

MODEL 700TH 1124

Model	5/15	TH
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Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TH M24

DU PONT
REG. U.S. PAT. & TM. OFF.

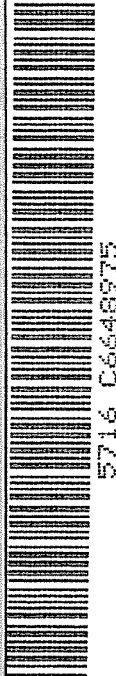
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6648975

ORDER NO.
5716

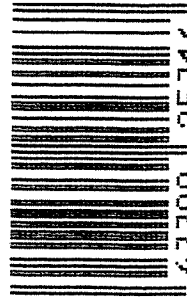
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.

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5716 C6648975

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648975

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	8 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/9/91	JS

op. #	BARBER - M24 0030183		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		4 $\frac{3}{4}$	5	4 $\frac{1}{2}$			9-9-91	DH
	G) Safety Off Force		2 $\frac{1}{2}$	2 $\frac{1}{2}$	2 $\frac{1}{2}$			9-9-91	DH
	H) Trigger Pull Test & Retainability							9-9-91	SH
	I) Firing Pin Indent		.024	.024	.024			9-9-91	DH
	J) Assemble Stock							9/12/91	RW
	K) Assemble Swivel Studs							9/13/91	SH
	L) Attach Front and Rear Sight Assemblies							9/12/91	RW
	M) Iron Sight Alignment							9/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container							9/12/91	RW
	O) Attach Scope to Rifle							9/12/91	RW
	P) Detach & Attach Scope 20 Times							9/12/91	RW
640	Gallery Target & Test							9/12/91	KT
	A) Time								KT
	B) Malfunctions								KT
	C) Pierced Primers								KT
	D) Optical Clarity of Scope								KT
645	Inspect for Live Ammo							9/12/91	KT
655	Final Inspection								
	A) Headspace							9/13/91	SH
	B) Trigger Pull		2.18	2.22	2.25	2.22	2.16	9/13/91	SH
	C) Function							9/13/91	SH
660	Pack							9-18-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6648975

DATE 9/9/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.30	2.44	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.36	2.40	2.22	
PULL #3	2.20	2.38	2.36	2.25	
PULL #4	2.56	2.46	2.42	2.22	
PULL #5	2.55	2.42	2.40	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.63		
PULL #2	3.30	3.31		
PULL #3	2.55	3.58		
PULL #4	3.46	3.40		
PULL #5	3.61	3.65		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.56		4.56
PULL #2	4.25	4.63		4.64
PULL #3	4.20	4.55		4.48
PULL #4	4.55	4.63		4.62
PULL #5	4.61	4.69		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648975
13 Sep 1991

CENTROIDAL DISTANCES

0 TO 1 .171432
1 TO 2 .108157
1 TO 3 .171406
1 TO 4 .143544
1 TO 5 .275363

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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0476
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0166
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0504115
THE AMR FOR THIS RIFLE IS: .9996

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B4B975

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 3.280

VS= 3.201

GS= 3.767

PATTERN #

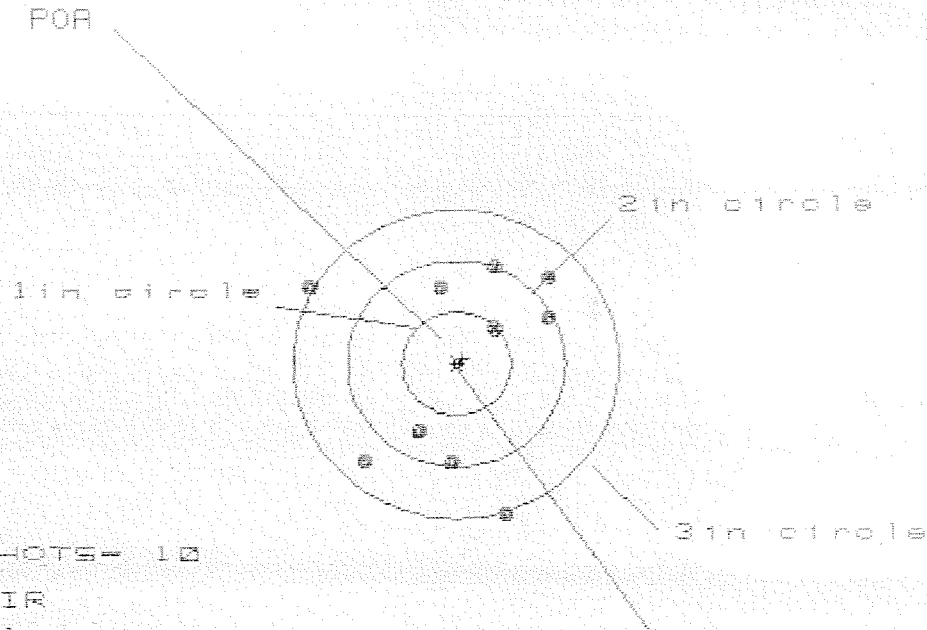
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.158	1.223	.966
MINIMUM X	-2.122	-2.057	-1.178
MAXIMUM Y	2.328	.662	.659
MINIMUM Y	-.873	-.615	-.618
CENTROID X	-.083	-.148	.109
CENTROID Y	-.150	-.408	-.405
POA TO CENTROID in.	.171	.435	.419
MIN RADIUS	.372	.106	.276
MEAN RADIUS	1.034	.833	.634
MAX RADIUS	2.402	2.057	1.184
HORIZONTAL SPREAD	3.280	3.280	2.144
VERTICAL SPREAD	3.201	1.277	1.277
EXTREME SPREAD	3.767	3.290	2.146
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB48375

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.244

VS= 2.418

GS= 2.868

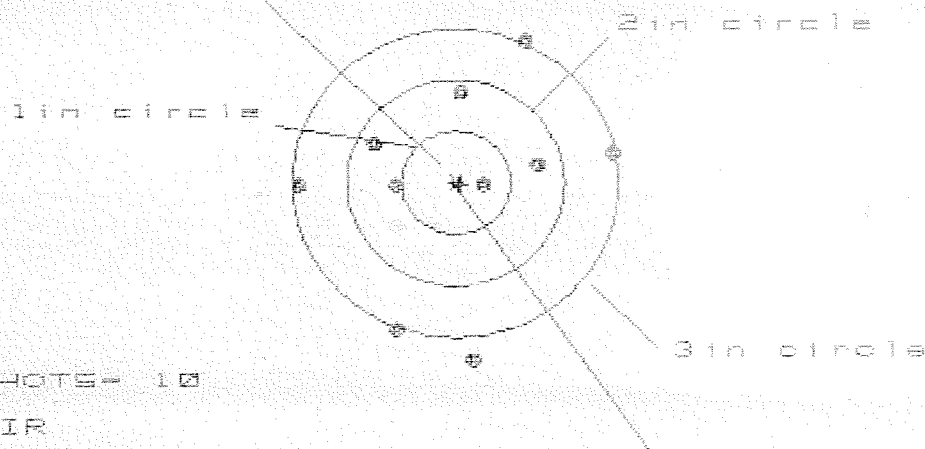
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.893	.941	.778
MINIMUM X	-1.351	-1.303	-.992
MAXIMUM Y	.922	.756	.829
MINIMUM Y	-1.496	-1.111	-1.038
CENTROID X	-.050	-.098	.065
CENTROID Y	-.047	.119	.046
POA TO CENTROID in.	.069	.154	.080
MIN RADIUS	.489	.428	.343
MEAN RADIUS	1.043	.966	.888
MAX RADIUS	1.558	1.427	1.436
HORIZONTAL SPREAD	2.244	2.244	1.770
VERTICAL SPREAD	2.418	1.867	1.867
EXTREME SPREAD	2.868	2.527	2.527
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648975

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.890

VS= 3.093

GS= 3.140

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.454
MINIMUM X	-1.436
MAXIMUM Y	1.411
MINIMUM Y	-1.682
CENTROID X	-.049
CENTROID Y	.018
POA TO CENTROID in.	.052
MIN RADIUS	.221
MEAN RADIUS	1.090
MAX RADIUS	1.688
HORIZONTAL SPREAD	2.890
VERTICAL SPREAD	3.093
EXTREME SPREAD	3.140
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B975

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.740

VS= 2.269

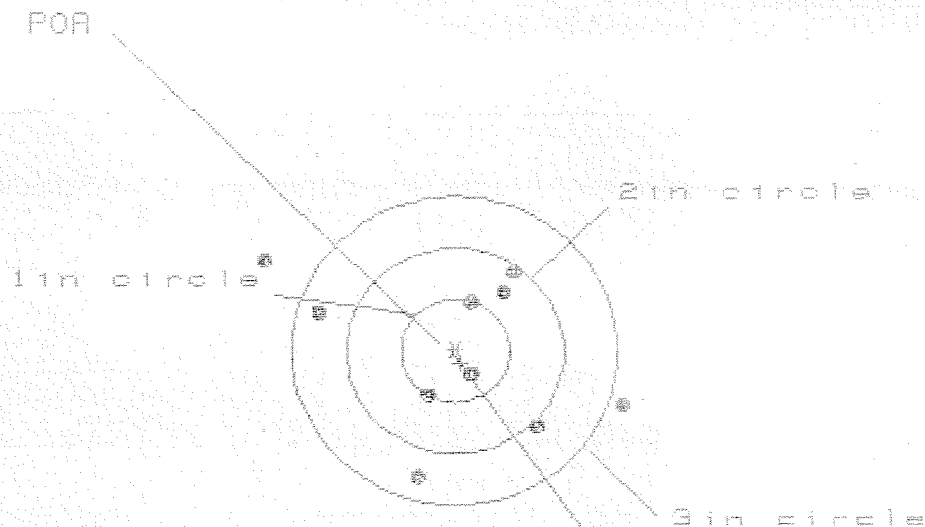
GS= 2.271

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.470	.329	.355
MINIMUM X	-1.270	-.587	-.561
MAXIMUM Y	1.172	1.134	.784
MINIMUM Y	-1.097	-1.135	-.993
CENTROID X	-.009	.132	.106
CENTROID Y	-.027	.012	-.130
POA TO CENTROID in.	.028	.132	.168
MIN RADIUS	.429	.403	.475
MEAN RADIUS	.821	.755	.706
MAX RADIUS	1.316	1.176	1.047
HORIZONTAL SPREAD	1.740	.916	.916
VERTICAL SPREAD	2.269	2.269	1.777
EXTREME SPREAD	2.271	2.271	1.812
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06646975

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.319

VS= 2.088

GS= 3.612

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.564

1.369

.720

MINIMUM X

-1.755

-1.409

-1.238

MAXIMUM Y

.884

.906

.851

MINIMUM Y

-1.204

-1.106

-1.161

CENTROID X

-.047

.140

-.023

CENTROID Y

.123

.025

.081

POA TO CENTROID in.

.132

.150

.084

MIN RADIUS

.206

.117

.157

MEAN RADIUS

1.010

.982

.905

MAX RADIUS

1.965

1.503

1.323

HORIZONTAL SPREAD

3.319

2.778

1.953

VERTICAL SPREAD

2.088

2.012

2.012

EXTREME SPREAD

3.612

2.941

2.291

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8