

C6649226

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

* 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.
06649226

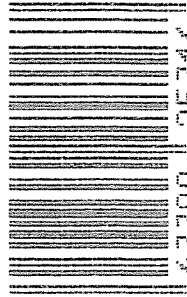
ORDER NO.
5716

MADE IN U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 06649226

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649226

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	91	RW
600	Proof	6 25	91	RW
607	Check Headspace	6 25	91	RW
610	Dis-assemble Gun	6 25	91	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LG
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	12
	Apply Coating (Bolt)			
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		9-6-91	DH

op. #	BARBER M24 0066677	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9-6-91	DH
	G) Safety Off Force	3	3	3			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	.021	.020	.021			9-6-91	DH
	J) Assemble Stock						9/6/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/6/91	RW
	M) Iron Sight Alignment						9/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/91	RW
	O) Attach Scope to Rifle						9/6/91	RW
	P) Detach & Attach Scope 20 Times						9/6/91	RW
640	Gallery Target & Test						9-9-91	AC
	A) Time						9-9-91	AC
	B) Malfunctions						9-9-91	AC
	C) Pierced Primers						9-9-91	AC
	D) Optical Clarity of Scope						9-9-91	AC
645	Inspect for Live Ammo						9-9-91	AC
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	241	245	225	240	233	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

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

SERIAL NO. CCC49226
DATE 7-6-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.34	2.53	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.12	2.19	2.45	
PULL #3	2.52	2.27	2.43	2.25	
PULL #4	2.55	2.22	2.33	2.40	
PULL #5	2.54	2.15	2.51	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.17		
PULL #2	3.42	3.32		
PULL #3	3.35	3.05		
PULL #4	3.23	3.28		
PULL #5	3.39	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.29		4.27
PULL #2	4.33	4.28		4.30
PULL #3	4.33	4.39		4.43
PULL #4	4.28	4.28		4.53
PULL #5	4.28	4.17		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649226
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.131103
1 TO	2	.131187
1 TO	3	.453475
1 TO	4	.306007
1 TO	5	.204436

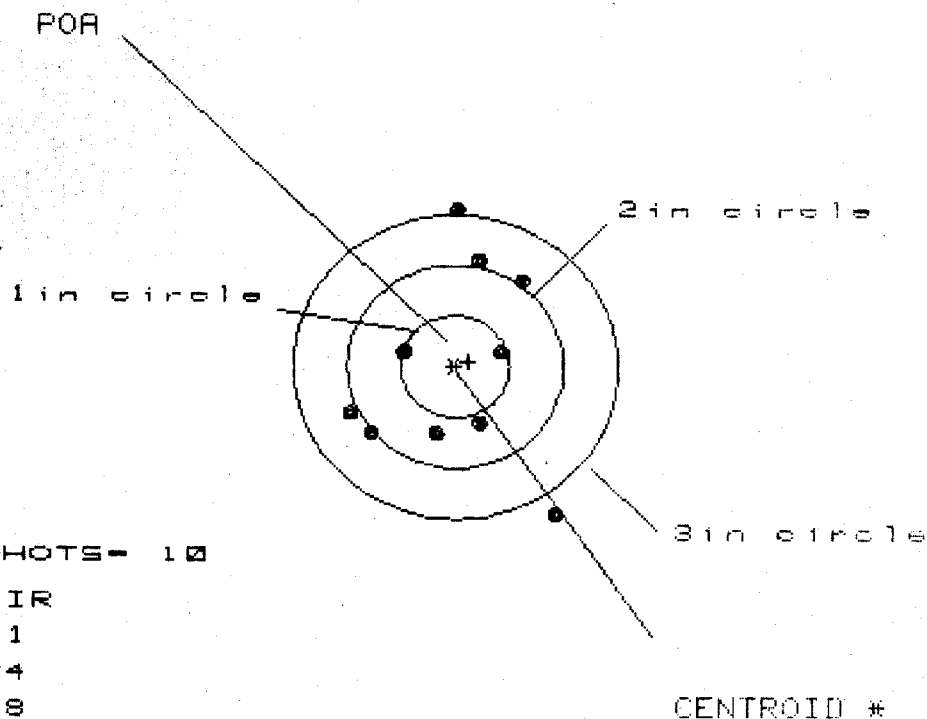
$\frac{5}{4} \frac{1}{3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1932
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.13
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .232865
THE AMR FOR THIS RIFLE IS: .8828

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649226

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.911

VS= 2.929

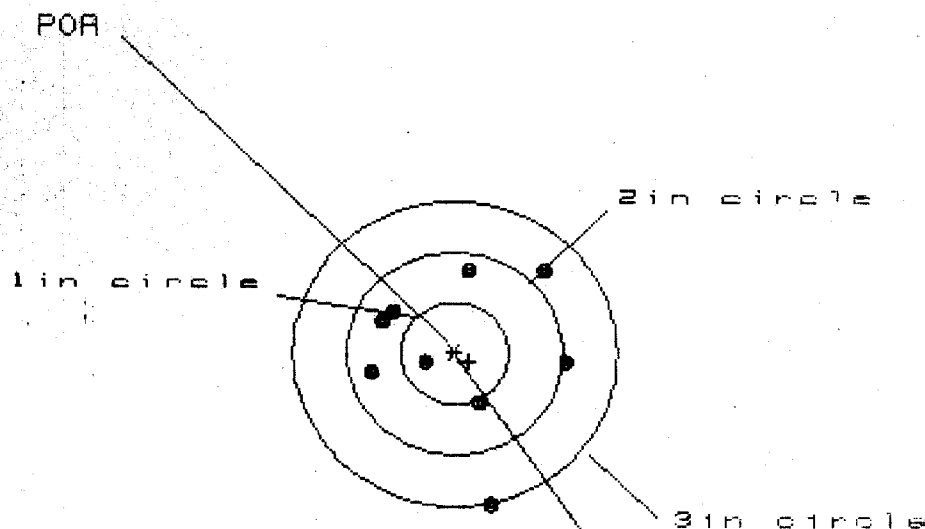
GS= 3.079

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.947	.711	.724
MINIMUM X	-.964	-.858	-.845
MAXIMUM Y	1.500	1.341	1.050
MINIMUM Y	-1.429	-.827	-.659
CENTROID X	-.122	-.228	-.241
CENTROID Y	-.048	.111	-.057
POA TO CENTROID in.	.131	.253	.247
MIN RADIUS	.463	.392	.418
MEAN RADIUS	.961	.873	.792
MAX RADIUS	1.715	1.345	1.100
HORIZONTAL SPREAD	1.911	1.569	1.569
VERTICAL SPREAD	2.929	2.168	1.709
EXTREME SPREAD	3.079	2.307	2.040
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.864

VS= 2.311

GS= 2.320

CENTROID *

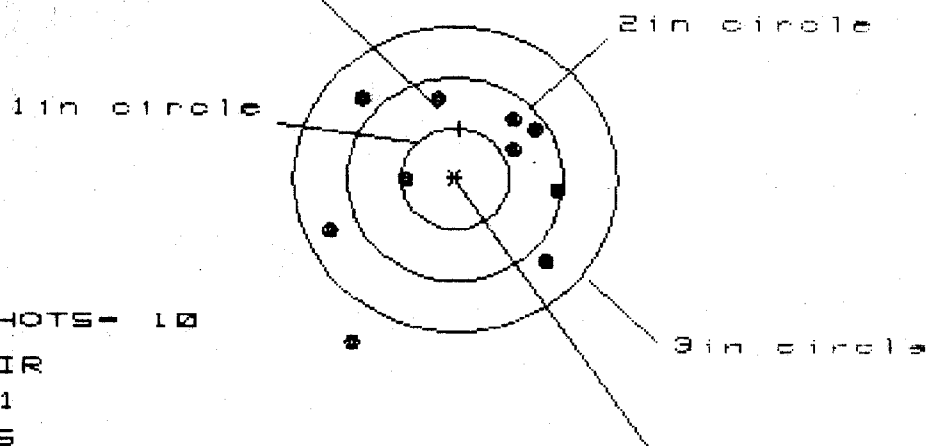
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.060	1.098	1.206
MINIMUM X	-.804	-.766	-.658
MAXIMUM Y	.860	.699	.780
MINIMUM Y	-1.451	-.682	-.601
CENTROID X	-.129	-.167	-.275
CENTROID Y	.083	.244	.162
POA TO CENTROID in.	.153	.296	.320
MIN RADIUS	.226	.272	.140
MEAN RADIUS	.795	.709	.617
MAX RADIUS	1.490	1.131	1.221
HORIZONTAL SPREAD	1.864	1.864	1.864
VERTICAL SPREAD	2.311	1.381	1.381
EXTREME SPREAD	2.320	1.936	1.867
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.121

VS= 2.443

GS= 2.732

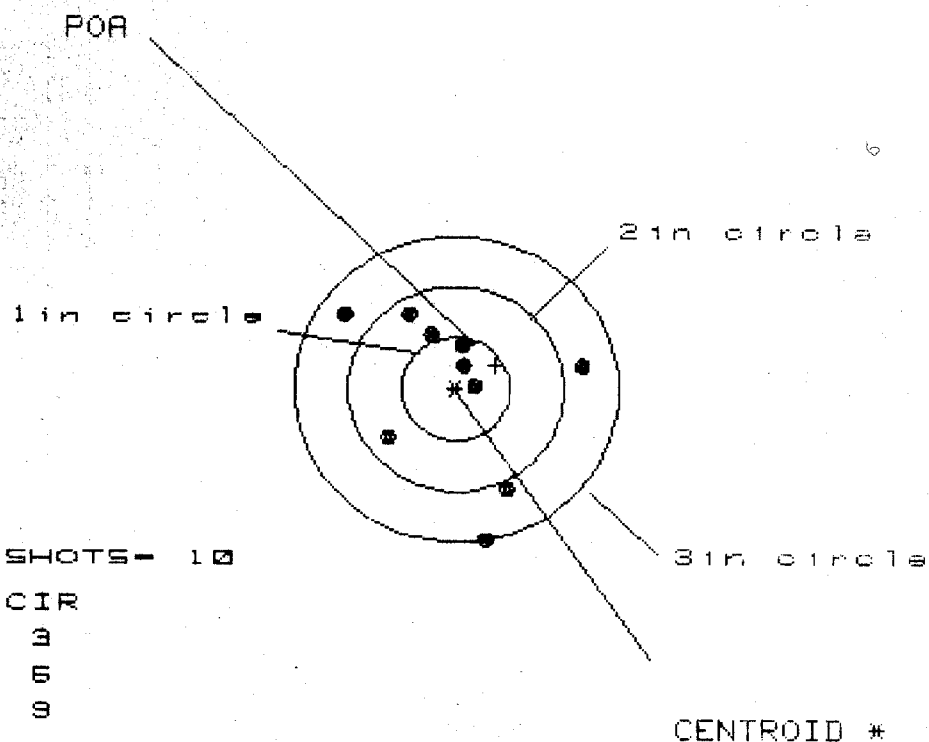
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.931	.822	.660
MINIMUM X	-1.190	-1.299	-1.090
MAXIMUM Y	.796	.613	.528
MINIMUM Y	-1.647	-.957	-1.042
CENTROID X	-.040	.069	.231
CENTROID Y	-.494	-.311	-.226
POA TO CENTROID in.	.495	.318	.323
MIN RADIUS	.425	.496	.321
MEAN RADIUS	1.001	.853	.732
MAX RADIUS	1.915	1.462	1.204
HORIZONTAL SPREAD	2.121	2.121	1.750
VERTICAL SPREAD	2.443	1.570	1.570
EXTREME SPREAD	2.732	2.275	2.275
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 2

HS= 2.257

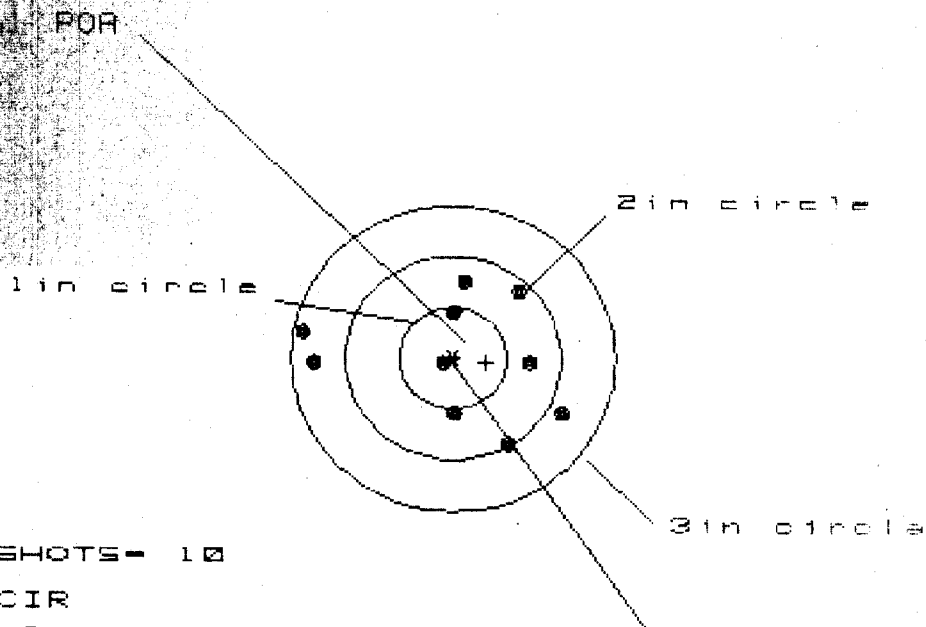
VS= 2.267

GS= 2.643

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	1.247	1.121
MINIMUM X	-1.045	-1.010	-0.765
MAXIMUM Y	.749	.580	.629
MINIMUM Y	-1.518	-1.139	-1.066
CENTROID X	-.360	-.403	-.277
CENTROID Y	-.230	-.061	-.134
POA TO CENTROID in.	.434	.408	.307
MIN RADIUS	.181	.168	.092
MEAN RADIUS	.829	.706	.644
MAX RADIUS	1.550	1.253	1.138
HORIZONTAL SPREAD	2.257	2.257	1.886
VERTICAL SPREAD	2.267	1.719	1.695
EXTREME SPREAD	2.643	2.322	1.997
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

FILE: PATTERNING/CENTERFIRE_PATT/C6649226

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.403

VS = 1.645

GS = 2.505

PATTERN #	10	9	8
SHOTS (BEST CF)	10	9	8
MAXIMUM X	.972	.813	.635
MINIMUM X	-1.431	-1.423	-.478
MAXIMUM Y	.774	.798	.790
MINIMUM Y	-.871	-.847	-.855
CENTROID X	-.307	-.148	.030
CENTROID Y	.039	.015	.023
POA TO CENTROID in.	.309	.149	.038
MIN RADIUS	.166	.307	.357
MEAN RADIUS	.828	.747	.653
MAX RADIUS	1.447	1.424	.876
HORIZONTAL SPREAD	2.403	2.236	1.113
VERTICAL SPREAD	1.645	1.645	1.645
EXTREME SPREAD	2.505	2.273	1.711
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		