C663625

MODEL 700™ M24

Model 5M5 ™

Action

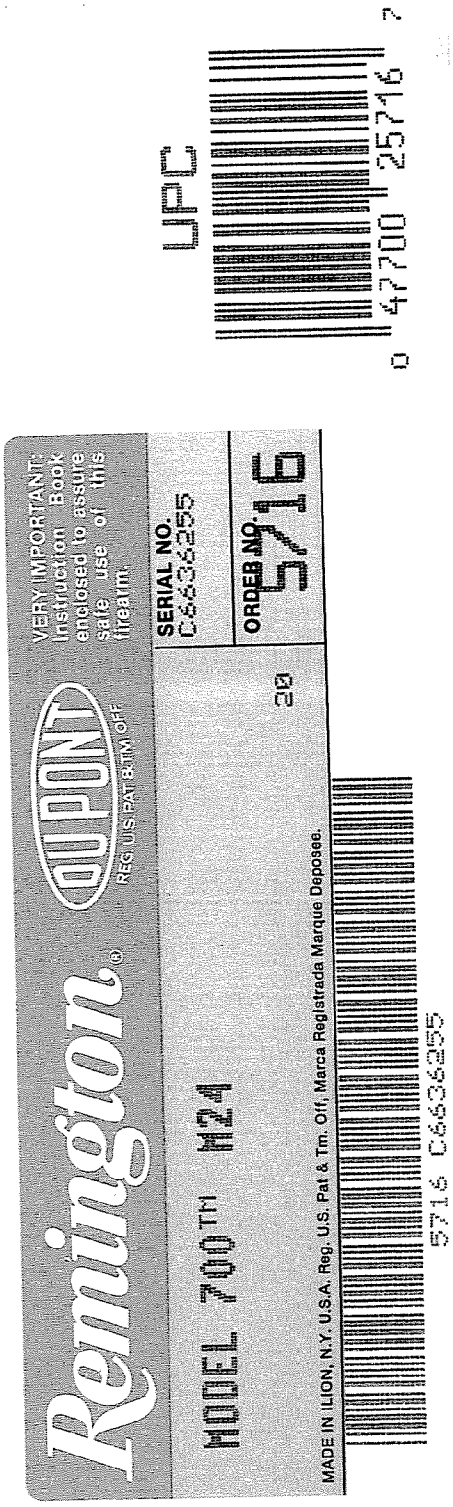
Barrel Length

Capacity

Order No. 57L6

*Includes 1 in chamber.

Remington.


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24
SERIAL NO. C6636255
ORDER NO. 16
20
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.
5716 C6636255
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636255

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KK
600	Proof		6/25/91	KK
607	Check Headspace		6/25/91	KK
610	Dis-assemble Gun		6/25/91	KK
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	DS
617	Drill and Tap Sight Holes	JUL	1 1991	LG
618	Polish Barrel	JUL	2 1991	cwb
620	Apply Coatings (Barrel Action)		7-23-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-25-91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6	6			7-29-91	DH
	G) Safety Off Force	4	4	4			7-29-91	DH
	H) Trigger Pull Test & Retainability						7-29-91	DH
	I) Firing Pin Indent	.021	.021	.020			7-29-91	DH
	J) Assemble Stock						7/29/91	KS
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/29/91	KS
	M) Iron Sight Alignment						7/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/29/91	KS
	O) Attach Scope to Rifle						7/29/91	KS
	P) Detach & Attach Scope 20 Times						7/29/91	KS
640	Gallery Target & Test						7-29-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clearity of Scope						"	AF
645	Inspect for Live Ammo						7-29-91	AF
655	Final Inspection A) Headspace						8-5-91	A
	B) Trigger Pull	2.40	2.41	2.20	2.28	2.47	8-5-91	JH
	C) Function						8-5-91	A
660	Pack						9-18-91	AF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	JO Rds shoot ok	
TEST 1-31-91	test	94
TGT	OK	
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. _____ CAL. _____ GUN # 6255

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	7/29	Bolt Closes Hard over shell!	KS
	2nd		
	7/29	WIRE Brushed SHROUD WORKS WELL WITH NEW Dummys (Bench Test)	KS
	3rd	Needs [redacted] Test With live Rounds	
	4th		

FUNCTION RD 6654 Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636255
DATE 7-25-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.44	2.45	2.40	MIN. SETTING,
PULL #2	2.31	2.41	2.40	2.41	NO AVG. OF 5
PULL #3	2.40	2.42	2.43	2.20	READINGS ACCEPT-
PULL #4	2.30	2.41	2.40	2.28	ABLE LESS THAN 2#
PULL #5	2.27	2.39	2.46	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.51		
PULL #2	3.53	3.49		
PULL #3	3.50	3.46		
PULL #4	3.44	3.42		
PULL #5	3.45	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.43		4.47
PULL #2	4.35	4.48		4.50
PULL #3	4.39	4.45		4.54
PULL #4	4.35	4.45		4.45
PULL #5	4.38	4.47		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636255
29 Jul 1991

CENTROIDAL DISTANCES

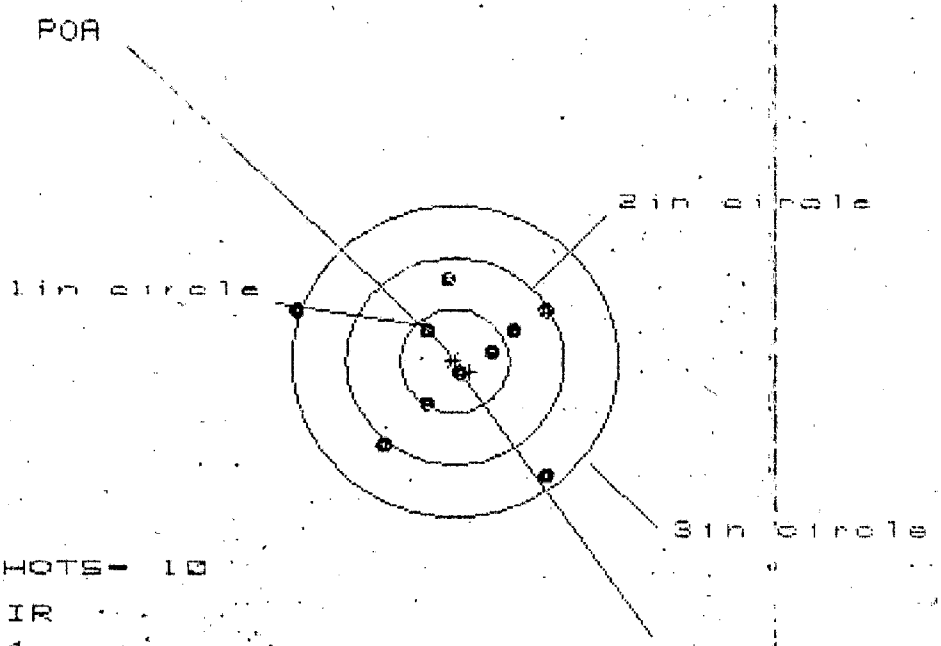
0	TO	1	.178003
1	TO	2	.358066
1	TO	3	.122544
1	TO	4	.0586941
1	TO	5	.25005

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0368
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .113
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118841

THE AMR FOR THIS RIFLE IS: .8828

23 Jul 1931 FILE:/PATTERNING/CENTERFIRE_PATT/C6636255

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

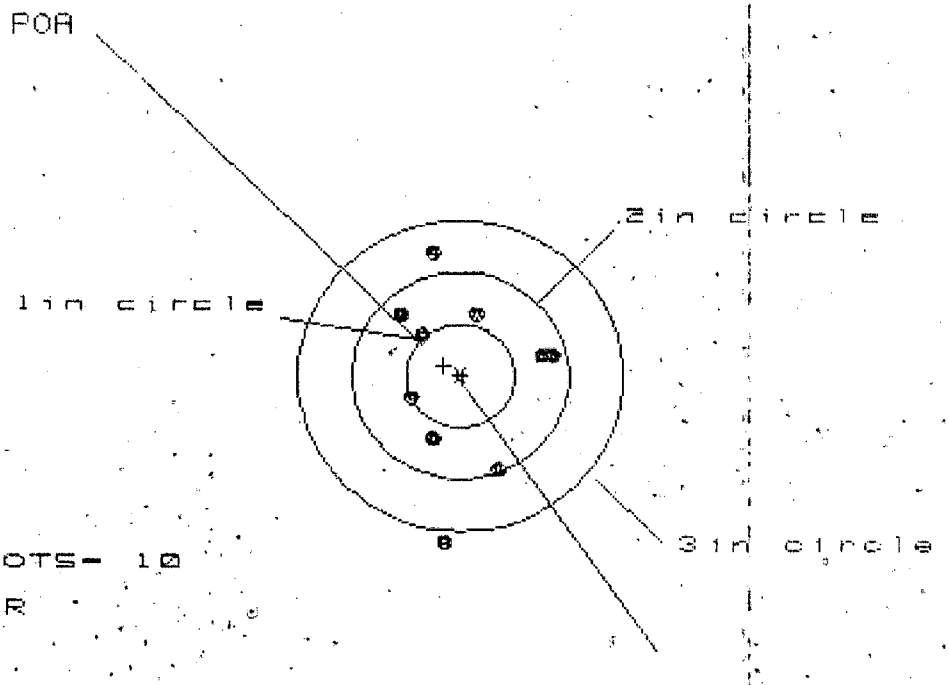
# IN CIR
1in = 4
2in = 7
3in = 8

HS= 2.290
VS= 1.975
GS= 2.822

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.872	.715	.802
MINIMUM X	:	-1.418	-.824	-.737
MAXIMUM Y	:	.834	.893	.758
MINIMUM Y	:	-1.141	-1.082	-.868
CENTROID X	:	-.143	.014	-.073
CENTROID Y	:	.106	.047	.182
POA TO CENTROID in.	:	.178	.049	.196
MIN RADIUS	:	.138	.118	.201
MEAN RADIUS	:	.771	.676	.589
MAX RADIUS	:	1.515	1.286	1.139
HORIZONTAL SPREAD	:	2.290	1.539	1.539
VERTICAL SPREAD	:	1.975	1.975	1.626
EXTREME SPREAD	:	2.822	2.191	1.984
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Jul 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6636255

CENTERFIRE PATTERNS # 2

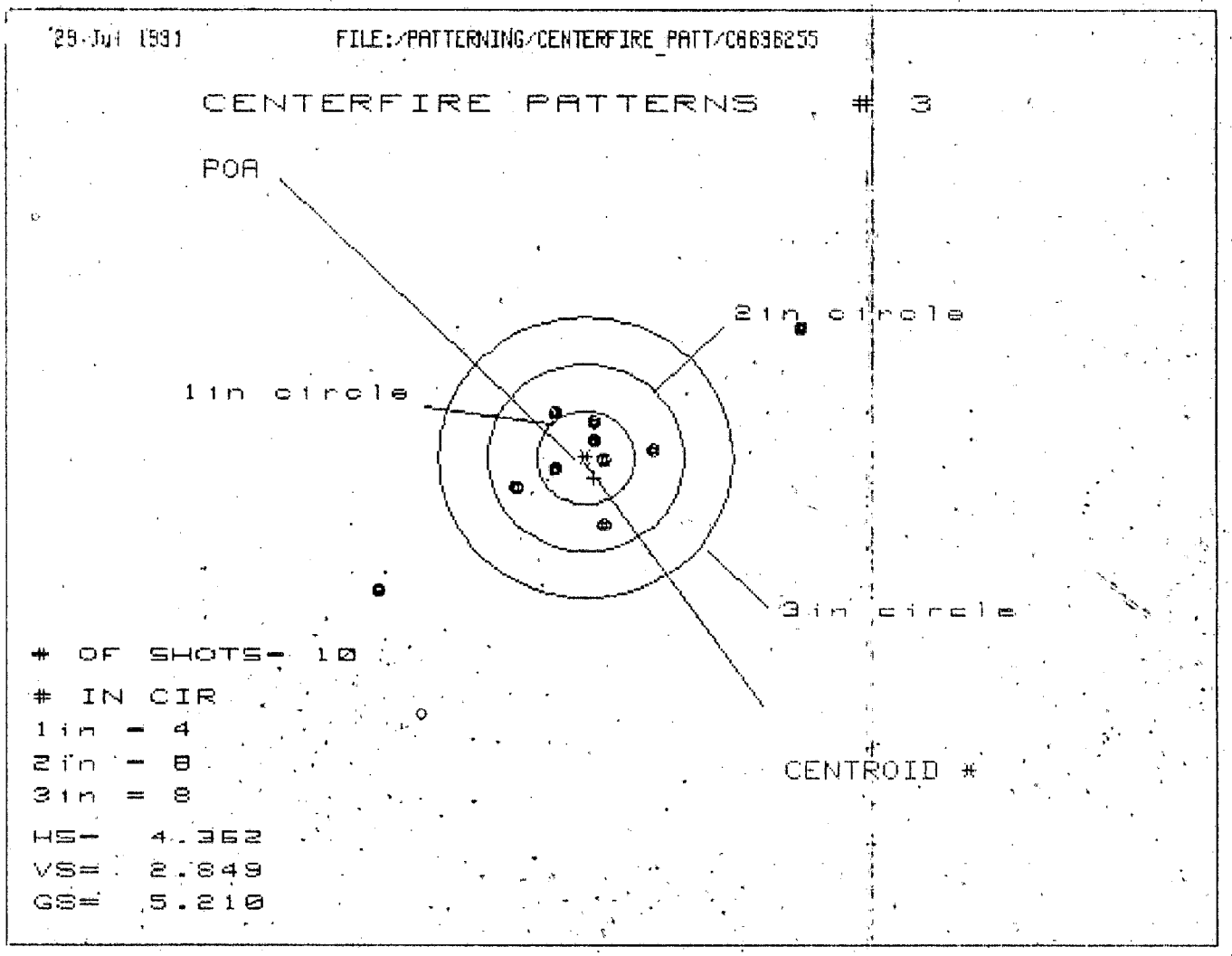


# OF SHOTS= 10
# IN CIR
1in = 0
2in = 8
3in = 9
HS= 1.355
VS= 2.738
GS= 2.739

PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.827	.807	.774
MINIMUM X	-.528	-.548	-.581
MAXIMUM Y	1.183	1.010	.582
MINIMUM Y	-1.555	-1.046	-.919
CENTROID X	.152	.172	.205
CENTROID Y	-.098	.075	-.052
POA TO CENTROID in.	.181	.187	.211
MIN RADIUS	.511	.435	.536
MEAN RADIUS	.841	.739	.703
MAX RADIUS	1.565	1.088	.957
HORIZONTAL SPREAD	1.355	1.355	1.355
VERTICAL SPREAD	2.738	2.056	1.501
EXTREME SPREAD	2.739	2.131	1.720

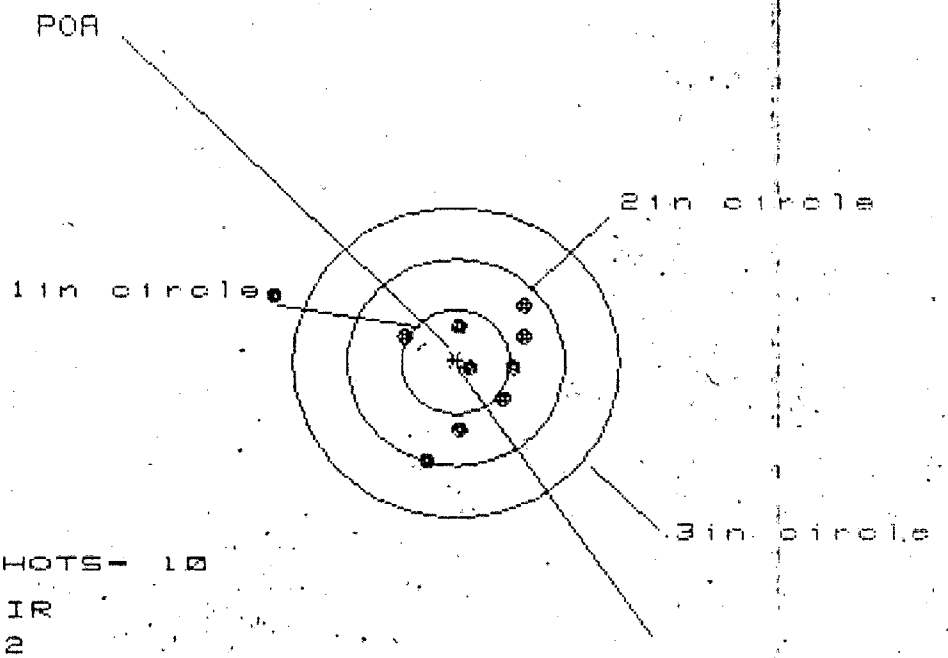
NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 8
NUMBER IN THREE INCH CIRCLE = 9



PATTERN # :	3		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	2.225	.925	.688
MINIMUM X :	-2.137	-1.889	-.680
MAXIMUM Y :	1.428	.658	.500
MINIMUM Y :	-1.421	-1.262	-.762
CENTROID X :	-.087	-.335	-.098
CENTROID Y :	.215	.056	.214
POA TO CENTROID in.:	.232	.339	.236
MIN RADIUS :	.158	.059	.169
MEAN RADIUS :	.909	.747	.485
MAX RADIUS :	2.644	2.272	.794
HORIZONTAL SPREAD :	4.362	2.814	1.368
VERTICAL SPREAD :	2.849	1.920	1.262
EXTREME SPREAD :	5.210	3.197	1.426
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

29 Jul 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6B3B255

CENTERFIRE PATTERNS # 4

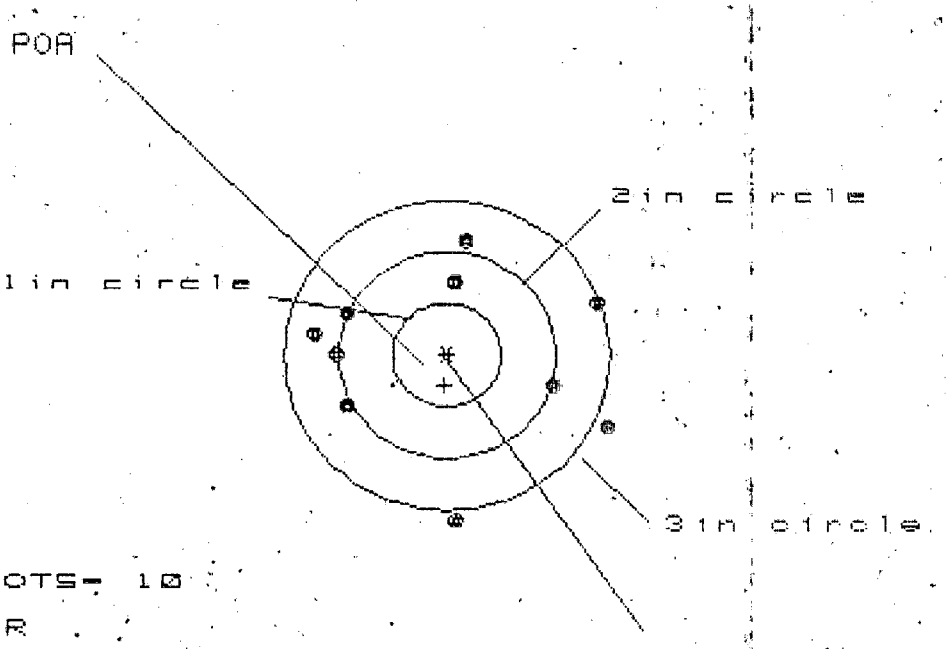


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 8
3in = 9
HS= 2.314
VS= 1.572
GS= 2.314

PATTERN #	:	[redacted]	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.665	.482	.419
MINIMUM X	:	-1.649	-.635	-.698
MAXIMUM Y	:	.615	.657	.546
MINIMUM Y	:	-.957	-.889	-.708
CENTROID X	:	-.129	.054	.117
CENTROID Y	:	.049	-.019	.092
POA TO CENTROID in.	:	.138	.057	.149
MIN RADIUS	:	.177	.047	.172
MEAN RADIUS	:	.713	.548	.485
MAX RADIUS	:	1.760	1.020	.744
HORIZONTAL SPREAD	:	2.314	1.117	1.117
VERTICAL SPREAD	:	1.572	1.546	1.254
EXTREME SPREAD	:	2.314	1.831	1.411
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Jul 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6636255

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 4
3in = 8
HS= 2.710
VS= 2.725
GS= 2.869

PATTERN # :	5		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.456	1.495	1.525
MINIMUM X :	-1.254	-1.092	-1.062
MAXIMUM Y :	1.128	1.050	.840
MINIMUM Y :	-1.597	-1.675	-.760
CENTROID X :	.023	-.139	-.169
CENTROID Y :	.293	.371	.581
POA TO CENTROID in. :	.293	.397	.605
MIN RADIUS :	.736	.684	.498
MEAN RADIUS :	1.180	1.098	.988
MAX RADIUS :	1.620	1.693	1.546
HORIZONTAL SPREAD :	2.710	2.587	2.587
VERTICAL SPREAD :	2.725	2.725	1.600
EXTREME SPREAD :	2.869	2.728	2.606
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	