

C6594562

MODEL 700™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6594562

ORDER NO.
5716

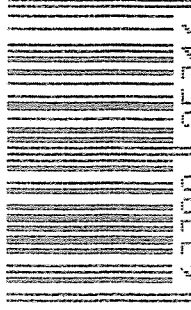
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6594562

UPC



0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594562

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LG
617	Drill and Tap Sight Holes	1 10	91	LB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-12-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/25/91	W

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/28/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			1/28/91	WB
	H) Trigger Pull Test & Retainability						1-25/91	WJ
	I) Firing Pin Indent	.021	.0215	.021			1/28/91	WB
	J) Assemble Stock						1/28/91	RW
	K) Assemble Swivel Studs						2-4-91	
	L) Attach Front and Rear Sight Assemblies						1/28/91	RW
	M) Iron Sight Alignment						1/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/28/91	RW
	O) Attach Scope to Rifle						1/28/91	RW
	P) Detach & Attach Scope 20 Times						1/28/91	RW
640	Gallery Target & Test						1-28-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-28-91	NF
655	Final Inspection							
	A) Headspace						2-4-91	AE
	B) Trigger Pull	2.53	2.41	2.39	2.43	2.46	2-1-91	WJ
	C) Function						2-27-91	AE
660	Pack						3-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594562

DATE 1-25-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.42	2.40	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.43	2.44	2.41	
PULL #3	2.23	2.41	2.39	2.39	
PULL #4	2.38	2.43	2.37	2.43	
PULL #5	2.36	2.19	2.38	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.22		
PULL #2	3.43	3.21		
PULL #3	3.42	3.24		
PULL #4	3.43	3.30		
PULL #5	3.42	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.29		4.27
PULL #2	4.41	4.18		4.33
PULL #3	4.37	4.27		4.40
PULL #4	4.21	4.14		4.36
PULL #5	4.23	4.18		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594562
29 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.24588
1 TO 2	.198073
1 TO 3	.1886
1 TO 4	.19965
1 TO 5	.397457

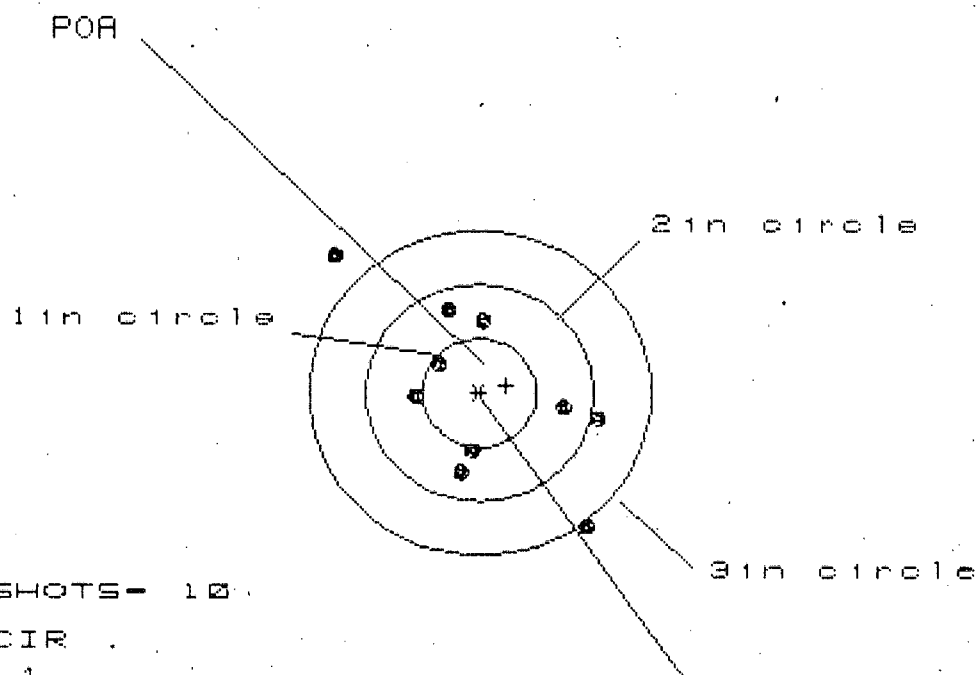
POI <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.087
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137596
THE AMR FOR THIS RIFLE IS: 1.027

29 Jan 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.228

VS= 2.493

GS= 3.269

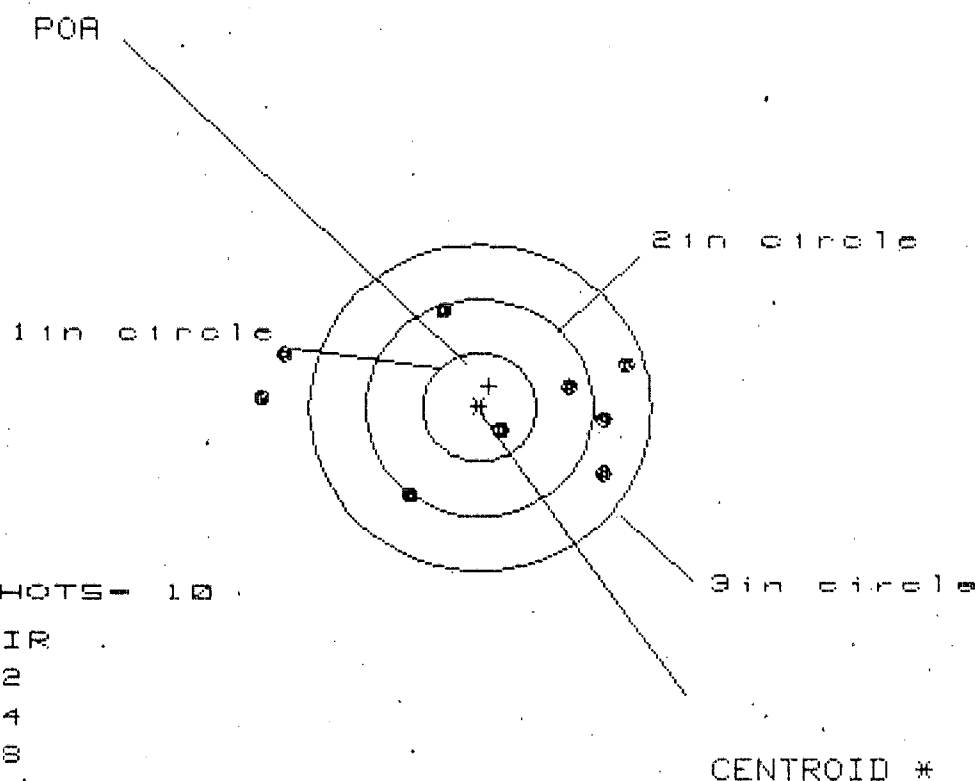
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	.868	.963
MINIMUM X	-1.224	-.719	-.624
MAXIMUM Y	1.231	.951	.810
MINIMUM Y	-1.262	-1.125	-.749
CENTROID X	-.236	-.100	-.195
CENTROID Y	-.069	-.206	-.065
POA TO CENTROID in.	.246	.229	.205
MIN RADIUS	.449	.445	.480
MEAN RADIUS	.901	.804	.719
MAX RADIUS	1.736	1.355	1.004
HORIZONTAL SPREAD	2.228	1.587	1.587
VERTICAL SPREAD	2.493	2.076	1.559
EXTREME SPREAD	3.269	2.395	1.706
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.189

VS= 1.751

GS= 3.204

PATTERN #	12	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.297	1.087	.841
MINIMUM X	-1.892	-1.967	-1.070
MAXIMUM Y	.899	.909	.970
MINIMUM Y	-.852	-.842	-.781
CENTROID X	-.084	.126	.372
CENTROID Y	-.196	-.206	-.267
POA TO CENTROID in.	.214	.241	.458
MIN RADIUS	.254	.211	.342
MEAN RADIUS	1.074	.933	.760
MAX RADIUS	1.893	2.027	1.324
HORIZONTAL SPREAD	3.189	3.054	1.911
VERTICAL SPREAD	1.751	1.751	1.751
EXTREME SPREAD	3.204	3.093	2.279
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.671

VS= 2.292

GS= 2.745

CENTROID #

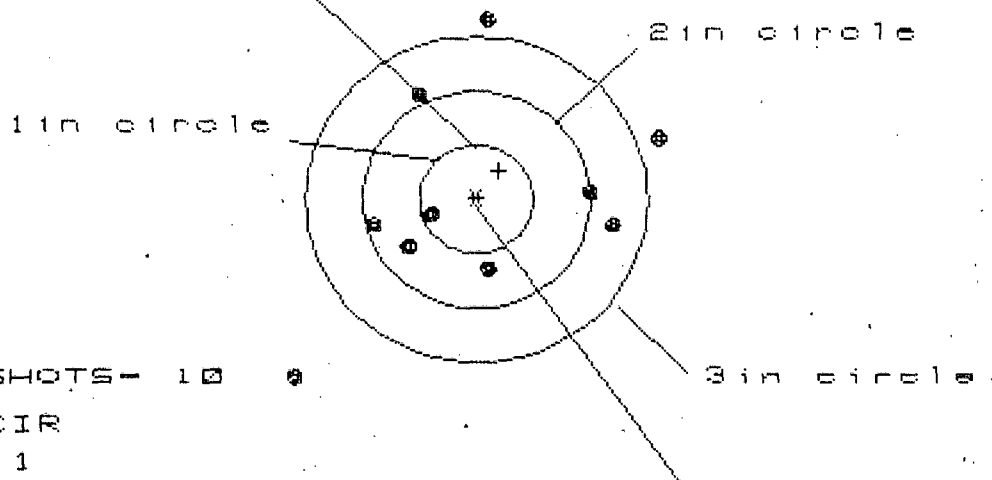
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.061	.882	.970
MINIMUM X	-1.610	-1.000	-.912
MAXIMUM Y	1.192	1.149	1.006
MINIMUM Y	-1.100	-1.143	-.597
CENTROID X	-.055	.124	.036
CENTROID Y	-.122	-.079	.064
POA TO CENTROID in.	.134	.147	.073
MIN RADIUS	.337	.219	.244
MEAN RADIUS	.941	.828	.763
MAX RADIUS	1.655	1.339	1.146
HORIZONTAL SPREAD	2.671	1.882	1.882
VERTICAL SPREAD	2.292	2.292	1.603
EXTREME SPREAD	2.745	2.651	2.093
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.232

VS= 3.297

GS= 3.880

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.584	1.400	1.396
MINIMUM X	:	-1.648	-1.086	-1.090
MAXIMUM Y	:	1.694	1.516	.996
MINIMUM Y	:	-1.603	-.815	-.625
CENTROID X	:	-.198	-.014	-.010
CENTROID Y	:	-.265	-.087	-.277
POA TO CENTROID in.	:	.331	.088	.277
MIN RADIUS	:	.404	.646	.581
MEAN RADIUS	:	1.174	1.064	.975
MAX RADIUS	:	2.299	1.516	1.502
HORIZONTAL SPREAD	:	3.232	2.486	2.486
VERTICAL SPREAD	:	3.297	2.331	1.622
EXTREME SPREAD	:	3.880	2.605	2.605
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	

NUMBER IN THREE INCH CIRCLE =

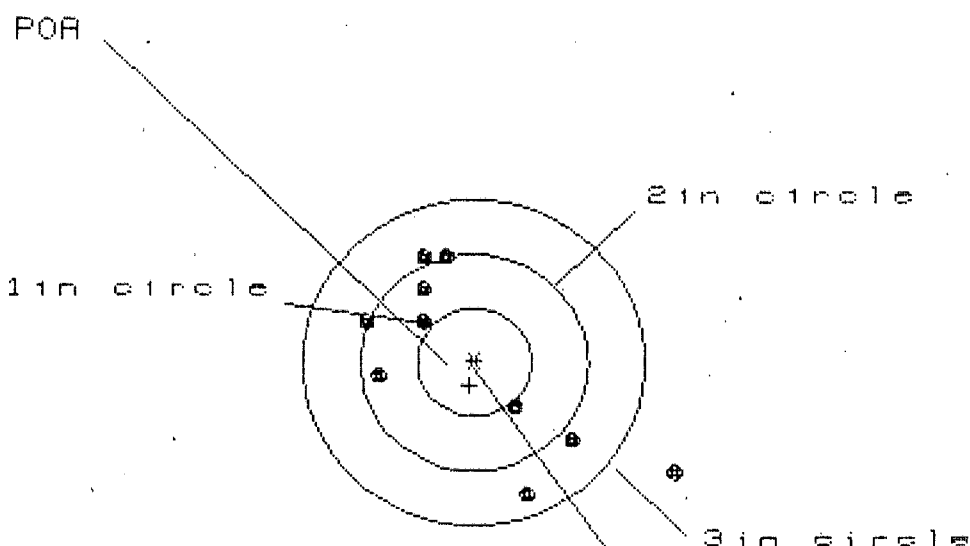
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CENTERFIRE PATTERNS

5



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 6

HS = 2.7000

VS = 2.270

GS = 3.039

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.751	1.033	1.115
MINIMUM X	-.949	-.755	-.673
MAXIMUM Y	1.014	.896	.725
MINIMUM Y	-1.256	-1.374	-.956
CENTROID X	.040	-.154	-.236
CENTROID Y	.217	.335	.506
POA TO CENTROID in.	.221	.369	.559
MIN RADIUS	.549	.396	.219
MEAN RADIUS	1.045	.878	.736
MAX RADIUS	2.046	1.522	1.469
HORIZONTAL SPREAD	2.700	1.788	1.788
VERTICAL SPREAD	2.270	2.270	1.681
EXTREME SPREAD	3.039	2.453	2.131
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	