

C8649156

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700TM M24

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

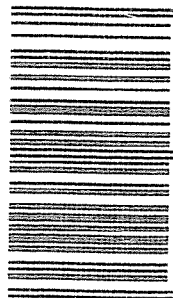
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6649156

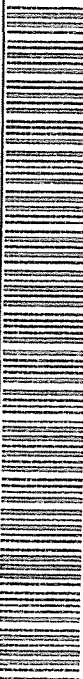
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649156

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649156

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		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	JS
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7/22/91	JS
	Apply Coating (Bolt)		7/22/91	JS
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/5/91	JS

op. #	BARBER M24 0065450	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 $\frac{1}{4}$	6			9-5-91	DH
	G) Safety Off Force	4	4	4			9-5-91	DH
	H) Trigger Pull Test & Retainability						9/5/91	921
	I) Firing Pin Indent	1.022	1.021	1.021			9-5-91	DH
	J) Assemble Stock						9/5/91	RW
	K) Assemble Swivel Studs						9-10-91	AC
	L) Attach Front and Rear Sight Assemblies						9/5/91	RW
	M) Iron Sight Alignment						9/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/91	RW
	O) Attach Scope to Rifle						9/5/91	RW
	P) Detach & Attach Scope 20 Times						9/5/91	RW
640	Gallery Target & Test						9-5-91	DH
	A) Time						9-5-91	DH
	B) Malfunctions						9-5-91	DH
	C) Pierced Primers						9-5-91	DH
	D) Optical Clarity of Scope						9-5-91	DH
645	Inspect for Live Ammo						9-5-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	2.26	2.32	2.29	2.36	2.37	9-6-91	921
	C) Function						9-10-91	AC
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649156DATE 9-5-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.52	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.41	2.48	2.32	
PULL #3	2.35	2.48	2.44	2.29	
PULL #4	2.36	2.46	2.50	2.36	
PULL #5	2.45	2.51	2.46	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.47		
PULL #2	3.43	3.43		
PULL #3	3.44	3.49		
PULL #4	3.47	3.52		
PULL #5	3.43	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.20		4.31
PULL #2	4.18	4.26		4.35
PULL #3	4.22	4.33		4.22
PULL #4	4.21	4.32		4.36
PULL #5	4.23	4.34		4.38
TOTAL				
AVG.				

0	TO	1	.142443
1	TO	2	.144617
1	TO	3	.574346
1	TO	4	.366175
1	TO	5	.521525

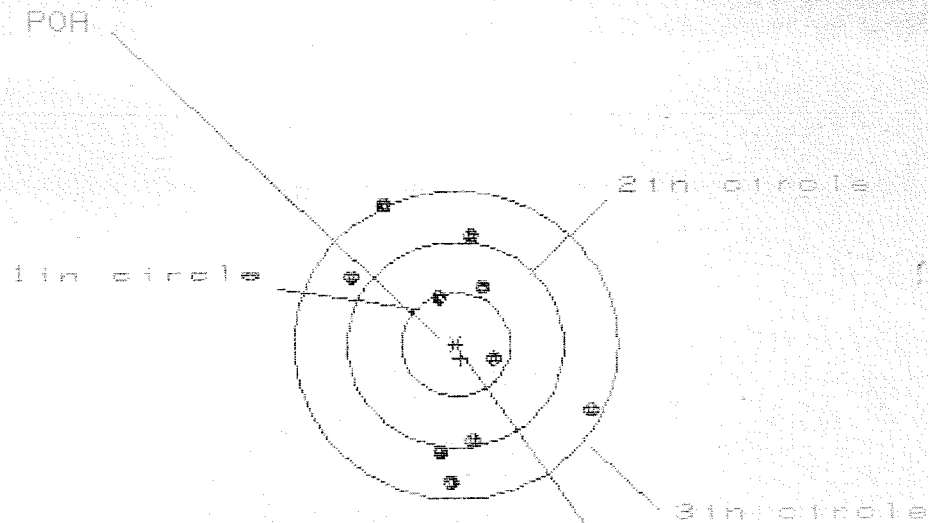
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BARBER - M24 **M2400065491**

5 SEP 1991

FILE:/PATTERNING/CENTERFIRE PATT/CG648156

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

#IN CIR








$$\text{Phenol} \xrightarrow{\text{HNO}_3/\text{H}_2\text{SO}_4} \text{2-nitrophenol} \xrightarrow{\text{HNO}_3/\text{H}_2\text{SO}_4} \text{2,4-dinitrophenol}$$

NBS Special Publication 500-10-101
 Gaithersburg, MD 20899-1010

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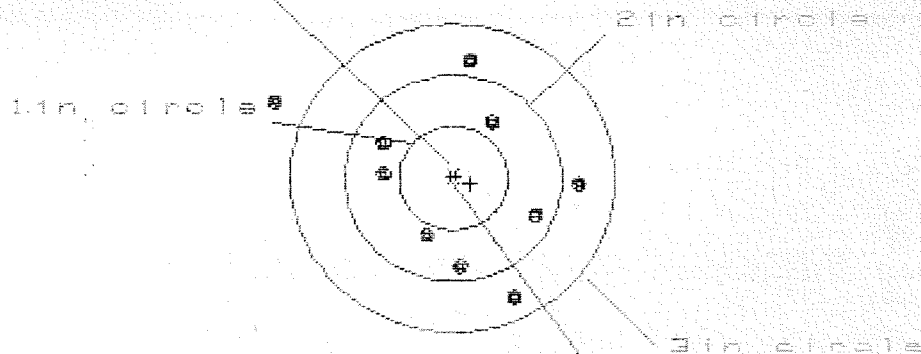
MAXIMUM	X	:	1.240	1.165	.434
MINIMUM	X	:	-1.003	-1.078	-.932
MAXIMUM	Y	:	1.371	1.228	1.163
MINIMUM	Y	:	-1.366	-1.213	-1.272
CENTROID	X	:	-.039	.036	-.110
CENTROID	Y	:	.137	-.016	.043
POA TO CENTROID	in.	:	.142	.039	.118
MIN RADIUS	:	:	.382	.290	.435
MEAN RADIUS	:	:	1.004	.937	.899
MAX RADIUS	:	:	1.527	1.335	1.272
HORIZONTAL SPREAD	:	:	2.243	2.243	1.366
VERTICAL SPREAD	:	:	2.737	2.441	2.441
EXTREME SPREAD	:	:	2.798	2.570	2.450
NUMBER IN ONE	INCH CIRCLE	=		1	
NUMBER IN TWO	INCH CIRCLE	=		4	
NUMBER IN THREE	INCH CIRCLE	=		9	

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649156

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 2.864

VS= 2.326

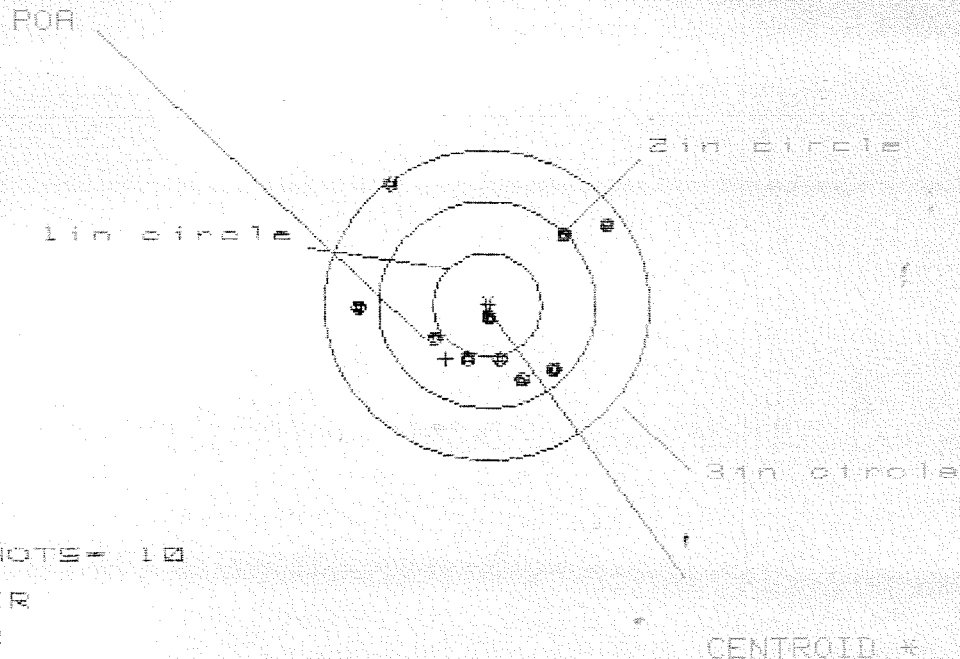
GS= 2.966

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.193	1.007	1.054
MINIMUM X	-1.671	-.794	-.747
MAXIMUM Y	1.182	1.266	1.133
MINIMUM Y	-1.144	-1.060	-.879
CENTROID X	-.156	.030	-.017
CENTROID Y	.052	-.032	.100
POA TO CENTROID in.	.164	.044	.102
MIN RADIUS	.608	.656	.564
MEAN RADIUS	.982	.874	.837
MAX RADIUS	1.833	1.266	1.134
HORIZONTAL SPREAD	2.864	1.801	1.801
VERTICAL SPREAD	2.326	2.326	2.012
EXTREME SPREAD	2.966	2.358	2.010
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.273

VS = 1.825

GS = 2.408

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.068

.970

.729

MINIMUM X

-1.205

-1.303

-1.182

MAXIMUM Y

1.147

.945

.960

MINIMUM Y

-.678

-.551

-.432

CENTROID X

.389

.487

.366

CENTROID Y

.520

.393

.275

POA TO CENTROID in.

.649

.626

.458

MIN RADIUS

.140

.114

.107

MEAN RADIUS

.836

.729

.606

MAX RADIUS

1.449

1.354

1.212

HORIZONTAL SPREAD

2.273

2.273

1.911

VERTICAL SPREAD

1.825

1.496

1.392

EXTREME SPREAD

2.408

2.408

2.032

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

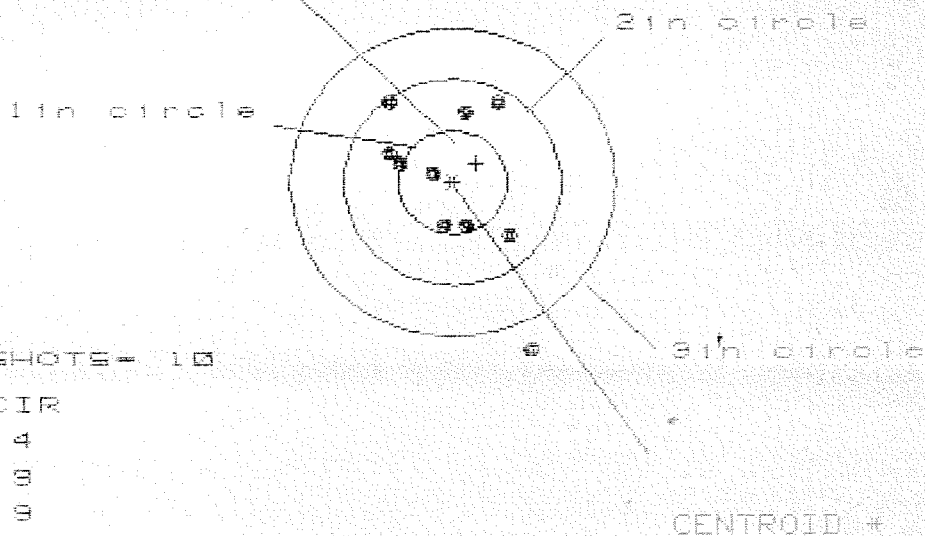
10

5 Sep 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 9

HS = 1.317

VS = 2.394

GS = 2.707

CENTROID +

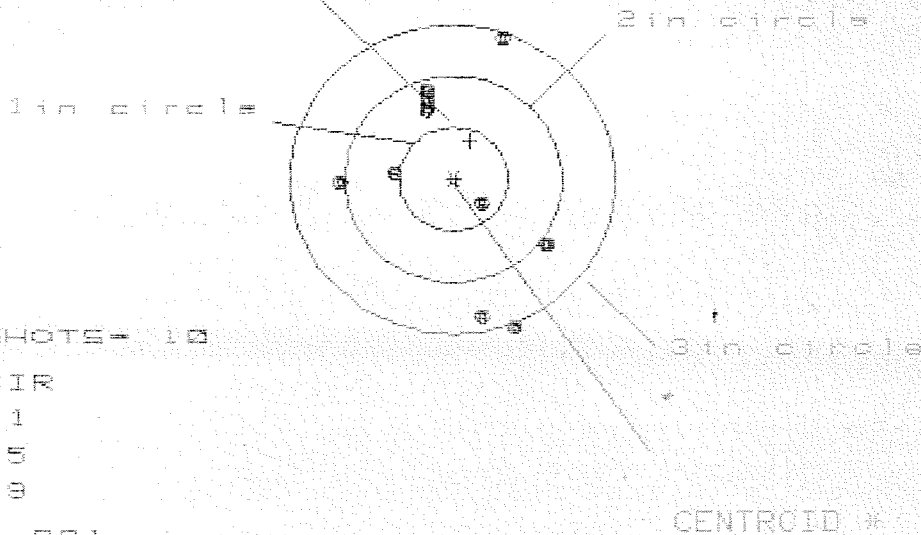
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.701	.622	.562
MINIMUM X	-.616	-.539	-.599
MAXIMUM Y	.819	.644	.713
MINIMUM Y	-1.575	-.706	-.626
CENTROID X	-.217	-.294	-.234
CENTROID Y	-.183	-.008	-.088
POA TO CENTROID in.	.283	.295	.250
MIN RADIUS	.240	.183	.213
MEAN RADIUS	.742	.610	.585
MAX RADIUS	1.724	.942	.850
HORIZONTAL SPREAD	1.317	1.161	1.161
VERTICAL SPREAD	2.394	1.350	1.339
EXTREME SPREAD	2.707	1.746	1.443
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.891

VS= 2.738

GS= 2.739

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.819
MINIMUM X	-1.072
MAXIMUM Y	1.322
MINIMUM Y	-1.416
CENTROID X	-.157
CENTROID Y	-.371
POA TO CENTROID in.	.402
MIN RADIUS	.349
MEAN RADIUS	.975
MAX RADIUS	1.517
HORIZONTAL SPREAD	1.891
VERTICAL SPREAD	2.738
EXTREME SPREAD	2.739
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9