

06648938

MODEL 700™ M24

Model **5M5**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

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

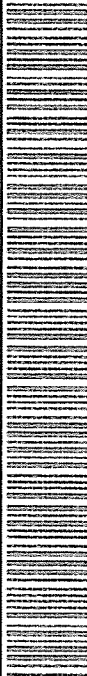
MODEL 700™ M24

SERIAL NO.
 C6648938

ORDER NO.
 5716

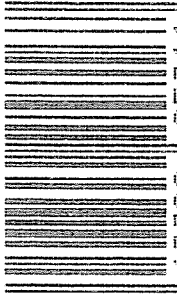
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6648938

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648938

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 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	III 2 2 1991		LS.
	Magnaflux Bolt	III 2 2 1991		LS.
615	Rollmark Caliber	JUL 2 2 1991		LS.
617	Drill and Tap Sight Holes	JUL 2 2 1991		FB
618	Polish Barrel	7/22/91		WB
620	Apply Coatings (Barrel Action)	8/2/91		FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/91	JS

op. #	BARBER - M24 0033545	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	6½			8-21-91	DH
	G) Safety Off Force	3	2½	2½			8-21-91	DH
	H) Trigger Pull Test & Retainability						8/21/91	SH
	I) Firing Pin Indent	.021	.020	.020			8-21-91	DH
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs						8/22/91	SH
	L) Attach Front and Rear Sight Assemblies						8/21/91	RW
	M) Iron Sight Alignment						8/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	RW
	O) Attach Scope to Rifle						8/21/91	RW
	P) Detach & Attach Scope 20 Times						8/21/91	RW
640	Gallery Target & Test						8-22-91	AC
	A) Time						8-22-91	AC
	B) Malfunctions						8-22-91	AC
	C) Pierced Primers						8-22-91	AC
	D) Optical Clarity of Scope						8-22-91	AC
645	Inspect for Live Ammo						8-22-91	AC
655	Final Inspection						8/22/91	SH
	A) Headspace							
	B) Trigger Pull	2.18	2.15	2.19	2.15	2.18	8/22/91	SH
	C) Function						8/22/91	SH
660	Pack						9-19-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6648938

DATE 8/21/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.60	2.46	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.61	2.48	2.15	
PULL #3	2.54	2.45	2.55	2.19	
PULL #4	2.35	2.48	2.50	2.15	
PULL #5	2.51	2.25	2.38	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.34		
PULL #2	3.20	3.30		
PULL #3	3.25	3.35		
PULL #4	3.33	3.41		
PULL #5	3.41	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.52		4.56
PULL #2	4.48	4.60		4.47
PULL #3	4.25	4.59		4.65
PULL #4	4.36	4.46		4.68
PULL #5	4.51	4.66		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648938
22 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.254486
1 TO 2	.326173
1 TO 3	.378699
1 TO 4	.443483
1 TO 5	.378283

5.13
4.24 <----PDR

AVG H-ANGS COORDINATE FOR THIS RIFLE IS: .2468
AVG H-ANGS COORDINATE FOR THIS RIFLE IS: .0716
AVG H-ANGS AVERAGE POT RADIUS FOR THIS RIFLE IS: .256976
POT RADIUS RIFLE IS: .9176

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B338

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.892

VS = 2.230

GS = 2.261

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.985

1.005

.982

MINIMUM X

-.907

-.887

-.910

MAXIMUM Y

1.081

.953

.664

MINIMUM Y

-1.149

-.628

-.508

CENTROID X

.140

.128

.151

CENTROID Y

.207

.335

.215

POA TO CENTROID in.

.254

.358

.263

1in RADIUS

.251

.372

.260

2in RADIUS

.801

.767

.719

3in RADIUS

1.162

1.005

.987

HORIZONTAL SPREAD

1.892

1.892

1.892

VERTICAL SPREAD

2.230

1.581

1.172

EXTREME SPREAD

2.261

1.908

1.908

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8848938

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.030

VS = 2.792

GS = 2.799

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.009

1.002

1.018

MINIMUM X

-1.021

-1.028

-1.012

MAXIMUM Y

1.542

.764

.629

MINIMUM Y

-1.250

-1.079

-.494

CENTROID X

.331

.338

.323

CENTROID Y

-.063

-.234

-.099

POA TO CENTROID in.

.337

.411

.337

MIN RADIUS

.068

.137

.062

MEAN RADIUS

.766

.675

.606

MAX RADIUS

1.543

1.086

1.021

HORIZONTAL SPREAD

2.030

2.030

2.030

VERTICAL SPREAD

2.792

1.843

1.123

EXTREME SPREAD

2.799

2.031

2.031

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

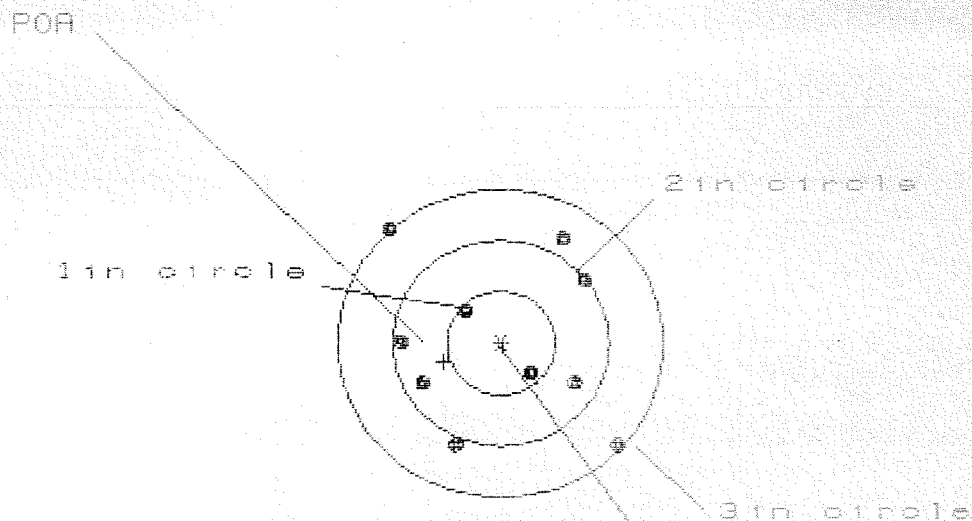
NUMBER IN THREE INCH CIRCLE =

9

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B938

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 3

HS = 2.098

VS = 2.134

GS = 2.976

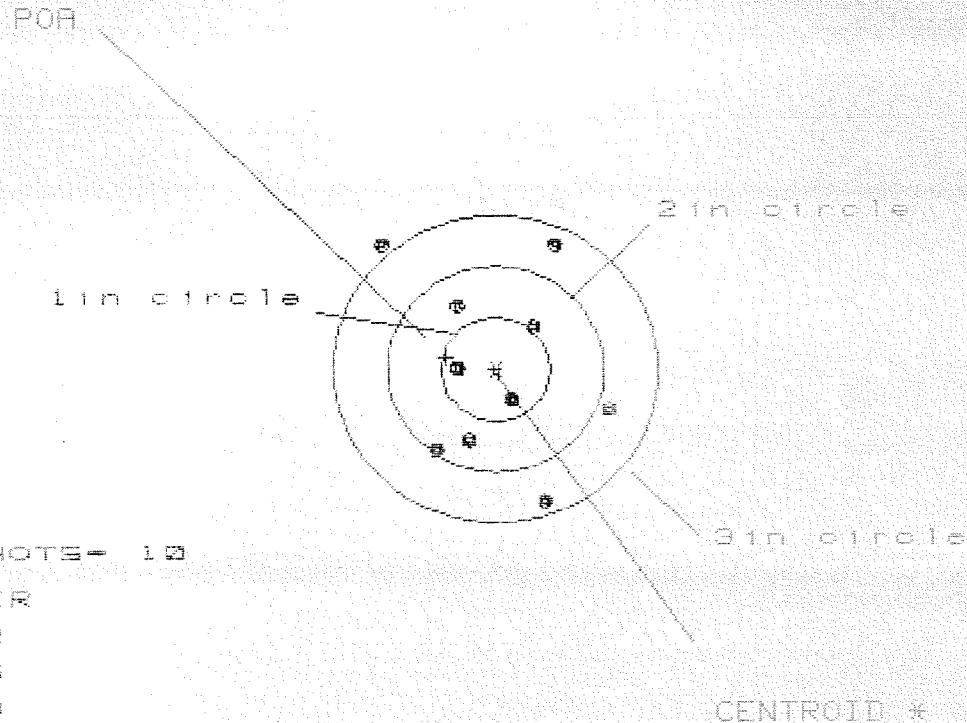
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.061	.946	.822
MINIMUM X	-1.037	-1.056	-1.037
MAXIMUM Y	1.114	1.140	1.031
MINIMUM Y	-1.020	-1.096	-1.005
CENTROID X	.526	.641	.522
CENTROID Y	.184	.060	.169
POA TO CENTROID in.	.557	.643	.549
MIN RADIUS	.415	.246	.407
MEAN RADIUS	.989	.892	.839
MAX RADIUS	1.522	1.287	1.194
HORIZONTAL SPREAD	2.098	2.002	1.759
VERTICAL SPREAD	2.134	2.036	2.036
EXTREME SPREAD	2.976	2.288	2.288
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B938

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.068

VS= 2.510

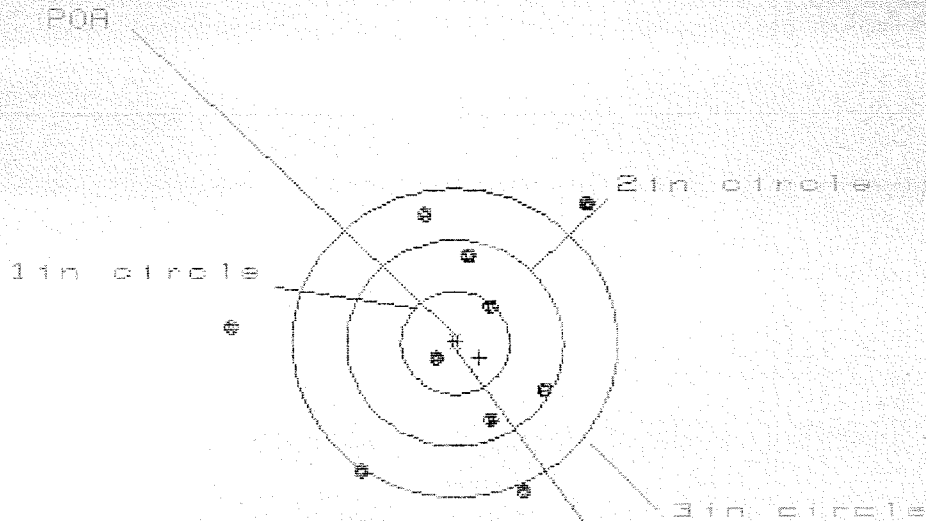
GS= 2.873

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	.933	.974
MINIMUM X	-1.022	-.652	-.611
MAXIMUM Y	1.212	1.343	1.197
MINIMUM Y	-1.298	-1.167	-.826
CENTROID X	.454	.567	.526
CENTROID Y	-.114	-.245	-.099
POA TO CENTROID in.	.468	.610	.536
MIN RADIUS	.312	.182	.330
MEAN RADIUS	.895	.810	.757
MAX RADIUS	1.557	1.397	1.270
HORIZONTAL SPREAD	2.068	1.585	1.505
VERTICAL SPREAD	2.510	2.510	2.023
EXTREME SPREAD	2.873	2.511	2.273
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B938

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 3.238

VS= 2.778

GS= 3.472

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.206

.980

.732

MINIMUM X

-2.832

-1.877

-.954

MAXIMUM Y

1.364

1.376

1.489

MINIMUM Y

-1.414

-1.402

-1.230

CENTROID X

-.225

.001

-.122

CENTROID Y

.144

.132

-.040

POA TO CENTROID in.

.267

.132

.128

MIN RADIUS

.187

.378

.267

MEAN RADIUS

1.157

1.044

.951

MAX RADIUS

2.035

1.690

1.543

HORIZONTAL SPREAD

3.238

2.857

1.686

VERTICAL SPREAD

2.778

2.778

2.719

EXTREME SPREAD

3.472

3.340

2.865

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

6

Stock Needs
Repair on Tip
=