

06649134

MODEL 700™ M24

Model 5145™

Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

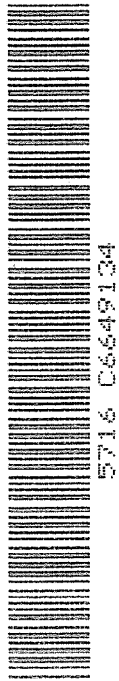
Capacity \_\_\_\_\_

Order No. 5715

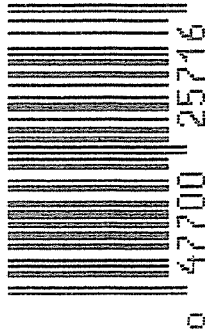
\*Includes 1 in chamber.



|                                                                                                                  |  |                                                                                                                                                 |
|------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------|
| <p><b>Remington</b><br/> <small>REG. U.S. PAT. &amp; TM. OFF.</small></p>                                        |  | <p><b>VERY IMPORTANT:</b><br/>         Instruction Book<br/>         enclosed to assure<br/>         safe use of this<br/>         firearm.</p> |
| <p><b>MODEL 700™ M24</b></p>                                                                                     |  | <p><b>SERIAL NO.</b><br/>         C6649134</p>                                                                                                  |
| <p><small>MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. &amp; Tm. Off. Marca Registrada Marque Deposee.</small></p> |  | <p><b>ORDER NO.</b><br/> <b>5716</b></p>                                                                                                        |



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

**C6649134**

| OP. #        | OP. NAME                                                       | READINGS | DATE         | INIT |
|--------------|----------------------------------------------------------------|----------|--------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/26/91      | KA   |
| 600          | Proof                                                          |          | 6/26/91      | KA   |
| 607          | Check Headspace                                                |          | 6/26/91      | KA   |
| 610          | Dis-assemble Gun                                               |          | 6/26/91      | KA   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 8 1991 | CS   |
|              | Magnaflux Bolt                                                 |          | JUL 1 8 1991 | CS   |
| 615          | Rollmark Caliber                                               |          | JUL 1 8 1991 | CS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 8 1991 | KB   |
| 618          | Polish Barrel                                                  |          | JUL 2 0 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8-7-91       | KA   |
|              | Apply Coating (Bolt)                                           |          |              |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/8/91       | KA   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/8/91       | KA   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/8/91       | KA   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/8/91       | KA   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8-10-91      | JCL  |

| op. #        | UP. NAME<br><b>BARBER, M24 0065200</b>                      | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 8-10-91 | DH   |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 8-10-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8-10-91 | SP   |
|              | I) Firing Pin Indent                                        | .022     | .021 | .022 |      |      | 8-10-91 | DH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8-13-91 | TK   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8-15-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8-13-91 | TK   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8-13-91 | TK   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8-13-91 | TK   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8-13-91 | TK   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8-13-91 | TK   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-14-91 | DH   |
|              | A) Time                                                     |          |      |      |      |      | 8-14-91 | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-14-91 | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-14-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-14-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-14-91 | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      | 8-15-91 | DH   |
|              | A) Headspace                                                |          |      |      |      |      | 8-15-91 | DH   |
|              | B) Trigger Pull                                             | 2.47     | 2.42 | 2.48 | 2.54 | 2.45 | 8-14-91 | SP   |
|              | C) Function                                                 |          |      |      |      |      | 8-15-91 | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 9-19-91 | AF   |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06649134  
23 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .19901  |
| 1 TO | 2 | .105304 |
| 1 TO | 3 | .24969  |
| 1 TO | 4 | .154055 |
| 1 TO | 5 | .526047 |

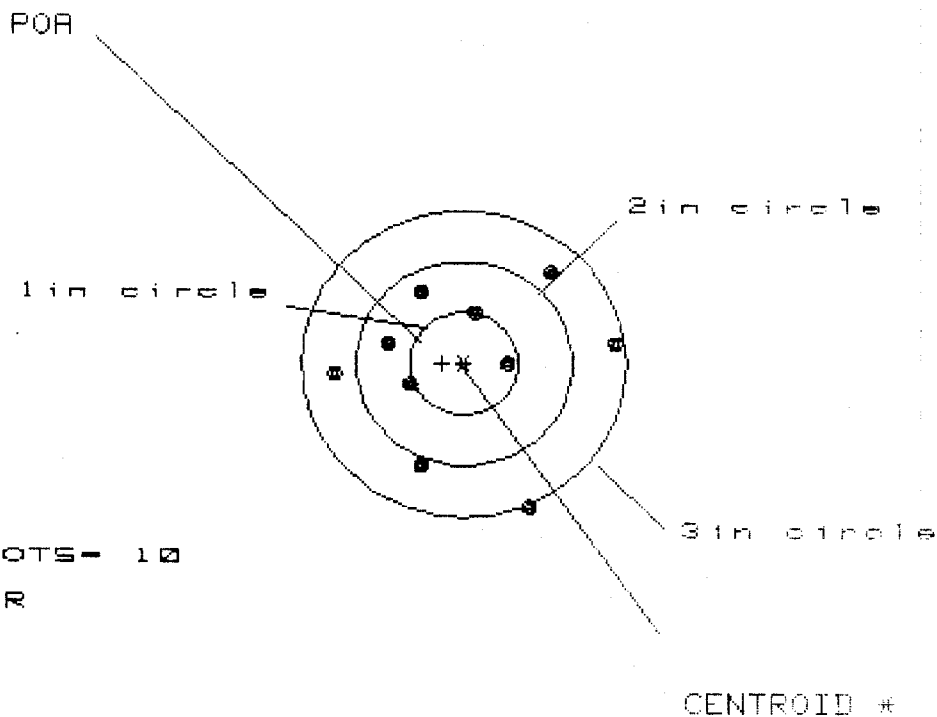
4.3 <----POA  
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2088  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1586  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .604531  
THE AMR FOR THIS RIFLE IS: .9432

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6849134

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.536

VS= 2.300

GS= 2.559

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.360  | 1.421  | .996   |
| MINIMUM X                   | : | -1.176 | -1.115 | -.937  |
| MAXIMUM Y                   | : | .899   | .744   | .754   |
| MINIMUM Y                   | : | -1.401 | -1.107 | -1.097 |
| CENTROID X                  | : | .199   | .138   | -.040  |
| CENTROID Y                  | : | -.002  | .153   | .143   |
| POA TO CENTROID in.         | : | .199   | .206   | .149   |
| MIN RADIUS                  | : | .399   | .354   | .397   |
| MEAN RADIUS                 | : | .925   | .834   | .740   |
| MAX RADIUS                  | : | 1.505  | 1.424  | 1.249  |
| HORIZONTAL SPREAD           | : | 2.536  | 2.536  | 1.933  |
| VERTICAL SPREAD             | : | 2.300  | 1.851  | 1.851  |
| EXTREME SPREAD              | : | 2.559  | 2.559  | 2.196  |
| NUMBER IN ONE INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 9      |        |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6649134

## CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS - 10

# IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.083

VS= 1.570

GS= 3.172

| PATTERN #                   | : | 10     | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.307  | 1.109  | .715  |
| MINIMUM X                   | : | -1.776 | -1.012 | -.873 |
| MAXIMUM Y                   | : | .953   | .902   | .932  |
| MINIMUM Y                   | : | -.617  | -.668  | -.638 |
| CENTROID X                  | : | .099   | .297   | .158  |
| CENTROID Y                  | : | -.035  | .016   | -.014 |
| POA TO CENTROID in.         | : | .105   | .297   | .159  |
| MIN RADIUS                  | : | .092   | .222   | .115  |
| MEAN RADIUS                 | : | .875   | .744   | .693  |
| MAX RADIUS                  | : | 1.834  | 1.208  | 1.144 |
| HORIZONTAL SPREAD           | : | 3.083  | 2.121  | 1.588 |
| VERTICAL SPREAD             | : | 1.570  | 1.570  | 1.570 |
| EXTREME SPREAD              | : | 3.172  | 2.180  | 1.794 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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FILE:/PATTERNING/CENTERFIRE\_PATT/CG649134

## CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.136

VS= 3.252

GS= 3.604

| PATTERN #                   | : | 10     | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.263  | 1.189 | 1.128 |
| MINIMUM X                   | : | -.873  | -.947 | -.799 |
| MAXIMUM Y                   | : | 1.378  | 1.170 | 1.290 |
| MINIMUM Y                   | : | -1.874 | -.741 | -.621 |
| CENTROID X                  | : | .426   | .500  | .352  |
| CENTROID Y                  | : | -.106  | .102  | -.018 |
| POA TO CENTROID in.         | : | .439   | .511  | .352  |
| MIN RADIUS                  | : | .061   | .255  | .097  |
| MEAN RADIUS                 | : | 1.043  | .960  | .838  |
| MAX RADIUS                  | : | 1.990  | 1.528 | 1.337 |
| HORIZONTAL SPREAD           | : | 2.136  | 2.136 | 1.927 |
| VERTICAL SPREAD             | : | 3.252  | 1.911 | 1.911 |
| EXTREME SPREAD              | : | 3.604  | 2.670 | 2.192 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8     |       |

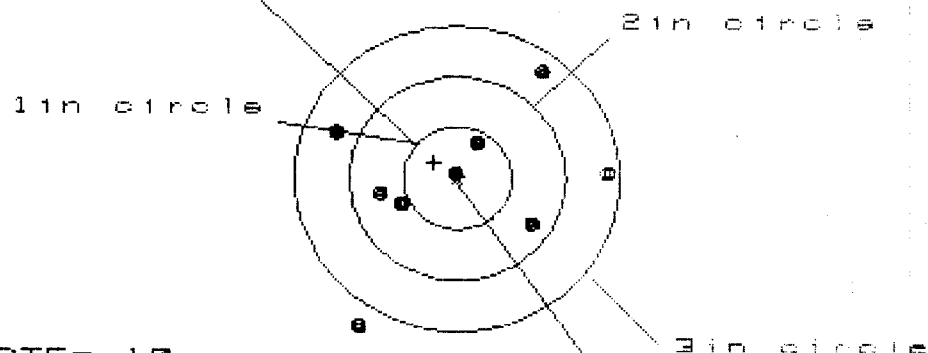


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FILE:/PATTERNING/CENTERFIRE\_PATT/C6649134

## CENTERFIRE PATTERNS # 4

FOR



# OF SHOTS - 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.510

VS= 2.471

GS= 2.973

CENTROID X

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.384  | 1.287  | .844   |
| MINIMUM X                     | -1.126 | -1.223 | -1.063 |
| MAXIMUM Y                     | 1.007  | .844   | .834   |
| MINIMUM Y                     | -1.464 | -.640  | -.650  |
| CENTROID X                    | .217   | .314   | .153   |
| CENTROID Y                    | -.155  | .008   | .018   |
| FOR TO CENTROID in.           | .267   | .314   | .155   |
| MIN RADIUS                    | .091   | .146   | .094   |
| MEAN RADIUS                   | .850   | .731   | .654   |
| MAX RADIUS                    | 1.705  | 1.289  | 1.186  |
| HORIZONTAL SPREAD             | 2.510  | 2.510  | 1.906  |
| VERTICAL SPREAD               | 2.471  | 1.484  | 1.484  |
| EXTREME SPREAD                | 2.973  | 2.536  | 2.001  |
| NUMBER IN ONE INCH CIRCLE =   |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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FILE:/PATTERNS/CENTERFIRE\_PATT/C0045154

## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS - 10

# IN CIR

1in = 0

2in = 5

3in = 9

MS = 1.930

VS = 2.626

GS = 3.085

CENTROID #

| PATTERN #                   | 10     | 9      | 8     |
|-----------------------------|--------|--------|-------|
| SHOTS (BEST OF)             | 10     | 9      | 8     |
| MAXIMUM X                   | .900   | .900   | .901  |
| MINIMUM X                   | -.950  | -1.022 | -.908 |
| MAXIMUM Y                   | 1.029  | .852   | .913  |
| MINIMUM Y                   | -1.597 | -1.064 | -.958 |
| CENTROID X                  | .353   | .425   | .311  |
| CENTROID Y                  | -.505  | -.328  | -.424 |
| POA TO CENTROID in.         | .617   | .536   | .534  |
| MIN RADIUS                  | .502   | .497   | .502  |
| MEAN RADIUS                 | 1.023  | .934   | .890  |
| MAX RADIUS                  | 1.720  | 1.302  | 1.288 |
| HORIZONTAL SPREAD           | 1.930  | 1.930  | 1.849 |
| VERTICAL SPREAD             | 2.626  | 1.916  | 1.871 |
| EXTREME SPREAD              | 3.085  | 2.402  | 2.266 |
| NUMBER IN ONE INCH CIRCLE   | =      | 0      |       |
| NUMBER IN TWO INCH CIRCLE   | =      | 5      |       |
| NUMBER IN THREE INCH CIRCLE | =      | 9      |       |

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

SERIAL NO. 06649134DATE 8-10-91TESTER JY

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.54             | 2.17                     | 2.32                           | 2.47 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.20             | 2.43                     | 2.30                           | 2.42 |                                                                        |
| PULL #3 | 2.20             | 2.43                     | 2.43                           | 2.48 |                                                                        |
| PULL #4 | 2.17             | 2.36                     | 2.46                           | 2.54 |                                                                        |
| PULL #5 | 2.18             | 2.29                     | 2.30                           | 2.45 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.27             | 3.32                     |  |          |
| PULL #2 | 3.24             | 3.32                     |  |          |
| PULL #3 | 3.38             | 3.43                     |  |          |
| PULL #4 | 3.19             | 3.42                     |  |          |
| PULL #5 | 3.25             | 3.31                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.19             | 4.46                     |                                | 4.50                                 |
| PULL #2 | 4.38             | 4.36                     |                                | 4.49                                 |
| PULL #3 | 4.43             | 4.54                     |                                | 4.53                                 |
| PULL #4 | 4.43             | 4.54                     |                                | 4.60                                 |
| PULL #5 | 4.37             | 4.56                     |                                | 4.57                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |