

C6611448

MODEL 700™ M24

Model 5145

Action

Barrel Length

Capacity

Order No.

5716

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611448
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611448

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JS

op. #	BARBER M24 0077038	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5			4-22-91	D/H
	G) Safety Off Force	4	4	4			4-22-91	D/H
	H) Trigger Pull Test & Retainability						4/19/91	824
	I) Firing Pin Indent	.021	.020	.022			4-22-91	D/H
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4-23-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-23-91	AF
655	Final Inspection							
	A) Headspace						5-2-91	D/H
	B) Trigger Pull	2.33	2.20	2.17	2.24	2.41	4/24/91	824
	C) Function						5-2-91	D/H
660	Pack						6-18-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 06611448DATE 4/19/91 (2)TESTER: J. J. H.

J. J. H.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.52	2.40	2.33	MIN. SETTING,
PULL #2	2.51	2.35	2.35	2.20	NO AVG. OF 5
PULL #3	2.39	2.14	2.48	2.17	READINGS ACCEPT-
PULL #4	2.46	2.53	2.43	2.24	ABLE LESS THAN 2#
PULL #5	2.44	2.42	2.46	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.22		
PULL #2	3.18	3.47		
PULL #3	3.26	3.18		
PULL #4	3.18	3.20		
PULL #5	3.23	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.42		4.37
PULL #2	4.54	4.50		4.59
PULL #3	4.57	4.20		4.38
PULL #4	4.51	4.47		4.41
PULL #5	4.35	4.55		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611448
23 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.106231
1 TO	2	.16311
1 TO	3	.183469
1 TO	4	.0661287
1 TO	5	.117414

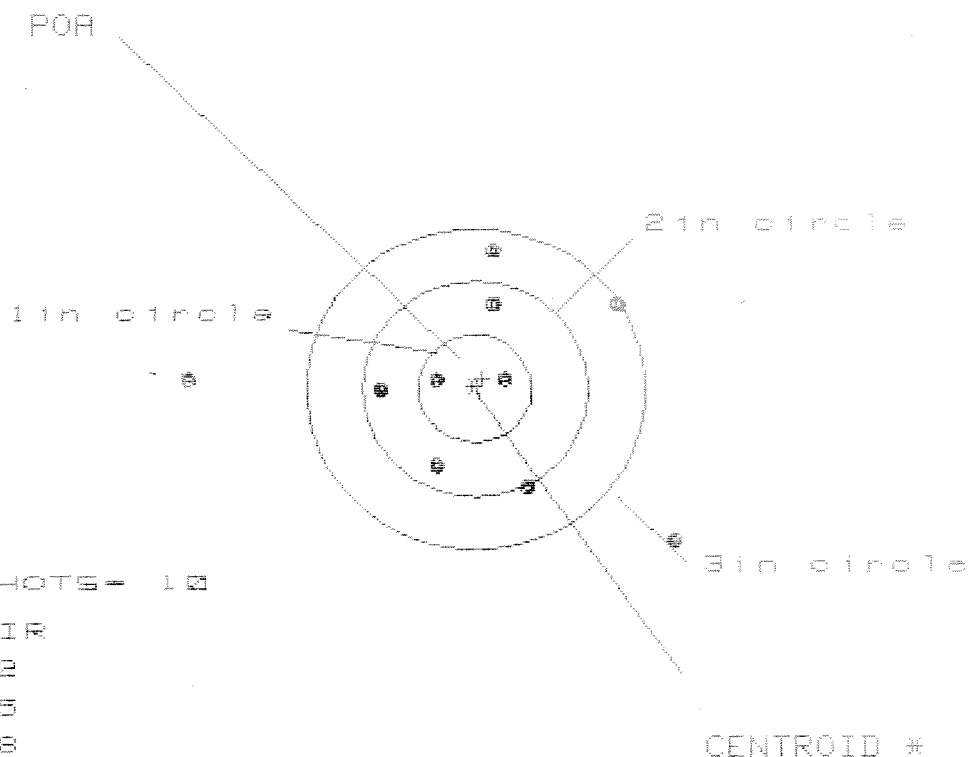
⊙ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .025
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0634
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .068151
THE AMR FOR THIS RIFLE IS: 1.032

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66A48

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 4.270

VS= 2.667

GS= 4.543

PATTERN #

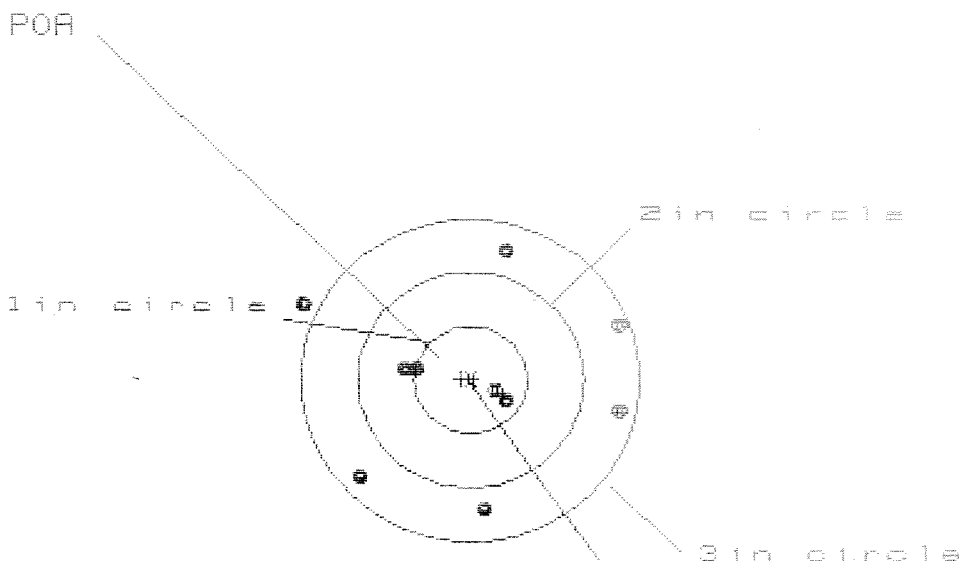
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.740	1.458	1.148
MINIMUM X	-2.530	-1.087	-.904
MAXIMUM Y	1.246	1.261	1.085
MINIMUM Y	-1.421	-1.406	-1.066
CENTROID X	-.058	.224	.041
CENTROID Y	-.089	-.104	.072
POA TO CENTROID in.	.106	.246	.083
MIN RADIUS	.288	.088	.200
MEAN RADIUS	1.162	1.007	.844
MAX RADIUS	2.534	2.026	1.310
HORIZONTAL SPREAD	4.270	2.545	2.052
VERTICAL SPREAD	2.667	2.667	2.151
EXTREME SPREAD	4.543	3.121	2.249
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 2.798

VS= 2.369

GS= 2.964

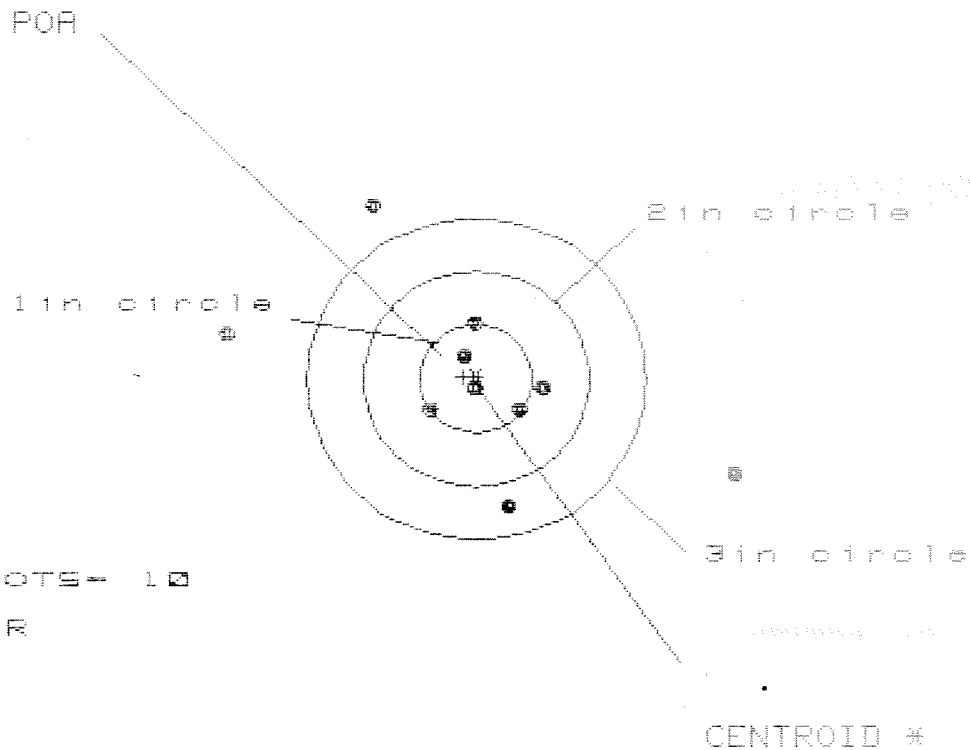
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.326	1.162	1.301
MINIMUM X	:	-1.472	-1.169	-1.030
MAXIMUM Y	:	1.192	1.268	1.338
MINIMUM Y	:	-1.177	-1.101	-1.031
CENTROID X	:	.083	.247	.108
CENTROID Y	:	-.007	-.083	-.153
POA TO CENTROID in.	:	.084	.261	.187
MIN RADIUS	:	.246	.069	.188
MEAN RADIUS	:	.985	.886	.845
MAX RADIUS	:	1.622	1.423	1.360
HORIZONTAL SPREAD	:	2.798	2.331	2.391
VERTICAL SPREAD	:	2.369	2.369	2.369
EXTREME SPREAD	:	2.964	2.663	2.439
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 7

HS= 4.506

VS= 2.806

GS= 4.682

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.311	.849	.607
MINIMUM X	-2.195	-1.939	-.914
MAXIMUM Y	1.646	1.550	1.589
MINIMUM Y	-1.160	-1.256	-1.217
CENTROID X	.112	-.144	.098
CENTROID Y	-.020	.076	.037
POA TO CENTROID in.	.114	.163	.105
MIN RADIUS	.104	.234	.162
MEAN RADIUS	1.018	.896	.690
MAX RADIUS	2.467	1.964	1.833
HORIZONTAL SPREAD	4.506	2.788	1.521
VERTICAL SPREAD	2.806	2.806	2.806
EXTREME SPREAD	4.682	3.066	3.066
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.956

VS= 2.179

GS= 4.006

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.497	1.224	1.355
MINIMUM X	:	-2.459	-1.327	-1.196
MAXIMUM Y	:	.733	.700	.515
MINIMUM Y	:	-1.446	-1.479	-.842
CENTROID X	:	-.035	.238	.107
CENTROID Y	:	-.027	.006	.191
POA TO CENTROID in.	:	.044	.238	.219
MIN RADIUS	:	.238	.344	.148
MEAN RADIUS	:	1.118	.939	.798
MAX RADIUS	:	2.477	1.814	1.360
HORIZONTAL SPREAD	:	3.956	2.551	2.551
VERTICAL SPREAD	:	2.179	2.179	1.357
EXTREME SPREAD	:	4.006	3.013	2.567
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.180

VS= 2.586

GS= 2.600

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.029	1.077	1.171
MINIMUM X	:	-1.151	-1.103	-1.008
MAXIMUM Y	:	1.597	1.061	.959
MINIMUM Y	:	-.990	-.812	-.599
CENTROID X	:	.023	-.025	-.119
CENTROID Y	:	-.174	-.351	-.249
POA TO CENTROID in.	:	.175	.352	.277
MIN RADIUS	:	.323	.164	.193
MEAN RADIUS	:	.879	.765	.718
MAX RADIUS	:	1.654	1.170	1.214
HORIZONTAL SPREAD	:	2.180	2.180	2.180
VERTICAL SPREAD	:	2.586	1.873	1.558
EXTREME SPREAD	:	2.600	2.262	2.262
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	