

C6649134

MODEL 700™ M24

Model 5145™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM 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.
C6649134

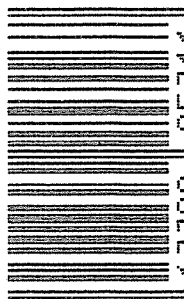
ORDER NO.
5716

20



5716 C6649134

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649134

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	KB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	JCL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-10-91	DH
	G) Safety Off Force	3	3	3			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	SP
	I) Firing Pin Indent	.022	.021	.022			8-10-91	DH
	J) Assemble Stock						8-13-91	TK
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8-13-91	TK
	M) Iron Sight Alignment						8-13-91	TK
	N) Detach Front & Rear Sights & place in numbered container						8-13-91	TK
	O) Attach Scope to Rifle						8-13-91	TK
	P) Detach & Attach Scope 20 Times						8-13-91	TK
640	Gallery Target & Test						8-14-91	DH
	A) Time						8-14-91	DH
	B) Malfunctions						8-14-91	DH
	C) Pierced Primers						8-14-91	DH
	D) Optical Clarity of Scope						8-14-91	DH
645	Inspect for Live Ammo						8-14-91	DH
655	Final Inspection						8-15-91	DH
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.47	2.42	2.48	2.54	2.45	8-14-91	SP
	C) Function						8-15-91	DH
660	Pack						9-19-91	AF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649134
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.19901
1 TO	2	.105304
1 TO	3	.24969
1 TO	4	.154055
1 TO	5	.526047

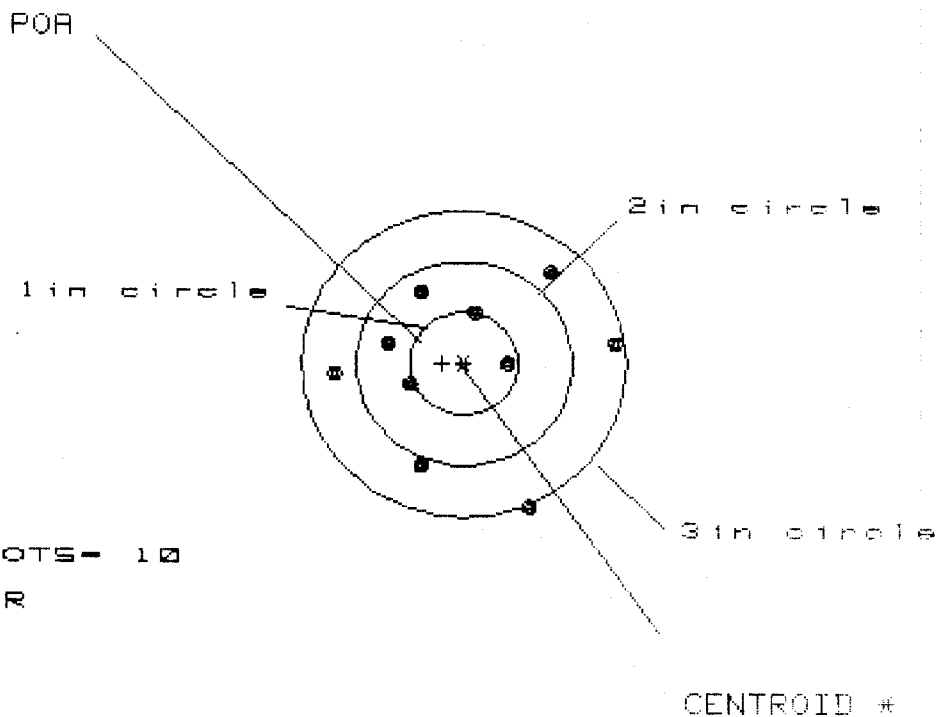
4.3 <----POA
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2088
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1586
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .604531
THE AMR FOR THIS RIFLE IS: .9432

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849134

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.536

VS= 2.300

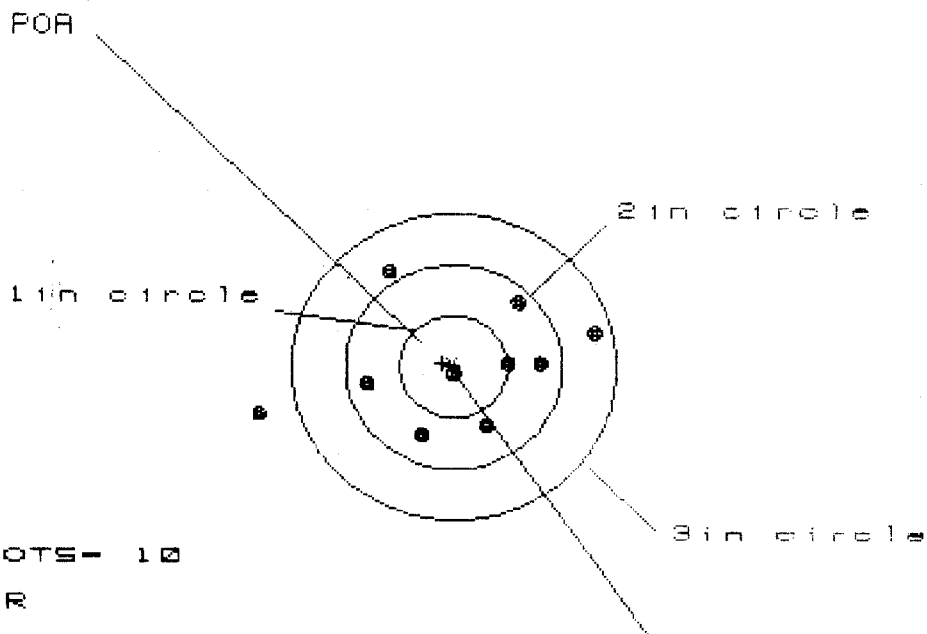
QS= 2.559

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.360	1.421	.996
MINIMUM X	:	-1.176	-1.115	-.937
MAXIMUM Y	:	.899	.744	.754
MINIMUM Y	:	-1.401	-1.107	-1.097
CENTROID X	:	.199	.138	-.040
CENTROID Y	:	-.002	.153	.143
POA TO CENTROID in.	:	.199	.206	.149
MIN RADIUS	:	.399	.354	.397
MEAN RADIUS	:	.925	.834	.740
MAX RADIUS	:	1.505	1.424	1.249
HORIZONTAL SPREAD	:	2.536	2.536	1.933
VERTICAL SPREAD	:	2.300	1.851	1.851
EXTREME SPREAD	:	2.559	2.559	2.196
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649134

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 3.083

VS = 1.570

GS = 3.172

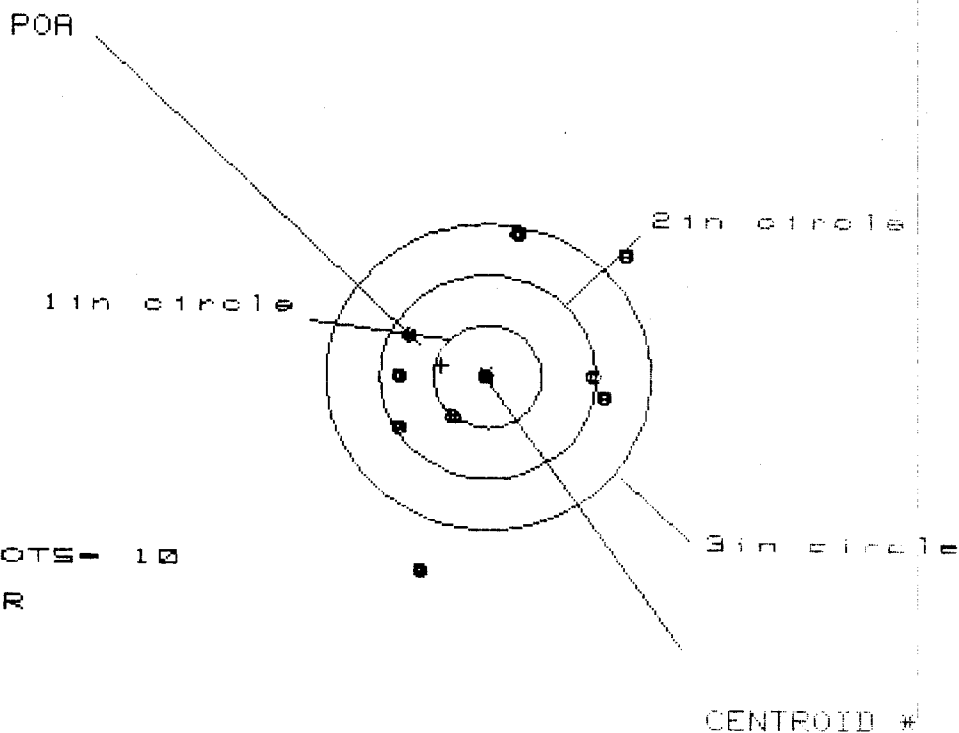
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.109	.715
MINIMUM X	:	-1.776	-1.012	-.873
MAXIMUM Y	:	.953	.902	.932
MINIMUM Y	:	-.617	-.668	-.638
CENTROID X	:	.099	.297	.158
CENTROID Y	:	-.035	.016	-.014
POA TO CENTROID in.	:	.105	.297	.159
MIN RADIUS	:	.092	.222	.115
MEAN RADIUS	:	.875	.744	.693
MAX RADIUS	:	1.834	1.208	1.144
HORIZONTAL SPREAD	:	3.083	2.121	1.588
VERTICAL SPREAD	:	1.570	1.570	1.570
EXTREME SPREAD	:	3.172	2.180	1.794
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/CG649134

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.136

VS= 3.252

GS= 3.604

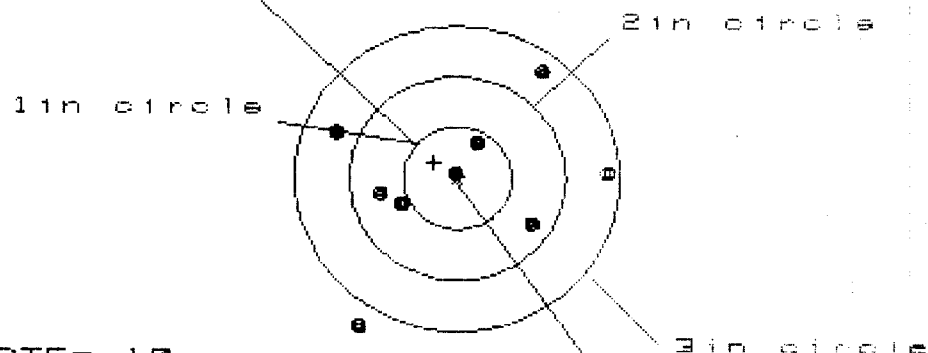
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.263	1.189	1.128
MINIMUM X	:	-.873	-.947	-.799
MAXIMUM Y	:	1.378	1.170	1.290
MINIMUM Y	:	-1.874	-.741	-.621
CENTROID X	:	.426	.500	.352
CENTROID Y	:	-.106	.102	-.018
POA TO CENTROID in.	:	.439	.511	.352
MIN RADIUS	:	.061	.255	.097
MEAN RADIUS	:	1.043	.960	.838
MAX RADIUS	:	1.990	1.528	1.337
HORIZONTAL SPREAD	:	2.136	2.136	1.927
VERTICAL SPREAD	:	3.252	1.911	1.911
EXTREME SPREAD	:	3.604	2.670	2.192
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649134

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.510

VS= 2.471

GS= 2.973

CENTROID X

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.384	1.287	.844
MINIMUM X	:	-1.126	-1.223	-1.063
MAXIMUM Y	:	1.007	.844	.834
MINIMUM Y	:	-1.464	-.640	-.650
CENTROID X	:	.217	.314	.153
CENTROID Y	:	-.155	.008	.018
FOR TO CENTROID in.	:	.267	.314	.155
MIN RADIUS	:	.091	.146	.094
MEAN RADIUS	:	.850	.731	.654
MAX RADIUS	:	1.705	1.289	1.186
HORIZONTAL SPREAD	:	2.510	2.510	1.906
VERTICAL SPREAD	:	2.471	1.484	1.484
EXTREME SPREAD	:	2.973	2.536	2.001
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNS/CENTERFIRE_PATT/C0045151

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 9

MS = 1.930

VS = 2.626

GS = 3.085

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.900	.900	.901
MINIMUM X	-.950	-1.022	-.908
MAXIMUM Y	1.029	.852	.913
MINIMUM Y	-1.597	-1.064	-.958
CENTROID X	.353	.425	.311
CENTROID Y	-.505	-.328	-.424
POA TO CENTROID in.	.617	.536	.534
MIN RADIUS	.502	.497	.502
MEAN RADIUS	1.023	.934	.890
MAX RADIUS	1.720	1.302	1.288
HORIZONTAL SPREAD	1.930	1.930	1.849
VERTICAL SPREAD	2.626	1.916	1.871
EXTREME SPREAD	3.085	2.402	2.266
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

SWS TRIGGER PULL TEST

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

SERIAL NO. 06649134

DATE 8-10-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.17	2.32	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.43	2.30	2.42	
PULL #3	2.20	2.43	2.43	2.48	
PULL #4	2.17	2.36	2.46	2.54	
PULL #5	2.18	2.29	2.30	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.32		
PULL #2	3.24	3.32		
PULL #3	3.38	3.43		
PULL #4	3.19	3.42		
PULL #5	3.25	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.46		4.50
PULL #2	4.38	4.36		4.49
PULL #3	4.43	4.54		4.53
PULL #4	4.43	4.54		4.60
PULL #5	4.37	4.56		4.57
TOTAL				
AVG.				