

06611549

MODEL 700™ M24

Model 5145™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6611549

ORDER NO.
5716

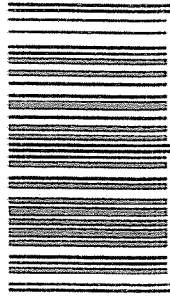
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611549

UPC



0 42700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611549

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KS
600	Proof		2/1/91	KS
607	Check Headspace		2/1/91	KS
610	Dis-assemble Gun		2/1/91	KS
612	Magnaflux Barrel Action	2 11 91		Ked
	Magnaflux Bolt	2 11 91		Ked
615	Rollmark Caliber	2 11 91		GB
617	Drill and Tap Sight Holes	2 13 91		WB
618	Polish Barrel <i>PBB</i>	2 13 91		WB
620	Apply Coatings (Barrel Action)		2/12/91	KA
	Apply Coating (Bolt)			P
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-29/91	DH

op. #	BARBER M24 0078654 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{3}{4}$	4 $\frac{1}{4}$			4-2-91	DH
	G) Safety Off Force	2 $\frac{1}{2}$	2 $\frac{1}{2}$	2 $\frac{1}{2}$			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	DH
	I) Firing Pin Indent	.020	.0225	.022			4-2-91	DH
	J) Assemble Stock						4/5/91	KS
	K) Assemble Swivel Studs						4-11-91	DH
	L) Attach Front and Rear Sight Assemblies						4/5/91	KS
	M) Iron Sight Alignment						4/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/5/91	KS
	O) Attach Scope to Rifle						4/5/91	KS
	P) Detach & Attach Scope 20 Times						4/5/91	KS
640	Gallery Target & Test						4-8-91	DH
	A) Time						4-8-91	DH
	B) Malfunctions						4-8-91	AC
	C) Pierced Primers						4-8-91	AC
	D) Optical Clarity of Scope						4-8-91	AC
645	Inspect for Live Ammo						4-8-91	AC
655	Final Inspection							
	A) Headspace						4-11-91	DH
	B) Trigger Pull	2.45	2.36	2.36	2.33	2.44	4/11/91	JPL
	C) Function						4-11-91	DH
660	Pack						6-17-91	NF

TIME

BARBER - M24 0078655

SWS TRIGGER PULL TEST

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

SERIAL NO. 56611549DATE 4-2-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.59	2.49	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.62	2.48	2.36	
PULL #3	2.55	2.66	2.60	2.36	
PULL #4	2.61	2.70	2.61	2.33	
PULL #5	2.63	2.60	2.62	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.16		
PULL #2	3.02	3.05		
PULL #3	3.28	3.08		
PULL #4	3.10	3.14		
PULL #5	3.33	3.06		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.02		4.07
PULL #2	4.39	4.42		4.06
PULL #3	4.21	4.43		4.06
PULL #4	4.37	4.46		4.02
PULL #5	4.31	4.30		4.05
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611549
8 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.260864
1 TO	2	.108784
1 TO	3	.300242
1 TO	4	.460943
1 TO	5	.397005

4.33 ←---POA

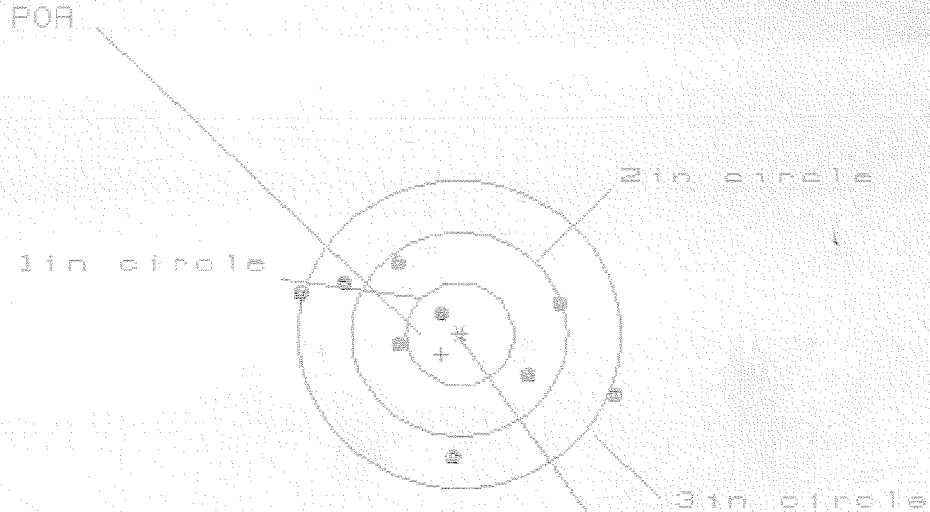
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1212
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0976
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155612

THE AMR FOR THIS RIFLE IS: 1.007

6 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611549

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.926

VS= 1.844

GS= 3.077

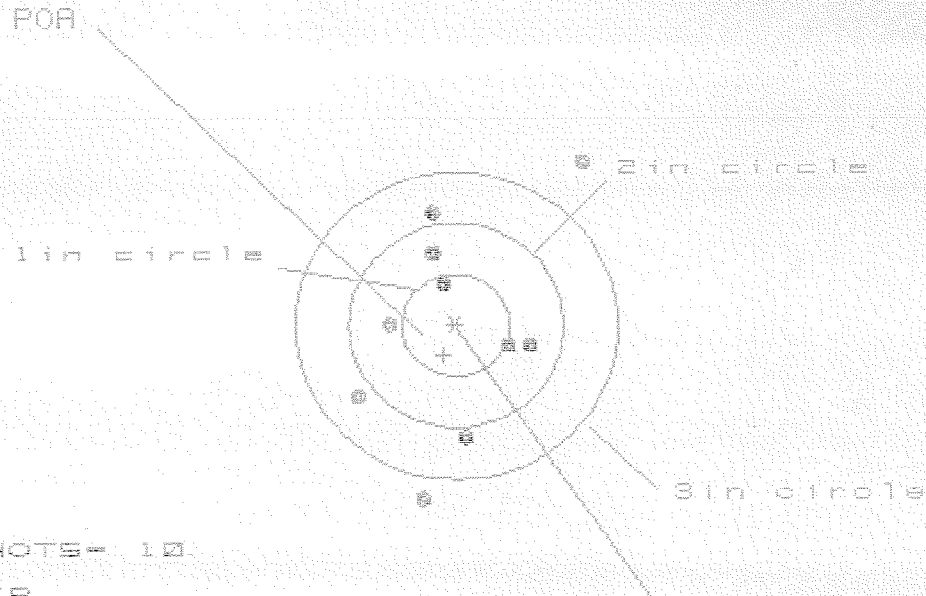
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.471	1.086	.924
MINIMUM X	-1.455	-1.291	-1.046
MAXIMUM Y	.666	.602	.641
MINIMUM Y	-1.178	-1.242	-1.203
CENTROID X	.171	.007	.169
CENTROID Y	.197	.261	.222
FOR TO CENTROID in.	.261	.261	.278
MIN RADIUS	.300	.154	.282
MEAN RADIUS	.987	.892	.847
MAX RADIUS	1.579	1.329	1.207
HORIZONTAL SPREAD	2.926	2.377	1.971
VERTICAL SPREAD	1.844	1.844	1.844
EXTREME SPREAD	3.077	2.380	1.987
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

8 Apr 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08611549

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.032

VS = 3.235

GS = 3.546

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.159	.833	.813
MINIMUM X	-.873	-.744	-.764
MAXIMUM Y	1.575	1.251	1.066
MINIMUM Y	-1.660	-1.485	-1.113
CENTROID X	.118	-.011	.009
CENTROID Y	.292	.117	.302
POA TO CENTROID in.	.315	.117	.383
MIN RADIUS	.457	.485	.423
MEAN RADIUS	1.000	.892	.789
MAX RADIUS	1.956	1.494	1.128
HORIZONTAL SPREAD	2.032	1.577	1.577
VERTICAL SPREAD	3.235	2.736	2.170
EXTREME SPREAD	3.546	2.736	2.204
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

6 Apr 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06611549

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 9

HS = 2.573

VS = 2.390

GS = 2.726

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.453

.855

.743

MINIMUM X

-1.120

-.958

-1.070

MAXIMUM Y

.987

1.086

.753

MINIMUM Y

-1.403

-1.304

-1.188

CENTROID X

.435

.273

.385

CENTROID Y

.054

-.045

-.181

POA TO CENTROID in.

.438

.277

.425

MIN RADIUS

.261

.437

.398

MEAN RADIUS

.972

.912

.845

MAX RADIUS

1.707

1.408

1.314

HORIZONTAL SPREAD

2.573

1.813

1.813

VERTICAL SPREAD

2.390

2.390

1.931

EXTREME SPREAD

2.726

2.706

2.372

NUMBER IN ONE

INCH CIRCLE =

3

NUMBER IN TWO

INCH CIRCLE =

4

NUMBER IN THREE

INCH CIRCLE =

9

8 Apr 1991

FILE: \PATTERNING\CENTERFIRE_PATT\CB611549

CENTERFIRE PATTERNS # 4

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 10

CENTROID *

HS = 2.525

VS = 2.348

GS = 2.632

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POR TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

24

10

9

8

1.062

.899

.913

-1.464

-.738

-.626

1.043

1.050

1.153

-1.305

-1.298

-1.193

-.287

-.124

-.236

.145

.138

.035

.321

.185

.239

.370

.346

.459

.994

.928

.894

1.465

1.302

1.312

2.525

1.637

1.539

2.348

2.348

2.348

2.632

2.431

2.431

1

4

10

6 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611549

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.116

VS= 2.899

GS= 3.330

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POR TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.471

1.047

.862

-1.645

-1.481

-1.199

1.247

1.153

1.181

-.852

-.943

-.915

.169

.005

.191

-.020

.074

.046

.170

.075

.196

.374

.378

.444

1.001

1.009

.930

1.700

1.499

1.408

3.116

2.520

2.049

2.899

2.096

2.096

3.330

2.560

2.513

1

4

8