

C6636186

MODEL 700TM M24

Model 515TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington®  REG. U.S. PAT. & TM. OFF.

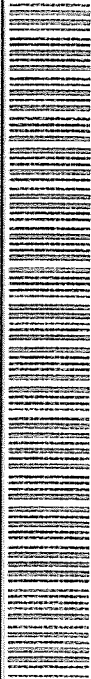
MODEL 700™ M24

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

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

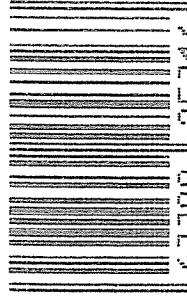
SERIAL NO.
C6636186

ORDER NO.
5716



5716 C6636186

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636186

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GR.
617	Drill and Tap Sight Holes	5 15 9 1		LS
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-21-91	JA
	Apply Coating (Bolt)		5-21-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		7/17/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/17/91	K.S.
	C) Inspect Ejector Hole for Chamfer		7/17/91	K.S.
	D) Oil Firing Pin Ass'y		7/17/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		7-19-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-19-91	QU
	G) Safety Off Force	4	4	4			7-19-91	QU
	H) Trigger Pull Test & Retainability						7-19-91	QU
	I) Firing Pin Indent	.0225	.0225	.0225			7-19-91	QU
	J) Assemble Stock						7/22/91	KS
	K) Assemble Swivel Studs						7/22/91	NH
	L) Attach Front and Rear Sight Assemblies						7/22/91	KS
	M) Iron Sight Alignment						7/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	KS
	O) Attach Scope to Rifle						7/22/91	KS
	P) Detach & Attach Scope 20 Times						7/22/91	KS
640	Gallery Target & Test						7/24/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						7/24/91	KT
655	Final Inspection							
	A) Headspace						7-26-91	NH
	B) Trigger Pull	2.22	2.27	2.33	2.38	2.21	7-26-91	QU
	C) Function						7-26-91	NH
660	Pack						9-18-91	NH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636186
DATE 7-19-91
TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.44	2.38	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.42	2.40	2.27	
PULL #3	2.50	2.40	2.44	2.33	
PULL #4	2.48	2.44	2.40	2.38	
PULL #5	2.50	2.44	2.40	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.50		
PULL #2	3.28	3.54		
PULL #3	3.21	3.52		
PULL #4	3.57	3.57		
PULL #5	3.58	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.20		4.39
PULL #2	4.30	4.30		4.33
PULL #3	4.35	4.32		4.38
PULL #4	4.37	4.36		4.39
PULL #5	4.36	4.30		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636186
24 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.209022
1 TO	2	.249648
1 TO	3	.268561
1 TO	4	.411534
1 TO	5	.346625

4 <----POB

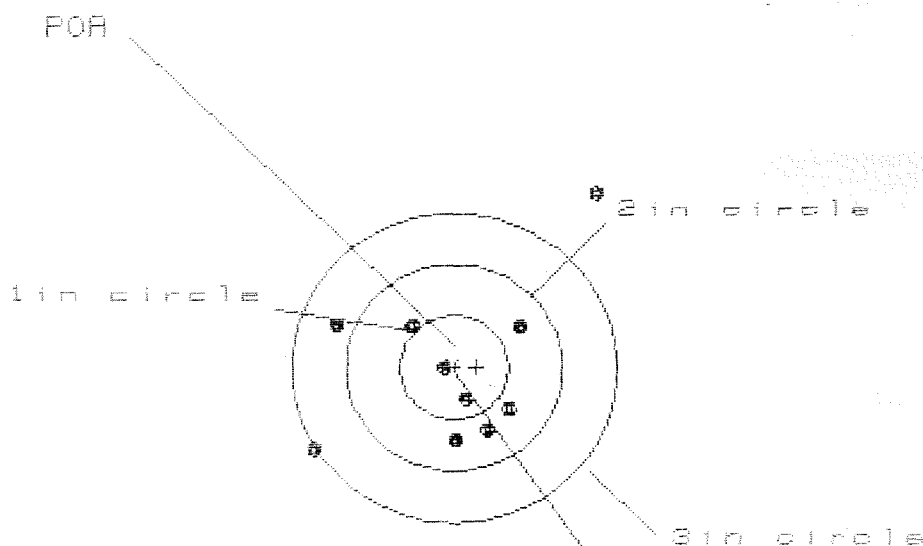
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0448
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1784
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .183939
THE AMR FOR THIS RIFLE IS: .9354

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B6

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.522

VS= 2.501

CS= 3.552

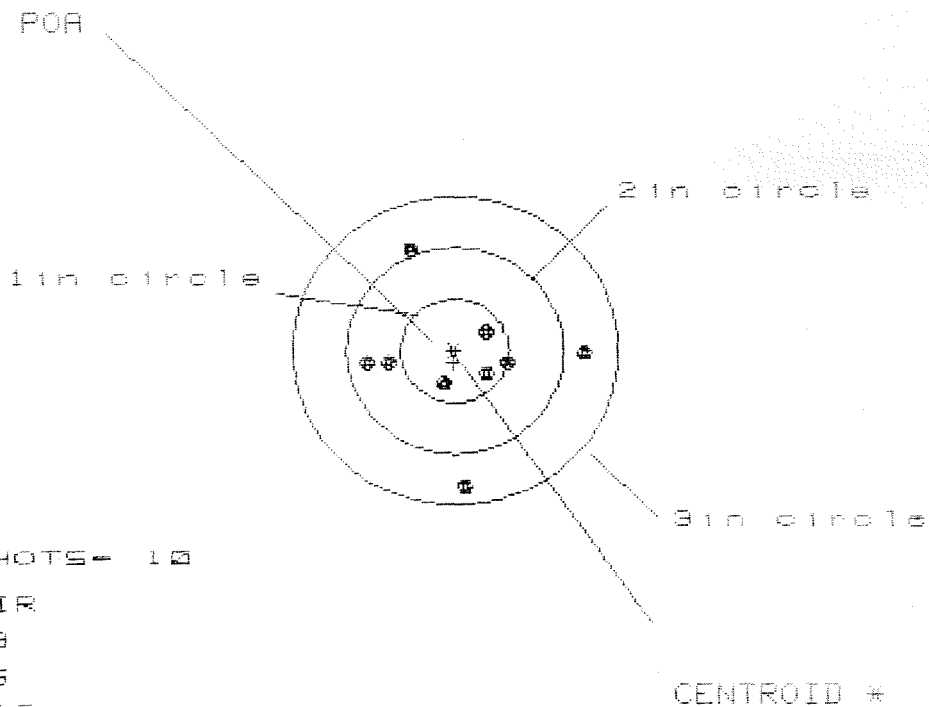
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.268	.729	.589
MINIMUM X	-1.254	-1.113	-1.048
MAXIMUM Y	1.690	.635	.557
MINIMUM Y	-.811	-.623	-.573
CENTROID X	-.209	-.350	-.210
CENTROID Y	-.003	-.191	-.113
POA TO CENTROID in.	.209	.398	.239
MIN RADIUS	.093	.154	.101
MEAN RADIUS	.837	.679	.575
MAX RADIUS	2.113	1.276	1.186
HORIZONTAL SPREAD	2.522	1.842	1.637
VERTICAL SPREAD	2.501	1.258	1.130
EXTREME SPREAD	3.552	2.181	1.783
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636166

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 2.054

VS = 2.284

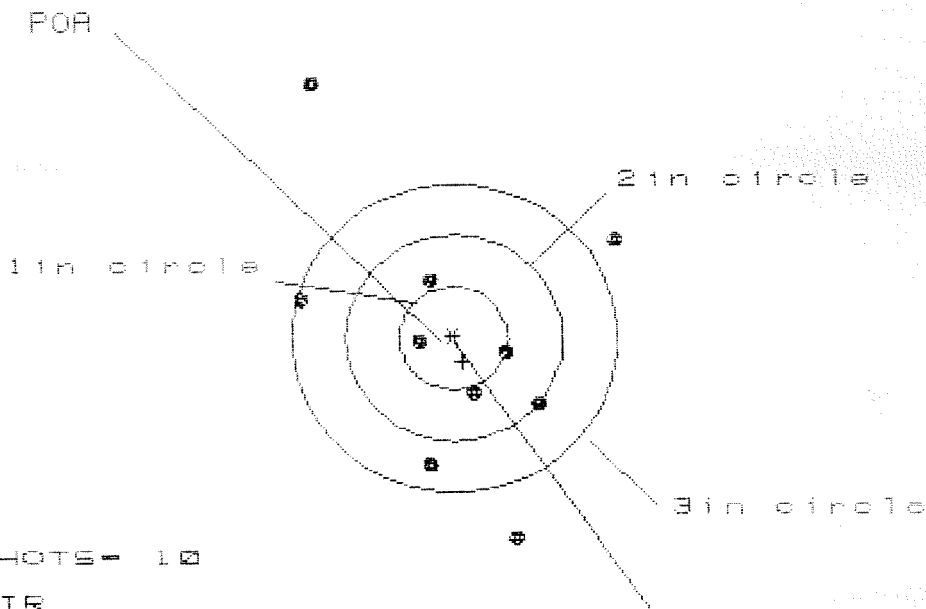
GS = 2.345

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.285	1.219	.698
MINIMUM X	:	-.849	-.835	-.683
MAXIMUM Y	:	1.000	.857	.837
MINIMUM Y	:	-1.284	-.477	-.497
CENTROID X	:	.011	-.003	-.155
CENTROID Y	:	.115	.258	.278
POA TO CENTROID in.	:	.116	.258	.318
MIN RADIUS	:	.346	.296	.444
MEAN RADIUS	:	.770	.719	.658
MAX RADIUS	:	1.290	1.229	.873
HORIZONTAL SPREAD	:	2.054	2.054	1.373
VERTICAL SPREAD	:	2.284	1.334	1.334
EXTREME SPREAD	:	2.345	2.056	1.439
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636186

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 6

HS = 2.942

VS = 4.371

GS = 4.792

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.478	1.328	1.386
MINIMUM X	:	-1.464	-1.614	-1.556
MAXIMUM Y	:	2.461	1.245	1.040
MINIMUM Y	:	-1.910	-1.636	-1.133
CENTROID X	:	-.079	.071	.013
CENTROID Y	:	.232	-.042	.163
POA TO CENTROID in.	:	.245	.083	.163
MIN RADIUS	:	.315	.223	.367
MEAN RADIUS	:	1.222	.995	.914
MAX RADIUS	:	2.806	1.820	1.733
HORIZONTAL SPREAD	:	2.942	2.942	2.942
VERTICAL SPREAD	:	4.371	2.881	2.173
EXTREME SPREAD	:	4.792	3.108	2.997
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

24 Jul 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HE = 2.812

VS = 2.942

GS = 4.051

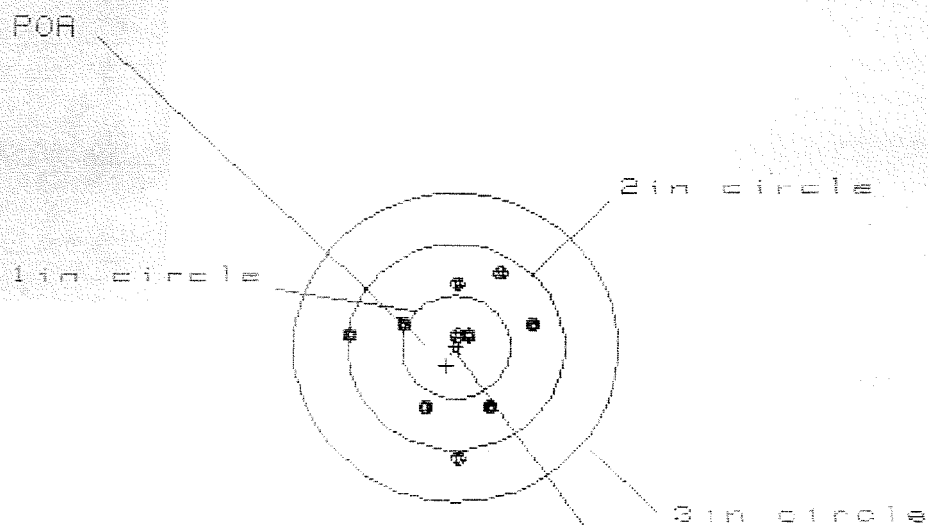
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.659	1.259	1.138
MINIMUM X	:	-1.153	-.969	-.694
MAXIMUM Y	:	1.418	1.573	1.402
MINIMUM Y	:	-1.524	-1.369	-1.247
CENTROID X	:	-.033	-.217	-.096
CENTROID Y	:	.369	.214	.385
POA TO CENTROID in.	:	.370	.305	.397
MIN RADIUS	:	.525	.365	.461
MEAN RADIUS	:	1.221	1.076	1.006
MAX RADIUS	:	2.166	1.677	1.541
HORIZONTAL SPREAD	:	2.812	2.228	1.832
VERTICAL SPREAD	:	2.942	2.942	2.649
EXTREME SPREAD	:	4.051	3.144	2.877
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

24 Jul 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.625

VS= 1.753

GS= 1.793

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.678	.681	.563
MINIMUM X	-.947	-.944	-.554
MAXIMUM Y	.688	.569	.568
MINIMUM Y	-1.065	-.677	-.678
CENTROID X	.086	.083	.202
CENTROID Y	.179	.298	.299
POA TO CENTROID in.	.199	.309	.361
MIN RADIUS	.156	.060	.046
MEAN RADIUS	.627	.550	.490
MAX RADIUS	1.066	.944	.768
HORIZONTAL SPREAD	1.625	1.625	1.117
VERTICAL SPREAD	1.753	1.246	1.246
EXTREME SPREAD	1.793	1.628	1.403
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	