

C6649231

MODEL 700™ M24

Model **515**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

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

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

MODEL 700™ M24

SERIAL NO.
C6649231

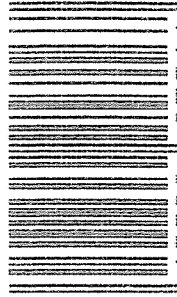
ORDER NO.
5716

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



5716 C6649231

UPC



0 47700 25716

7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649231

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KA
600	Proof		7/24/91	KA
607	Check Headspace		7/24/91	KA
610	Dis-assemble Gun		7/24/91	KA
612	Magnaflux Barrel Action	AUG 7	1991	KR
	Magnaflux Bolt	AUG 7	1991	KR
615	Rollmark Caliber	AUG 7	1991	SB
617	Drill and Tap Sight Holes	AUG 7	1991	FB
618	Polish Barrel	AUG 13	1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	KA
	Apply Coating (Bolt)		8/27/91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KA
	C) Inspect Ejector Hole for Chamfer		8/29/91	KA
	D) Oil Firing Pin Ass'y		8/29/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/91	KA

op. #	BARBER M24 0066733	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/30/91	SH
	G) Safety Off Force	4	4	4			8/30/91	SH
	H) Trigger Pull Test & Retainability						8/30/91	SH
	I) Firing Pin Indent	.025	.021	.021			8/30/91	SH
	J) Assemble Stock						8/30/90	SH
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						8/30/91	SH
	M) Iron Sight Alignment						8/30/91	SH
	N) Detach Front & Rear Sights & place in numbered container						8/30/91	SH
	O) Attach Scope to Rifle						8/30/91	SH
	P) Detach & Attach Scope 20 Times						8/30/91	SH
640	Gallery Target & Test						9-4-91	DH
	A) Time						9-4-91	DH
	B) Malfunctions						9-4-91	DH
	C) Pierced Primers						9-4-91	DH
	D) Optical Clarity of Scope						9-4-91	DH
645	Inspect for Live Ammo						9-4-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	268	266	263	269	270	9-6-91	SH
	C) Function						9-10-91	DH
660	Pack						9-18-91	SH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649231

DATE 8/30/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.19	2.40	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.17	2.44	2.66	
PULL #3	2.29	2.44	2.40	2.63	
PULL #4	2.26	2.50	2.48	2.69	
PULL #5	2.19	2.46	2.50	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.32		
PULL #2	3.36	3.33		
PULL #3	3.47	3.48		
PULL #4	3.47	3.32		
PULL #5	3.37	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.45		4.56
PULL #2	4.42	4.52		4.52
PULL #3	4.39	4.49		4.60
PULL #4	4.53	4.56		4.40
PULL #5	4.49	4.39		4.62
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649231
4 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.616437
1 TO	2	.366853
1 TO	3	.940707
1 TO	4	.759084
1 TO	5	.389197

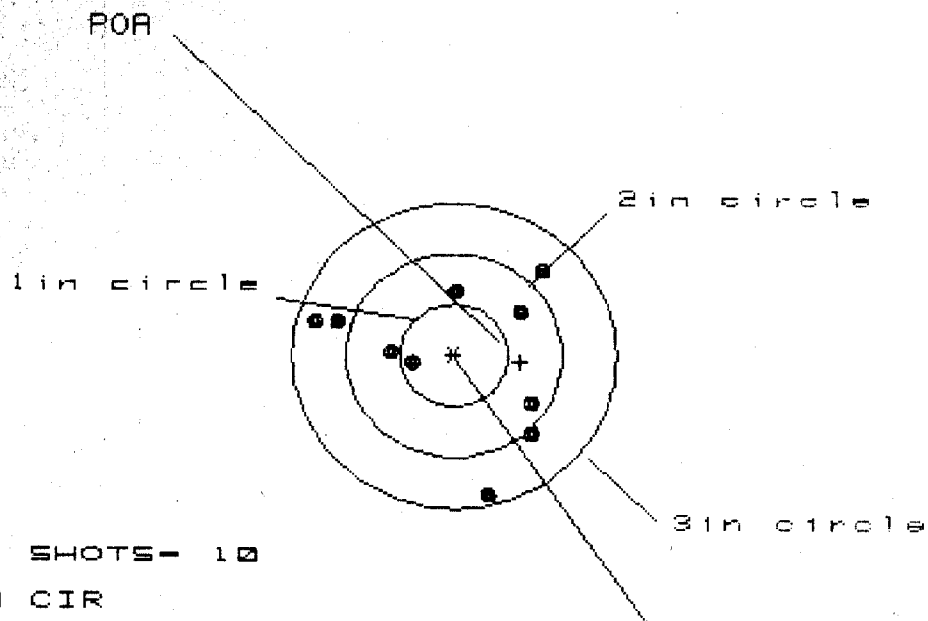
1st 2nd <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2112
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1376
AVERAGE POI RADIUS FOR THIS RIFLE IS: .25207
DIP FOR THIS RIFLE IS: .956

4 Sep 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 10

HS- 2.107

VS- 2.146

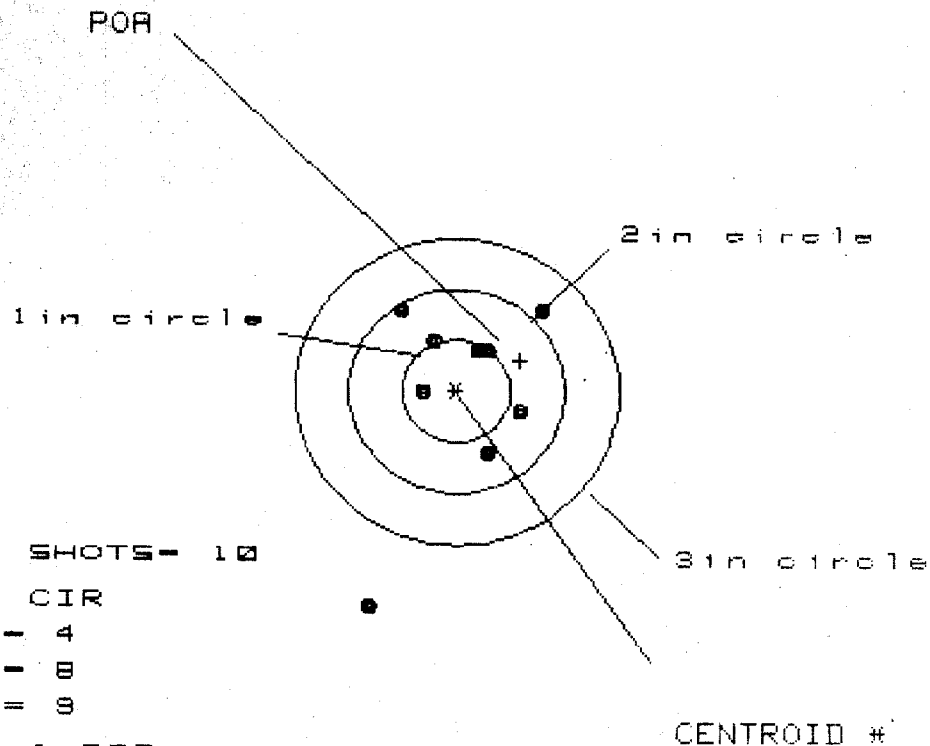
GS- 2.293

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.846	.885	.732
MINIMUM X	-1.261	-1.222	-1.177
MAXIMUM Y	.829	.683	.704
MINIMUM Y	-1.317	-.915	-.894
CENTROID X	-.613	-.652	-.499
CENTROID Y	.065	.211	.190
POA TO CENTROID in.	.617	.685	.534
MIN RADIUS	.372	.390	.517
MEAN RADIUS	.934	.871	.824
MAX RADIUS	1.362	1.234	1.195
HORIZONTAL SPREAD	2.107	2.107	1.909
VERTICAL SPREAD	2.146	1.598	1.598
EXTREME SPREAD	2.293	2.257	2.092
NUMBER IN ONE INCH CIRCLE =	1	5	10
NUMBER IN TWO INCH CIRCLE =	5	10	
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.558

VS= 2.945

GS= 3.332

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.755	.666	.587
MINIMUM X	-.803	-.613	-.530
MAXIMUM Y	.846	.612	.650
MINIMUM Y	-2.099	-.856	-.779
CENTROID X	-.588	-.499	-.582
CENTROID Y	-.301	-.067	-.144
POA TO CENTROID in.	.661	.504	.600
MIN RADIUS	.292	.200	.313
MEAN RADIUS	.770	.550	.512
MAX RADIUS	2.248	.905	.842
HORIZONTAL SPREAD	1.558	1.279	1.117
VERTICAL SPREAD	2.945	1.468	1.429
EXTREME SPREAD	3.332	1.663	1.663
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.838

VS= 1.968

GS= 2.917

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.642	1.197	1.007
MINIMUM X	:	-1.196	-1.014	-.864
MAXIMUM Y	:	.927	1.022	.903
MINIMUM Y	:	-1.041	-.946	-.732
CENTROID X	:	.286	.104	-.046
CENTROID Y	:	-.212	-.307	-.188
POA TO CENTROID in.	:	.356	.324	.194
MIN RADIUS	:	.463	.534	.403
MEAN RADIUS	:	.994	.875	.773
MAX RADIUS	:	1.850	1.526	1.053
HORIZONTAL SPREAD	:	2.838	2.211	1.871
VERTICAL SPREAD	:	1.968	1.968	1.635
EXTREME SPREAD	:	2.917	2.525	1.927
NUMBER IN ONE INCH CIRCLE	=	1	7	9
NUMBER IN TWO INCH CIRCLE	=	7	9	9
NUMBER IN THREE INCH CIRCLE	=	9	9	9

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FILE: /PATTERNING/CENTERFIRE_PATT/08649231

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

+ OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.680

VS= 2.740

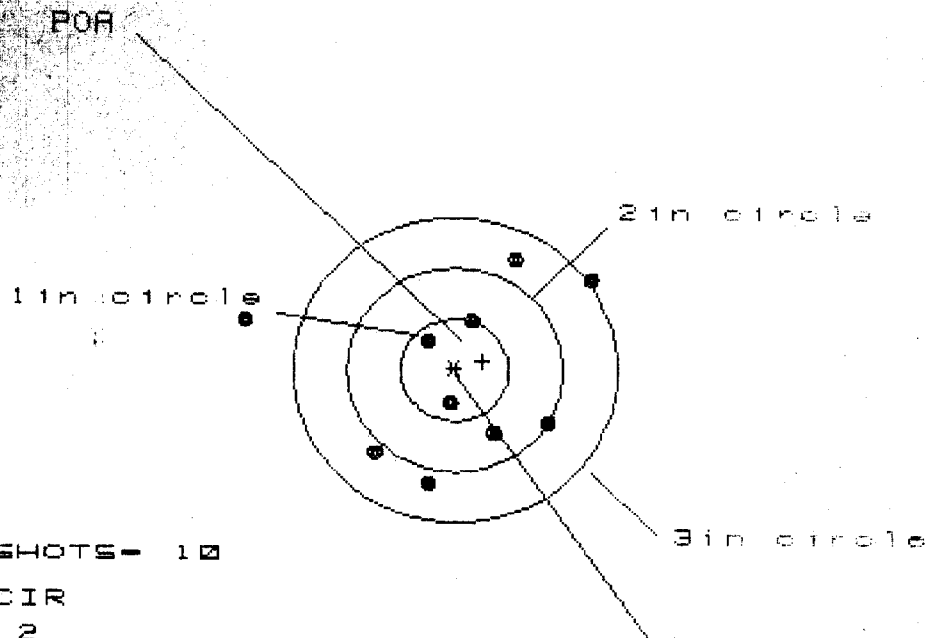
GS= 3.015

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.057	1.107	.910
MINIMUM X	-1.623	-1.573	-.976
MAXIMUM Y	1.032	.843	.871
MINIMUM Y	-1.708	-1.152	-1.124
CENTROID X	.115	.065	.262
CENTROID Y	-.150	.039	.011
POA TO CENTROID in.	.189	.076	.262
MIN RADIUS	.588	.419	.418
MEAN RADIUS	1.081	.972	.877
MAX RADIUS	1.765	1.598	1.446
HORIZONTAL SPREAD	2.680	2.680	1.986
VERTICAL SPREAD	2.740	1.995	1.995
EXTREME SPREAD	3.015	3.015	2.483
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	8	8	8

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.148

VS= 2.157

GS= 3.173

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.224	1.010	.810
MINIMUM X	-1.924	-.948	-.821
MAXIMUM Y	1.092	1.150	1.274
MINIMUM Y	-1.065	-1.007	-.883
CENTROID X	-.256	-.042	-.169
CENTROID Y	-.090	-.148	-.272
POA TO CENTROID in.	.271	.154	.320
MIN RADIUS	.344	.357	.185
MEAN RADIUS	1.001	.877	.780
MAX RADIUS	1.995	1.413	1.348
HORIZONTAL SPREAD	3.148	1.958	1.631
VERTICAL SPREAD	2.157	2.157	2.157
EXTREME SPREAD	3.173	2.609	2.303
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	