

C6648954

MODEL 700™ M24

Model **515**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6648954

ORDER NO.
5716

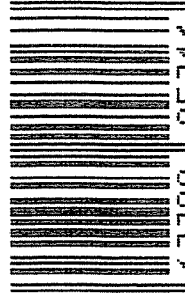
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6648954

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648954

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 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		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)		7/22/91	LB
	Apply Coating (Bolt)		7/22/91	LB
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	HL

op. #	BARBER M24 0033728	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-21-91	D/H
	G) Safety Off Force	2 1/2	2 1/2	2 1/4			8-21-91	D/H
	H) Trigger Pull Test & Retainability						8/21/91	SM
	I) Firing Pin Indent	.021	.020	.020			8-21-91	D/H
	J) Assemble Stock						8/26/91	RW
	K) Assemble Swivel Studs						8-26-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/26/91	RW
	M) Iron Sight Alignment						8/26/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/26/91	RW
	O) Attach Scope to Rifle						8/26/91	RW
	P) Detach & Attach Scope 20 Times						8/26/91	RW
640	Gallery Target & Test						8-26-91	AC
	A) Time						8-26-91	AC
	B) Malfunctions						8-26-91	AC
	C) Pierced Primers						8-26-91	AC
	D) Optical Clarity of Scope						8-26-91	AC
645	Inspect for Live Ammo						8-26-91	AC
655	Final Inspection						8-26-91	D/H
	A) Headspace							
	B) Trigger Pull	264	264	252	248	263	8-26-91	D/H
	C) Function						8-26-91	D/H
660	Pack						9-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6648954

DATE 8-21-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.60	2.41	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.41	2.44	2.64	
PULL #3	2.54	2.65	2.54	2.52	
PULL #4	2.61	2.59	2.48	2.48	
PULL #5	2.58	2.50	2.58	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.30		
PULL #2	3.41	3.28		
PULL #3	3.23	3.30		
PULL #4	3.34	3.34		
PULL #5	3.55	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.65		4.47
PULL #2	4.58	4.69		4.33
PULL #3	4.48	4.20		4.38
PULL #4	4.43	4.45		4.56
PULL #5	4.44	4.43		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648954
26 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0376962
1 TO	2	.15331
1 TO	3	.0629682
1 TO	4	.312021
1 TO	5	.278218

42 <---FOR

ADJUST: FOR THIS RIFLE IS: -.1192

ADJUST: FOR THIS RIFLE IS: .0552

ADJUST: RADIUS FOR THIS RIFLE IS: .131361

ADJUST: .7146

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648354

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.456

VS= 1.784

CS= 2.574

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.227

1.266

1.044

MINIMUM X

-1.229

-1.093

-.934

MAXIMUM Y

.843

.739

.745

MINIMUM Y

-.941

-.757

-.665

CENTROID X

-.035

-.171

-.330

CENTROID Y

.014

.118

.026

POA TO CENTROID in.

.038

.209

.331

1IN RADIUS

.301

.241

.188

2IN RADIUS

.838

.710

.598

3IN RADIUS

1.546

1.466

1.238

HORIZONTAL SPREAD

2.456

2.359

1.970

VERTICAL SPREAD

1.784

1.496

1.410

OVERALL SPREAD

2.574

2.568

2.036

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8646954

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HE= 1.573

VS= 2.325

GS= 2.787

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.845

.753

.573

MINIMUM X

-.828

-.689

-.595

MAXIMUM Y

1.578

.935

.876

MINIMUM Y

-.747

-.572

-.631

CENTROID X

.113

.205

.111

CENTROID Y

.054

-.121

-.062

POR TO CENTROID in.

.125

.238

.127

MIN RADIUS

.288

.214

.275

MEAN RADIUS

.769

.616

.587

MAX RADIUS

1.782

.935

.880

HORIZONTAL SPREAD

1.673

1.442

1.167

VERTICAL SPREAD

2.325

1.507

1.507

EXTREME SPREAD

2.787

1.613

1.598

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648354

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.036

VS= 1.126

GS= 2.049

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	.859	.755
MINIMUM X	-.954	-.834	-.593
MAXIMUM Y	.665	.644	.589
MINIMUM Y	-.461	-.482	-.537
CENTROID X	-.069	-.189	-.085
CENTROID Y	-.039	-.018	.037
POA TO CENTROID in.	.079	.190	.092
MIN RADIUS	.274	.193	.305
MEAN RADIUS	.689	.634	.601
MAX RADIUS	1.099	1.074	.958
HORIZONTAL SPREAD	2.036	1.693	1.348
VERTICAL SPREAD	1.126	1.126	1.126
EXTREME SPREAD	2.049	2.010	1.505
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648954

CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 10

3 in = 10

HS= .652

VS= 1.129

GS= 1.130

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.254	.272	.299
MINIMUM X	-.398	-.380	-.353
MAXIMUM Y	.636	.465	.412
MINIMUM Y	-.493	-.422	-.338
CENTROID X	-.341	-.359	-.386
CENTROID Y	.075	.004	.057
POR TO CENTROID in.	.349	.359	.390
MIN RADIUS	.097	.091	.050
MEAN RADIUS	.374	.324	.310
MAX RADIUS	.656	.536	.480
HORIZONTAL SPREAD	.652	.652	.652
VERTICAL SPREAD	1.129	.887	.751
EXTREME SPREAD	1.130	.998	.835
NUMBER IN ONE INCH CIRCLE =		7	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	

26 Aug 1993

FILE:/PATTERNING/CENTERFIRE_PATT/08548354

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HE = 3.219

VS = 2.282

GS = 3.772

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.891

.751

.611

MINIMUM X

-1.328

-1.117

-.768

MAXIMUM Y

1.356

1.288

.606

MINIMUM Y

-.926

-.994

-.833

CENTROID X

-.264

-.475

-.335

CENTROID Y

.172

.240

.079

POA TO CENTROID (in.)

.316

.532

.344

MIN RADIUS

.209

.421

.232

MEAN RADIUS

.903

.796

.650

MAX RADIUS

1.988

1.705

.952

HORIZONTAL SPREAD

3.219

1.868

1.379

VERTICAL SPREAD

2.282

2.282

1.439

EXTREME SPREAD

3.772

2.575

1.659

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8