

C6611601

MODEL 700™ M24

Model **5145**™

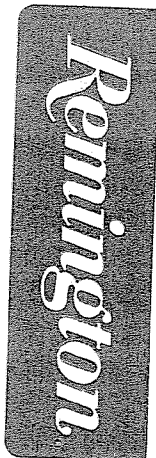
Action _____

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.



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

MODEL 700™ H24

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

SERIAL NO.
C6611601

ORDER NO.
5716

46

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



5716 C6611601

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611601

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	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	EB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/15/91	JA

op. #	BARBER - M24 0079442 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/15/91	JK
	G) Safety Off Force	3	3	3			4/15/91	JK
	H) Trigger Pull Test & Retainability						4/15/91	JK
	I) Firing Pin Indent	.0215	.0215	.0215			4/15/91	JK
	J) Assemble Stock						4/17/91	KS
	K) Assemble Swivel Studs						5-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/17/91	KS
	M) Iron Sight Alignment						4/17/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	KS
	O) Attach Scope to Rifle						4/17/91	KS
	P) Detach & Attach Scope 20 Times						4/17/91	KS
640	Gallery Target & Test						4-18-91	DH
	A) Time						4-18-91	AC
	B) Malfunctions						4-18-91	AC
	C) Pierced Primers						4-18-91	AC
	D) Optical Clarity of Scope						4-18-91	AC
645	Inspect for Live Ammo						4-18-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.58	2.59	2.60	2.62	2.62	4/22/91	JK
	C) Function						5-2-91	DH
660	Pack						6-18-91	AC

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

SERIAL NO. C6611601
DATE 4/15/91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.31	2.28	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.22	2.30	2.59	
PULL #3	2.30	2.22	2.25	2.60	
PULL #4	2.28	2.23	2.29	2.62	
PULL #5	2.24	2.31	2.33	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.12		
PULL #2	3.26	3.49		
PULL #3	3.28	3.59		
PULL #4	3.17	3.25		
PULL #5	3.22	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.31		4.41
PULL #2	4.63	4.23		4.38
PULL #3	4.58	4.20		4.27
PULL #4	4.29	4.26		4.41
PULL #5	4.40	4.27		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611601
18 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0355106
1 TO	2	.344449
1 TO	3	.676512
1 TO	4	.248871
1 TO	5	.257529

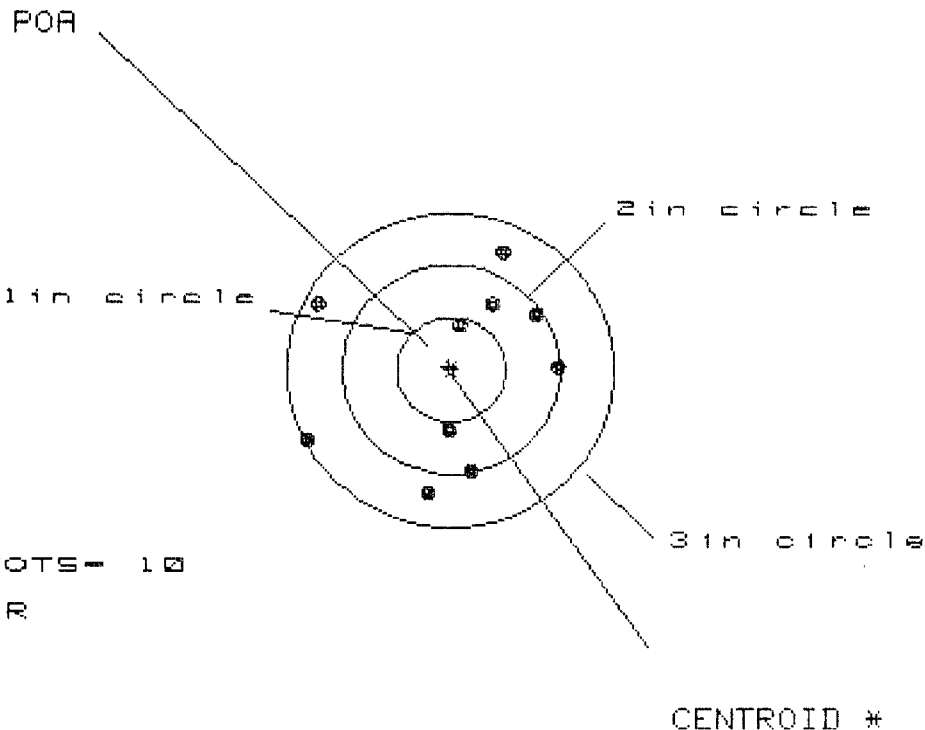
$\pm \sigma$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3132
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .318562
THE AMR FOR THIS RIFLE IS: 1.132

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611681

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.334

VS= 2.375

GS= 2.579

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.831	.655
MINIMUM X	:	-1.352	-1.409	-.508
MAXIMUM Y	:	1.177	1.104	1.178
MINIMUM Y	:	-1.198	-1.271	-1.197
CENTROID X	:	.019	.170	.346
CENTROID Y	:	-.030	.043	-.031
POA TO CENTROID in.	:	.036	.175	.347
MIN RADIUS	:	.415	.345	.482
MEAN RADIUS	:	.992	.905	.812
MAX RADIUS	:	1.503	1.528	1.300
HORIZONTAL SPREAD	:	2.334	2.240	1.163
VERTICAL SPREAD	:	2.375	2.375	2.375
EXTREME SPREAD	:	2.579	2.461	2.461
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611601

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.214

VS = 2.870

GS = 3.000

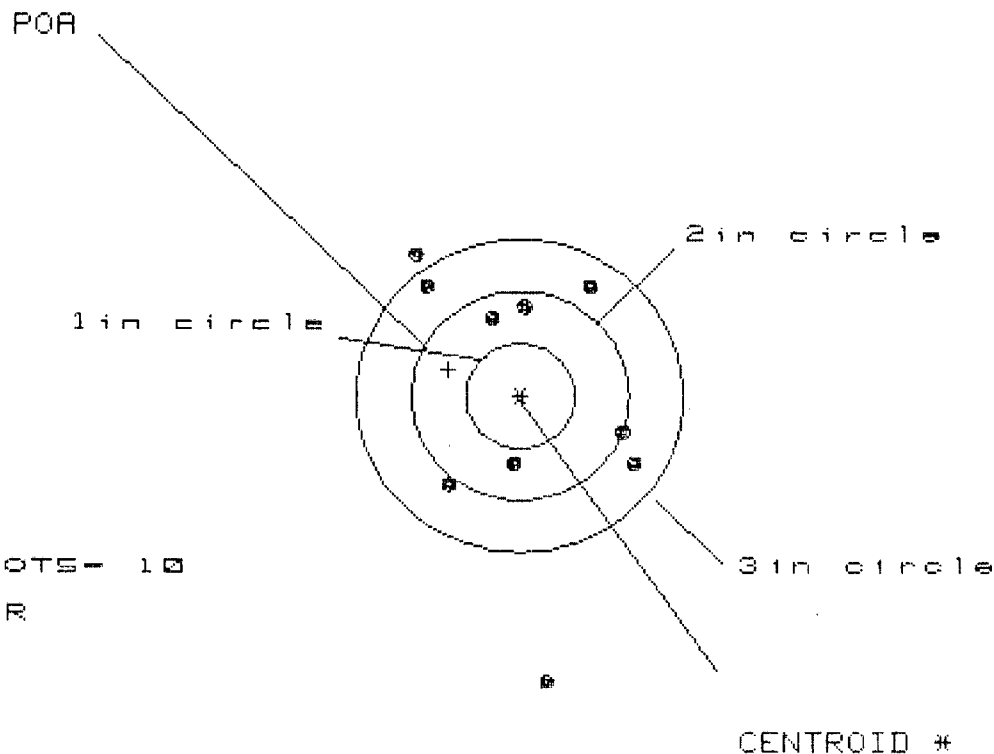
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	.735	.711
MINIMUM X	:	-1.011	-.878	-.902
MAXIMUM Y	:	1.483	1.602	1.409
MINIMUM Y	:	-1.387	-1.268	-1.067
CENTROID X	:	.361	.228	.252
CENTROID Y	:	.011	-.109	-.310
POA TO CENTROID in.	:	.362	.253	.399
MIN RADIUS	:	.445	.472	.392
MEAN RADIUS	:	1.121	1.047	.952
MAX RADIUS	:	1.616	1.614	1.578
HORIZONTAL SPREAD	:	2.214	1.613	1.613
VERTICAL SPREAD	:	2.870	2.870	2.476
EXTREME SPREAD	:	3.000	3.000	2.477
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611601

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 1.998

VS= 4.122

GS= 4.280

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.044
MINIMUM X	-.954
MAXIMUM Y	1.391
MINIMUM Y	-2.731
CENTROID X	.657
CENTROID Y	-.255
POA TO CENTROID in.	.705
MIN RADIUS	.618
MEAN RADIUS	1.266
MAX RADIUS	2.738
HORIZONTAL SPREAD	1.998
VERTICAL SPREAD	4.122
EXTREME SPREAD	4.280
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	8

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611681

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 2.388

VS= 2.398

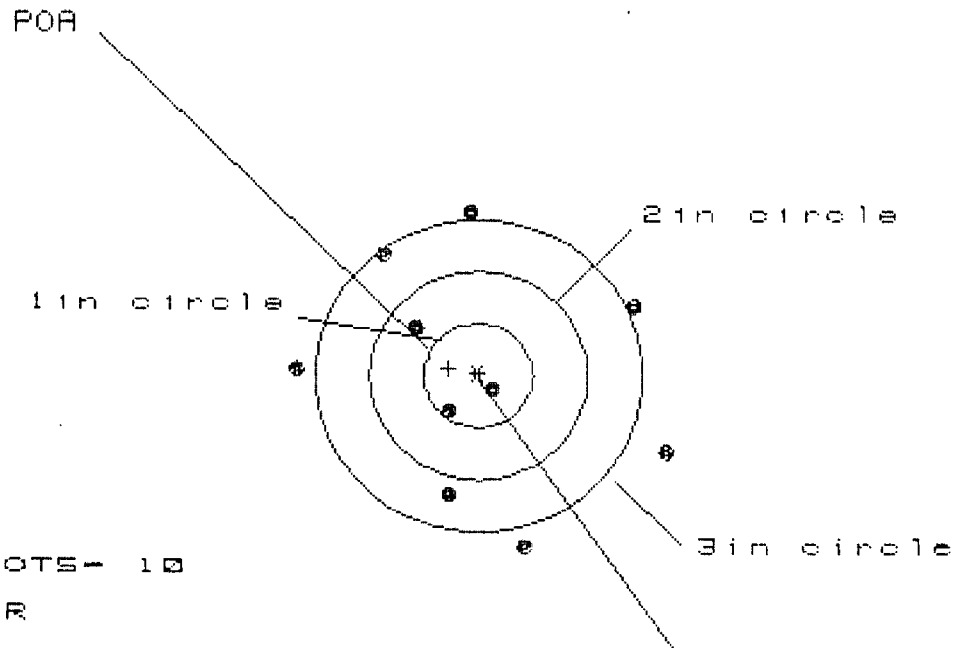
GS= 2.922

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.596	1.053
MINIMUM X	:	-.925	-.792	-.593
MAXIMUM Y	:	1.446	1.217	1.256
MINIMUM Y	:	-.952	-.792	-.754
CENTROID X	:	.255	.122	-.077
CENTROID Y	:	.049	-.111	-.150
POA TO CENTROID in.	:	.260	.165	.168
MIN RADIUS	:	.610	.540	.398
MEAN RADIUS	:	1.056	.920	.791
MAX RADIUS	:	1.875	1.625	1.306
HORIZONTAL SPREAD	:	2.388	2.388	1.646
VERTICAL SPREAD	:	2.398	2.009	2.009
EXTREME SPREAD	:	2.922	2.492	2.191
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611601

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.401

VS= 3.149

GS= 3.505

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.757	1.579	1.398
MINIMUM X	:	-1.644	-1.449	-.833
MAXIMUM Y	:	1.559	1.477	1.479
MINIMUM Y	:	-1.590	-1.672	-1.670
CENTROID X	:	.274	.079	.260
CENTROID Y	:	-.066	.016	.014
POA TO CENTROID in.	:	.282	.080	.260
MIN RADIUS	:	.183	.372	.262
MEAN RADIUS	:	1.223	1.134	1.093
MAX RADIUS	:	1.908	1.783	1.726
HORIZONTAL SPREAD	:	3.401	3.028	2.231
VERTICAL SPREAD	:	3.149	3.149	3.149
EXTREME SPREAD	:	3.505	3.194	3.194
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	