

06649274

MODEL 700TM M24

Model **545**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

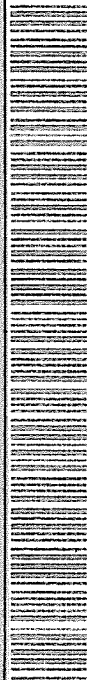
Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

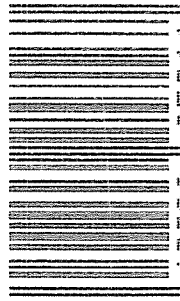
SERIAL NO. C6649274	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marquo Deposee.



5716 C6649274

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649274

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GL
617	Drill and Tap Sight Holes		JUL 2 1991	FA
618	Polish Barrel		JUL 1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-29-91	JP

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	7-29-91	JK		
	G) Safety Off Force	4	4	4	7-29-91	JK		
	H) Trigger Pull Test & Retainability				7-29-91	JK		
	I) Firing Pin Indent	.0205	.022	.0215	7/29/91	JK		
	J) Assemble Stock				7/30/91	RW		
	K) Assemble Swivel Studs				8-6-91	AC		
	L) Attach Front and Rear Sight Assemblies				7/30/91	RW		
	M) Iron Sight Alignment				7/30/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				7/30/91	RW		
	O) Attach Scope to Rifle				7/30/91	RW		
	P) Detach & Attach Scope 20 Times				7/30/91	RW		
640	Gallery Target & Test				7-31-91	AF		
	A) Time				"	AF		
	B) Malfunctions				"	AF		
	C) Pierced Primers				"	AF		
	D) Optical Clarity of Scope				"	AF		
645	Inspect for Live Ammo				7-31-91	AF		
655	Final Inspection							
	A) Headspace				8-6-91	AC		
	B) Trigger Pull	2.55	2.67	2.69	2.63	2.70	8-5-91	JK
	C) Function						8-6-91	AC
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06649274

DATE 7-29-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.33	2.45	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.37	2.38	2.67	
PULL #3	2.51	2.45	2.40	2.69	
PULL #4	2.43	2.45	2.46	2.63	
PULL #5	2.48	2.39	2.48	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.26		
PULL #2	3.39	3.27		
PULL #3	3.35	3.33		
PULL #4	3.31	3.25		
PULL #5	3.31	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.55		4.63
PULL #2	4.52	4.50		4.60
PULL #3	4.44	4.54		4.25
PULL #4	4.26	4.53		4.50
PULL #5	4.21	4.47		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649274
31 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.34858
1 TO 2	.579221
1 TO 3	.553181
1 TO 4	.337308
1 TO 5	.417337

241 <----PDA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0210
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.008
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0232215
THE AMR FOR THIS RIFLE IS: 1.014

31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649274

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.045

VS = 3.291

GS = 4.024

PATTERN #

:



SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.842

1.062

.933

MINIMUM X

:

-1.203

-.939

-.873

MAXIMUM Y

:

1.355

1.140

.973

MINIMUM Y

:

-1.936

-1.284

-1.270

CENTROID X

:

.328

.124

.248

CENTROID Y

:

-.118

-.097

.258

POA TO CENTROID in.

:

.349

.157

.358

MIN RADIUS

:

.352

.288

.109

MEAN RADIUS

:

1.154

.935

.819

MAX RADIUS

:

2.672

1.627

1.270

HORIZONTAL SPREAD

:

3.045

2.061

1.811

VERTICAL SPREAD

:

3.291

2.424

2.249

EXTREME SPREAD

:

4.024

2.831

2.286

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

31-JUL-1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8649274

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.737

VS= 2.269

GS= 3.788

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.653	1.421	1.010
MINIMUM X	-2.084	-1.294	-1.116
MAXIMUM Y	.992	.850	.750
MINIMUM Y	-1.277	-.945	-1.046
CENTROID X	-.248	-.016	-.194
CENTROID Y	-.057	.084	.184
POA TO CENTROID (in.)	.254	.086	.267
MIN RADIUS	.371	.206	.140
MEAN RADIUS	1.145	.944	.832
MAX RADIUS	2.445	1.631	1.453
HORIZONTAL SPREAD	3.737	2.715	2.126
VERTICAL SPREAD	2.269	1.795	1.795
EXTREME SPREAD	3.788	3.118	2.709
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649271

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.147

VS= 1.920

GS= 2.280

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.254

.832

.785

MINIMUM X

-.893

-.754

-.001

MAXIMUM Y

1.020

.973

.615

MINIMUM Y

-.900

-.947

-.025

CENTROID X

-.200

-.339

-.292

CENTROID Y

.047

.094

-.028

POA TO CENTROID in.

.205

.352

.294

MIN RADIUS

.424

.329

.459

MEAN RADIUS

.807

.735

.697

MAX RADIUS

1.322

1.043

.895

HORIZONTAL SPREAD

2.147

1.586

1.586

VERTICAL SPREAD

1.920

1.920

1.440

EXTREME SPREAD

2.280

1.922

1.666

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849274

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 10

HS= 2.316

VS= 2.124

GS= 2.618

CENTROID +

PATTERN #



SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.144

1.262

1.132

MINIMUM X

-1.172

-1.054

-1.184

MAXIMUM Y

1.062

.971

1.029

MINIMUM Y

-1.062

-1.153

-1.895

CENTROID X

.092

-.026

.184

CENTROID Y

.123

.214

.156

POR TO CENTROID in.

.154

.216

.198

MIN RADIUS

.669

.675

.635

MEAN RADIUS

1.077

1.042

1.015

MAX RADIUS

1.346

1.280

1.186

HORIZONTAL SPREAD

2.316

2.316

2.316

VERTICAL SPREAD

2.124

2.124

2.124

EXTREME SPREAD

2.618

2.401

2.327

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

10

31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649874

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 1.733

VS = 2.992

CS = 3.427

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.878

.793

.568

MINIMUM X

-.855

-.900

-.802

MAXIMUM Y

1.030

.812

.909

MINIMUM Y

-1.982

-1.823

-1.126

CENTROID X

-.081

.014

-.084

CENTROID Y

-.035

.183

.086

POA TO CENTROID IN

.088

.184

.120

MIN RADIUS

.317

.334

.297

MEAN RADIUS

.888

.729

.662

MAX RADIUS

2.140

1.276

1.217

HORIZONTAL SPREAD

1.733

1.683

1.370

VERTICAL SPREAD

2.992

2.035

2.035

EXTREME SPREAD

3.427

2.060

2.050

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9