C6523380

MODEL 700™ M24

Model 5HS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

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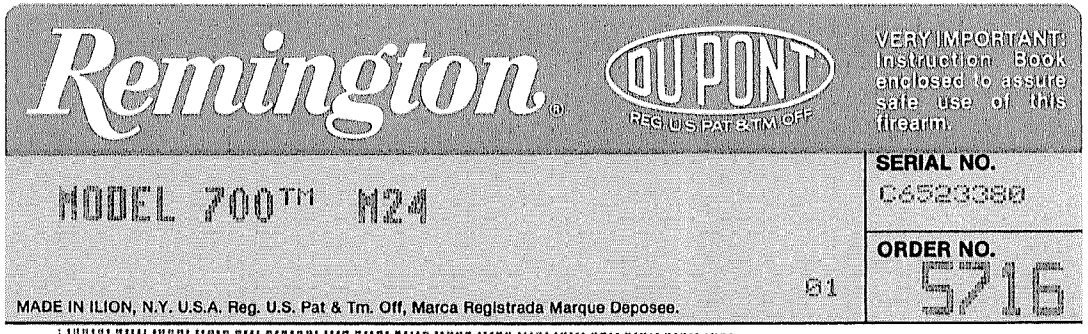

5716 C6523380

UPC

0 47700 25716 7

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M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523380

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9		RW
612	Magnaflux Barrel Action		9-25-90	RR
	Magnaflux Bolt		9-25-90	RR
615	Rollmark Caliber	9-25-90		
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel WB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TA
	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		10/12/90	

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op. #	OP. NAME	READINGS			DATE	INIT
635 nt.	F) Safety On Force	4 3/4	4 3/4	4 3/4	10/12/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2	10/12/90	WB
	H) Trigger Pull Test & Retainability				10/12/90	JH
	I) Firing Pin Indent	.022	.022-5	.022	10/12/90	WB
	J) Assemble Stock				10/10/90	RW
	K) Assemble Swivel Studs				2N6/90	GS
	L) Attach Front and Rear Sight Assemblies				10/12/90	RW
	M) Iron Sight Alignment				10/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container				10/12/90	RW
	O) Attach Scope to Rifle				10/13/90	GS
	P) Detach & Attach Scope 20 Times				10/13/90	GS
640	Gallery Target & Test				10-16-90	KT
	A) Time				10-16-90	KT
	B) Malfunctions				10-16-90	KT
	C) Pierced Primers				10-16-90	KT
	D) Optical Clearity of Scope				10-16-90	KT
645	Inspect for Live Ammo				10-16-90	KT
655	Final Inspection A) Headspace				2N8/90	GS
	B) Trigger Pull	222 216	222	227 211	2N8/90	GS
	C) Function				2N8/90	GS
660	Pack				12/14/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523380

DATE 10-12-90

TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.30	2.40	2.22	MIN. SETTING,
PULL #2	2.41	2.52	2.38	2.10	NO AVG. OF 5
PULL #3	2.36	2.40	2.45	2.22	READINGS ACCEPT-
PULL #4	2.38	2.34	2.34	2.27	ABLE LESS THAN 2#
PULL #5	2.23	2.42	2.30	2.11	
TOTAL	11.82	11.98	11.87		
AVG.	2.364	2.396	2.374		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.31		
PULL #2	3.30	3.54		
PULL #3	3.15	3.43		
PULL #4	3.36	3.26		
PULL #5	3.52	3.25		
TOTAL	16.9	16.79		
AVG.	3.38	3.358		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.29		4.23
PULL #2	4.47	4.45		4.40
PULL #3	4.25	4.50		4.43
PULL #4	4.35	4.46		4.37
PULL #5	4.50	4.52		4.19
TOTAL	21.98	22.22		21.62
AVG.	4.396	4.444		4.324

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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523380
17 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.0514782
1	TO	2	.187883
1	TO	3	.342348
1	TO	4	.109238
1	TO	5	.13324

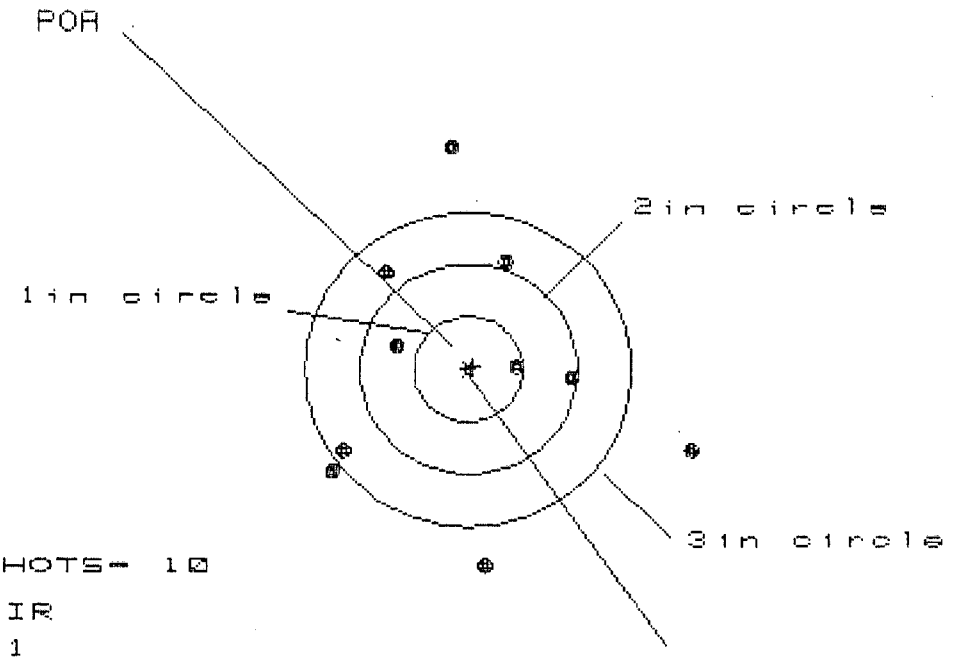
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0414082

THE AMR FOR THIS RIFLE IS: 1.062

17 Oct 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6523380

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR	
1in	= 1
2in	= 3
3in	= 6

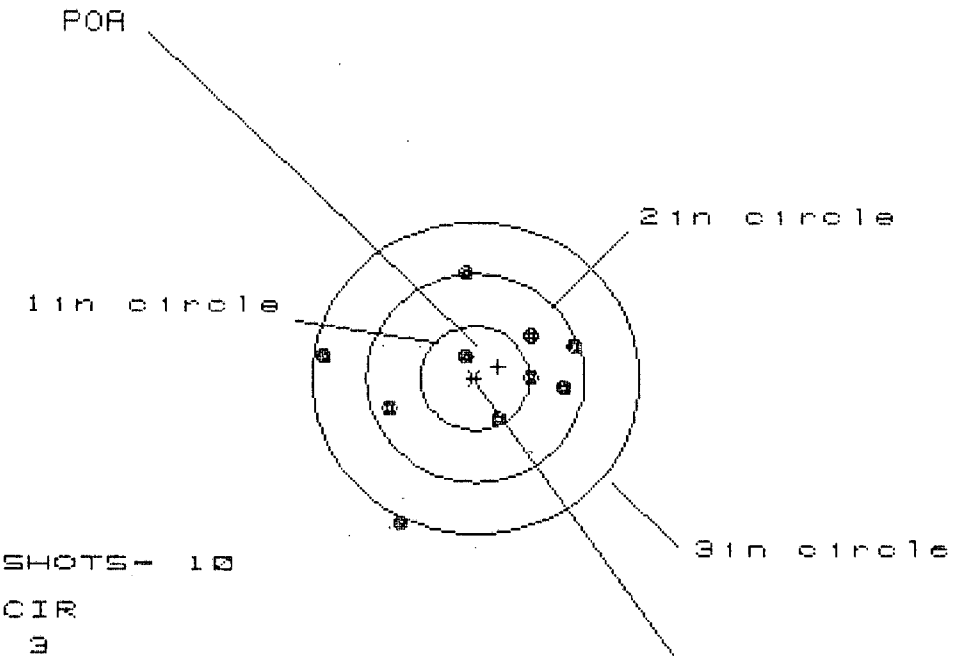
HS= 3.254
VS= 4.039
GS= 4.051

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.026	1.179	1.188
MINIMUM X	:	-1.228	-1.003	-.994
MAXIMUM Y	:	2.139	2.053	1.239
MINIMUM Y	:	-1.900	-1.986	-1.729
CENTROID X	:	-.045	-.270	-.279
CENTROID Y	:	-.025	.061	-.196
POA TO CENTROID in.	:	.051	.277	.341
MIN RADIUS	:	.450	.502	.626
MEAN RADIUS	:	1.357	1.248	1.149
MAX RADIUS	:	2.167	2.055	1.773
HORIZONTAL SPREAD	:	3.254	2.182	2.182
VERTICAL SPREAD	:	4.039	4.039	2.968
EXTREME SPREAD	:	4.051	4.051	2.979

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 3
NUMBER IN THREE INCH CIRCLE = 6

17 Oct 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6523380

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

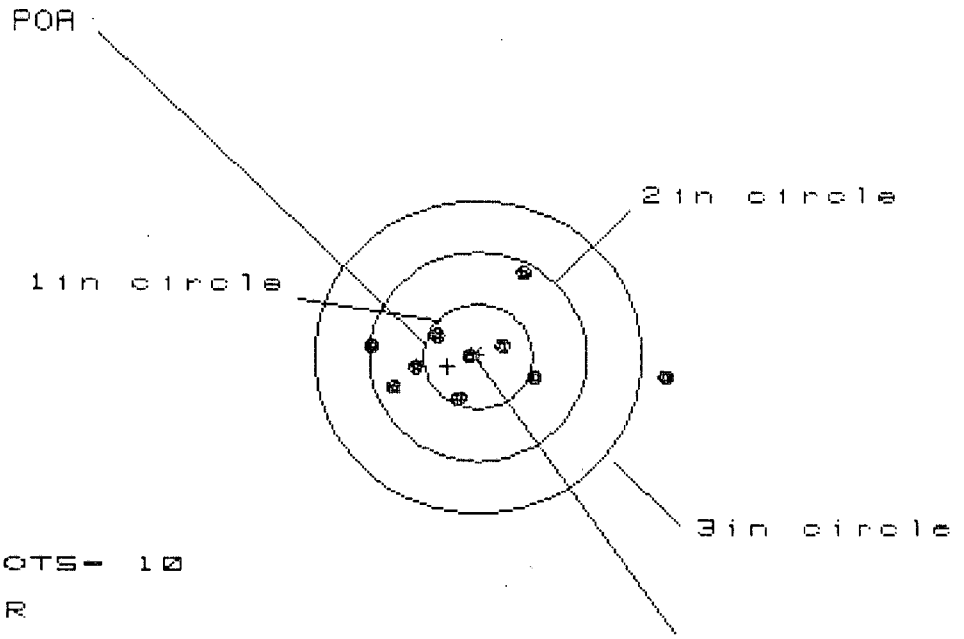
# IN CIR
1in = 3
2in = 7
3in = 9

HS= 2.236
VS= 2.450
GS= 2.521

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.825	.649
MINIMUM X	:	-1.339	-1.411	-1.067
MAXIMUM Y	:	1.028	.870	.883
MINIMUM Y	:	-1.422	-.499	-.486
CENTROID X	:	-.211	-.139	.037
CENTROID Y	:	-.113	.045	.032
POA TO CENTROID in.	:	.239	.146	.049
MIN RADIUS	:	.186	.121	.253
MEAN RADIUS	:	.827	.715	.590
MAX RADIUS	:	1.561	1.414	1.161
HORIZONTAL SPREAD	:	2.236	2.236	1.716
VERTICAL SPREAD	:	2.450	1.369	1.369
EXTREME SPREAD	:	2.521	2.236	1.812
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523380

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 4
2in = 8
3in = 9

HS= 2.728
VS= 1.214
GS= 2.746

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.711	.702	.599
MINIMUM X	:	-1.017	-.827	-.687
MAXIMUM Y	:	.835	.811	.822
MINIMUM Y	:	-.379	-.403	-.392
CENTROID X	:	.276	.086	.189
CENTROID Y	:	.094	.118	.107
POA TO CENTROID in.	:	.292	.146	.218
MIN RADIUS	:	.053	.168	.075
MEAN RADIUS	:	.676	.544	.497
MAX RADIUS	:	1.724	1.038	.985
HORIZONTAL SPREAD	:	2.728	1.529	1.286
VERTICAL SPREAD	:	1.214	1.214	1.214
EXTREME SPREAD	:	2.746	1.681	1.681
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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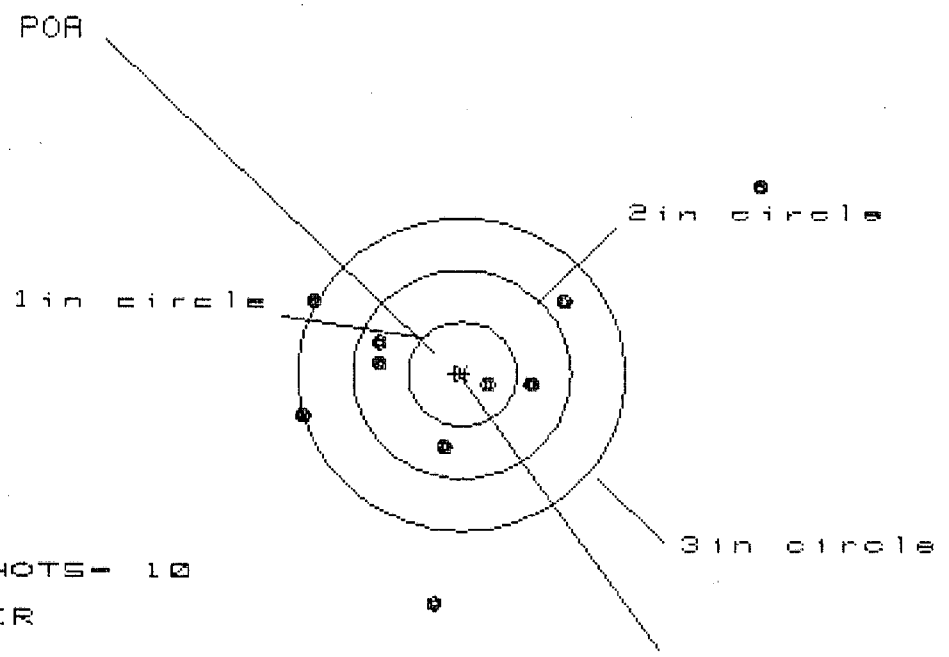
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 7

HS= 4.211
VS= 3.991
GS= 5.033

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.769	1.293	1.294
MINIMUM X	:	-1.442	-1.134	-1.133
MAXIMUM Y	:	1.765	.947	.694
MINIMUM Y	:	-2.226	-2.030	-.802
CENTROID X	:	.062	-.246	-.247
CENTROID Y	:	-.003	-.199	.054
POA TO CENTROID in.	:	.062	.317	.253
MIN RADIUS	:	.263	.541	.444
MEAN RADIUS	:	1.302	1.049	.902
MAX RADIUS	:	3.284	2.030	1.468
HORIZONTAL SPREAD	:	4.211	2.427	2.427
VERTICAL SPREAD	:	3.991	2.977	1.496
EXTREME SPREAD	:	5.033	3.241	2.700
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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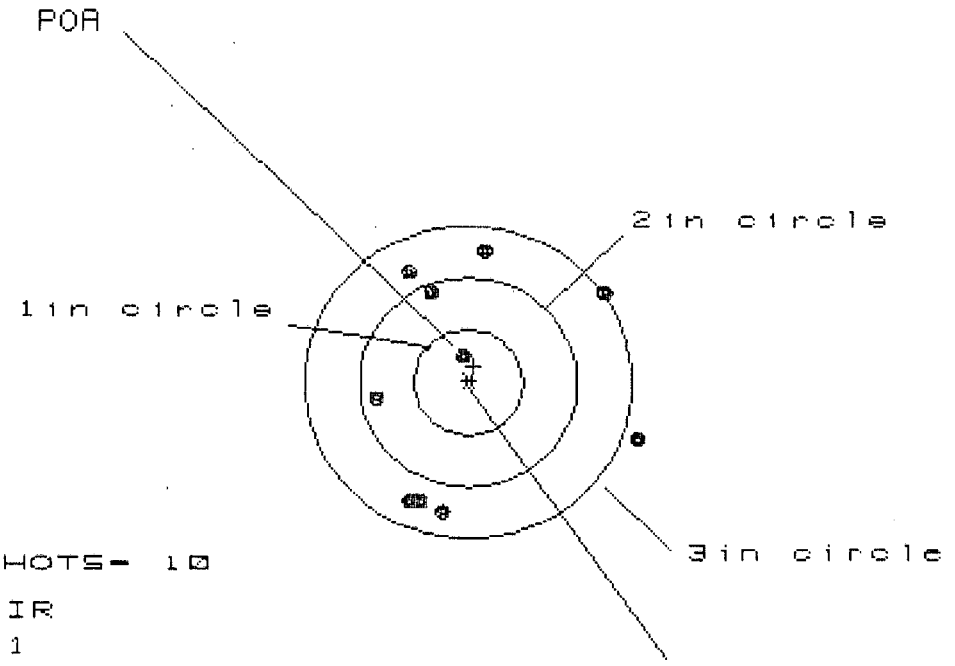
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 1
2in = 3
3in = 8

HS= 2.435
VS= 2.461
GS= 2.702

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.557	1.470	.511
MINIMUM X	:	-.878	-.705	-.522
MAXIMUM Y	:	1.229	1.164	1.265
MINIMUM Y	:	-1.232	-1.297	-1.196
CENTROID X	:	-.053	-.226	-.409
CENTROID Y	:	-.158	-.093	-.194
POA TO CENTROID in.	:	.167	.244	.453
MIN RADIUS	:	.274	.207	.393
MEAN RADIUS	:	1.147	1.055	.966
MAX RADIUS	:	1.663	1.678	1.365
HORIZONTAL SPREAD	:	2.435	2.175	1.033
VERTICAL SPREAD	:	2.461	2.461	2.461
EXTREME SPREAD	:	2.702	2.702	2.488
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	