

C6522184

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

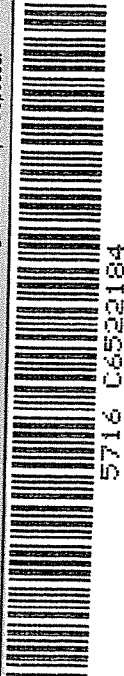
MODEL 700TM M24

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

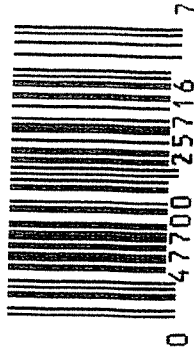
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6522184	ORDER NO. 5716
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Ø1



LPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522184
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.569309
1 TO	2	.335261
1 TO	3	.543383
1 TO	4	.715573
1 TO	5	.522422

5 4 3
3 4 (----POR

1.2604
1.5008
RIFLE IS: .564454

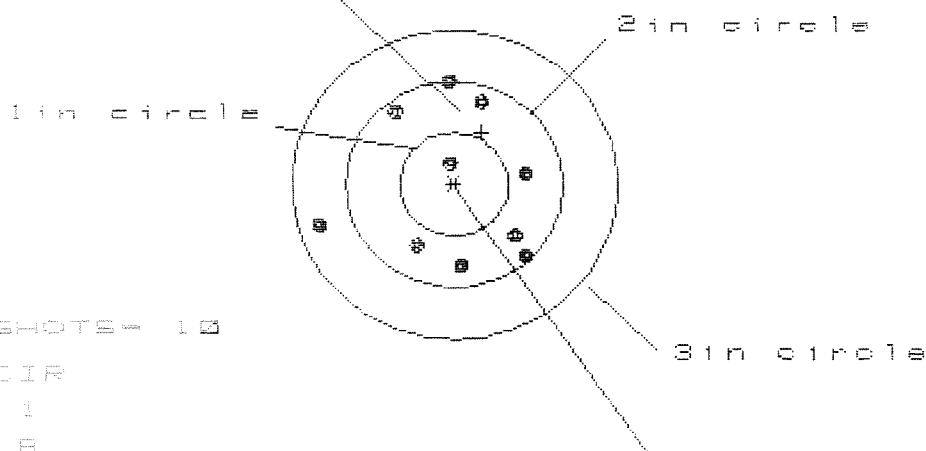
21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522184

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

ME = 1.588

SE = 1.738

SM = 1.860

CENTROID #

Pattern #

SHOTS (BEST OF)	10	9	8
MAXIMUM	1.680	1.549	1.526
MINIMUM	-1.288	-1.688	-1.691
MAXIMUM	1.020	1.975	1.916
MINIMUM	-1.775	-1.820	-1.698
CENTROID	-1.187	-1.124	-1.101
CENTROID	1.588	1.463	1.585
SPREAD (1st 10)	1.588	1.479	1.593
SPREAD (1st 9)	1.588	1.438	1.351
SPREAD (1st 8)	1.738	1.738	1.692
SPREAD (1st 7)	1.860	1.931	1.809
SPREAD (1st 6)	1.982	1.917	1.817
SPREAD (1st 5)	1.760	1.795	1.614
SPREAD (1st 4)	1.988	1.864	1.750
NUMBER IN ONE	1	1	1
NUMBER IN TWO	8	8	8
NUMBER IN THREE	10	10	10

21 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B4

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 6

CEX = 0.0000

CYC = 0.0004

CSC = 0.0004

CENTROID *

PATTERN #

2

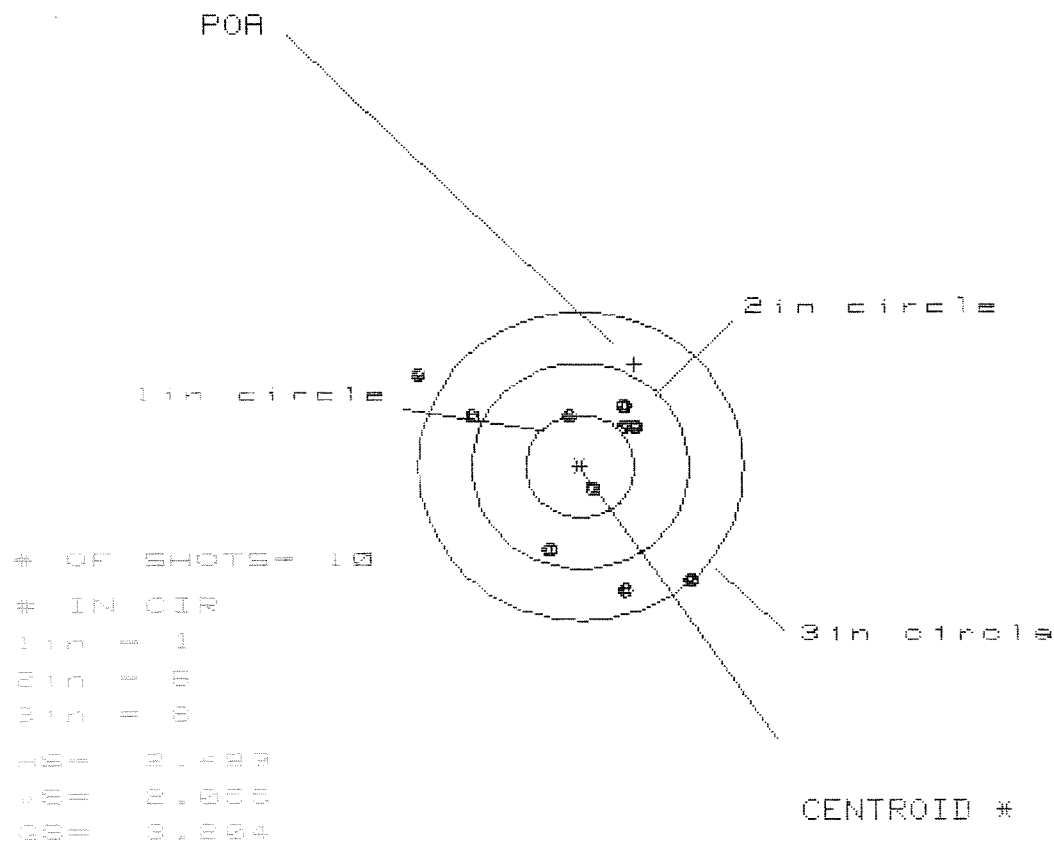
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.031	.869
MINIMUM X	-1.277	-1.296	-.841
MAXIMUM Y	1.491	.681	.640
MINIMUM Y	-.903	-.737	-.778
CENTROID X	-.157	-.138	.024
CENTROID Y	-.168	-.354	-.313
POA TO CENTROID (in)	.245	.380	.314
MIN RADIUS	.262	.381	.117
MEAN RADIUS	.811	.711	.623
MAX RADIUS	1.501	1.326	1.080
HORIZONTAL SPREAD	2.327	2.327	1.710
VERTICAL SPREAD	2.394	1.418	1.418
EXTREME SPREAD	2.534	2.534	1.989
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	6	

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FILE:/PATTERNING/CENTERFIRE_PATT/C85221B4

CENTERFIRE PATTERNS

3



Pattern #

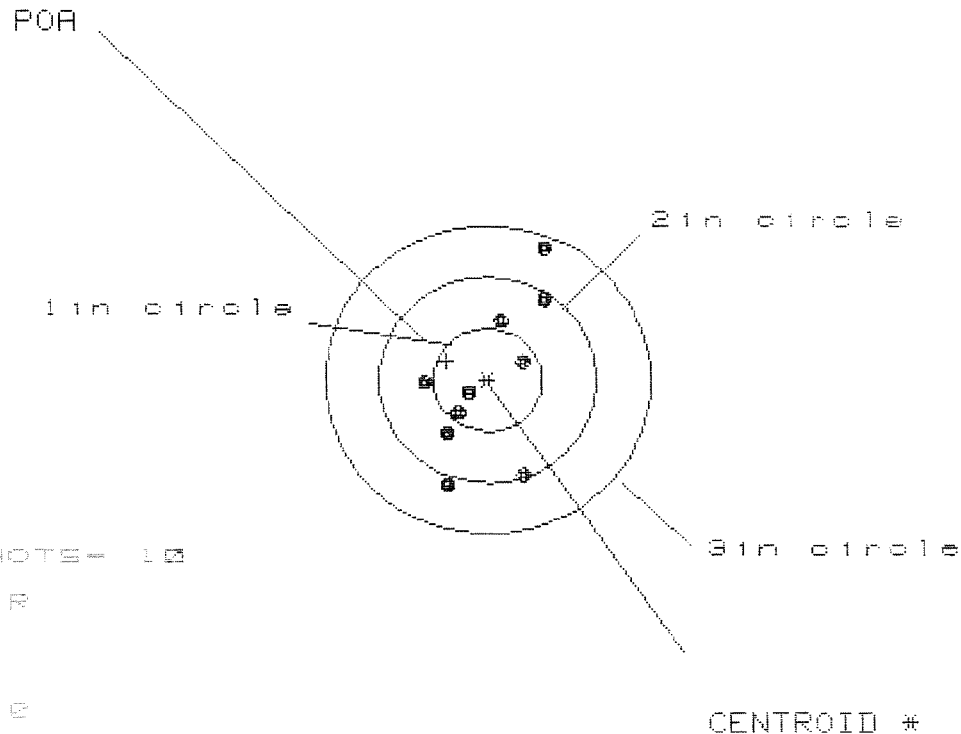
3

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.012	.848	.468
MINIMUM X	-1.481	-1.119	-1.014
MAXIMUM Y	.870	.698	.567
MINIMUM Y	-1.185	-1.088	-1.219
CENTROID X	-.504	-.340	-.446
CENTROID Y	-.992	-1.089	-.958
POA TO CENTROID (in)	1.113	1.140	1.057
MIN RADIUS	.209	.128	.228
MEAN RADIUS	.910	.806	.721
MAX RADIUS	1.718	1.346	1.260
HORIZONTAL SPREAD	2.490	1.967	1.481
VERTICAL SPREAD	2.855	1.786	1.786
EXTREME SPREAD	3.264	2.550	2.132
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HE= 1.124

VE= 2.300

GE= 2.462

CENTROID #

PATTERN #	1	4	9	8
SHOTS (BEST OF)	10	9	9	8
MAXIMUM X	.538	.587	.587	.546
MINIMUM X	-.601	-.547	-.547	-.589
MAXIMUM Y	1.284	.947	.947	.838
MINIMUM Y	-1.016	-.873	-.873	-.915
CENTROID X	.380	.326	.326	.367
CENTROID Y	-.182	-.325	-.325	-.216
POA TO CENTROID (in)	.422	.460	.460	.426
MIN RADIUS	.227	.138	.138	.199
MEAN RADIUS	.732	.633	.633	.602
MAX RADIUS	1.375	1.114	1.114	1.000
HORIZONTAL SPREAD	1.134	1.134	1.134	1.134
VERTICAL SPREAD	2.300	1.820	1.820	1.753
EXTREME SPREAD	2.462	2.040	2.040	1.764
NUMBER IN ONE INCH CIRCLE =		3		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		10		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.172

VS= 2.241

GS= 2.557

CENTROID #

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.325	1.402	.706
MINIMUM X	-.847	-.770	-.595
MAXIMUM Y	1.312	.695	.677
MINIMUM Y	-.929	-.783	-.801
CENTROID X	-.764	-.841	-1.016
CENTROID Y	-.634	-.780	-.762
POA TO CENTROID in.	.993	1.147	1.270
MIN RADIUS	.370	.247	.370
MEAN RADIUS	.859	.772	.685
MAX RADIUS	1.486	1.409	.858
HORIZONTAL SPREAD	2.172	2.172	1.301
VERTICAL SPREAD	2.241	1.478	1.478
EXTREME SPREAD	2.557	2.196	1.660
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522184DATE 9-14-90TESTER JRU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.14	2.36	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.50	2.30	2.15	
PULL #3	2.22	2.37	2.38	2.20	
PULL #4	2.33	2.24	2.40	2.11	
PULL #5	2.47	2.45	2.31	2.15	
TOTAL	11.87	11.70	11.75	10.71	
AVG.	2.374	2.34	2.35	2.142	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.32		
PULL #2	3.20	3.44		
PULL #3	3.42	3.26		
PULL #4	3.30	3.14		
PULL #5	3.47	3.43		
TOTAL	16.43	16.59		
AVG.	3.286	3.318		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.44		4.51
PULL #2	4.42	4.41		4.42
PULL #3	4.40	4.43		4.28
PULL #4	4.43	4.44		4.40
PULL #5	4.40	4.46		4.43
TOTAL	22.02	22.18		22.04
AVG.	4.404	4.436		4.408

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522184

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/90	KJ
600	Proof		6/27/90	KJ
607	Check Headspace		6/27/90	KJ
610	Dis-assemble Gun		6/27/90	KJ
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	B.S.
617	Drill and Tap Sight Holes		7/11/90	KB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/17/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/90	KS
	C) Inspect Ejector Hole for Chamfer		8/17/90	KS
	D) Oil Firing Pin Ass'y		8/17/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-14-90	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/14/90	WOB
	G) Safety Off Force	2	2	2			9/14/90	WOB
	H) Trigger Pull Test & Retainability						9-14-90	SL
	I) Firing Pin Indent	.0245	.0245	.0245			9/14/90	WOB
	J) Assemble Stock						8/20/90	KS
	K) Assemble Swivel Studs						9/15/90	SL
	L) Attach Front and Rear Sight Assemblies						8/20/90	KS
	M) Iron Sight Alignment						8/20/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	KS
	O) Attach Scope to Rifle						8/20/90	KS
	P) Detach & Attach Scope 20 Times						8/20/90	KS
640	Gallery Target & Test						8-21-90	A
	A) Time						1	A
	B) Malfunctions						100	A
	C) Pierced Primers						100	A
	D) Optical Clarity of Scope						100	A
645	Inspect for Live Ammo						8-21-90	A
655	Final Inspection							
	A) Headspace						9/15/90	SL
	B) Trigger Pull	2-10	2-15	2-20	2-11	2-15	9-14-90	SL
	C) Function						9/15/90	SL
660	Pack						9/19/90	LF

C6522184

MOD. _____ GA. _____ GUN# ~~6522184~~

CAL. _____ # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Mag. box hard to load	TS
	2nd	New follower OK	KS
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

800 (2511) 01100
4807A C 51000

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		