

C6523520

MODEL 700™ M24

Model 515™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



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

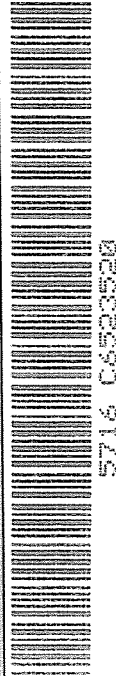
VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

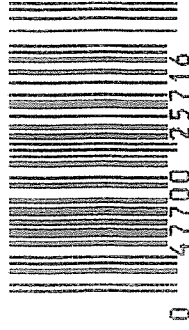
SERIAL NO.
06523520

ORDER NO.
5716

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



UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523520
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.191128
1 TO	2	.30728
1 TO	3	.47183
1 TO	4	.145014
1 TO	5	.194833

POI <----POI

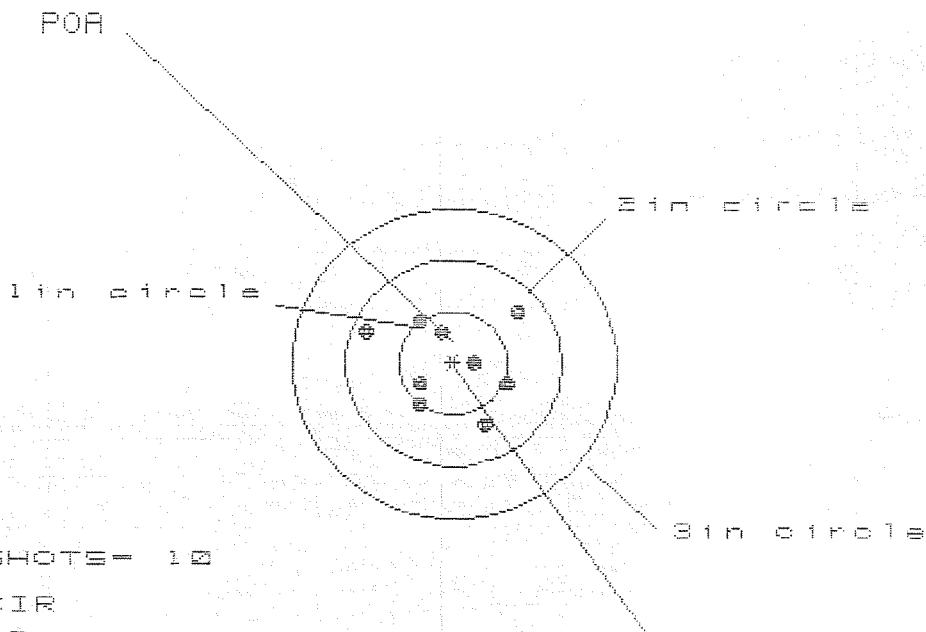
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0278
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0334
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0434557

THE AMR FOR THIS RIFLE IS: .7162

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523520

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.430

VS= 1.163

GS= 1.458

CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.626	.537	.481
MINIMUM X	-.804	-.426	-.359
MAXIMUM Y	.541	.570	.481
MINIMUM Y	-.622	-.593	-.522
CENTROID X	-.191	-.102	-.169
CENTROID Y	-.007	-.036	-.107
POA TO CENTROID in.	.191	.108	.200
MIN RADIUS	.221	.134	.220
MEAN RADIUS	.502	.450	.414
MAX RADIUS	.844	.783	.585
HORIZONTAL SPREAD	1.430	.963	.840
VERTICAL SPREAD	1.163	1.163	1.003
EXTREME SPREAD	1.458	1.324	1.158
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6523520

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 1.908

VS = 2.324

GS = 2.404

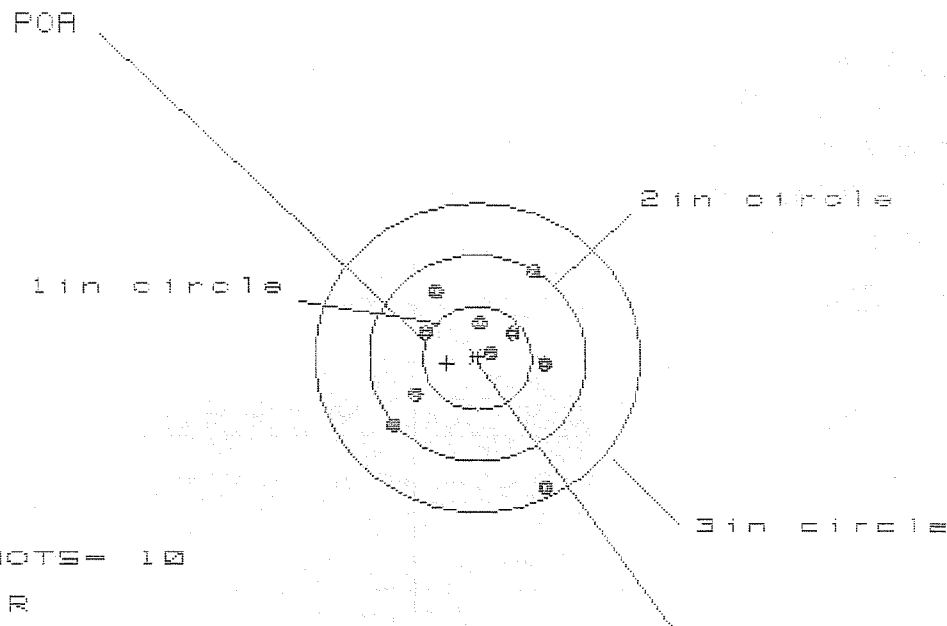
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.772	.847	.895
MINIMUM X	:	-1.136	-1.061	-1.013
MAXIMUM Y	:	1.109	1.182	1.045
MINIMUM Y	:	-1.215	-1.091	-.954
CENTROID X	:	.104	.029	-.019
CENTROID Y	:	.079	-.045	.092
POA TO CENTROID in.	:	.131	.053	.094
MIN RADIUS	:	.191	.318	.296
MEAN RADIUS	:	.791	.743	.691
MAX RADIUS	:	1.301	1.249	1.105
HORIZONTAL SPREAD	:	1.908	1.908	1.908
VERTICAL SPREAD	:	2.324	2.273	1.999
EXTREME SPREAD	:	2.404	2.404	2.019
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.073

VS = 2.086

GS = 2.120

CENTROID #

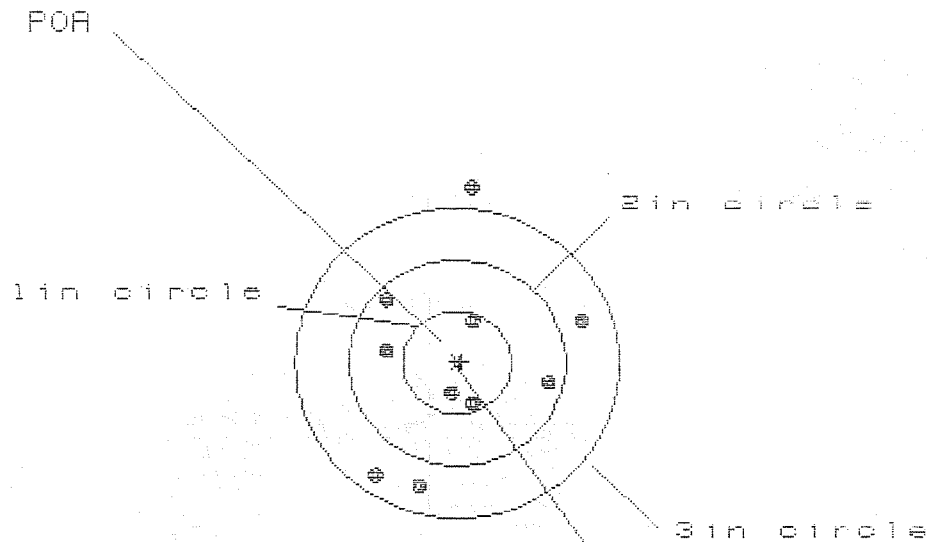
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.596	.659	.570
MINIMUM X	-.777	-.714	-.569
MAXIMUM Y	.857	.720	.617
MINIMUM Y	-1.229	-.829	-.543
CENTROID X	.277	.214	.303
CENTROID Y	.053	.190	.293
POA TO CENTROID in.	.282	.286	.422
MIN RADIUS	.117	.162	.064
MEAN RADIUS	.672	.574	.485
MAX RADIUS	1.356	1.094	.817
HORIZONTAL SPREAD	1.373	1.373	1.139
VERTICAL SPREAD	2.086	1.549	1.160
EXTREME SPREAD	2.120	2.048	1.602
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.838

VS= 2.902

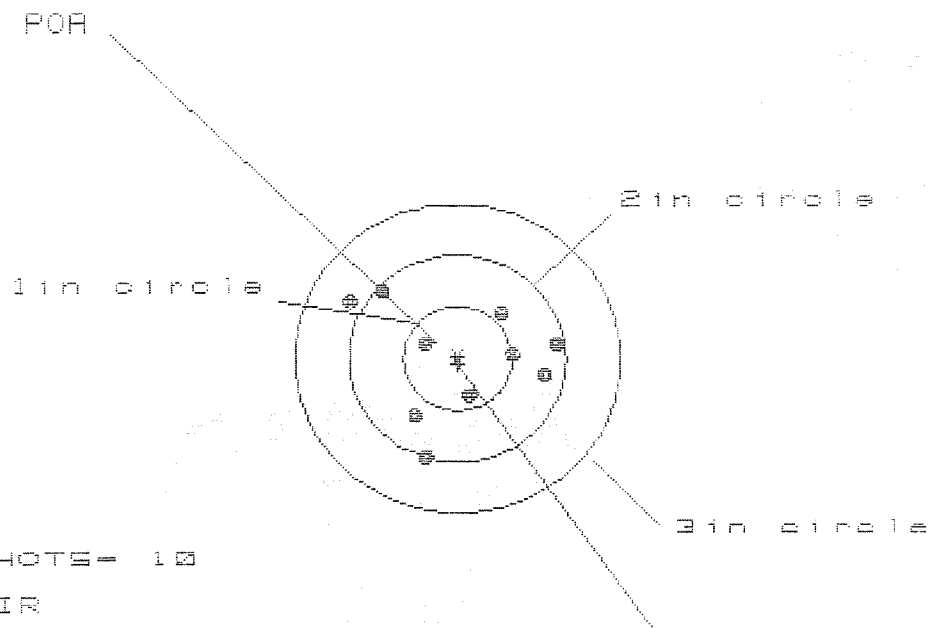
GS= 2.955

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	1.128	1.039
MINIMUM X	-.726	-.710	-.715
MAXIMUM Y	1.699	.839	.722
MINIMUM Y	-1.203	-1.014	-1.131
CENTROID X	-.046	-.061	.028
CENTROID Y	-.009	-.198	-.081
POA TO CENTROID in.	.046	.207	.085
MIN RADIUS	.332	.143	.283
MEAN RADIUS	.903	.788	.739
MAX RADIUS	1.705	1.254	1.214
HORIZONTAL SPREAD	1.838	1.838	1.754
VERTICAL SPREAD	2.902	1.853	1.853
EXTREME SPREAD	2.955	2.364	2.152
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.950

VS = 1.506

GS = 1.986

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.921	.807	.754
MINIMUM X	-1.029	-.800	-.853
MAXIMUM Y	.605	.663	.557
MINIMUM Y	-.901	-.843	-.566
CENTROID X	-.005	.109	.162
CENTROID Y	.051	-.008	.098
POA TO CENTROID in.	.051	.109	.189
MIN RADIUS	.332	.249	.330
MEAN RADIUS	.713	.647	.601
MAX RADIUS	1.154	1.039	1.019
HORIZONTAL SPREAD	1.950	1.607	1.607
VERTICAL SPREAD	1.506	1.506	1.123
EXTREME SPREAD	1.986	1.671	1.671
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
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. C6523520
DATE 9/5/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.16	2.34	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.19	2.16	2.12	
PULL #3	2.52	2.37	2.27	2.07	
PULL #4	2.50	2.29	2.32	2.08	
PULL #5	2.27	2.25	2.28	2.05	
TOTAL	12.11	11.26	11.37		
AVG.	2.42	2.25	2.27		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.11		
PULL #2	3.07	3.26		
PULL #3	3.11	3.22		
PULL #4	3.20	3.10		
PULL #5	3.24	3.10		
TOTAL	15.77	15.79		
AVG.	3.15	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.08		4.08
PULL #2	4.01	4.10		4.20
PULL #3	4.13	4.06		4.22
PULL #4	4.07	4.00		4.38
PULL #5	4.03	4.08		4.14
TOTAL	20.43	20.32		21.02
AVG.	4.08	4.06		4.20

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523520

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-22-90	DB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/5/90	WB

op. #	BARBER - M24 0029571					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2		9/6/90	WB
	G) Safety Off Force	2	2	2		9/6/90	WB
	H) Trigger Pull Test & Retainability					9/5/90	WB
	I) Firing Pin Indent	.023	.023	.023		9/6/90	WB
	J) Assemble Stock					9/7/90	RW
	K) Assemble Swivel Studs					9/9/90	RS
	L) Attach Front and Rear Sight Assemblies					9/7/90	RW
	M) Iron Sight Alignment					9/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container					9/7/90	RW
	O) Attach Scope to Rifle					9/7/90	RW
	P) Detach & Attach Scope 20 Times					9/7/90	RW
640	Gallery Target & Test					9/7/90	RS
	A) Time					9/7/90	RS
	B) Malfunctions					9/7/90	RS
	C) Pierced Primers					9/7/90	RS
	D) Optical Clarity of Scope					9/7/90	RS
645	Inspect for Live Ammo					9/7/90	RS
655	Final Inspection					9/9/90	RS
	A) Headspace					9/9/90	RS
	B) Trigger Pull	216	212	207	208	205	9/9/90
	C) Function					9/9/90	RS
660	Pack					9-18-90	RS