAXIMUM Y	:	.923	1.008	.944
MINIMUM Y	:	-.935	-.850	-.914
CENTROID X	:	.170	-.027	-.229
CENTROID Y	:	-.155	-.240	-.176
POA TO CENTROID in.	:	.230	.241	.288
MIN RADIUS	:	.144	.074	.156
MEAN RADIUS	:	.992	.844	.715
MAX RADIUS	:	1.932	1.690	1.042
HORIZONTAL SPREAD	:	2.869	2.508	1.538
VERTICAL SPREAD	:	1.858	1.858	1.858
EXTREME SPREAD	:	3.177	2.628	2.036
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	