

C6587546

MODEL 708™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

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

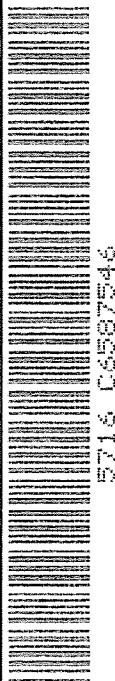
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700[™] M24

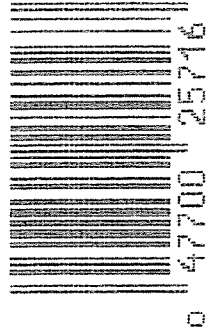
SERIAL NO.
C6587546

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587546

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/6/90	W.B.
618	Polish Barrel RB		11/7/90	W.B.
620	Apply Coatings (Barrel Action)		11-26-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	JH

op. #	BARBER - M24 0022475 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.25	4.50	4.25			1/2/91	KJ
	G) Safety Off Force	2.25	2.25	2.25			1/2/91	KJ
	H) Trigger Pull Test & Retainability						1-3-91	JJ
	I) Firing Pin Indent	.020	.020	.020			1/2/91	KJ
	J) Assemble Stock						1-16-91	KS
	K) Assemble Swivel Studs						2-21-91	A
	L) Attach Front and Rear Sight Assemblies						1-16-91	KS
	M) Iron Sight Alignment						1-16-91	KS
	N) Detach Front & Rear Sights & place in numbered container						1-16-91	KS
	O) Attach Scope to Rifle						1-16-91	KS
	P) Detach & Attach Scope 20 Times						1-16-91	KS
640	Gallery Target & Test						1/17/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						1/17/91	KJ
655	Final Inspection							
	A) Headspace						2-21-91	A
	B) Trigger Pull	2.73	2.75	2.77	2.74	2.76	2/18/91	WBS
	C) Function						2-21-91	A
660	Pack						3-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06587546DATE 1-3-91TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.38	2.38	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.34	2.32	2.75	
PULL #3	2.41	2.32	2.38	2.77	
PULL #4	2.42	2.37	2.35	2.74	
PULL #5	2.38	2.34	2.35	2.76	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.31		
PULL #2	3.49	3.30		
PULL #3	3.38	3.31		
PULL #4	3.37	3.35		
PULL #5	3.38	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	4.19	4.42		4.46
PULL #2	4.41	4.40		4.48
PULL #3	4.40	4.46		4.43
PULL #4	4.46	4.47		4.48
PULL #5	4.45	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587546
18 Jan 1991

CENTROIDAL DISTANCES

Ø TO	1	.141209
1 TO	2	.158051
1 TO	3	.13336
1 TO	4	.172409
1 TO	5	.285911

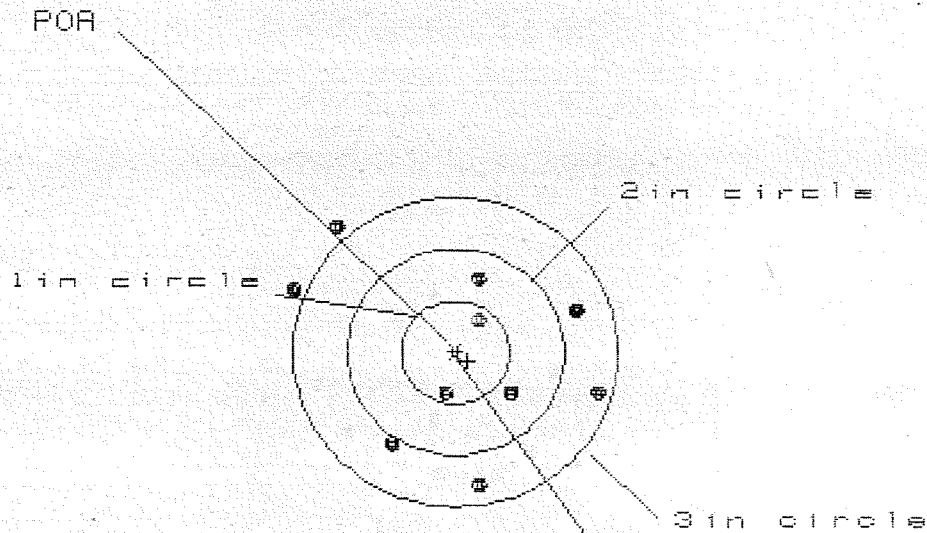
POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.007
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0244
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0253842
THE AMR FOR THIS RIFLE IS: .852

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587546

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HE = 2.840

VS = 2.549

CS = 3.036

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.303	1.132	.969
MINIMUM X	-1.537	-1.300	-.964
MAXIMUM Y	1.226	1.300	.984
MINIMUM Y	-1.323	-1.249	-1.087
CENTROID X	-.112	.059	.222
CENTROID Y	.086	.013	-.150
POA TO CENTROID in.	.141	.061	.267
MIN RADIUS	.357	.360	.184
MEAN RADIUS	1.038	.939	.803
MAX RADIUS	1.674	1.839	1.164
HORIZONTAL SPREAD	2.840	2.432	1.933
VERTICAL SPREAD	2.549	2.549	2.071
EXTREME SPREAD	3.036	2.932	2.152
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

18 Jan 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.130

VS= 1.723

GS= 2.143

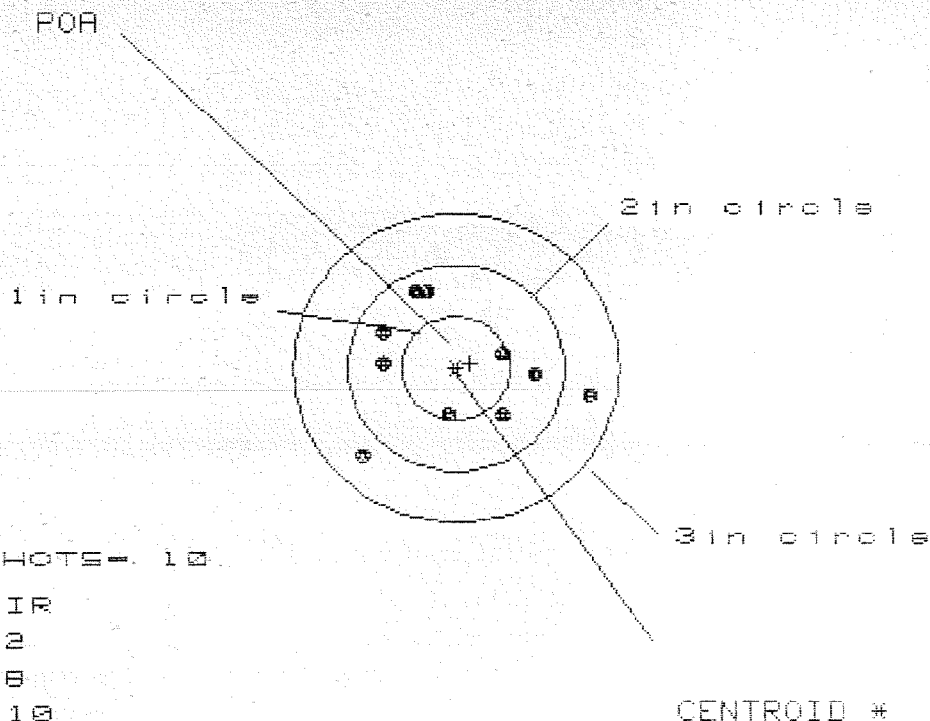
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	.964	.818
MINIMUM X	:	-1.127	-1.166	-.580
MAXIMUM Y	:	1.335	.731	.746
MINIMUM Y	:	-.388	-.240	-.225
CENTROID X	:	.046	.085	.231
CENTROID Y	:	.082	-.066	-.081
POA TO CENTROID in.	:	.094	.108	.244
MIN RADIUS	:	.370	.219	.203
MEAN RADIUS	:	.723	.609	.532
MAX RADIUS	:	1.380	1.172	.916
HORIZONTAL SPREAD	:	2.130	2.130	1.398
VERTICAL SPREAD	:	1.723	.971	.971
EXTREME SPREAD	:	2.143	2.143	1.452
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 2.170

VS= 1.645

GS= 2.245

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.274	.897	.982
MINIMUM X	-.896	-.754	-.638
MAXIMUM Y	.791	.760	.650
MINIMUM Y	-.854	-.885	-.584
CENTROID X	-.131	-.273	-.178
CENTROID Y	-.046	-.015	.095
POA TO CENTROID in.	.139	.273	.202
MIN RADIUS	.396	.453	.430
MEAN RADIUS	.781	.717	.652
MAX RADIUS	1.304	1.162	.820
HORIZONTAL SPREAD	2.170	1.651	1.441
VERTICAL SPREAD	1.645	1.645	1.234
EXTREME SPREAD	2.245	1.847	1.485
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	

NUMBER IN THREE INCH CIRCLE =

10

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.351

VS= 1.432

GS= 2.397

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	.869	.742
MINIMUM X	:	-1.155	-1.023	-.648
MAXIMUM Y	:	.700	.725	.699
MINIMUM Y	:	-.733	-.707	-.734
CENTROID X	:	-.010	-.142	-.015
CENTROID Y	:	-.053	-.078	-.052
POA TO CENTROID in.	:	.053	.162	.054
MIN RADIUS	:	.231	.293	.234
MEAN RADIUS	:	.722	.648	.603
MAX RADIUS	:	1.217	1.055	.946
HORIZONTAL SPREAD	:	2.351	1.892	1.390
VERTICAL SPREAD	:	1.432	1.432	1.432
EXTREME SPREAD	:	2.397	2.019	1.537
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

CENTROID #

HS = 3.625

VS = 1.694

GS = 3.952

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.607	1.383	1.549
MINIMUM X	-2.018	-.775	-.609
MAXIMUM Y	.783	.682	.743
MINIMUM Y	-.911	-.939	-.854
CENTROID X	.172	.396	.230
CENTROID Y	.053	.154	.069
POA TO CENTROID in.	.180	.425	.240
MIN RADIUS	.265	.457	.298
MEAN RADIUS	.996	.890	.761
MAX RADIUS	2.214	1.493	1.600
HORIZONTAL SPREAD	3.625	2.158	2.158
VERTICAL SPREAD	1.694	1.621	1.597
EXTREME SPREAD	3.952	2.446	2.286
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	