

06522352

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™

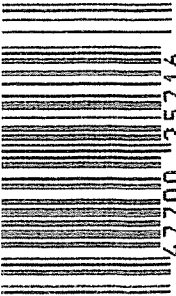
124

SERIAL NO.
C6522352

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6522352

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522352
12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.260969
1 TO	2	.203902
1 TO	3	.192416
1 TO	4	.336621
1 TO	5	.470545

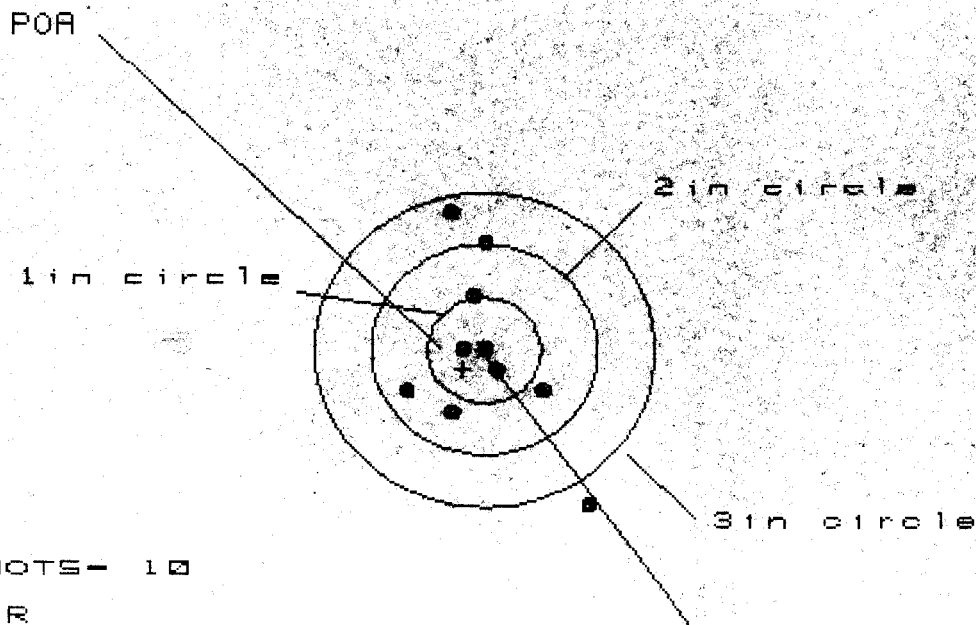
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1794
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0434
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104575
THE AMR FOR THIS RIFLE IS: 1.058

11 Sep 1990

FILE: PATTERNING/CENTERFIRE_PATT/C6522352

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.648

VS= 2.799

GS= 3.053

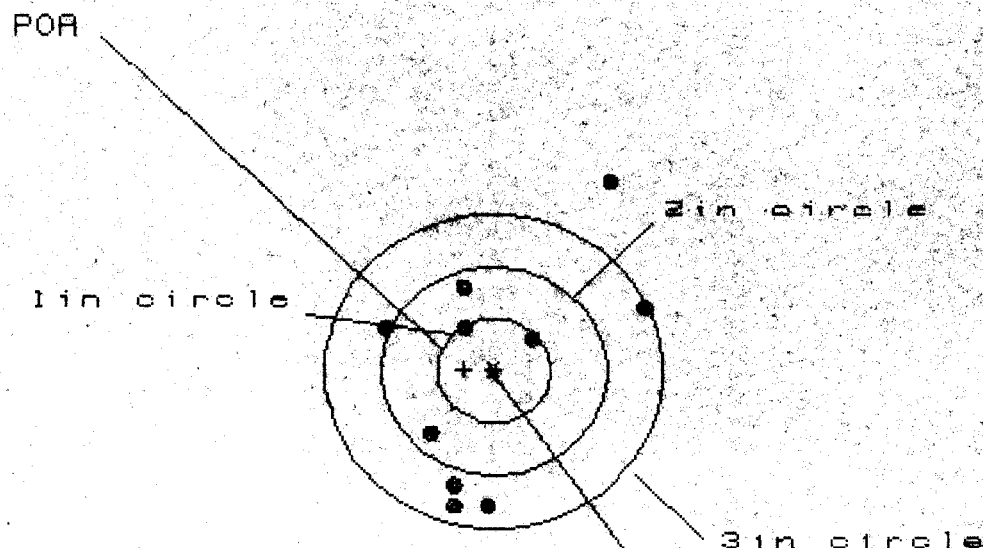
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.923	.650	.626
MINIMUM X	:	-.725	-.622	-.646
MAXIMUM Y	:	1.348	1.187	1.004
MINIMUM Y	:	-1.451	-.767	-.618
CENTROID X	:	.188	.085	.109
CENTROID Y	:	.181	.342	.193
POA TO CENTROID in.	:	.260	.352	.222
MIN RADIUS	:	.080	.180	.142
MEAN RADIUS	:	.737	.633	.533
MAX RADIUS	:	1.720	1.203	1.008
HORIZONTAL SPREAD	:	1.648	1.272	1.272
VERTICAL SPREAD	:	2.799	1.954	1.622
EXTREME SPREAD	:	3.053	1.954	1.650
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

11 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522352

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.279

VS= 3.152

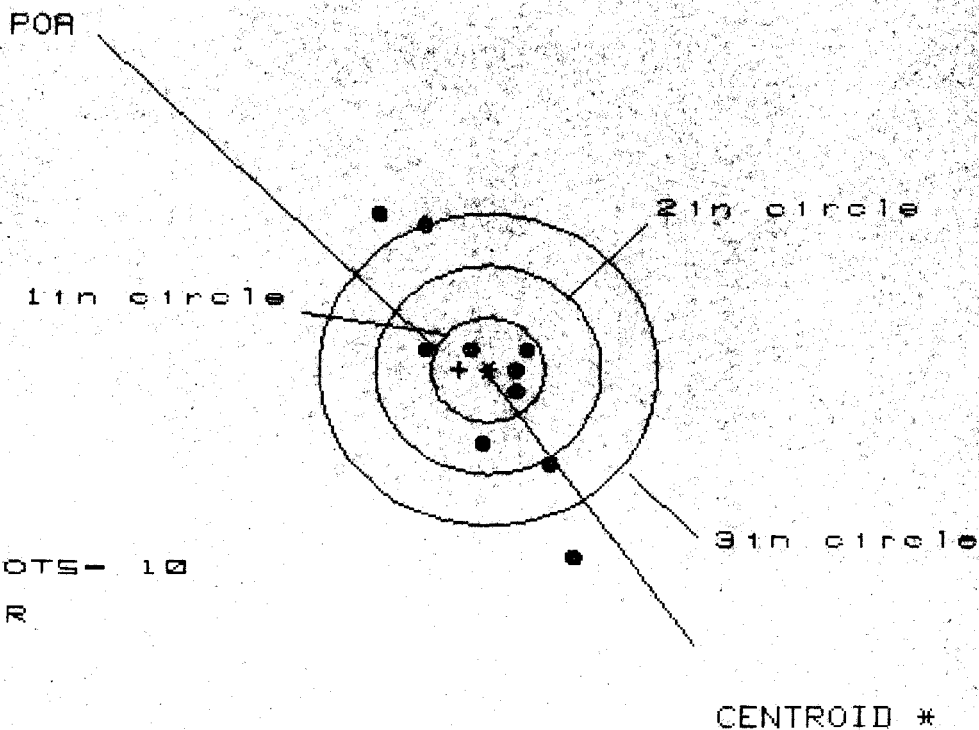
GS= 3.449

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	1.465	.637
MINIMUM X	:	-.935	-.814	-.631
MAXIMUM Y	:	1.826	1.054	1.151
MINIMUM Y	:	-1.326	-1.123	-1.026
CENTROID X	:	.262	.141	-.042
CENTROID Y	:	-.009	-.212	-.309
POA TO CENTROID in.	:	.262	.255	.311
MIN RADIUS	:	.422	.598	.411
MEAN RADIUS	:	1.102	.973	.861
MAX RADIUS	:	2.125	1.656	1.154
HORIZONTAL SPREAD	:	2.279	2.279	1.268
VERTICAL SPREAD	:	3.152	2.177	2.177
EXTREME SPREAD	:	3.449	2.517	2.179
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/CB522352

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 7

HS= 1.670

VS= 3.281

GS= 3.682

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.747	.649	.543
MINIMUM X	:	-.923	-.840	-.554
MAXIMUM Y	:	1.517	1.321	1.403
MINIMUM Y	:	-1.764	-1.052	-.887
CENTROID X	:	.256	.173	.278
CENTROID Y	:	.001	.197	.032
POA TO CENTROID in.	:	.256	.263	.280
MIN RADIUS	:	.271	.116	.268
MEAN RADIUS	:	.885	.778	.643
MAX RADIUS	:	1.916	1.566	1.509
HORIZONTAL SPREAD	:	1.670	1.489	1.098
VERTICAL SPREAD	:	3.281	2.373	2.290
EXTREME SPREAD	:	3.682	2.801	2.540
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE: PATTERNING/CENTERFIRE_PATT/C6582352

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 3.154

VS= 1.942

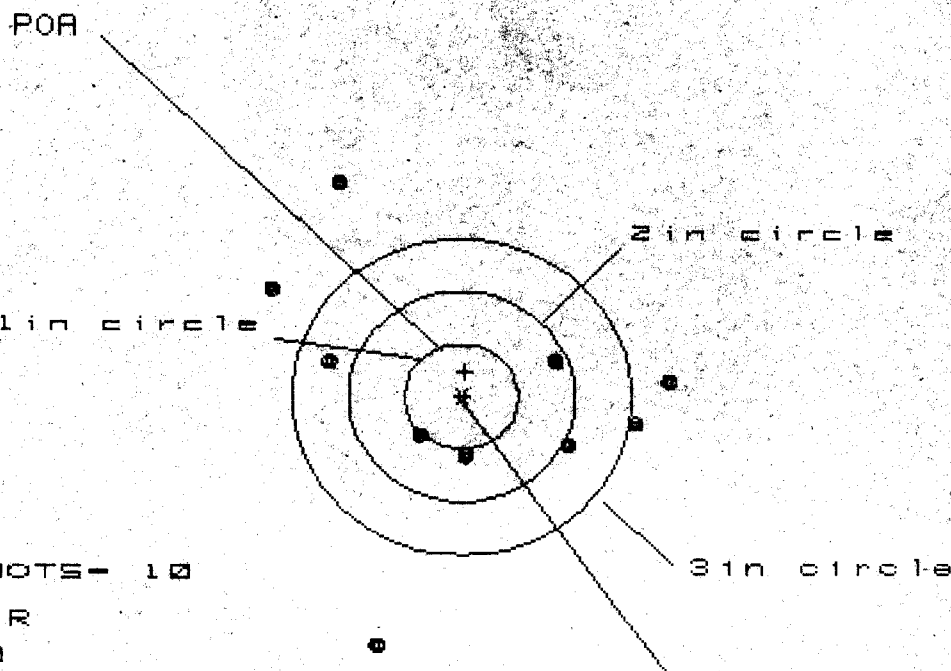
GS= 3.263

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.799	1.491	1.346
MINIMUM X	:	-1.355	-1.155	-.967
MAXIMUM Y	:	1.050	1.044	.932
MINIMUM Y	:	-.892	-.898	-.919
CENTROID X	:	.221	.021	.166
CENTROID Y	:	-.154	-.148	-.036
POA TO CENTROID in.	:	.270	.150	.170
MIN RADIUS	:	.512	.549	.539
MEAN RADIUS	:	1.138	1.041	.995
MAX RADIUS	:	1.800	1.768	1.586
HORIZONTAL SPREAD	:	3.154	2.646	2.313
VERTICAL SPREAD	:	1.942	1.942	1.851
EXTREME SPREAD	:	3.263	3.227	2.727
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

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FILE: PATTERNING/CENTERFIRE_PATT/C8522352

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS = 3.470

VS = 4.380

GS = 4.391

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.815	1.728	1.580
MINIMUM X	:	-1.655	-1.742	-1.890
MAXIMUM Y	:	2.060	1.802	.974
MINIMUM Y	:	-2.320	-.797	-.572
CENTROID X	:	-.030	.057	.205
CENTROID Y	:	-.236	.022	-.204
POA TO CENTROID in.	:	.238	.061	.289
MIN RADIUS	:	.540	.728	.605
MEAN RADIUS	:	1.429	1.330	1.163
MAX RADIUS	:	2.448	2.156	2.126
HORIZONTAL SPREAD	:	3.470	3.470	3.470
VERTICAL SPREAD	:	4.380	2.599	1.545
EXTREME SPREAD	:	4.391	3.580	3.580
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522352

DATE 9/10/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.35	2.39	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.37	2.29	2.44	
PULL #3	2.20	2.35	2.38	2.45	
PULL #4	2.29	2.33	2.38	2.47	
PULL #5	2.27	2.39	2.34	2.42	
TOTAL	11.57	11.79	11.78	12.22	
AVG.	2.31	2.36	2.36	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.21		
PULL #2	3.18	3.25		
PULL #3	3.20	3.30		
PULL #4	3.22	3.23		
PULL #5	3.17	3.19		
TOTAL	15.88	16.18		
AVG.	3.18	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.14		4.15
PULL #2	4.05	4.21		4.21
PULL #3	4.07	4.10		4.29
PULL #4	4.11	4.11		4.14
PULL #5	4.08	4.13		4.24
TOTAL	20.38	20.79		20.03
AVG.	4.08	4.16		4.21

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522352

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes		8/16/90	WB
618	Polish Barrel <i>R/B</i>		8/16/90	WB
620	Apply Coatings (Barrel Action)		8/31/90	JA
	Apply Coating (Bolt)			
625	Final Assembly		9/10/90	WB
	A) Clean inside of Bolt Assembly		9/10/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/10/90	WB
	C) Inspect Ejector Hole for Chamfer		9/10/90	WB
	D) Oil Firing Pin Ass'y		9/10/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	.023	.023	.023			9/10/90	WB
	J) Assemble Stock						9/10/90	KS
	K) Assemble Swivel Studs						9/15/90	928
	L) Attach Front and Rear Sight Assemblies						9/10/90	KS
	M) Iron Sight Alignment						9/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KS
	O) Attach Scope to Rifle						9/14/90	KS
	P) Detach & Attach Scope 20 Times						9/10/90	KS
640	Gallery Target & Test						9/11/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/11/90	NF
655	Final Inspection							
	A) Headspace						9/15/90	928
	B) Trigger Pull	2.44	2.44	2.45	2.47	2.42	9-14-90	921
	C) Function						9/15/90	928
660	Pack						9/20/90	NF