

C6594656

MODEL 700™ M24

Model 5145™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Smith
No. 2-152-51

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

MODEL 700TM H24

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. C6594656

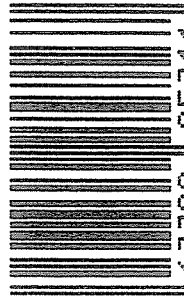
ORDER NO. 5716

20



5716 C6594656

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594656

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18 91		KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		28.
617	Drill and Tap Sight Holes	1 24 91		FB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		2-15-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KA
	C) Inspect Ejector Hole for Chamfer		3/8/91	KA
	D) Oil Firing Pin Ass'y		3/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		3/23/91	WB

BARBER - M24 0021215

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/25/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			3/25/91	WB
	H) Trigger Pull Test & Retainability						3/25/91	WB
	I) Firing Pin Indent	.0215	.0215	.0215			3/25/91	WB
	J) Assemble Stock						3/25/91	KA
	K) Assemble Swivel Studs						4/5/91	JA
	L) Attach Front and Rear Sight Assemblies						3/25/91	KA
	M) Iron Sight Alignment						3/25/91	KA
	N) Detach Front & Rear Sights & place in numbered container						3/25/91	KA
	O) Attach Scope to Rifle						3/25/91	KA
	P) Detach & Attach Scope 20 Times						3/25/91	KA
640	Gallery Target & Test						4-4-91	DA
	A) Time						4-4-91	DA
	B) Malfunctions						4-4-91	DA
	C) Pierced Primers						4-4-91	DA
	D) Optical Clarity of Scope						4-4-91	DA
645	Inspect for Live Ammo						4-4-91	DA
655	Final Inspection						4/5/91	JA
	A) Headspace						4/5/91	JA
	B) Trigger Pull	2.47	2.44	2.43	2.44	2.42	4/5/91	JA
	C) Function						4/5/91	JA
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594656

DATE 3/25/91

TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.38	2.35	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.39	2.36	2.44	
PULL #3	2.38	2.37	2.36	2.43	
PULL #4	2.40	2.34	2.37	2.44	
PULL #5	2.38	2.31	2.38	2.42	
TOTAL	12.05	11.79	11.82		
AVG.	2.41	2.36	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.09		
PULL #2	3.12	3.11		
PULL #3	3.13	3.12		
PULL #4	3.12	3.10		
PULL #5	3.14	3.12		
TOTAL	15.65	15.54		
AVG.	3.13	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.08		4.18
PULL #2	4.01	4.05		4.19
PULL #3	4.06	4.04		4.19
PULL #4	4.05	3.96		4.17
PULL #5	4.02	4.04		4.15
TOTAL	20.22	20.17		20.86
AVG.	4.04	4.03		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594656
4 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.448538
1 TO	2	.507887
1 TO	3	.686604
1 TO	4	.613209
1 TO	5	.634391

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0596
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0830241
THE AMP FOR THIS RIFLE IS: .907

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594656

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 4

2 in - 6

3 in - 10

HS - 2.290

VS - 2.043

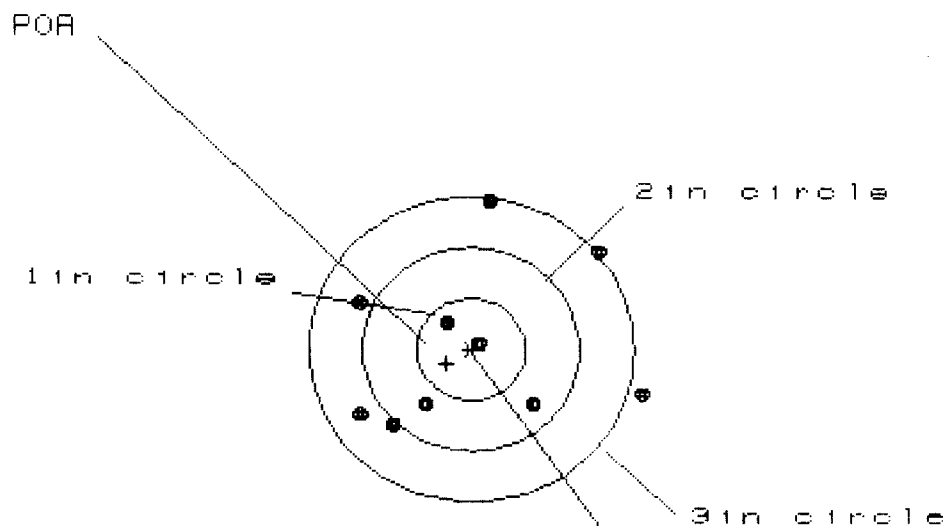
GS - 2.411

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.133	1.196	.664
MINIMUM X	-1.157	-1.094	-.944
MAXIMUM Y	1.256	1.211	1.130
MINIMUM Y	-.787	-.648	-.396
CENTROID X	.255	.192	.042
CENTROID Y	-.369	-.508	-.427
POA TO CENTROID in.	.449	.543	.429
MIN RADIUS	.241	.324	.255
MEAN RADIUS	.809	.728	.660
MAX RADIUS	1.381	1.361	1.146
HORIZONTAL SPREAD	2.290	2.290	1.608
VERTICAL SPREAD	2.043	1.859	1.526
EXTREME SPREAD	2.411	2.411	1.680
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594656

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in - 2

2in - 4

3in - 8

HS - 2.641

VS - 2.203

GS - 2.765

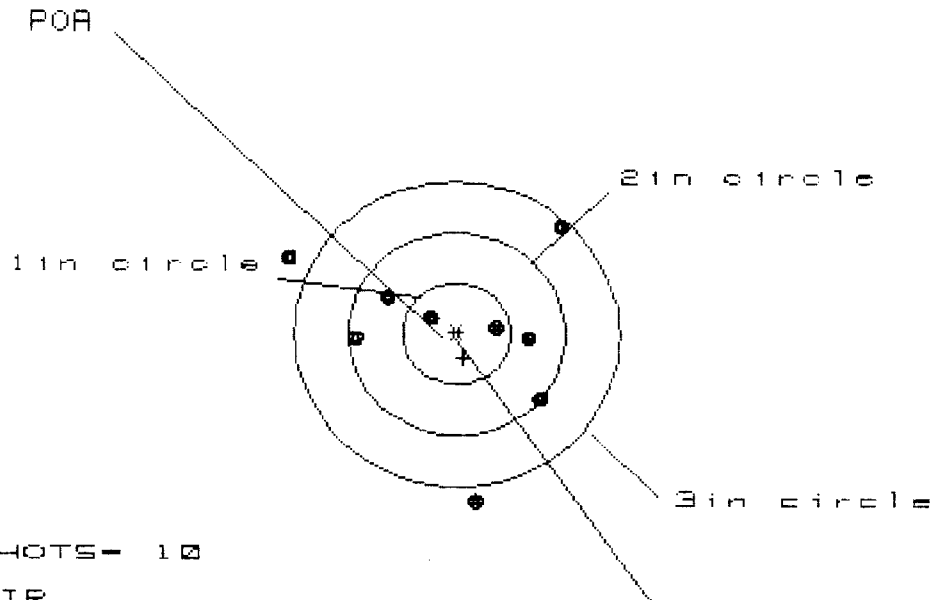
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.622	1.393	.885
MINIMUM X	-1.019	-.839	-.665
MAXIMUM Y	1.431	1.378	1.486
MINIMUM Y	-.772	-.825	-.717
CENTROID X	.225	.045	-.129
CENTROID Y	.138	.191	.083
POA TO CENTROID in.	.264	.196	.153
MIN RADIUS	.030	.210	.323
MEAN RADIUS	.993	.900	.790
MAX RADIUS	1.691	1.639	1.563
HORIZONTAL SPREAD	2.641	2.232	1.550
VERTICAL SPREAD	2.203	2.203	2.203
EXTREME SPREAD	2.765	2.749	2.411
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594656

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.482

VS = 2.707

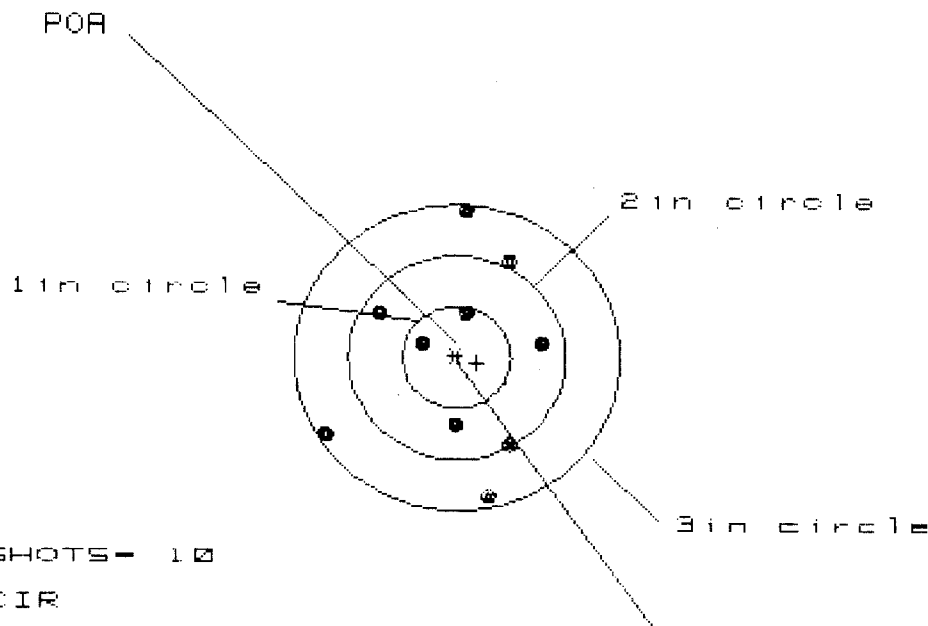
GS = 2.913

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.985	.819	.824
MINIMUM X	-1.497	-1.054	-1.049
MAXIMUM Y	1.062	1.142	.946
MINIMUM Y	-1.645	-1.565	-1.776
CENTROID X	-.064	.102	.097
CENTROID Y	.239	.159	.355
POA TO CENTROID in.	.247	.189	.368
MIN RADIUS	.292	.188	.189
MEAN RADIUS	.895	.787	.671
MAX RADIUS	1.659	1.566	1.255
HORIZONTAL SPREAD	2.482	1.873	1.873
VERTICAL SPREAD	2.707	2.707	1.722
EXTREME SPREAD	2.913	2.815	2.180
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594656

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.981

VS = 2.795

GS = 2.804

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.753	.764	.611
MINIMUM X	:	-1.228	-1.217	-.839
MAXIMUM Y	:	1.472	1.158	1.080
MINIMUM Y	:	-1.323	-1.159	-1.237
CENTROID X	:	-.188	-.199	-.046
CENTROID Y	:	.055	-.109	-.031
POA TO CENTROID in.	:	.195	.227	.056
MIN RADIUS	:	.337	.440	.502
MEAN RADIUS	:	.937	.879	.806
MAX RADIUS	:	1.476	1.367	1.249
HORIZONTAL SPREAD	:	1.981	1.981	1.450
VERTICAL SPREAD	:	2.795	2.317	2.317
EXTREME SPREAD	:	2.804	2.466	2.323
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594656

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.283

VS = 2.252

GS = 2.475

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.064	.928	1.011
MINIMUM X	-1.219	1.266	-1.183
MAXIMUM Y	1.005	1.067	.688
MINIMUM Y	-1.247	-1.185	-1.051
CENTROID X	.061	.197	.114
CENTROID Y	.235	.173	.039
POA TO CENTROID in.	.242	.262	.120
MIN RADIUS	.110	.223	.311
MEAN RADIUS	.901	.850	.809
MAX RADIUS	1.340	1.313	1.202
HORIZONTAL SPREAD	2.283	2.194	2.194
VERTICAL SPREAD	2.252	2.252	1.739
EXTREME SPREAD	2.475	2.392	2.194
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	10	

R ORDER
94-18728

MAIN FAULT

BARBER - M24 0021229

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

SERIAL NO. C6594656
DATE 10-30-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.33	2.43	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.38	2.31	
PULL #3	2.31	2.56	2.34	
PULL #4	2.31	2.49	2.34	
PULL #5	2.28	2.42	2.27	
TOTAL	11.57	12.28	11.59	
AVG.	2.31	2.45	2.31	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.21	3.17	
PULL #2	3.16	3.13	
PULL #3	3.20	3.19	
PULL #4	3.13	3.13	
PULL #5	3.17	3.20	
TOTAL	15.87	15.82	
AVG.	3.17	3.16	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.15	4.05	
PULL #2	4.19	4.20	4.05	
PULL #3	4.14	4.14	4.10	
PULL #4	4.18	4.17	4.00	
PULL #5	4.18	4.17	4.00	
TOTAL	20.85	20.83	20.20	
AVG.	4.17	4.16	4.04	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594656

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

BARBER - M24 0021226

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5	3/4		12/14	WB
	G) Safety Off Force	3	3	3			12/14	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.37	2.36	2.33	2.32	2.31	12/14	WB
	C) Function							
660	Pack							